



RUST BUSTER

RB7023
Forward Spare Tire Crossmember
2009-2014 Ford F-150



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
Wrench
Hammer
Punch

KIT CONTAINS

Forward Spare Tire Crossmember
Support 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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3) PREPARING FOR YOUR INSTALL

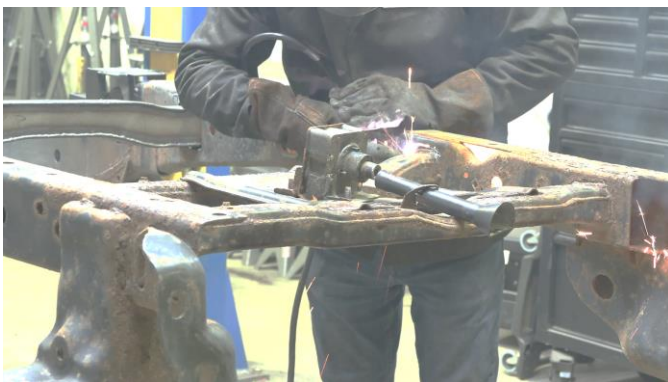
Remove or lift your bed out of the way.

4) CUT

Relieve the welds between your spare tire plate and the factory spare tire crossmember.



Cut out the factory spare tire crossmember. You may need to cut your crossmember into thirds to make it easier to remove.



After removing your crossmember, you will need to remove a small amount of material around the perimeter of the hole you created when cutting out the factory crossmember. This will allow your replacement crossmember to slide into place. Do this on both sides of your frame rail.





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After expanding the holes on your frame rail, take the two included support plates and slide them onto your replacement forward spare tire crossmember. Push them towards the center so your crossmember is able to slide into place.

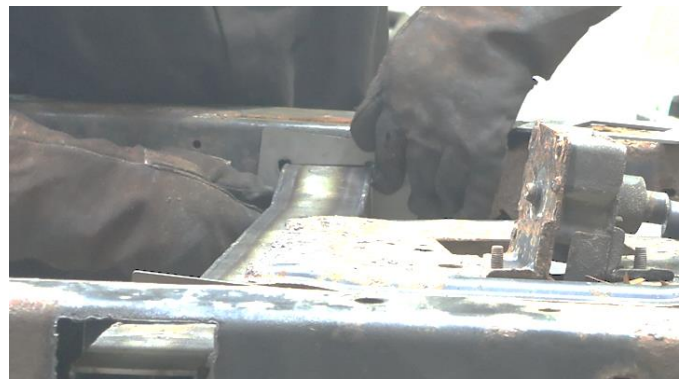
NOTE: The square hole on your support plate should be on the bottom and angled downwards towards the front of your vehicle.



Then, slide your crossmember into place, one side at a time.



Slide the two remaining plates onto the outer side of your frame rail. Push the inner plates to where they sit against the inner side of your frame rail.



5) **WELD**

Following proper welding procedures, tack weld the inner and outer support plates into place, followed by welding them on fully. Then, weld your spare tire crossmember onto the crossmember.





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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).

