



# RUST BUSTER

**RB7841**

**Center Frame Crossmember  
2011-2018 Chevy Silverado 2500HD  
2011-2018 GMC Sierra 2500HD**



**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  
Sockets & Ratchet  
Fire Extinguisher

## **KIT CONTAINS**

Center Frame Crossmember  
Reinforcement Plate

## **QTY**

1  
4



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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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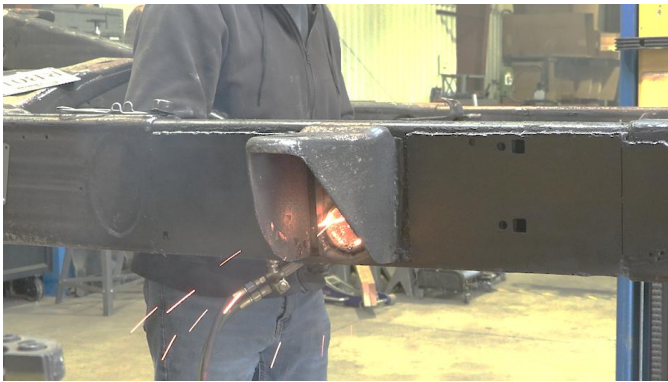
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**3) PREPARING FOR YOUR INSTALL**

Lift up or remove your cab.

**4) CUT**

Cut out the factory center frame crossmember and any obstructions in the work area. You can cut your crossmember in half 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**

Slide your crossmember through one side of your frame rail. Then, take two of your reinforcement plates and slide them onto your replacement fuel tank crossmember.



Slide the crossmember through to the opposite side of the frame rail. Then, position the two inner plates against the inside surfaces of the frame rails.



Take the two remaining plates and slide them onto the outer side of your crossmember. Push them against the outer side of your frame rail.





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Following proper welding procedures, tac weld your plates and crossmember into place, followed by welding them on fully. Weld 100% around all edges.



**6) PAINT AND PROTECT**

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 cab.