



2021+ Bronco Billet Rear Upper Control Arm Kit 532ADS

INCLUDED HARDWARE:

QTY	DESCRIPTION	PART NUMBER
1	21+ BRONCO BILLET UCA LHS	721R73
1	21+ BRONCO BILLET UCA RHS	721R74
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
4	3/8-24 X 1.25" SOCKET HEAD CAP SCREW	5R2961
1	POLYURETHANE BUSHING GREASE 1 OZ PACKET	270R54
1	ADS STICKER	99R10671Y
1	INSTRUCTIONS	199R12517

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**).

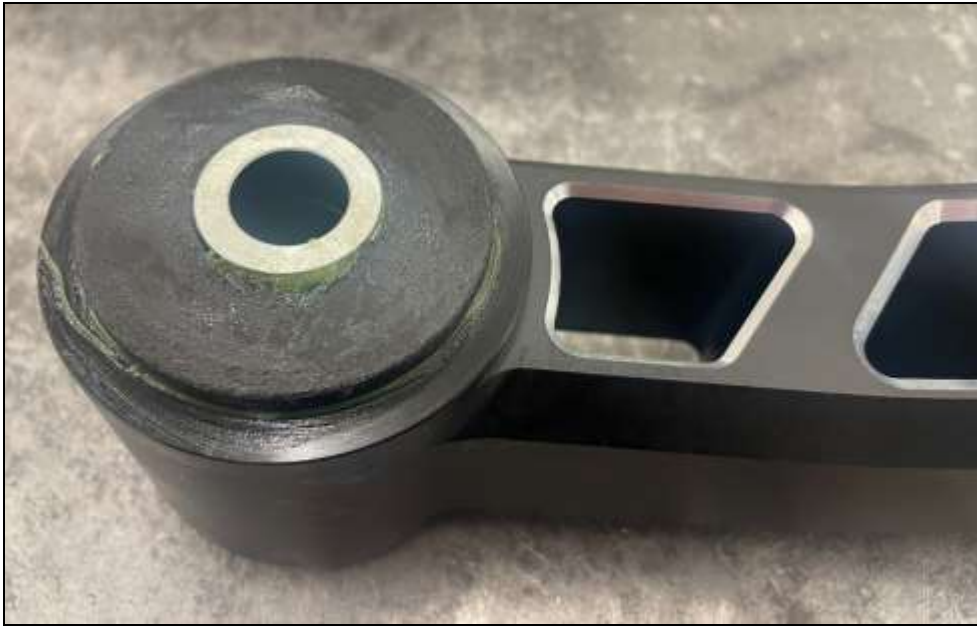


Figure 3

5. Adjust the heim joint to the desired length.
 - a. **Factory upper control arm length is 14.5" 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.**
 - b. **NOTE: ADS billet UCA's are left/right specific. They are meant to be installed with the head of the jam bolts facing outward on each side.**
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 pivot bolt for passenger's upper control arm.
9. Remove stock passenger's side upper control arm.
10. Install ADS Billet upper Control arm. Torque heim joint pivot bolt to **159 ft./lb.**, leave the polyurethane bushing pivot bolt hand tight at this time.
 - a. **NOTE:** It is easiest to install the polyurethane bushing pivot bolt on the axle housing first, then install the heim joint pivot bolt on the chassis side.
11. Re-install fuel tank.
12. Repeat steps 1-9 for driver's side.
13. Lower vehicle onto ground and allow suspension to settle.
14. Torque both polyurethane bushing side pivot bolts to **159 ft./lb.**
15. 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:
www.holley.com

© 2023 Holley Performance Products, Inc. All rights reserved. Tous Droits Réservés.

199R12517
Date: 8-24-23