



M-2300-ZX3 2000-2004 Focus SVT Brake Conversion Kit INSTALLATION INSTRUCTIONS

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Please visit www.fordracingparts.com for the most current instruction information

**!!! PLEASE READ ALL OF THE FOLLOWING INSTRUCTIONS CAREFULLY PRIOR TO INSTALLATION.
AT ANY TIME YOU DO NOT UNDERSTAND THE INSTRUCTIONS, PLEASE CALL THE FORD RACING
TECHLINE AT 1-800-367-3788 !!!**

OVERVIEW:

This kit is designed for the use on 2000 – 2004 Focus. The use of a floor hoist is recommended. If you do not have access to one, use a hydraulic floor jack and jack stands to raise the vehicle.

**!!! CAUTION: JACK STANDS MUST BE USED ON A LEVEL SURFACE AND BE SECURELY SEATED.
FAILURE TO DO SO MAY RESULT IN PERSONAL INJURY OR VEHICLE DAMAGE !!!**

KIT INCLUDES:

<u>Item #</u>	<u>Qty</u>	<u>Description</u>	<u>Part Number</u>
1	1	Knuckle - RF	2M5Z-3K185-AA
2	1	Knuckle - LF	2M5Z-3K186-AA
3	2	Hub Assembly - Front	YS4Z-1104-AA
4	2	Hub Retaining Nut - Front	6S4Z-3B477-AA
5	2	Brake Rotors - Front	2M5Z-1125-AA
6	1	Brake Caliper - RF	2M5Z-2B120-AA
7	1	Brake Caliper - LF	2M5Z-2B121-AA
8	2 pkgs	Caliper Mount Bolt Front	W700672-S309
9	1	Parking Brake Cable Assembly	1M5Z-2A603-AB
10	1	Splash Shield - LR	2M5Z-2C028-AA
11	1	Splash Shield - RR	2M5Z-2C028-BA
12	1	Spindle - LR	98AZ-4A013-BA
13	1	Spindle - RR	98AZ-4A013-AA
14	2	Rear Hub/Bearing Assembly	YS4Z-1A034-AA
15	2	Hub Retaining Nut - Rear	YS4Z-3B477-AA
16	1	Hose Bracket - LR	YS4Z-2082-EB
17	1	Hose Bracket - RR	YS4Z-2082-FB
18	2	Brake Rotors - Rear	2M5Z-2C026-AA
19	2	Rear Caliper Brackets & Caliper Bolts	2M5Z-2B582-AA
20	4	Rear Caliper Bracket to Spindle Bolts	W700684-S309
21	1	Brake Caliper - LR	1S4Z-2553-AA
22	1	Brake Caliper - RR	1S4Z-2552-AA
23	2	Brake Hose - Rear	5S4Z-2282-CA
24	2	Grease Caps – Rear Hub	YS4Z-1248-AA
25	1 pair	Brake Pads – Rear	1S4Z-222200-BA

Factory Ford shop manuals are available from Helm Publications, 1-800-782-4356



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INSTALLATION INSTRUCTIONS:

NOTES: Unless specified otherwise, reuse the existing hardware. Possession or access to a 2000 Focus workshop manual or equivalent is strongly recommended. The O.E. wheels will no longer clear the brake calipers after this kit is installed. A minimum wheel diameter of 17" will be required.

STEP 1: Disconnect battery.

STEP 2: Raise and support the vehicle.



Pic. 1 Front



Pic. 2 Rear

STEP 3: Remove front and rear wheels (See Pic. 1 & Pic. 2).

REMOVAL FRONT:

NOTE: For easier removal on some vehicles, spray penetrate on axle nuts, strut-to-knuckle pinch bolt, lower ball joint retaining bolt and nut, and tie rod nuts.



Pic. 3

STEP 4: Remove the right and left side hub retaining nuts (See Pic. 3). Use 31mm socket.

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Pic. 4



Pic. 5

STEP 5: Remove the lower ball joint retaining bolt (reuse) from the knuckles and disconnect the lower ball joint ball stud from knuckle (See Pic. 4 & Pic. 5). Use a T-50 torque bit and 15mm socket.



Pic. 6



Pic. 7

STEP 6: Disconnect both tie rod ends from the knuckles (See Pic. 6). 15mm nut.

STEP 7: Loosen brake line for later removal. Use 15mm wrench (See Pic. 7).



