

OPEN FIRST!

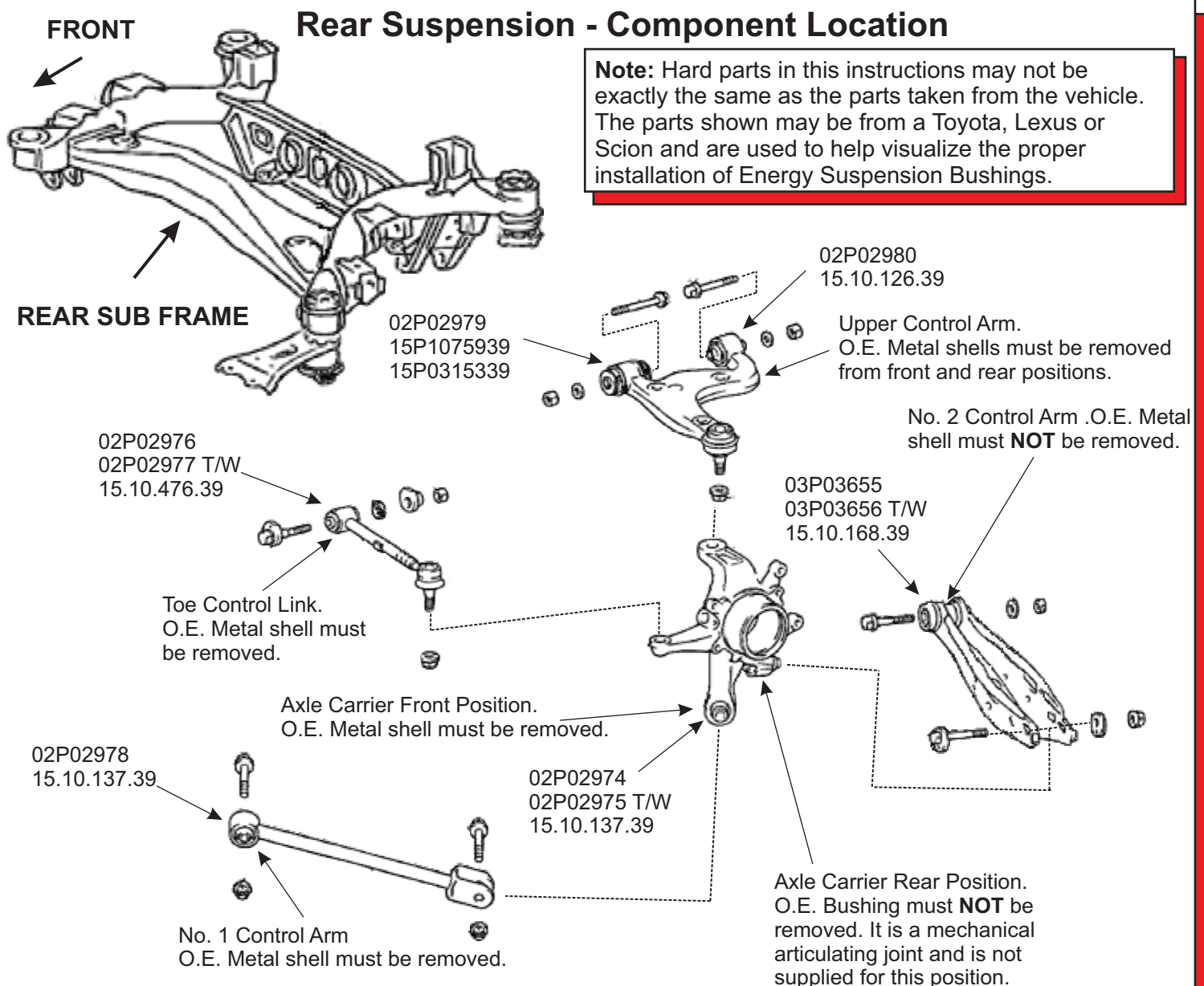
Installation Instructions

8.3140

Rear Control Arm Bushing Set
01-05 LEXUS IS 300

© 2022 Energy Suspension. All rights reserved.
May not be reproduced, in any form, or by any means,
without the written consent of Energy Suspension.

