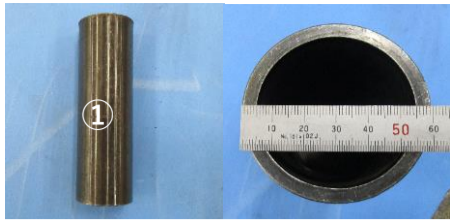


# A70Supra Front Lower Arm Bush Press-fit Work Procedure

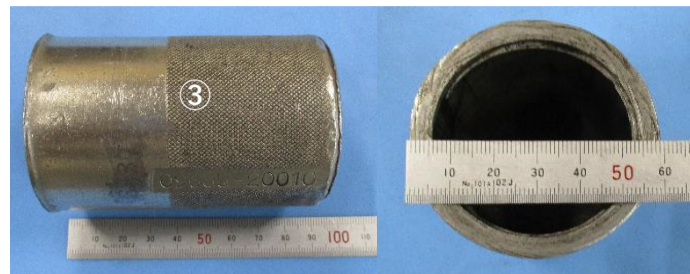
## Preparation tool



part number:09308-14010  
replacer pipe A  
necessary dimension  
inside diameter:Φ50



pipe length:150mm  
(similar alternatives are acceptable)  
outside diameter:Φ42

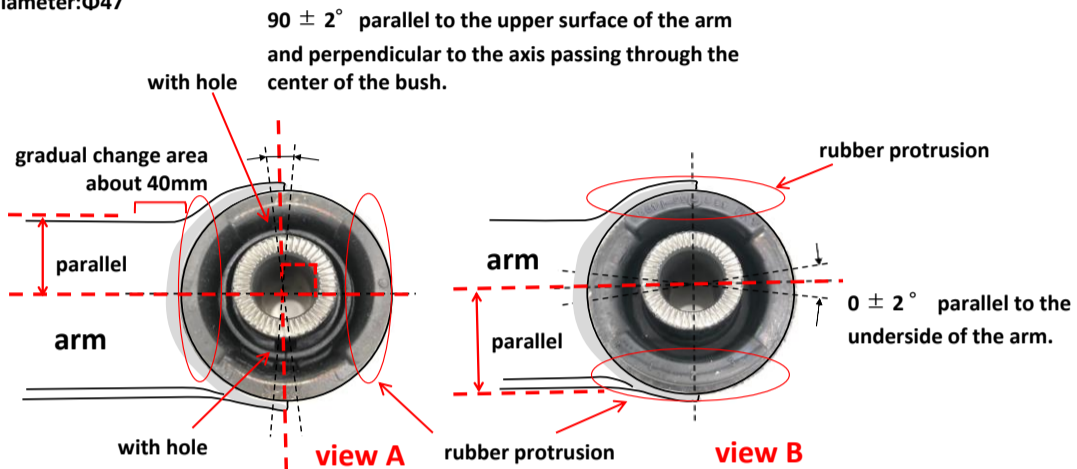
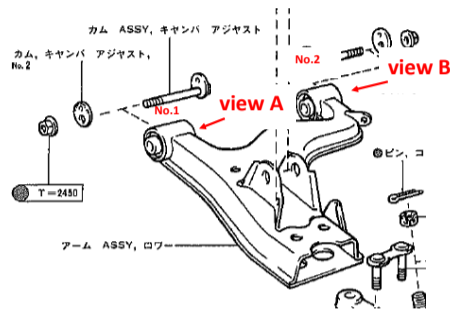


part number:09635-20010  
replacer pipe B  
necessary dimension  
inside diameter:Φ47

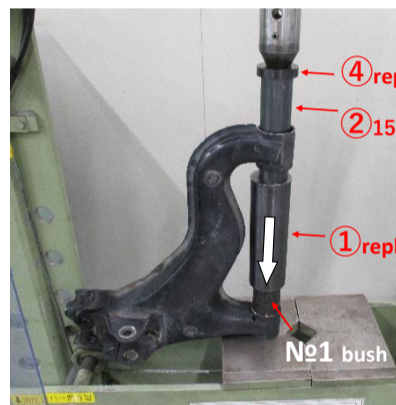


part number:09950-60010  
replacer set  
(similar alternatives are acceptable)

