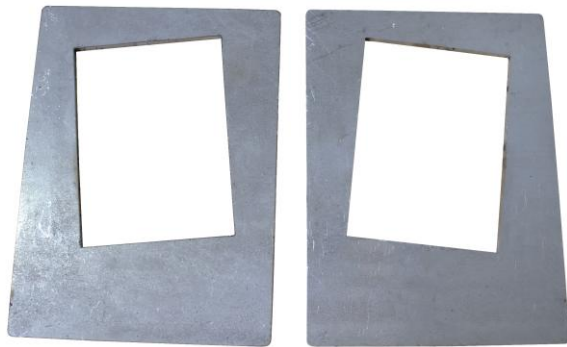


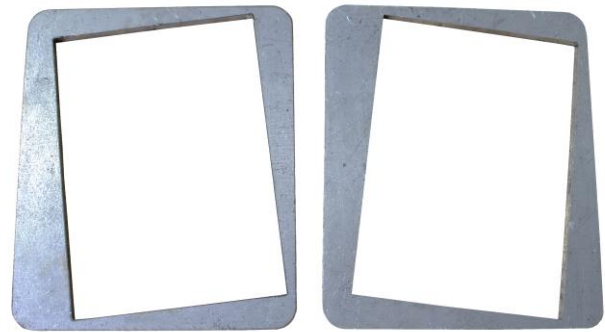


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RB7028 Rear Spare Tire Crossmember 2009-2014 Ford F-150



Inner Plates



Outer Plates



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
Wrench

KIT CONTAINS

Rear Spare Tire Crossmember
Inner Support Plates
Outer Support Plates

QTY

1
2
2



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Rear Spare Tire Crossmember 2009-2014 Ford F-150

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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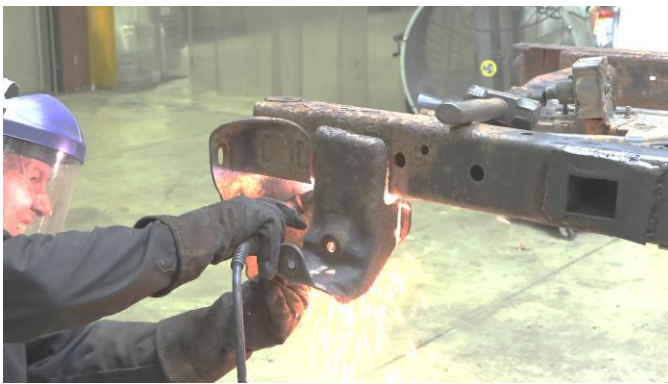
Rear Spare Tire Crossmember 2009-2014 Ford F-150

3) **PREPARING FOR YOUR INSTALL**

Remove or lift your bed out of the way. Unbolt your leaf spring.

4) **CUT**

Cut off the two leaf spring mounts on each side of your vehicle and set them aside.



Relieve the welds between your spare tire plate and the factory rear spare tire crossmember.

Cut out the factory spare tire crossmember. You may need to cut your crossmember into thirds to make it easier to remove.



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.

5) **WELD**

Take the two included inner support plates and slide them onto your replacement rear spare tire crossmember. Push them towards the center so your crossmember is able to slide into place.

NOTE: The square hole on your support plate should be angled downwards towards the front of your vehicle.





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Rear Spare Tire Crossmember 2009-2014 Ford F-150

Slide your crossmember into place, one side at a time.

Once you have your crossmember in place, you can push your inner plates to where they'll sit against the inner side of your frame rail.



Following proper welding procedures, tac weld them into place before welding them on fully.



Then, take your outer plates and slide them onto each end of your crossmember on the outside of your frame rail.



Tac your outer plates into place before welding them on fully.



After welding on your crossmember, spray the area around your outer plates with a weld through primer.





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RB7028 Rear Spare Tire Crossmember 2009-2014 Ford F-150

Then, take your leaf spring mount and hold it up to where it was originally located. Tac weld your mount onto the frame before welding it on fully. Repeat on the opposite side on your vehicle.



Finally, weld your spare tire plate onto your crossmember.

6) **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).



7) **REINSTALL**

Reinstall your leaf springs bolt.