It is recommended that if you are unfamiliar with this work that you refer to a qualified service center specializing in this type of work. It is also recommended that if you choose to do this work yourself that a service manual be obtained for the proper procedures pertaining to removal, replacement and proper torque specifications for your vehicle. This instruction set is intended as a guideline for the safe installation of Energy Suspension's polyurethane bushings, once you have removed the factory components from your vehicle. Wheel alignment is disturbed when suspension components are removed or replaced. It is recommended that you have the alignment checked on your vehicle at a qualified alignment shop. Energy Suspension recommends that you read over all the installation instructions and check all P/N's and quantities in the parts list before you start. Call customer service at 949-361-3935 if the parts in your kit do not match this parts list. Prior to installation, make sure that your vehicle is in top mechanical condition and that there are no suspension or steering related problems. These parts have been designed to work only with a factory original suspension components on a vehicle that is in good state of repair. No matter how carefully we design our parts, we have no control over and cannot be held responsible for vehicle condition.



NOTE: This instruction set is intended as a guideline for the safe installation of Energy Suspension's polyurethane bushings, once you have removed the factory components from your vehicle according to the vehicle service manual.

Parts List:

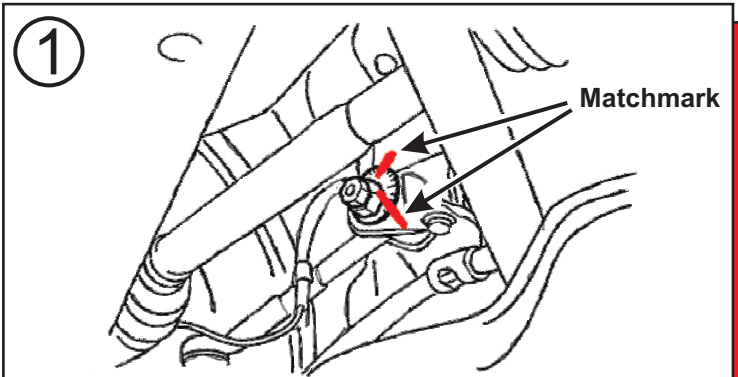
2 EA 02P02974 Axle Carrier Front Position
2 EA 02P02975 Axle Carrier Front Position T/W
2 EA 02P02976 Toe Control Link
2 EA 02P02977 Toe Control Link T/W
4 EA 02P02978 No. 1 Control Arm
4 EA 02P02979 Upper Control Arm Front Position
4 EA 02P02980 Upper Control Arm Rear Position
2 EA 03P03655 No. 2 Control Arm
2 EA 03P03656 No. 2 Control Arm T/W
4 EA 15P0315339 Cap Washer
2 EA 15.10.126.39 Sleeve (.750" x .480" x 2.125")
4 EA 15.10.137.39 Sleeve (.750" x .480" x 1.570")
2 EA 15.10.168.39 Sleeve (.875" x .563" x 2.150")
2 EA 15.10.476.39 Sleeve (.750" x .480" x 1.730")
2 EA 15P1075939 Sleeve (.875" x .563" x 2.300")
3 EA 9.11107 Grease
1 EA 17P17737 Instructions

