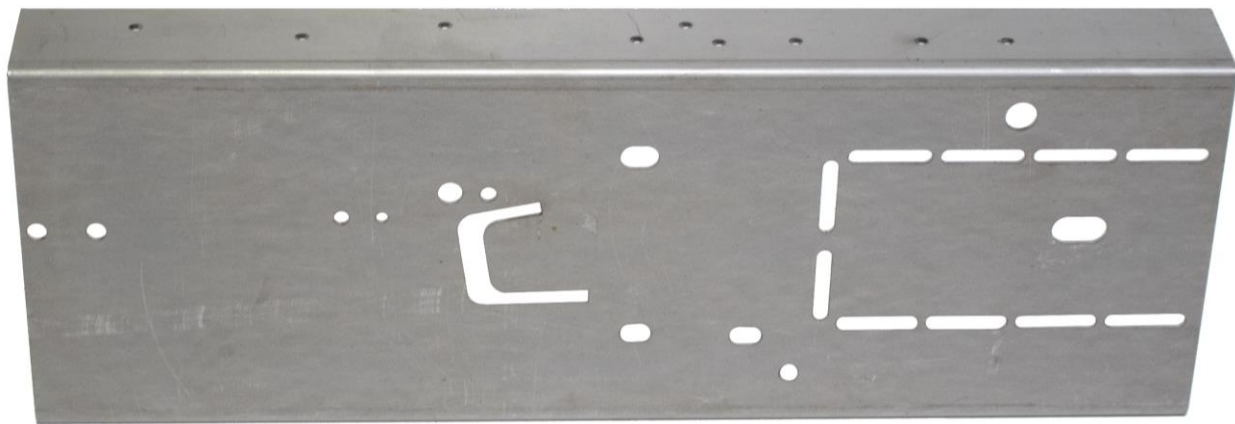




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RB7004L & RB7004R Center Frame Section 1997-2003 Ford F-150



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 & Wrench
Fire Extinguisher
C-Clamps
Hammer
Wrench

KIT CONTAINS

Center Frame Section
M10 Flanged Hex Screw
M10 Flange Locknut

QTY

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7
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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.**



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3) PREPARING FOR YOUR INSTALL

Lift or remove the cab from your frame. Remove or protect any fuel lines, brake lines, and wiring harnesses.

With an 18mm socket, remove the center bolt retaining your crossmember.

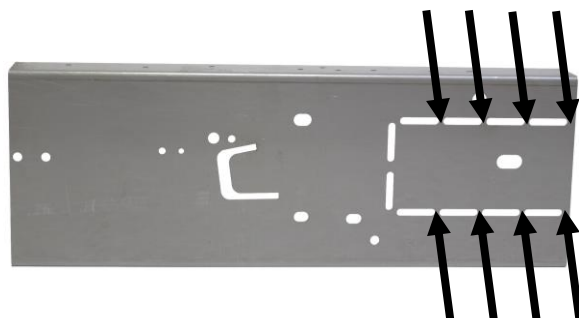


Then, remove the two bolts retaining the crossmembers bracket with a 15mm socket and 18mm wrench.



4) CUT

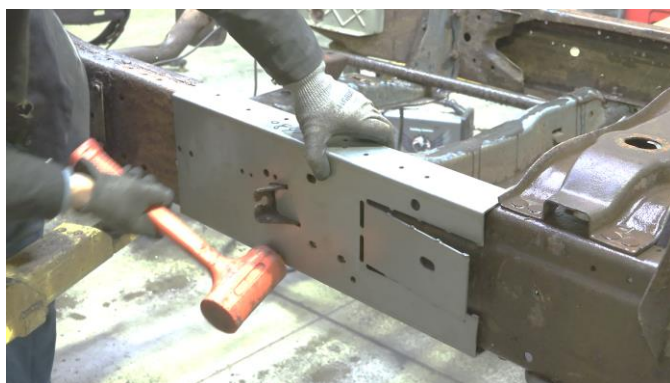
Take your center frame section and relieve the top and bottom perforations on your perforated plate. This will allow your frame section to fit over the raised bump on your frame rail.



