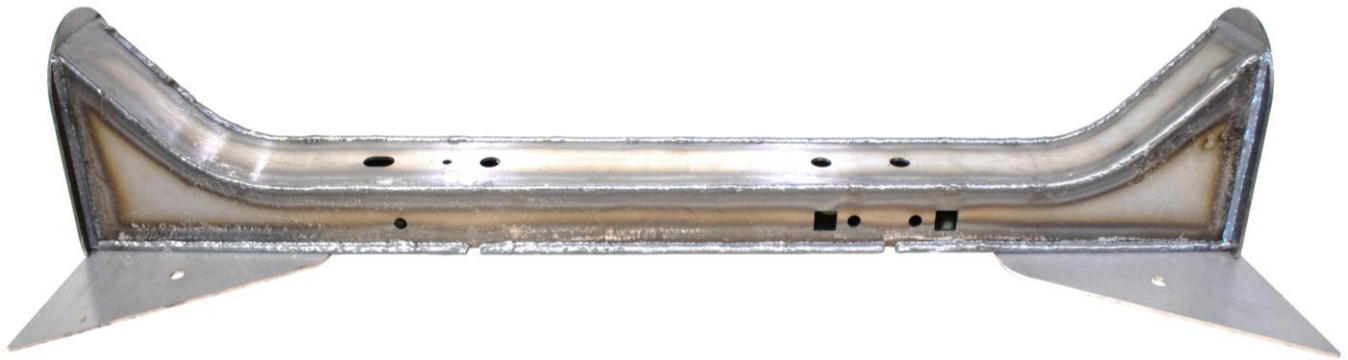




RUST BUSTER

RB7381
Mid Frame Crossmember
2007-2013 Chevy Silverado & GMC Sierra 1500
Crew Cab & Extended Cab



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
Hammer

KIT CONTAINS

Mid Frame Crossmember

QTY

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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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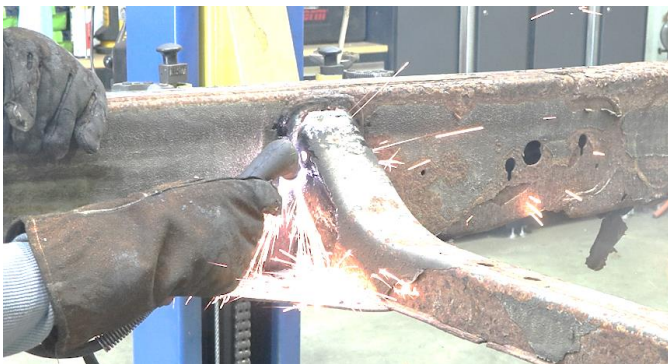
Crew Cab & Extended Cab

3) PREPARING FOR YOUR INSTALL

Lift up your vehicle.

4) CUT

Cut off the factory mid frame crossmember as well as any obstructions in the work area.



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

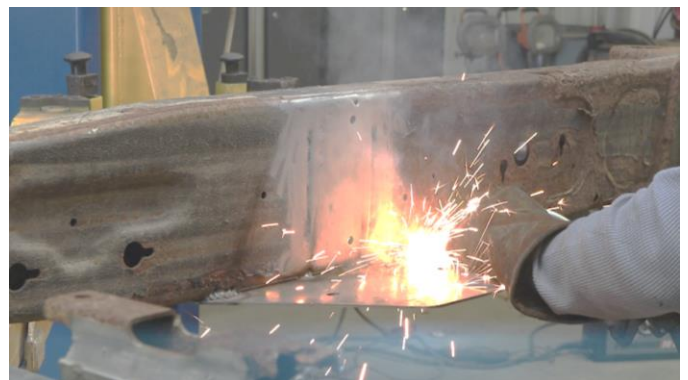


Spray the work area with a weld-through primer to help prevent against rust development.



5) WELD

Take your two support plates and hold them up to the bottom inner edge of your frame rail. Our plates feature two holes on each end to help you align your crossmember. Once you have your plates in place, tack weld them to the frame before welding them on fully.





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Then, slide your replacement crossmember into place using the factory crossmembers silhouette to help with the alignment. You can tap it into place using a hammer.

NOTE: The two square holes on your part will be facing towards the rear end of your vehicle.

Following proper welding procedures, tack weld your mid frame crossmember onto the frame before welding it on fully. Weld 100% around all edges.



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).

