



RUST BUSTER

RB7011 Spare Tire Crossmember 1997-2003 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
Bar Clamp
Wrench
Hammer
Punch

KIT CONTAINS

Spare Tire Crossmember – Right
Spare Tire Crossmember – Left
Support Plate
M10 Flanged Hex Screw
M10 Flange Locknut

QTY

1
1
1
20
20



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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

Cut and punch out the rivets retaining your factory spare tire crossmember. You may need to cut the crossmember in half to make it easier to remove.



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.

5) INSTALL

Slide the two crossmember halves in between your frame rail. Tap them into place using a hammer. The three holes on your crossmember should be facing towards the front of your vehicle.

Then, take the included hardware and screw them into place where your rivets were originally located. You can use a punch to help with the alignment.



Next, take your support plate and place it on top of your crossmember. Use the holes to help with the alignment.





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After screwing in all of the hardware, use a bar clamp to bring the frame rails closer together, aligning your two crossmember halves.

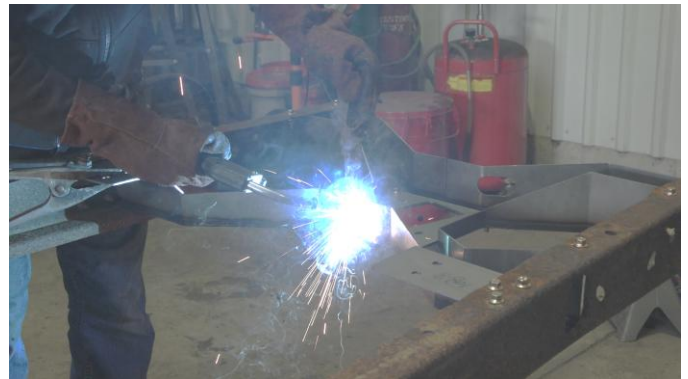


Then, with a 14mm socket and 15mm wrench, tighten your hardware.



6) **WELD**

Following proper welding procedures, tac weld your two crossmember halves together before welding them on fully. Make sure to weld around the support plate to secure part.



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 bed.