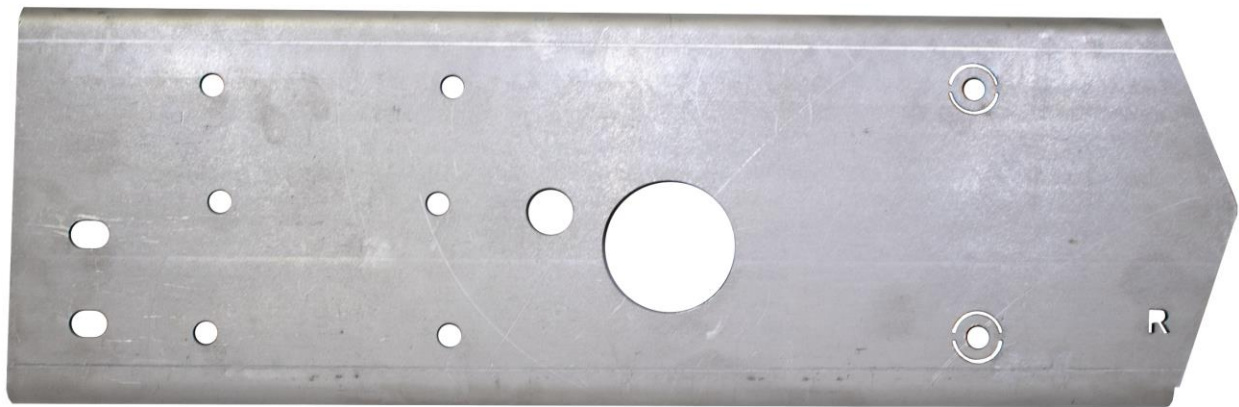




RUST BUSTER

RB7801L & RB7801R
Rear Frame Section
2001-2010 Chevy/GMC 2500HD
Crew Cab 6.5ft. Bed



REQUIRED TOOLS

Jack Stands or Lift
Mig Welder
Paint/Primer
Hand Grinder
Cutting Wheel or Torch
Welding Gloves
Welding Hood/Shield
Ear & Eye Protection
Sockets & Ratchet
Fire Extinguisher
Hammer
Punch

KIT CONTAINS

Rear Frame Section
M10 Flanged Hex Screw
M10 Flange Locknut

QTY

1
6
6



RUST BUSTER

RB7801L & RB7801R Rear Frame Section 2001-2010 Chevy/GMC 2500HD Crew Cab 6.5ft. Bed

1) **PREPARING YOUR VEHICLE**

Begin by disconnecting your battery prior to starting your installation.

Inspect your vehicle for leaking fuel lines, fuel tank and engine components. If you have fuel leaks repair all leaks prior to starting your installation. If your fuel tank is near your welding area **remove your tank prior to welding.**

Remove all combustible items above the work area such as seats, carpets, padding, etc.

Keep all flammable materials away from the vehicle work area.

2) **PREPARING YOUR WORKSTATION**

Keep a fire extinguisher close by in the case of fire and make sure you always have a designated "Fire Watch" to assist during the cutting or welding phases.

Abide by all apprenticed welding safety standards and practices.

Always use appropriate welding eye protection, ear protection, and work and fire safety gloves during the installation and within the work area.



WARNING!

If you are unsure on how to perform the installation or how to operate any of the required tools listed above, it is **HIGHLY** advised that you enlist the work of a certified welder/installer.

Failure to follow proper safety precautions and instructions may result in serious injury. **The user assumes all liability when installing the product.**



