



**RUST  
BUSTER**  
FRAMEWORKS

**RB7069R/RB7069L**  
**Ford® F-150 2004-2008**  
**Center Frame Section**



**REQUIRED TOOLS**

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

**KIT CONTAINS**

Center Frame Section  
E-Brake Line Support Bracket (For RB7069L Only)

**QTY**

1  
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 and water 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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### Center Frame Section

#### 3) PREPARING FOR YOUR INSTALL

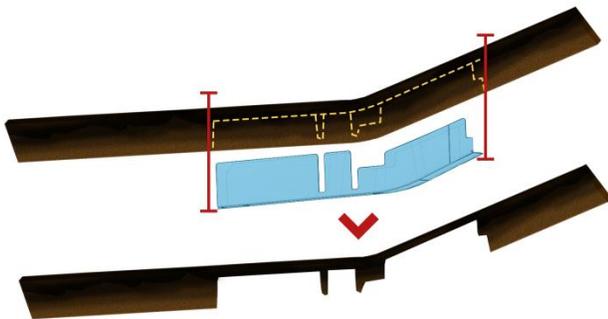
Lift your vehicle.

Drop and remove the gas tank and all cords and tubes associated with it, and plug/cover the remaining tubes to prevent fume leakage. Place it safely outside of your workstation as it poses a fire hazard during installation.

Remove your e-brake line from its bracket and push it aside and clear of any fire hazard.

Mark down 1.5 inches from the top of the frame rail, on the inside and outside, tracing the length of the Center Frame Section.

Depending on how you intend to cut, clean the cut zones free of rust and down to bare metal.



#### 4) CUT

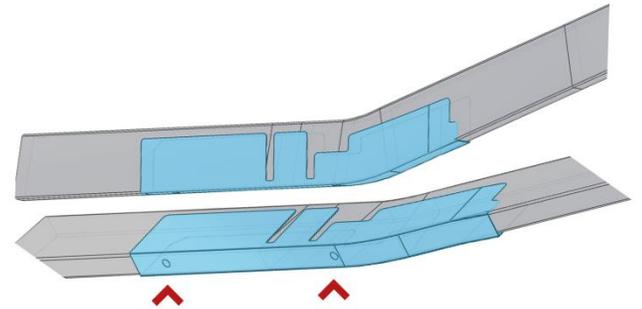
Begin cutting away the frame rail along the drawn line.

Grind all cut edges smooth for easier fitment.

#### 5) TEST FIT PART

Attempt to push the part into place and over the frame rails. Take note of any difficulties and cut away any obstructions.

The part may fit snugly and require force.



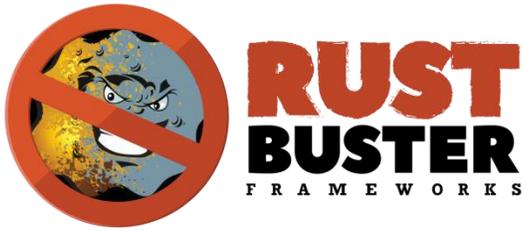
NOTE: If other frame repair components have been installed previously, additional modifications to the frame may be required.

#### 6) WELDING PREP

Once the part has been fitted, prepare your weld zones by clearing away any rust or debris, revealing bare metal.

(OPTIONAL): Coat the part with a weld-able primer or other rust inhibitor to help prevent or reduce the risk of rust formation.

Replace the part and C-clamp and tack weld it into place to prevent it from moving later.



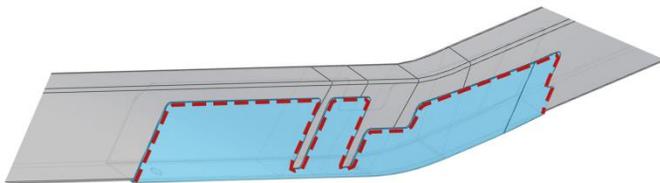
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**7) WELD**

Remove any remaining potential fire hazards on both the vehicle and surrounding area. Following proper welding procedures begin welding the part onto the frame rails.

100% weld around all edges.

If you purchased RB7069L (Driver Side Center Frame Section) choose a zone around the original e-brake bracket and weld the new onto the frame.



**8) PAINT AND PROTECT**

If you chose not to protect your part in (Step 6), coat the part and work area with a primer or other rust inhibitor to help prevent or reduce the risk of rust formation.

**9) REASSEMBLE VEHICLE**

Reinstall your gas tank, cords, and tubes.

Reconnect your battery.