



RUST BUSTER

RB7421
Front Frame Support Crossmember
2007-2013 Chevy Avalanche, 2007-2014
Chevy Suburban/Tahoe, 2007-2014 GMC Yukon & Yukon XL,
2007-2013 Cadillac Escalade EXT, 2007-2014 Cadillac Escalade



VIDEO AVAILABLE



REQUIRED TOOLS

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

KIT CONTAINS

Front Frame Support Crossmember

QTY

1



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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

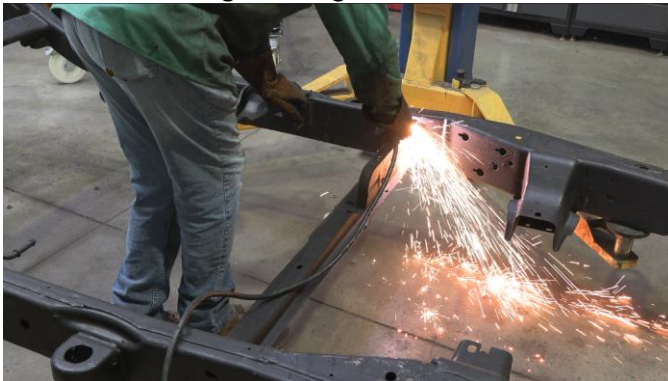
Before beginning your crossmember replacement, ensure that you have the tools, equipment, and clothing that are listed on page 1.

Once you have acquired the full list of required tools you may lift your vehicle to expose the frame, particularly the Front Frame Support Crossmember. Before beginning any work, remove all lines or power harnesses from the work area.



4) REMOVE THE ORIGINAL CROSSMEMBER

Begin cutting out the factory front frame support crossmember using a cutting wheel or torch.

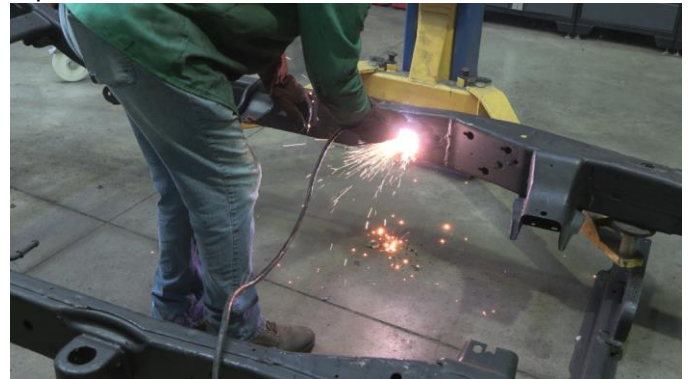


Once loose from the vehicle, move to the opposite side and repeat this step.



Once both sides have been thoroughly cut, the crossmember should come free of the frame rails with little to no difficulty.

After you have successfully removed the OEM Front Frame Support Crossmember, use your hand grinder to clean the areas of the frame where the crossmember was previously attached. Remove all rust possible, as you will need to create a smooth and clean point at which you can attach your replacement crossmember.



After you have cleaned the appropriate areas of the frame, paint the work area with a weld through primer. This will help prevent rust development, protecting against water, salt, and other road debris.



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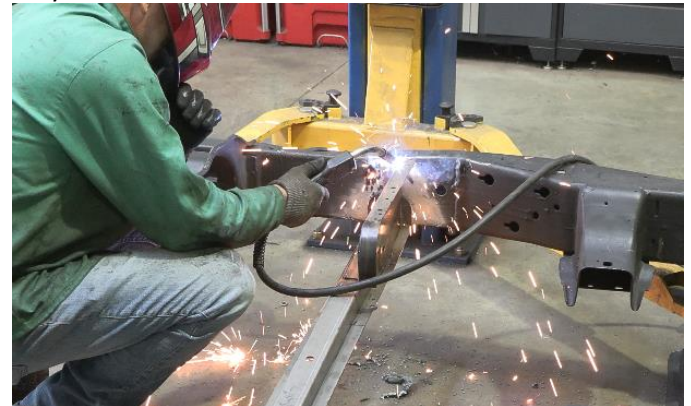
Additionally, the primer will set the base on which the crossmember can be sufficiently welded.

After you have prepped the areas on the frame for the replacement crossmember, insert the new component to see if there are any fitment complications; if so, further grinding and cleaning of the frame rails is required to ensure a proper fit before welding.



required tools and equipment, slide the front frame support crossmember into place, one side at a time.

Following standard welding procedures, tack weld one end of the crossmember to the frame. Note that it is crucial to finish tack welding the new crossmember onto the frame before welding it on fully.



After you have finished with the first side, you may move to the opposite and begin the same process. Make sure to weld 100% around all edges to ensure that the part is completely secured to the frame rails. Holes in the weld can allow for water and other debris to enter the space and corrode the adjoined components.

5) **WELD**

If you have cleaned the frame where the replacement crossmember will sit and there are no fitment issues, you may then begin the welding process. Please note that it is crucial that you have the proper experience and equipment to complete this portion of the job. Once prepared with the



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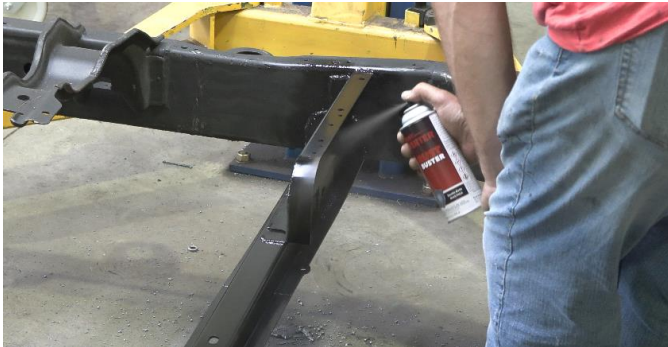
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6) PAINT AND PROTECT

The Final step in the installation process is to paint the part with primer or other rust inhibitor to help prevent or reduce the risk of rust formation.



Although our parts do ship with an oil coat to prevent oxidation, we recommend applying our Rust Buster Rust Converter & Primer Spray Paint (RB9917) for additional protection.