Pic. 8



Pic. 9

STEP 8: Remove calipers from the knuckles. Remove plastic caps and loosen 7mm hex pins (See Pic. 8) Disengage caliper retainer clip and remove caliper (See Pic. 9)

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Pic. 10

STEP 9: Separate the rubber brake line (loosened in STEP 7) from caliper and cap rubber lines with plastic caps (See Pic. 10).

STEP 10: Remove Anti-Lock sensors from knuckle, if equipped with one.



Pic. 11

STEP 11: Remove the rotors (See Pic. 11).

STEP 12: Separate the half shaft from the knuckle (See Pic. 12).



Pic. 12



Pic. 13



Pic. 14

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STEP 13: Remove the knuckle to strut pinch bolt (reuse) (See Pic. 13). Use 15mm socket.

STEP 14: Remove the knuckles from the vehicle (See Pic. 14).

INSTALLATION FRONT:



Pic. 15

NOTE: If dirty, wipe lower strut, lower ball joint stud, tie rod stud and axle spline. Use light anti-seize on spline (See Pic. 15).



Pic. 16



Pic. 17



Pic. 18

STEP 15: Support each inner bearing race of the SVT right and left knuckles (Items 1 & 2), then press the SVT hubs (Item 3) into each knuckle (See Pic. 16, Pic. 17 & Pic. 18).

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Pic. 19



Pic. 20

STEP 16: Install the SVT knuckle/hub assemblies on to the front struts and torque the strut to knuckle bolts to 90 Nm (66 lb-ft) (See Pic. 19 & Pic. 20). Use 15mm socket.



Pic. 21



Pic. 22

STEP 17: Fit the half shaft through the hub. Install the hub retaining nut (Item 4) and torque to 316 Nm (233 lb-ft) (See Pic. 21 & Pic. 22).



Pic. 23



Pic. 24

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STEP 18: Fit the lower ball joint stud into the knuckle. Reinstall the bolt and torque the bolt to 50 Nm (37 lb-ft) (See Pic. 23 & Pic. 24).



Pic. 25



Pic. 26

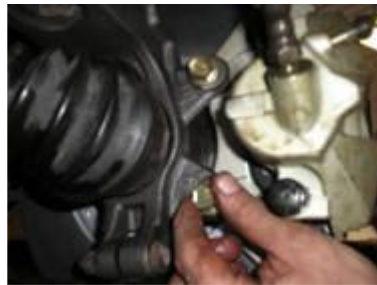
STEP 19: Reinstall Anti-Lock sensor if removed.

STEP 20: Reinstall the tie rod ends into the knuckles and torque the nuts to 47 Nm (35 lb-ft) (See Pic. 25).

STEP 21: Install the SVT rotor (Item 5) onto the hub (See Pic. 26).



Pic. 27



Pic. 28



Pic. 29

STEP 22: Connect the hoses to calipers and torque to 15 Nm (11 lb-ft) (See Pic. 27). Install the SVT caliper assemblies (Items 6 & 7) on to the knuckles with the retaining bolts (Item 8) (See Pic. 28) and torque the bolts to 115 Nm (85 lb-ft) (See Pic. 29).



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Pic. 30

STEP 23: Bleed brakes per shop manual (See Pic. 30).

STEP 24: Wheel alignment is recommended.



REMOVAL REAR:

STEP 1: For vehicles equipped with Anti-Lock brakes, disconnect the wheel speed sensor.

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Pic. 31



Pic. 32



Pic. 33

STEP 2: Remove the dust caps from the rear wheel hubs (See Pic. 31). New dust caps are supplied for reassembly.

STEP 3: Remove the hub retaining nuts from the splines (See Pic. 32). Use 30mm socket.

STEP 4: Remove the rear brake drums (See Pic. 33).



Pic. 34



Pic. 35

STEP 5: Remove the brake shoe retaining clips (See Pic. 34).

STEP 6: Disconnect the parking brake cables from the brake assemblies and remove the drum brake assemblies from the backing plates (See Pic. 35).

NOTE: For easier removal on some vehicles, spray penetrate on 4 spindle to retaining bolts, the upper control arm to trailing arm bolt and the rear brake line connections.

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Pic. 36



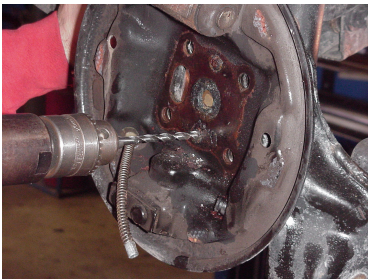
Pic. 37



Pic. 38

STEP 7: Disconnect the brake lines from the rear wheel cylinders (See Pic. 36). Use 7/16" line wrench.

