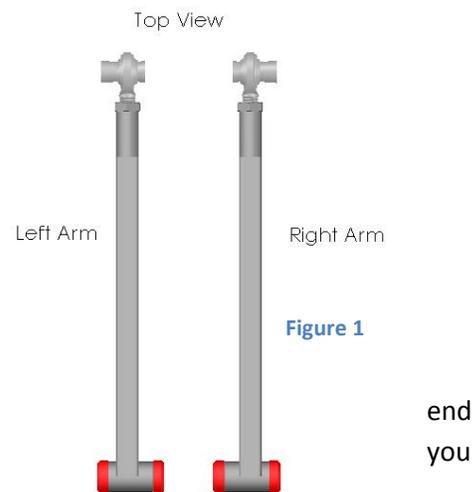


# GR40 Rear Suspension Installation Instructions

S197 Rear Control Arm and Relocation Bracket installation.

1. Raise car to comfortable work height.
2. Support rear axle with separate stands.
3. Remove one rear lower control arm.
4. Assemble new control arm. Position spacers in rod ends so that the front of each arm will be inboard as far as possible, and the rear of each arm will be outboard as far as possible. (Figure 1)
  - a. If you are using MCA 6000 series control arms (aluminum tube with spherical rod ends at each end ) be sure to apply anti-seize to the threads to ensure longer usable life.
  - b. If you are using MCA 4500 series control arms, (steel arm with bushing one end, rod end other) be sure to apply water proof synthetic grease to all surfaces of the urethane bushings and anti-seize lubricant to the threads on the rod
5. Set the length of the new arms to exactly that of the old arms that removed. You can easily do this by inserting the mounting bolts through the eyes of the old arm and then adjusting the new arms until the slip on over the bolts with the spacers. Do not tighten Jam nuts.
6. Install the Rear Axle Brackets and Rear Control Arms. (Image needed)
  - a. Use the OE 12mm control arm bolt through the upper hole in the bracket. Be sure to install the spacer in the bracket center.
  - b. Use the supplied ½-20 x 4.5" bolts to install the lower control arm.
    - i. MCA 6000 Aluminum arms: install long spacer inboard. (Image needed)
    - ii. MCA 4500 Steel arms: Install so that the long side of the bushing offset is inboard. (Image needed)
  - c. Install bolts so heads are inboard and nuts are outboard. (Not as shown in figure 2) This will facilitate removal if needed at a later date.
  - d. Torque all bolts to specifications on the Chart.
7. If you desire to check rear axle alignment by whatever means at your disposal you can do so now.
8. When finished aligning rear axle, be sure to tighten jam nuts on the control arms to approximately 40-45 ft-lbs.



## Bolt Torque:

½-20 G8 Bolts	95-100	ft-lbs
12mm OE LCA Bolts	120-129	ft-lbs
¾-16 Jam Nuts	40-50	ft Lbs

