



RUST BUSTER

2001-2010 Chevy/GMC Silverado/Sierra 2500HD – Crew Cab – 6.5ft Bed

RB7811

Rear Fuel Tank Crossmember



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
Fire Extinguisher
C-Clamp

KIT CONTAINS

Rear Fuel Tank Crossmember
M14x2mm Hex Screw
M14 Flat Washer
M14 Flange Hex Nut
M10 Hex Screw
Backing Plate

QTY

1
1
1
1
1
3



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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

Move any lines and wire harnesses from the work area, and uninstall your forward shock from the factory crossmember.



You may find it easier to remove the section by cutting the part in half.

4) CUT

Begin by removing the factory crossmember by cutting it free from the outside and inside of the frame rail on both sides.





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Grind the work area free of rust and debris, revealing bare metal, followed by coating the work area with a weld through primer to help prevent against further rust development.



Tac weld the pre-welded side into place and verify its alignment. Align the opposite side's plate with the top of the frame rail and tac weld it into place.



5) WELD

Slide a backing plate onto the new crossmember so that it mirrors the side with a plate pre-welded.



Insert the new tube through the inside of the frame as shown and use the frame rail as a reference to help with the support plate's alignment.



With the remaining two backing plates, push them onto the crossmember ends on the outside of the frame rails, and tac weld them into place.





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Remove any potential fire hazards from the work area. Following proper welding procedures, weld 100% around all edges. Completely weld the plates around the outside in inner edges.



Reinstall your forward shock.

Reinstall lines and wire harnesses.

Coat the part and work area with a 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).