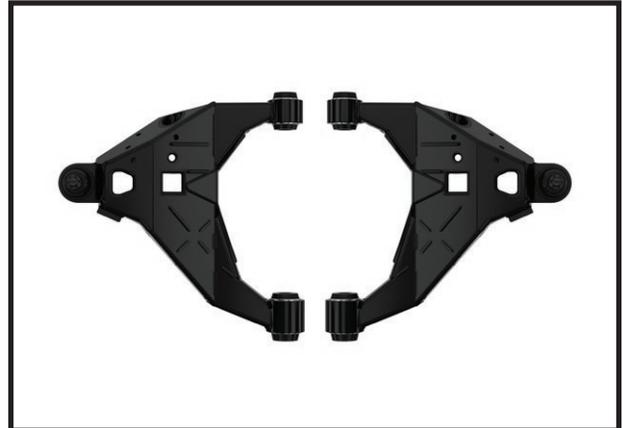


7929 Lincoln Ave. Riverside, CA 92504  
Phone: 951.689.ICON | Fax: 951.689.1016

PART #	DESCRIPTION
54300	05-23 TACOMA LOWER CONTROL ARMS

COMPONENTS INCLUDED	
(1) 154503 05-23 TACOMA LOWER CONTROL ARM DRVR	(1) 154504 05-23 TACOMA LOWER CONTROL ARM PASS
REQUIRED HARDWARE - SOLD SEPARATELY	
54301 HARDWARE KIT 16-23 TACOMA	
(2) 157024 LOWER ARM SLEEVE 64.8MM OAL 21.2MM ID	(4) 150119 FACE WASHER 21.2MM
(2) 157026 LOWER ARM SLEEVE 83MM OAL 16.2MM ID	(2) 257161 HEIM SPACER COM10 X 14MM X 1.925 CZINC
(4) 150117 TACOMA FACE WASHER 16.2MM	(2) 157168 HEIM SPACER COM10 X 14MM X 1.375 CZINC
54302 HARDWARE KIT 05-15 TACOMA	
(2) 157022 LOWER ARM SLEEVE 64.8MM OAL 14.2MM ID	(4) 150117 FACE WASHER 16.2MM ID
(2) 157023 LOWER ARM SLEEVE 64.8MM OAL 19.5MM ID	(4) 150118 FACE WASHER 19.5MM ID
(2) 157025 LOWER ARM SLEEVE 83MM OAL 14.2MM ID	(2) 257161 HEIM SPACER COM10 X 14MM X 1.925 CZINC
(4) 150116 FACE WASHER 14.2MM ID	(2) 157168 HEIM SPACER COM10 X 14MM X 1.375 CZINC
TOOLS REQUIRED	
FLOOR JACK JACK STANDS BALL JOINT SEPARATOR MOLY BASED GREASE PLIERS	3/4" WRENCH/SOCKET 19MM WRENCH/SOCKET 24MM WRENCH/SOCKET TORQUE WRENCH
TECH NOTES	
1. 05-15 TACOMA REQUIRES HARDWARE KIT PN:54302	
2. 16-23 TACOMA REQUIRES HARDWARE KIT PN:54301	
3. INSTALL TIME: 3-4 HOURS	



WARNING!
<p><b>** READ ALL INSTRUCTIONS THOROUGHLY FROM START TO FINISH BEFORE BEGINNING INSTALLATION! IF THESE INSTRUCTIONS ARE NOT PROPERLY FOLLOWED SEVERE FRAME, SUSPENSION AND TIRE DAMAGE MAY RESULT TO THE VEHICLE!</b></p> <p><b>** ICON VEHICLE DYNAMICS RECOMMENDS THAT YOU EXERCISE EXTREME CAUTION WHEN WORKING UNDER A VEHICLE THAT IS SUPPORTED WITH JACK STANDS.</b></p> <p><b>** ICON VEHICLE DYNAMICS RECOMMENDS ALL INSTALLATION TO BE PERFORMED BY A PROFESSIONAL SHOP/SERVICE TECHNICIAN. PRODUCT FAILURE CAUSED BY IMPROPER INSTALLATION WILL NOT BE COVERED UNDER ICON'S WARRANTY POLICY.</b></p>

## INSTALLATION

- Place the truck on a flat surface with the parking brake engaged, chock the rear tires.
- Use a suitable floor jack in the manufacturer designated spot on the frame to lift the front of the truck, then place a suitable jack stand under the frame and set the truck down securely on the jack stands. NEVER WORK UNDER AN UNSUPPORTED VEHICLE. Remove the front wheels and tires.
- Begin by removing the lower coilover hardware using a 19mm. This bolt, nut and washer will be reused. If a secondary shock is installed, remove that now using 3/4" wrenches. [FIGURE 1]

