



**RUST  
BUSTER**  
F R A M E W O R K S

**RB8419L & RB8419R**  
**2003-2009 Toyota® 4Runner**  
**Rear Frame Section**



**REQUIRED TOOLS**

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

**KIT CONTAINS**

Rear Frame Section  
M12 Flanged Hex Screw

**QTY**

1  
2



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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.**



# RUST BUSTER

FRAMEWORKS

## RB8419L & RB8419R 2003-2009 Toyota® 4Runner Rear Frame Section

### 3) PREPARING FOR YOUR INSTALL

Start by making room for your body mount. If you're keeping your existing body mount, remove the shown perforated plate.

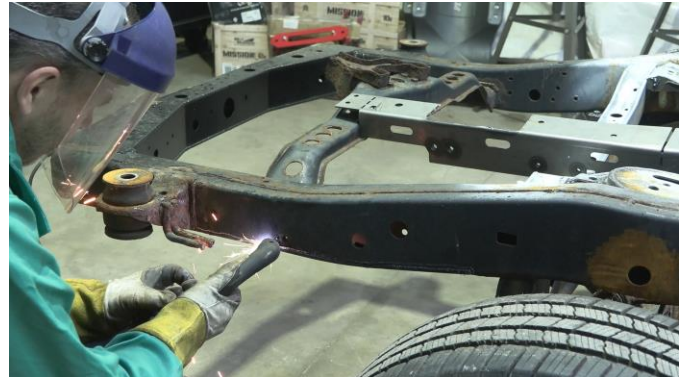


Hold the part up to the frame and mark off its coverage. Bend the opening on your rear frame section to create the contour of your frame. Then, mark your cutline  $\frac{3}{4}$  inch above the bottom of the frame.



### 4) CUT

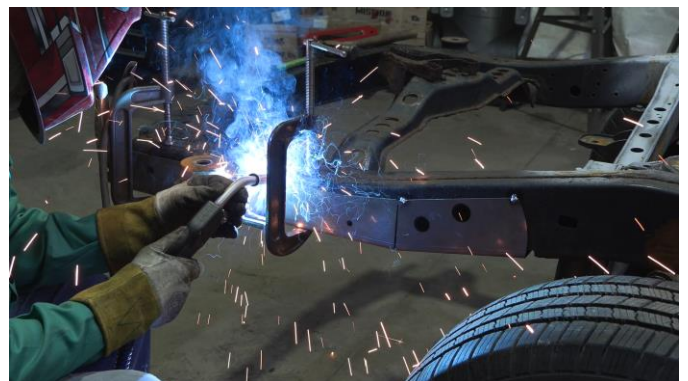
Begin cutting on the marked line and remove the bottom of the frame.



Then, grind down the zones free of rust and debris, revealing bare metal.

### 5) WELD

Remove any potential fire hazards from the work area. Tack weld the part to the frame using c-clamps as needed. Following proper welding procedures, begin welding the part. 100% weld around all edges.





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**6) PAINT AND PROTECT**

Coat the part and work area with a primer or other rust inhibitor to help prevent or reduce the risk of rust formation.



You can reinstall your hitch or any tow hooks that were mounted in the hole previously.