FASTENER TIGHTENING SPECIFICATIONS

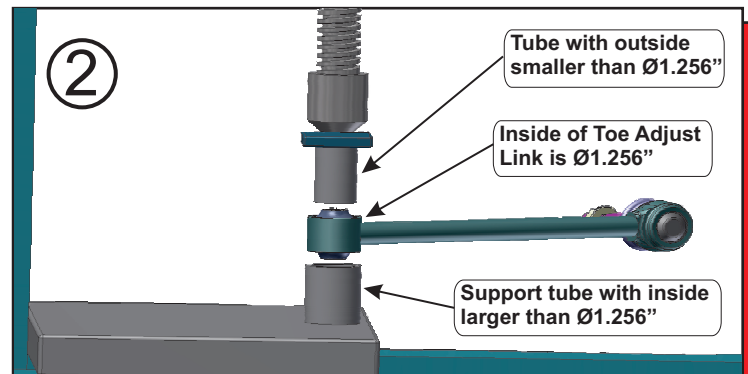
ABS Speed Sensor to Axle Carrier 71 lbs-in (8.0Nm)
ABS Speed Sensor Wire to Toe Control Link 44 lbs-in (5.0 Nm)
Axle Carrier to Upper Control Arm 80 lbs-ft (108 Nm)
Axle Shaft to Axle Hub Nut 213 lbs-ft (289 Nm)
Axle Shaft to Differential Side Gear Shaft 50 lbs-ft (68 Nm)
Brake Caliper to Axle Carrier 77 lbs-ft (104 Nm)
Center Exhaust Pipe to Tailpipe 32 lbs-ft (43 Nm)
Drive shaft Center Support Bearing Set Bolt 36 lbs-ft (49 Nm)
Drive Shaft Assembly to Rear Differential 54 lbs-ft (74 Nm)
Front Differential Mounting Bolt 71 lbs-ft (95 Nm)
Front Exhaust Pipe to Exhaust Pipe Assembly 46 lbs-ft (62 Nm)
Height Control Sensor to Control Arm Bracket 48 lbs-in (5.4 Nm)
No. 1 Lower Control Arm to Axle Carrier 55 lbs-ft (75 Nm)
No. 1 Lower Control Arm to Sub Frame 55 lbs-ft (75 Nm)
No. 2 Lower Control Arm to Axle Carrier 81 lbs-ft (110 Nm)
No. 2 Lower Control Arm to Shock Absorber 81 lbs-ft (110 Nm)
No. 2 Lower Control Arm to Stabilizer End Link 22 lbs-ft (30 Nm)
No. 2 Lower Control Arm to Sub Frame 81 lbs-ft (110 Nm)
Parking Brake Cable to Backing Plate 69 lbs-in (7.8 Nm)
Parking Brake Cable to Body 69 lbs-in (7.8 Nm)
Piston Rod to Upper Shock Mount 21 lbs-ft (28 Nm)
Rear Differential Mounting Bolt 105 lbs-ft (142 Nm)
Rear Sub Frame Brace Set Bolt 37 lbs-ft (50 Nm)
Stabilizer Bar Bracket to Sub Frame 13 lbs-ft (18 Nm)
Stabilizer Bar to Stabilizer End Link 33 lbs-ft (44 Nm)
Sub Frame to Body 94 lbs-ft (127 Nm)
Sub Frame Lower Brace to Body 14 lbs-ft (19 Nm)
Toe Control Link to Axle Carrier 36 lbs-ft (49 Nm)
Toe Control Link to Sub Frame 36 lbs-ft (49 Nm)
Upper Control Arm to Sub Frame Front Side 65 lbs-ft (88 Nm)
Upper Control Arm to Sub Frame Rear Side 55 lbs-ft (74 Nm)
Upper Shock Mount to Body Lower Side 13 lbs-ft (18 Nm)
Upper Shock Mount to Body Upper Side 47 lbs-ft (64 Nm)
NOTE: Recheck Torque after 500 miles.