FIG.1



**4.** Remove the (2) 19 mm bolts from the lower ball joint bracket. Support the spindle assembly so it does not over extend the CV (if applicable). [FIGURE 2]

FIG.2



**5.** Remove the inner cam bolts using a 19mm. Loosen the nut, if you try to loosen/rotate the bolt, the cams could break free and new bolts would be needed. Once the bolts and sleeve (05-15 years) are removed, the lower control arm can be removed. Note the orientation and location of each bolt for reinstallation. [FIGURE 3 & 4]

FIG.3



FIG.4



**6.** Locate the new driver-side arm and install the sleeves into the bushings. Add grease into the bushing before installing the sleeve.

**7.** Remove the lower ball joint bracket from the factory ball joint using a ball joint separator and 24mm. Note the orientation of the steering stop to the arm (Front/Back). [FIGURE 5]

FIG.5



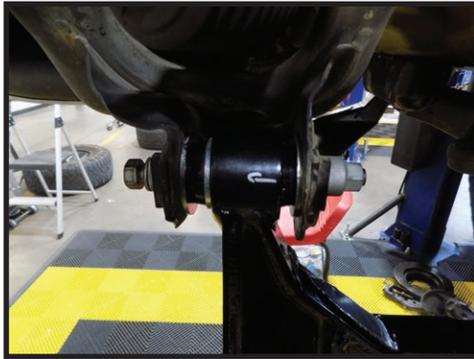
**8.** Install the bracket onto the new ICON lower ball joint. Tighten the ball joint nut and install the cotter key. [FIGURE 6]

FIG.6



**9.** Install the LCA into the frame pockets. The washers supplied in the hardware kits go on either side of the bushings, so the bushings do not get cut on the alignment slots. [FIGURE 7]

FIG.7



**10.** Set the alignment cams centered and tighten the bolts to 100 ft-lbs.

**11.** Rotate the arm up and install the ball joint bracket onto the bottom of the spindle using the OEM hardware. Apply thread locker. Torque to 120 ft-lbs. [FIGURE 8]

FIG.8



**12.** Reinstall the coilover and secondary shock if applicable. The hardware kit has new lower spacers for the coilover. The longer spacer goes towards the rear of the truck to push the shock away from the CV axle.

**13.** Reinstall wheels and tires.

**14.** Get vehicle professionally aligned.

***VERIFY ALL FASTENERS ARE PROPERLY TORQUED BEFORE DRIVING VEHICLE.***

***RETORQUE ALL NUTS, BOLTS AND LUGS AFTER 100 MILES AND PERIODICALLY THEREAFTER.***

## ICON VEHICLE DYNAMICS LIMITED LIFETIME WARRANTY

ICON Vehicle Dynamics warrants to the original retail purchaser who owns the vehicle on which the product was originally installed. ICON Vehicle Dynamics does not warrant the product for finish, alterations, modifications and/or installation contrary to ICON Vehicle Dynamics instructions. ICON Vehicle Dynamics products are not designed, nor are they intended to be installed on vehicles used in race applications, for racing purposes or for similar activities. (A "race" is defined as any contest between two or more vehicles, or a contest of one or more vehicles against the clock, whether or not such contest is for a prize). This warranty does not include coverage for police or taxi vehicles, race vehicles, or vehicles used for government or commercial purposes. Also excluded from this warranty are sales outside of the United States of America and Canada.

ICON Vehicle Dynamics' obligation under this warranty is limited to the repair or replacement, at ICON Vehicle Dynamics' discretion, of the defective product. Any and all costs of removal, installation or re-installation, freight charges and incidental or consequential damages are expressly excluded from this warranty. Items that are subject to wear are not considered defective when worn and are not covered.

ICON Vehicle Dynamics components must be installed as a complete kit as shown in our current application guide. Any substitutions or exemptions of required components will immediately void the warranty. Some finish damage may happen to parts during shipping and is not covered under warranty.

This warranty is expressly in lieu of all other warranties expressed or implied. This warranty shall not apply to any product that has been improperly installed, modified or customized subject to accident, negligence, abuse or misuse.



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PERFORMANCE SUSPENSION SYSTEMS AND SHOCK ABSORBERS

7929 Lincoln Ave. Riverside, CA 92504 Phone: 951.689.ICON Fax: 951.689.1016  
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