



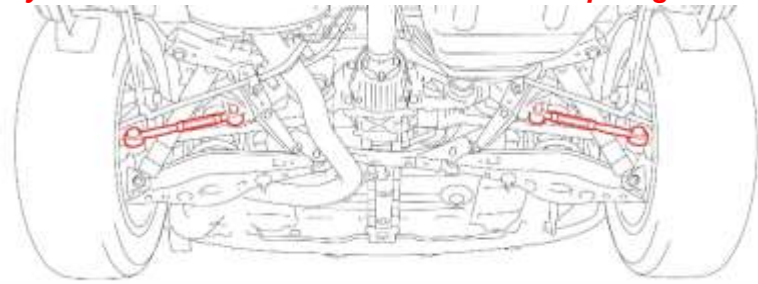
# SAFETY RECALL G0V



## RAV4 Rear Lower Suspension Arm No.1 Replacement

### 1. REPLACE RH AND LH REAR SUSPENSION ARMS

- Replace both the LH and RH Rear Lower Suspension Arm No.1.
- Replace the both the mounting bolt and nut securing the rear lower suspension arm to the suspension member.
- **Always hold the nut and turn the bolt when torquing.**



### 2. PERFORM FOUR WHEEL ALIGNMENT

- Jounce the front & rear of the vehicle to settle the suspension with vehicle on the alignment rack slide plates and the pins removed.
- Ensure the ball joint is aligned correctly before tightening lock nuts.
- **DO NOT move the adjusting tube when tightening the lock nuts.**
- **Torq. the lock nuts using the SST and follow the specific sequence.**
- **Failure to follow this procedure EXACTLY AS DESCRIBED could cause the arm to become loose.**

Tools: Rear Control Arm Torq. Fixture, 22mm crowfoot on torq. wrench



Torque lock nuts to 41 ft lbs.

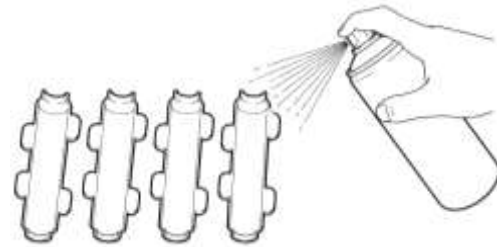
1) Inboard Nut

2) Outboard Nut

3) Inboard Nut Again

### 3. PREPARE MOLDS

- Confirm the molds are clean.
- Apply 2 coats of mold release, allow ~60 seconds dry time.
- Mold release should not be wet or pooling after drying time.



### 4. CLEAN SUSPENSION ARM

- **Clean the exterior surface of the new arms with brake clean.**
- **This is CRITICAL to confirm the epoxy adheres properly.**



### 5. PREPARE EPOXY

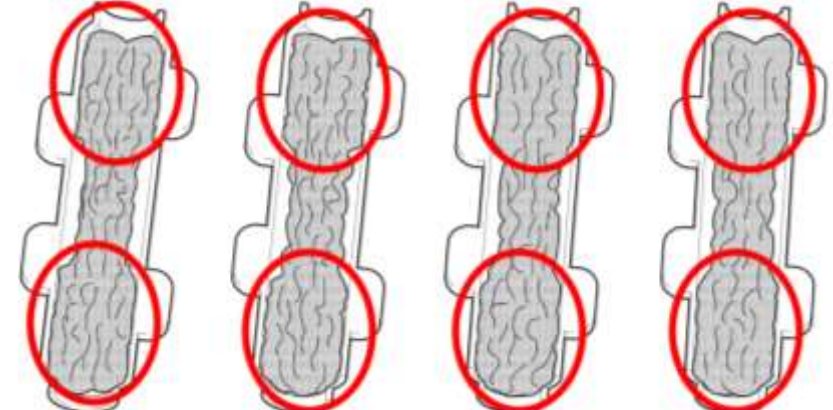
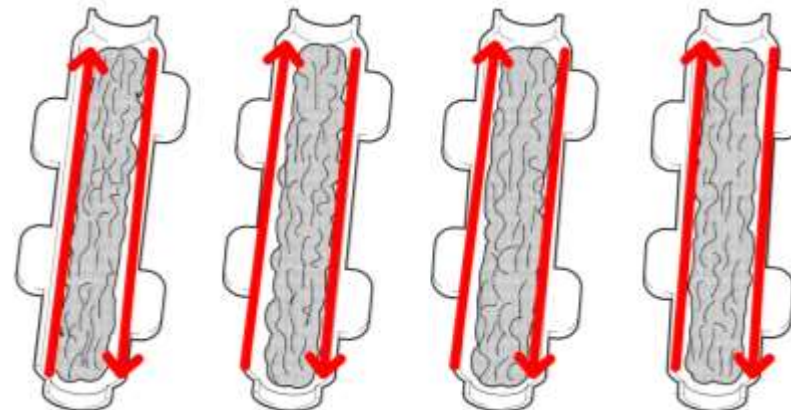
- Start by filling the mixing nozzle to the tip by squeezing the applicator handle, then releasing it when full.
- **Pre-filling the nozzle is CRITICAL to even epoxy distribution.**



### 6. FILL THE MOLDS WITH EPOXY

- **Follow step 6 EXACTLY, so there are no voids in the epoxy once set.**
- Apply 2 full squeezes of the epoxy along the length of each mold.
- One epoxy cartridge contains approximately 12 full squeezes.

- Apply the remaining 3-4 squeezes in the upper and lower thirds.
- The epoxy has approximately 5 minutes of working time.
- It is important that the epoxy is filled evenly between the 4 molds.



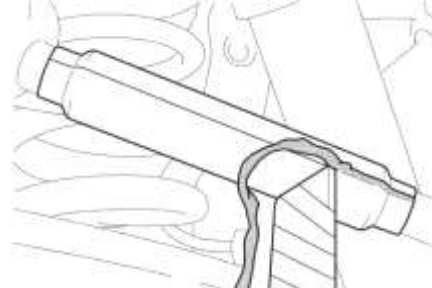
### 7. INSTALL THE MOLDS

- Apply the molds over the lock nuts and adjusting tube.
- Press the molds together so that the epoxy is forced out along the parting lines.
- Allow the epoxy to set.



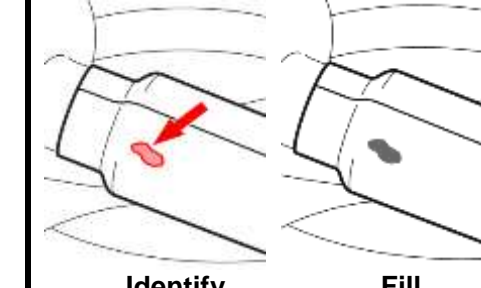
### 8. CLEAN/TRIM EPOXY

- Once set for a minimum of 30 minutes, remove the molds, **DO NOT remove them early.**
- Trim the excess epoxy.
- Wipe the epoxy using a clean shop cloth.



### 9. INSPECT EPOXY

- Inspect for voids that expose the arm, fill any voids with FIPG.
- There should not be any voids if the molds are filled with epoxy correctly.



### 10. APPLY LABEL

- Confirm all mold release residue has been wiped off of the arm.
- Wrap the caution label around the epoxy, it is designed to overlap on itself by 3/8".

