



# RUST BUSTER

## RB7127L Over-Axle Frame Section 2005-2015 Toyota Tacoma Crew Cab & Extended Cab



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  
Hammer  
C-Clamps

### KIT CONTAINS

Over-Axle Frame Section  
Bed Mount (Crew Cab Only)  
Gas Tank Strap Mount  
M10 Flanged Hex Screw  
M10 Flange Locknut

### QTY

1  
1  
1  
4  
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

Lift up your vehicle. Remove any lines or power harnesses in your work area. Remove your gas tank and gas tank straps.

### 4) CUT

Our part features a perforated plate to fit over your existing rear shock mount. If you plan on keeping your shock mount, remove the perforated plate. If not, remove your shock mount.



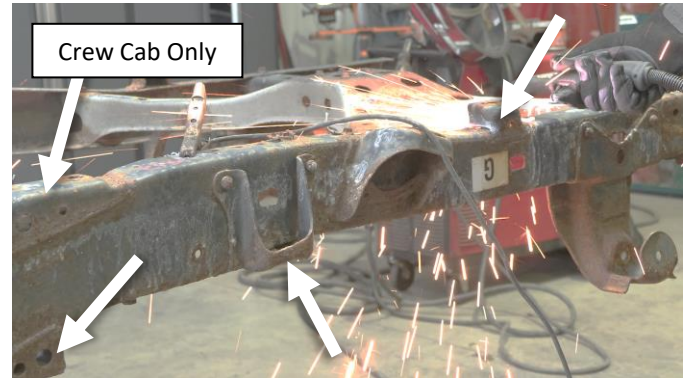
We also feature three perforated plates that can be removed to fit over your existing bed mounts and gas tank strap mount.



Our part also features perforated plates on the top and bottom of your frame section to fit over your existing rivets. If you plan on keeping your rivets, remove the plates at this time.



Begin by removing your gas tank strap mount, bed mounts, bump stop, and its rivets.



Grind the frame free of rust and debris, revealing bare metal.



Spray the work area with a weldable primer to help prevent against rust development.





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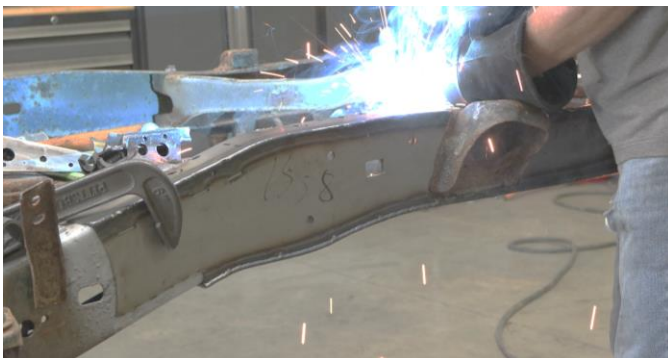
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### 5) WELD

Slide your leaf spring frame section onto the frame using the frame holes to help with the alignment. Tap it into place using a hammer. You can c-clamp your part to the frame to ensure a tight fit.



Following proper welding procedures, tac weld the leaf spring frame section onto the frame before welding the part on fully. Weld 100% around all edges.



**CREW CAB ONLY:** After welding on your frame section, take your included forward bed mount and hold it up to your frame section. Tac weld it into place before welding it on fully.



Weld on your gas tank strap mount.





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### 6) REINSTALL

Due to the materials thickness, the part is moved down to where the holes won't align. To line up the holes, you'll need to open the holes where the rivets were located.

With the included hardware, reinstall your bump stop with a 14mm socket and 15mm wrench.



If you removed your rear shock mount, we show you how to reinstall it with our installation video on our YouTube channel for RB7135.

### 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

Reinstall your gas tank and gas tank straps.