STEP 8: Remove the 4 spindle retaining bolts (reuse) from back of trailing arms using a 13mm socket (See Pic. 37). Remove the spindles (See Pic. 38).



Pic. 39



Pic. 40



Pic. 41

STEP 9: Drill out 2 rivets (use a .200 drill bit) that secure the backing plates to the trailing arms to remove the backing plates (See Pic. 39). Squeeze plastic retainer and remove parking brake cable from backing plates (See Pic. 40).

STEP 10: Disconnect the flexible rear brake hoses from the rear brake hard lines from frame rail attachment. Use 7/16" line wrench. Remove clips and remove line (See Pic. 41).

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Pic. 42



Pic. 43



Pic. 44

STEP 11: Remove the retaining nuts for the underbody exhaust heat shield (See Pic. 42) and slide the shield forward to access the parking brake cable attachment (See Pic. 43).

STEP 12: Disconnect interior brake cable from rear cable union (See Pic. 44).

STEP 13: Squeeze plastic retaining clips and pull right and left cables from floor bracket.



Pic. 45



Pic. 46



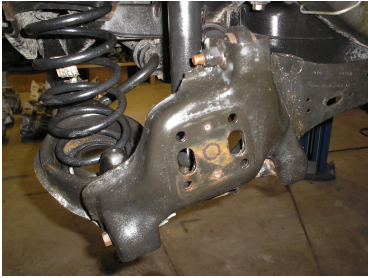
Pic. 47

STEP 14: Remove 2 screws from right and left cable retainers (See Pic. 45).

STEP 15: Remove screw from trailing arm (reuse) (See Pic. 46). Disconnect retaining clip that secures fuel and brake hard lines to the floor then remove parking brake cables from vehicle (See Pic. 47).

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INSTALLATION REAR:



Pic. 48



Pic. 49



Pic. 50

NOTE: If dirty, wipe trailing arm and suspension pieces for reassembly (See Pic. 48).

STEP 16: Install the SVT parking brake cable (Item 9) and route using existing clips. The cable with the green sleeve is the passenger side of the assembly (See Pic. 49 & Pic. 50).



Pic. 51



Pic. 52



Pic. 53

STEP 17: Install the SVT rear splash shields (Items 10 & 11) on the trailing arm with 3/16" rivets (See Pic. 51).

STEP 18: Install the SVT rear spindles (Items 12 & 13) on the trailing arm and torque the bolts to 66 Nm (49 lb-ft) (See Pic. 52 & Pic. 53). Use 13mm socket.

STEP 19: Install rear Anti-Lock brake sensor (if vehicle is equipped).

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Pic. 54



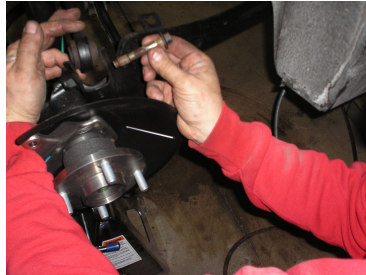
Pic. 55

STEP 20: Install the SVT hub and bearing assemblies (Item 14) onto the spindle (See Pic. 54).

STEP 21: Install the hub retaining nuts (Item 15) to secure the hub and bearings assemblies and torque nuts to 235 Nm (173 lb-ft) (See Pic. 55). Use 30mm socket.



Pic. 56



Pic. 57



Pic. 58

STEP 22: **Support** the bottom of the rear trailing arm being worked on and remove the upper control arm bolt to trailing arm (See Pic. 56). Use 15mm socket.

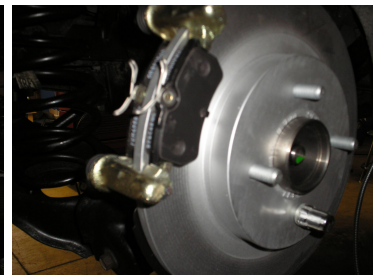
STEP 23: Reinstall the trailing arm bolt (add a little Anti-Seize to bolt shoulder) through the new SVT hose brackets (Items 16 & 17) and torque the bolts to 115 Nm (85 lb-ft) (See Pic. 57 & Pic. 58). Use 15mm socket.