Then, bend the plate outwards so it will sit over the bump on your frame rail.



Slide your center frame section onto the frame using the frame holes to help with the alignment. Tap it into place using a hammer.

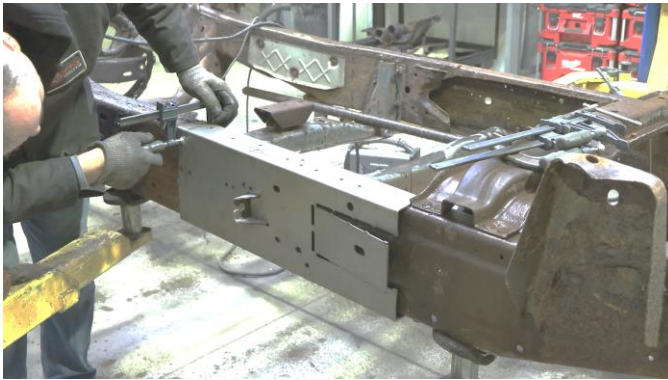




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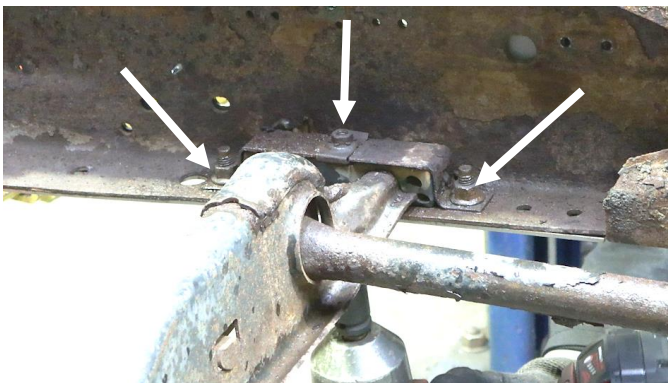
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You can clamp your part into place with a c-clamp to ensure a tight fit.



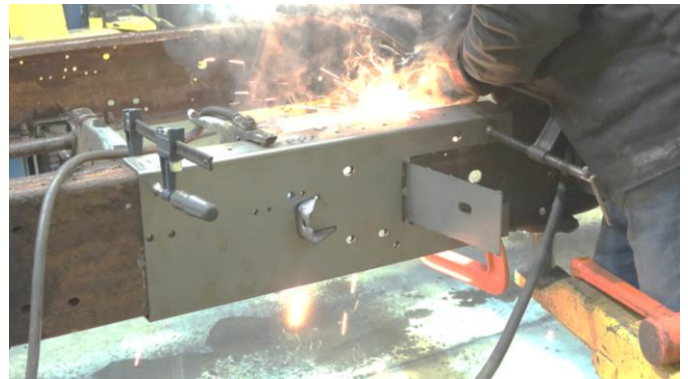
5) REINSTALL

Once you have your frame section in place, reinstall the bolts retaining your crossmember's bracket with a 15mm socket and 18mm wrench. Then reinstall the center bolt with an 18mm socket.

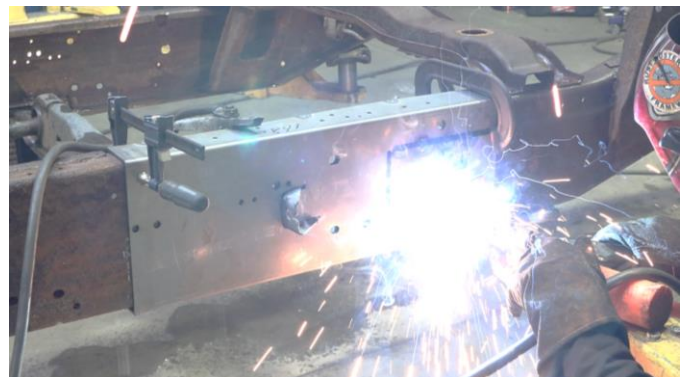


6) WELD

Following proper welding procedures, tack weld your center frame section onto the frame before welding it on fully.



Then, clamp your plate against the frame using a c-clamp, followed by welding the plate into place.





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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).