RUST BUSTER

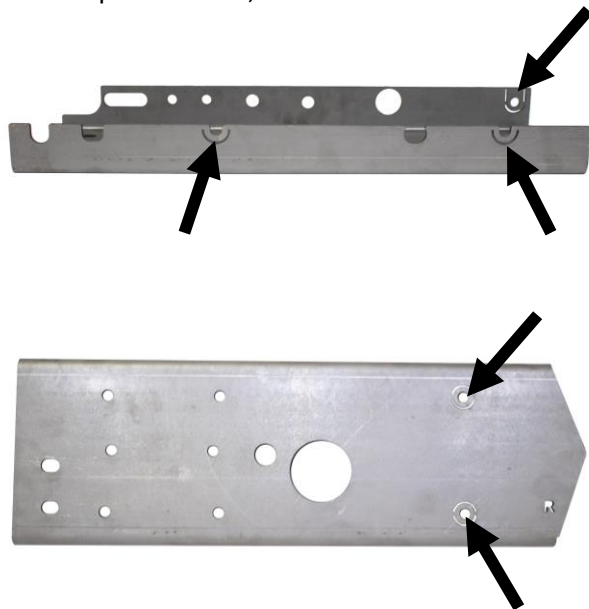
RB7801L & RB7801R Rear Frame Section 2001-2010 Chevy/GMC 2500HD Crew Cab 6.5ft. Bed

3) PREPARING FOR YOUR INSTALL

Lift up your vehicle. Remove any lines or power harnesses from the work area.

4) CUT

Our part features perforated plates on the top, bottom and front of your frame section to fit over the existing rivets retaining your crossmember. If you plan to keep your crossmembers rivets, remove the perforated plates. If not, cut out the rivets.



Remove the rivets retaining your rear leaf spring hanger and its bracket.



Punch out the rivets using a punch.





RUST BUSTER

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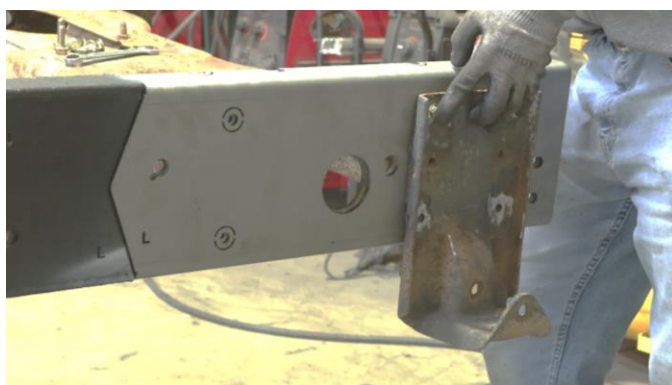
Grind the frame free of rust and debris, revealing bare metal.



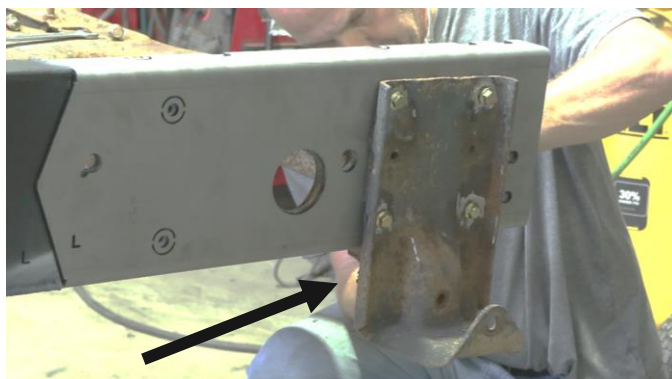
Spray the work area with a weld through primer to help prevent against rust development.



Once you have your frame section in place, take your leaf spring hanger and screw in four of the included bolts and nuts. We recommend doing this to keep your holes aligned while welding on your part. Tighten them using a 14mm socket and 15mm wrench.



Then, take your leaf spring hangers bracket and hold it up to the leaf spring hanger under your frame rail. Insert the two remaining bolts and nuts and screw them in with a 14mm socket and 15mm wrench.



5) **REINSTALL**

Slide the rear frame section onto the frame and tap it into place using a hammer. Use the frame holes to help with the alignment.





RUST BUSTER

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6) **WELD**

Following proper welding procedures, tack weld your rear frame section into place before welding the part on fully. Weld 100% around all edges.



7) **PAINT**

Paint the part with primer or other rust inhibitor to help prevent or reduce the risk of rust formation.

We recommend our Rust Buster Rust Converter & Primer Spray Paint (RB9917).