TOE ADJUST LINK & No. 1 CONTROL ARM

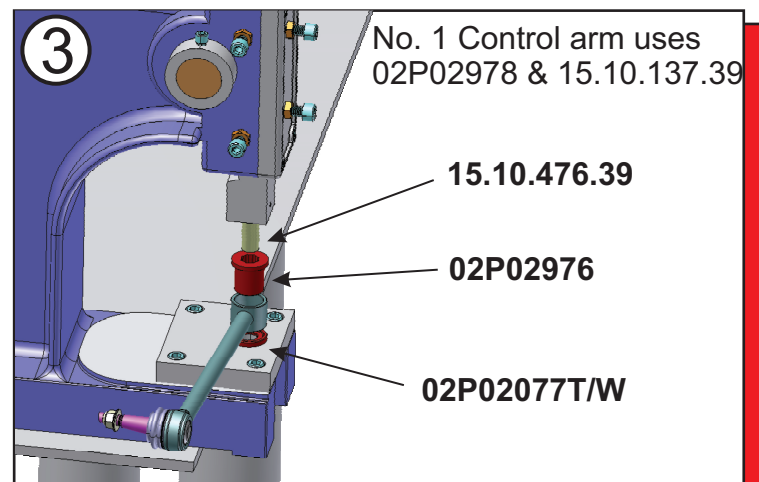
Inside of No. 1 Control Arm is $\varnothing 1.375"$



Before removing the Toe Adjust Link, place matchmarks on the front and rear of the adjusting cam bolts. You will need to use these matchmarks to reinstall the track arm back in the same position after the new polyurethane bushings are installed.

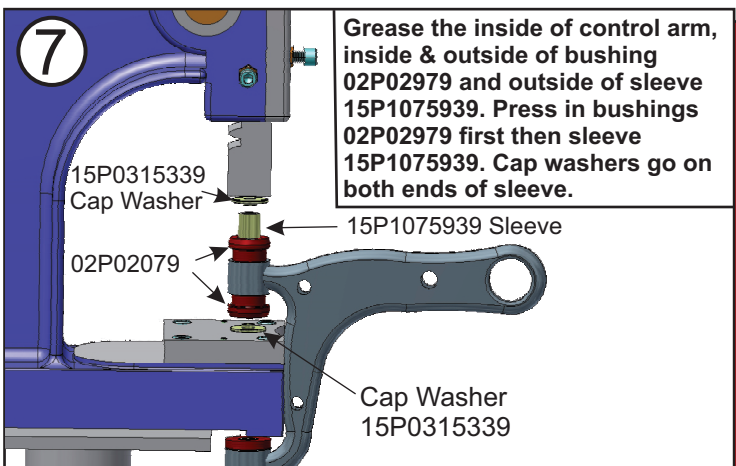
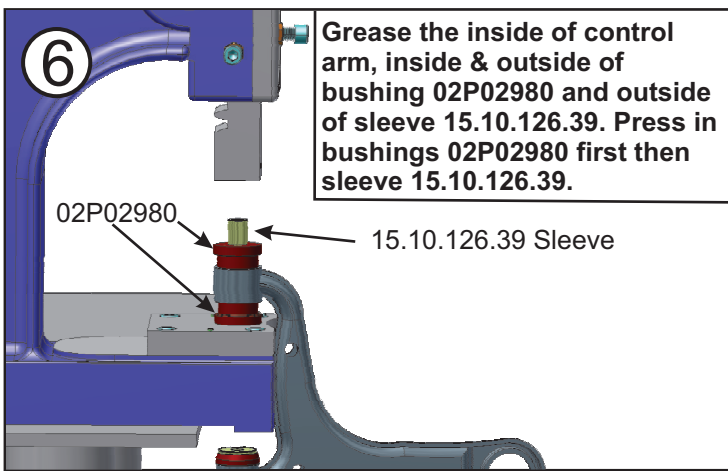
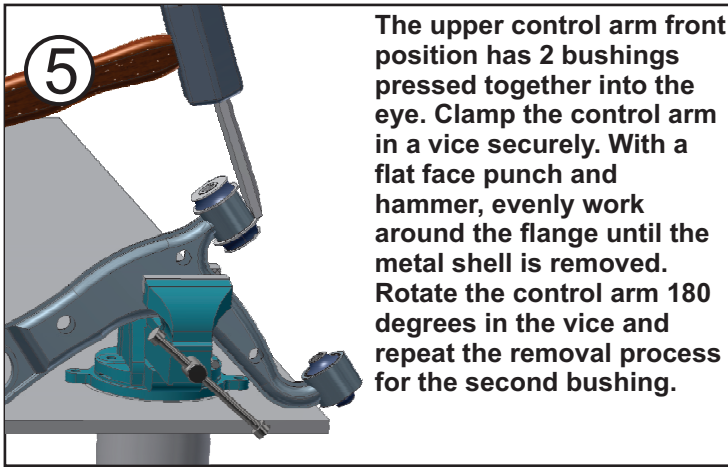
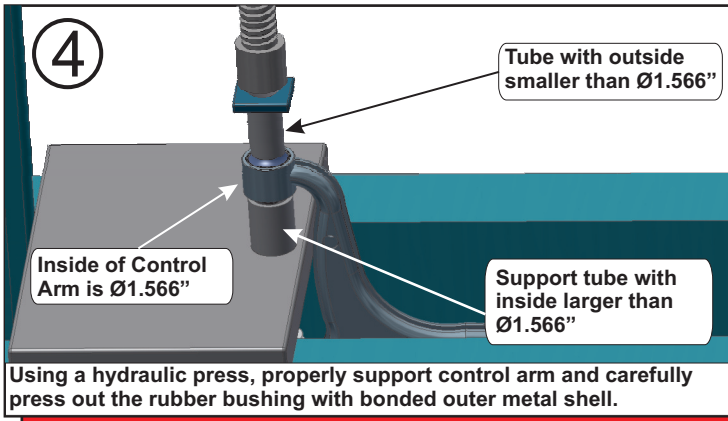