Pic. 59



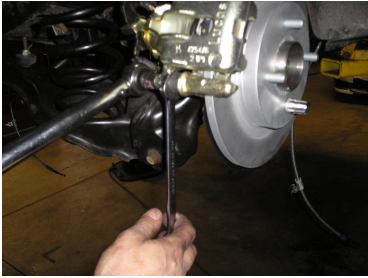
Pic. 60



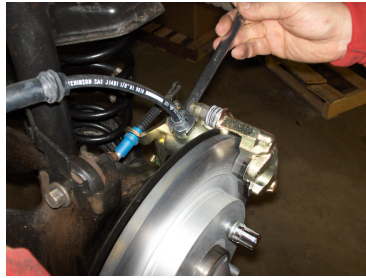
Pic. 61

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- STEP 24:** Install SVT rear rotors (Item 18) onto hubs. Install one lug nut to keep rotor from falling off during assembly (See Pic. 29).
- STEP 25:** Install the SVT rear caliper anchors (Item 19) onto spindles with SVT rear caliper anchor to spindle bolts (Item 20) and torque bolts to 90 Nm (66 lb-ft) (See Pic. 60). Use 13mm socket.
- STEP 26:** Install new brake pads into anchors (See Pic. 61).



Pic. 62



Pic. 63

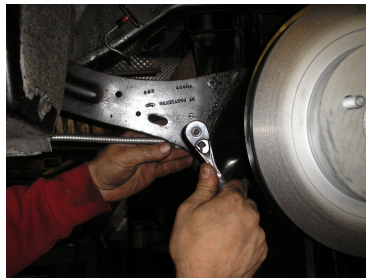


Pic. 64

- STEP 27:** Install the SVT rear calipers (Items 21 & 22) onto the caliper anchors and torque the 13mm bolt to 28 Nm (21 lb-ft). Use 15mm wrench to hold anchor sleeve nut when tightening (See Pic. 62).
- STEP 28:** Remove hex plug from SVT caliper and install the SVT rear brake hose (Item 23) onto the calipers and torque to 15 Nm (11 lb-ft) (See Pic. 63).
- STEP 29:** Connect the brake rubber hoses to the brake hard lines and torque to 15 Nm (11 lb-ft) (See Pic. 64).



Pic. 65



Pic. 66



Pic. 67

- STEP 30:** Install parking brake cables to floor lever (See Pic. 65) and route to trailing arms.
- STEP 31:** Secure the parking brake cables to trailing arms using existing pair of small, vertically aligned holes. Use the retaining screw from the original parking brake cable and torque to 9 Nm (80 lb-in) with socket (See Pic. 66).

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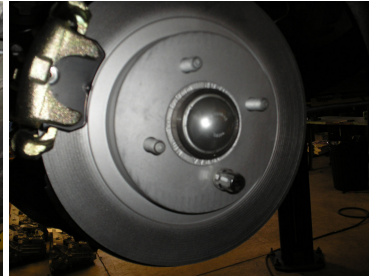
STEP 32: Connect parking brake cables to calipers (See Pic. 67).



Pic. 68



Pic. 69



Pic. 70

STEP 33: Reinstall exhaust heat shield and tighten the nuts (See Pic. 68 & Pic. 69). Reinstall fuel line to floor retainer.

STEP 34: Install grease caps (Item 24) into rear hubs (See Pic. 70).



Pic. 71



Pic. 72

STEP 35: Bleed rear brakes (See Pic. 71). Use 8mm wrench.

STEP 36: Install the wheels and torque the wheel nuts to 135 Nm (94 lb-ft) (See Pic. 72). Test drive vehicle.



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Torque Specifications:

Strut to knuckle bolt	90 Nm (66 lb-ft)
Hub retaining nut	316 Nm (233 lb-ft)
Lower ball joint stud retaining bolt	50 Nm (37 lb-ft)
Tie rod nut	47 Nm (35 lb-ft)
Front caliper to knuckle bolts	115 Nm (85 lb-ft)
Front brake hose to caliper	15 Nm (11 lb-ft)
Rear spindle retaining bolts	66 Nm (49 lb-ft)
Rear hub retaining nuts	235 Nm (173 lb-ft)
Rear upper control arm to trailing arm bolt	115 Nm (85 lb-ft)
Rear caliper anchor bolts	90 Nm (66 lb-ft)
Rear caliper to anchor bolts	28 Nm (21 lb-ft)
Rear brake hose to caliper	15 Nm (11 lb-ft)
Rear brake hose to line	15 Nm (11 lb-ft)
Rear parking brake cable screw	9 Nm (80 lb-in)
Wheel nuts	135 Nm (94 lb-ft)

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