## Overall view of the lower arm



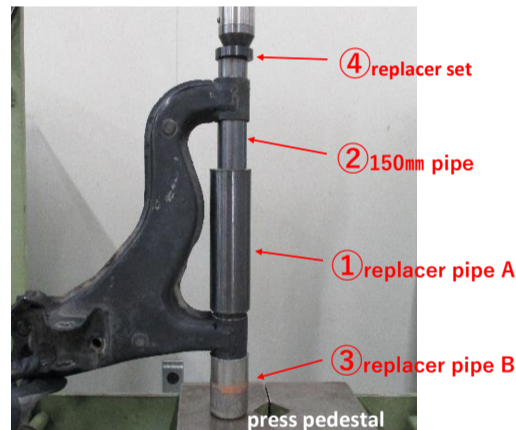
## Working procedure



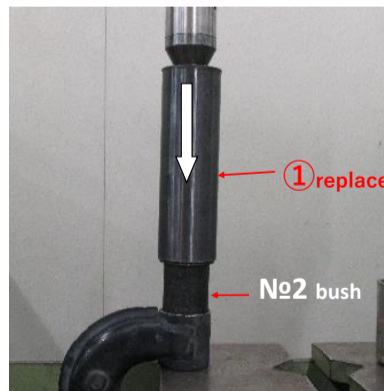
1. Set the preparation tool and lower arm to the hydraulic press. Type in the No. 1 bush first. Install the bush so that it is within the range shown in A view on the upper right.



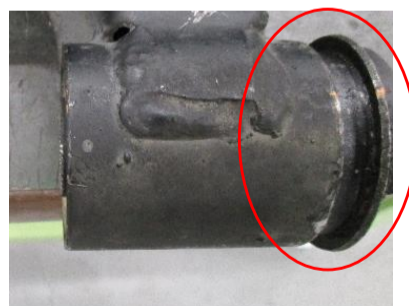
2. Press-fit the bush and stop just before it hits the press pedestal.



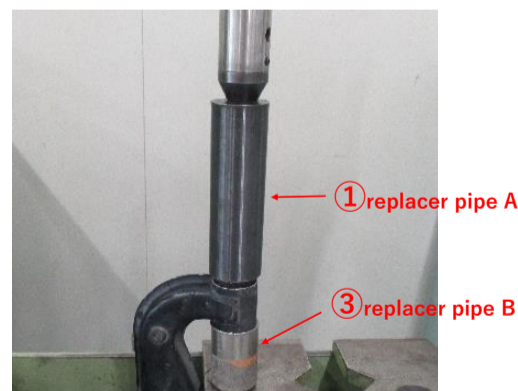
3. Put the replacer pipe B ③ under the arm to make a relief for the bush and drive it in. (Possible to put ③ in 1, but there is a risk because the arm tends to be unstable) Note that if press-fitting is performed without using the repress pipe B ③, the inner cylinder of the bush will come into contact with the press pedestal before the outer cylinder and the bush will be damaged.



4. Next, drive in the No. 2 bush. Install the bush so that it is within the range shown in B view on the upper right.



5. Press-fit the bush and stop it just before it hits the pedestal of the press.



6. Put the replacer pipe B ③ under the arm to make a relief for the bush and drive it in. (Possible to put ③ in 1, but there is a risk because the arm tends to be unsta Note that if press-fitting is performed without using the repress pipe B ③, the inner cylinder of the bush will come into contact with the press pedestal before the outer cylinder and the bush will be damaged.



«Memo»

After press-fitting, the rubber on the surface where the replacer pipe A ① hits