Using a hydraulic press, properly support the Toe Adjust Link or No. 1 Control Arm and carefully press out the rubber bushings with bonded outer metal shell.

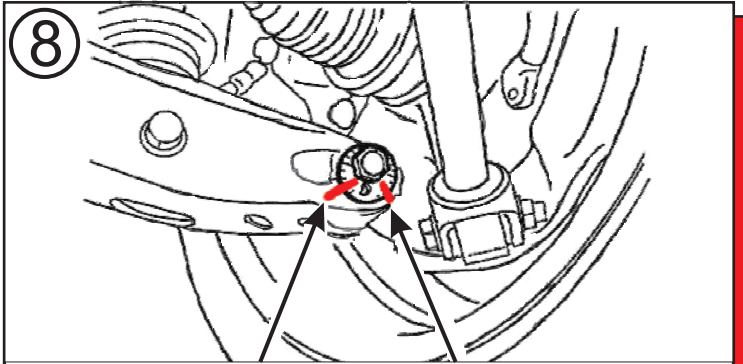


Grease the inside of Toe Adjust Link, inside & outside of bushing 02P02976, 02P02977T/W and outside of sleeve 15.10.476.39. Press in bushing 02P02976 then set 02P02977T/W under and then press in the inner metal sleeve 15.10.476.39.

