



RUST BUSTER

RB7013L & RB7013R
Over-Axle Frame Section
2009-2014 Ford F-150

**Single Cab – 8ft. Bed, Super Cab – 6.5ft. Bed,
& Super Crew Cab – 5.5ft. Bed**



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
C-Clamps

KIT CONTAINS

Over-Axle Frame Section

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

Lift or remove the cab from your frame. Remove or protect any fuel lines, brake lines, and wiring harnesses.

4) CUT

Cut out the perforated plate on your over-axle frame section. This will allow your part to slide over your existing rear fuel tank crossmember.



5) WELD

Slide your over-axle frame section onto the innermost side of your frame rail using the frame holes to help with the alignment.

C-clamp your part into place to ensure a tight fit.



Following proper welding procedures, tack weld your over-axle frame section 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).

