



RUST BUSTER

RB7802L & RB7802R
Over-Axle Frame Section
2001-2010 Chevy/GMC 2500HD
Crew Cab 6.5ft. Bed



Driver – RB7802L



Passenger – RB7802R

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
Hammer
Punch
C-Clamp

KIT CONTAINS

Over-Axle Frame Section
M10 Flanged Hex Screw
M10 Flange Locknut

QTY

1
2
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.**



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3) PREPARING FOR YOUR INSTALL

Lift up your vehicle. Remove your brake line as well as any other lines or power harnesses in the work area.

With a socket and wrench, remove the four bolts retaining the plastic clips that secure your lines along the frame rail.



With a 15mm socket and 14mm wrench, remove the nut and bolt retaining your bump stop. You may need to cut out the bolt if it is too rusted.



After removing your bump stop, punch out the holes using a punch and set your bump stop aside.



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.

4) REINSTALL

Slide your over-axle frame section onto the frame and tap it into place using a hammer. Use the frame holes to help with the alignment.





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Once you have your frame section in place, take your bump stop and screw in the included hardware. We recommend doing this to keep your holes aligned while welding on your part.



5) WELD

Following proper welding procedures, tack weld your over-axle frame section into place before welding the part on fully. Weld 100% around all edges.



6) TIGHTEN YOUR HARDWARE

Once you have your part welded on, use a 15mm socket and 14mm wrench to tighten the hardware retaining your bump stop.



7) 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).



8) REINSTALL

With a socket and wrench, reinstall the plastic clips along your frame rail as well as any lines you may have removed.