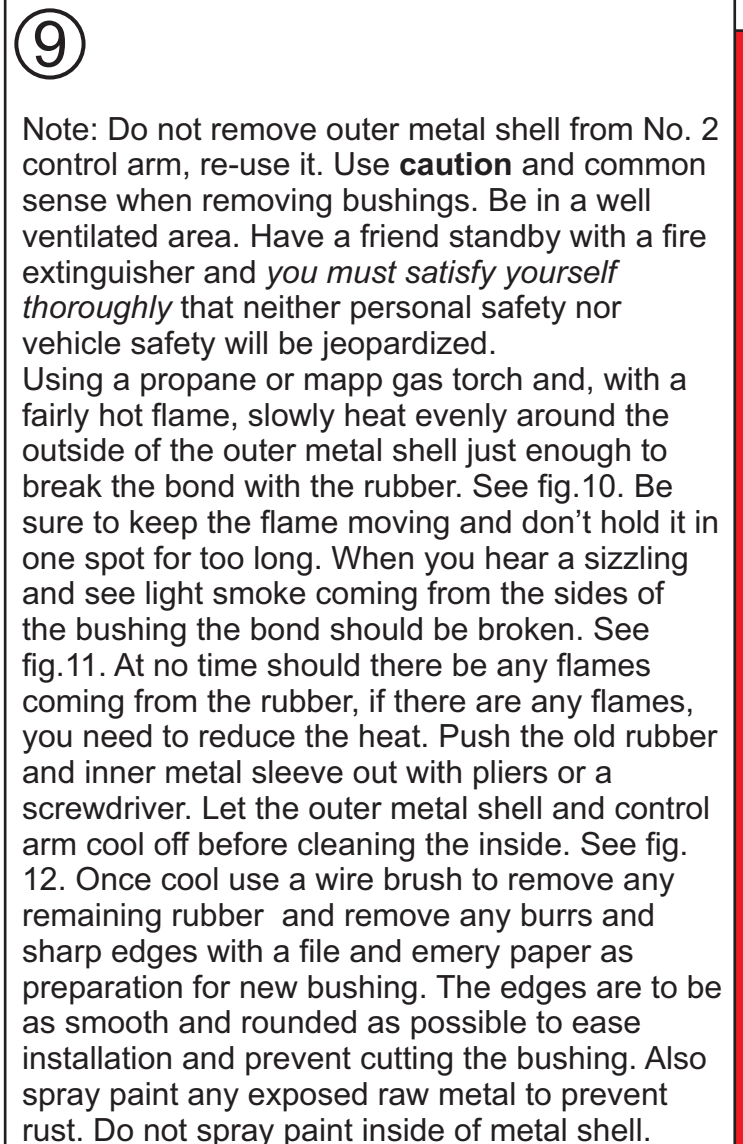
UPPER CONTROL ARM

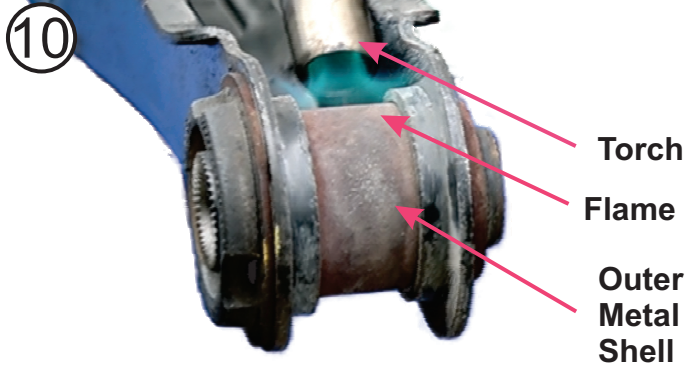


No. 2 CONTROL ARM



Before removing No. 2 control arm, place match marks on the front and rear of the adjusting cam bolts. You will need to use these match marks to reinstall the No. 2 control arm back in the same position after the new polyurethane bushings are installed.

