



2021+ Bronco Billet Rear Lower Control Arm Kit 531ADS

INCLUDED HARDWARE:

QTY	DESCRIPTION	PART NUMBER
1	21+ BRONCO BILLET LCA LHS	721R75
1	21+ BRONCO BILLET LCA RHS	721R76
2	REAR BUSHING STEEL INSERT	724R31
4	21+ BRONCO REAR CONTROL ARM POLY BUSHING	724R32
2	1.25" JAM NUT	724R34
2	1.25" HEIM JOINT	724R33
4	1.25" MISALIGNMENT BUSHING	724R30
2	ACETAL ROCK SLIDER	721R77
4	3/8-24 X 1.25" SOCKET HEAD CAP SCREW	5R2961
10	1/4-28X .375" SOCKET HEAD CAP SCREW	5R2962
1	POLYURETHANE BUSHING GREASE 1 OZ PACKET	270R54
1	ADS STICKER	99R10671Y
1	INSTRUCTIONS	199R12516

ADS recommends that all suspension components be installed by a qualified professional.

CONTROL ARM ASSEMBLY INSTRUCTIONS:

1. Before beginning, secure the vehicle chassis on jack stands, allowing the rear axle to droop. Never work on a vehicle that is not correctly supported. To prevent axle from shifting, install (x1) control arm at a time (**Figure 1**).



Figure 1

2. Loosely assembly the heim joint, jam nut, and 3/8th jam bolts as shown (**Figure 2**).



Figure 2

3. Press each polyurethane bushing half into the control arm. **Do not coat the OD of bushing or ID of control arm with grease. Bushings are designed to be pressed in dry.**
4. Coat the steel bushing insert with grease, and press it into the bushing assembly (**Figure 3**).



Figure 3

5. Adjust the heim joint to the desired length. **Factory lower control arm length is 25.75" center to center of the bushing holes. Unless instructed to do so by lift kit manufacturer, it is recommended to use this length as a starting point.**
6. Torque heim joint jam nut to **125 ft./lb.** using a 1-7/8th wrench. Torque (x2) 3/8th socket head caps pinch screws to **40 ft./lb.** in 3 steps: 12 ft./lb. > 25 ft./lb. > 40 ft./lb.
7. Install heim joint misalignment spacers as shown (**Figure 4**).



Figure 4

8. Lower fuel tank per manufacturer's recommended procedure to gain access to, and remove, pivot bolt cover.
9. Remove stock passenger's side lower control arm.

10. Install ADS Billet Lower Control arm. Torque heim joint pivot bolt to **159 ft./lb.**, leave the polyurethane bushing pivot bolt hand tight at this time.
11. Re-install fuel tank.
12. Repeat steps 1-9 for driver's side.
13. Install acetal sliders and torque (x5) bolts to **89 in./lb.** (Figure 5).



Figure 5

14. Lower vehicle onto ground and allow suspension to settle.
15. Torque both polyurethane bushing side pivot bolts to **159 ft./lb.**
16. Check all fasteners after 50 miles.

Toll Free Technical Service: 1-866-464-6553
For online help, please refer to the Technical Information section of our website:
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