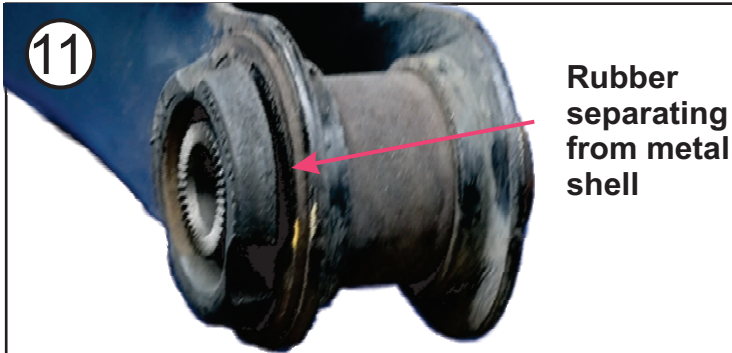




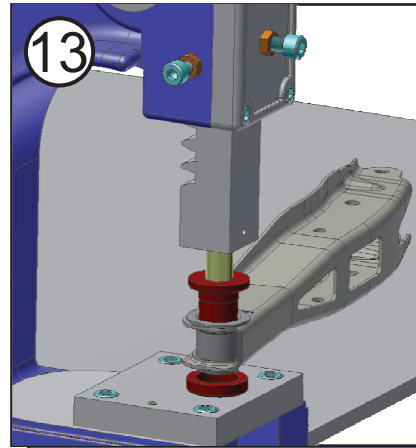
Heat slowly all around the outer metal shell on the inside of the control arm. Do not put the flame directly on any exposed rubber.



Push the old rubber out and let it cool before cleaning the inside of the metal shell.



When you see the rubber separating from the metal shell the bond is broken. Move the torch around until the bond is broken all around shell.



Grease the inside of metal shell, inside & outside of bushing 03P03655 and outside of sleeve 15.10.168.39 Put control arm on top of 03P03656 with flange of metal shell up. Press in bushing 03P03655 first then sleeve 15.10.126.39.

14 AXLE CARRIER FRONT POSITION ONLY.

IMPORTANT: Axle Carrier Rear Position.O.E. Bushing must **NOT** be removed. It is a mechanical articulating joint and is not supplied for this position.

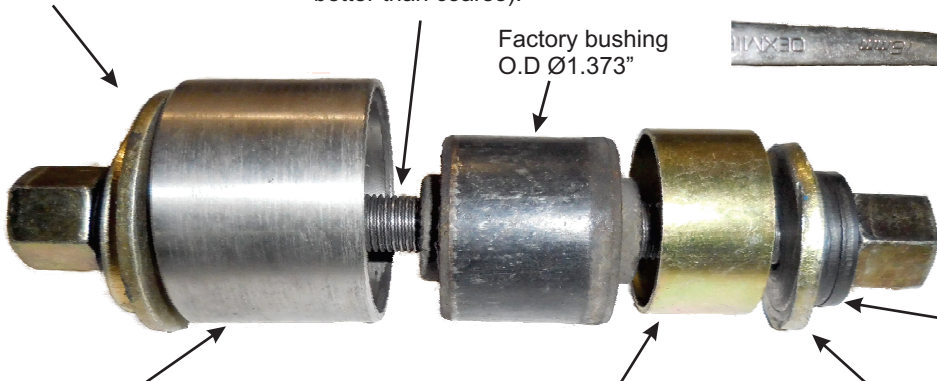
Big washer with O.D. same as tubing and I.D. same as threaded rod.

High-Strength Threaded Rod grade 8. (use fine thread if available, it works better than coarse).

Factory bushing O.D Ø1.373"



FRONT →



Tubing with an I.D. bigger than the O.D. of factory bushing coming out (2.125" I.D.) and the length should be longer than the factory bushing.

Tubing with an O.D. smaller than the O.D. of factory bushing coming out (1.373" O.D.) and the length doesn't matter much for removing factory bushing.

Nuts, one on each end. Use Grade 8 High Hex Nuts. The long length makes wrench-tightening easier.

Use extra flat washers at both ends to help spread the load. Use a little grease between the faces of washers & nuts on both sides.

Thick washer. O.D. should be smaller than O.D. of factory outer metal shell (1.373" O.D.).

Grease all sides of the bushing that will contact metal. Tighten all fasteners to factory specs. After installation is complete, Energy Suspension recommends an alignment be performed at a qualified alignment shop. Check all fasteners after 100, 200 and 500 miles and tighten to factory specs.