



RUST BUSTER

RB7024 Rear Fuel Tank Crossmember 2009-2014 Ford F-150



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
Tape Measure
Hammer

KIT CONTAINS

Rear Fuel Tank Crossmember
Support Plates
Rear Shock Mount
M10 Flange Locknut
M10 Hex Head Screw

QTY

1
4
2
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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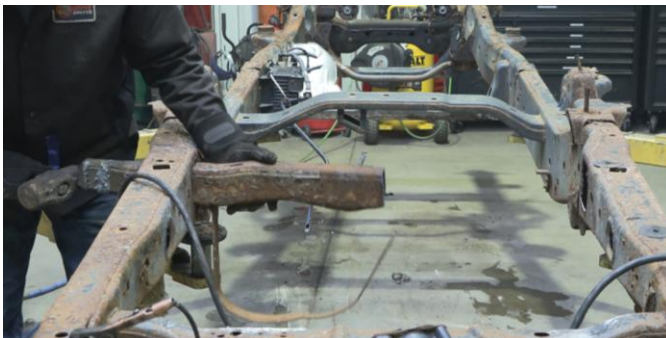
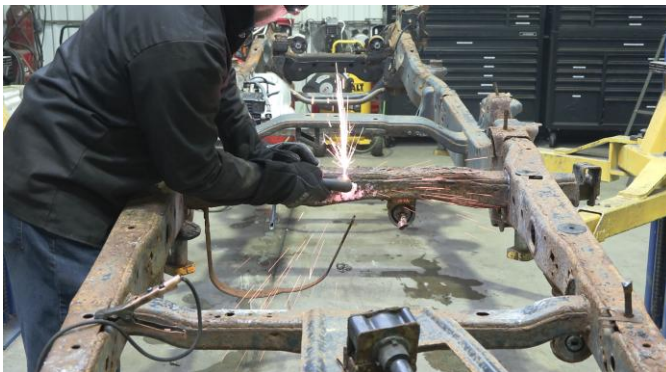
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3) PREPARING FOR YOUR INSTALL

Remove or lift your bed out of the way. Unbolt your shock with a 15mm socket, followed by removing your fuel tank strap and fuel tank.

4) CUT

Cut out the factory rear fuel tank crossmember and any obstructions in the work area. You may need to cut your crossmember in half to make it easier to remove.

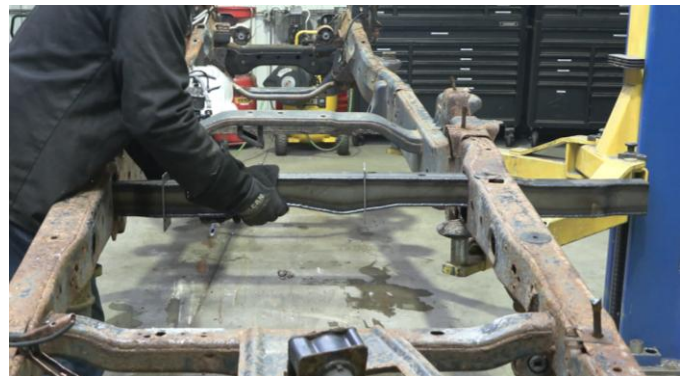


Grind the frame free of rust and debris, revealing bare metal.

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

5) WELD

Take two of the support plates and slide them onto your replacement rear fuel tank crossmember. Push them towards the center so your crossmember is able to slide into place.



Once the crossmember is in place, use a tape measure to ensure both sides are of equal length. We measured approximately 5 7/8 inches from the end of the crossmember to the outer side of the frame rail.





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Next, slide the outer plates onto the crossmember. Position the inner plates against the inner side of the frame rail, and the outer plates against the outer side.

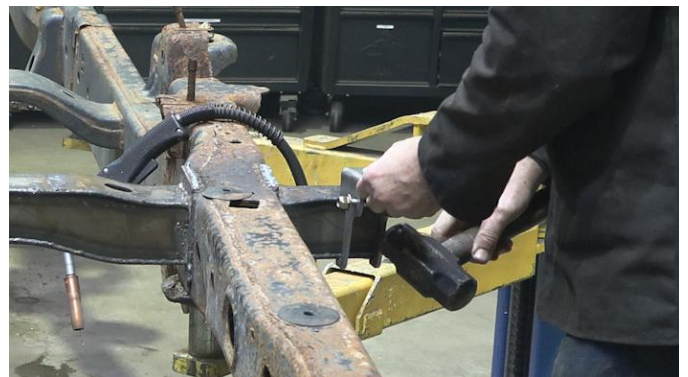


Following proper welding procedures, tac weld your crossmember and its plates to the frame before welding it on fully. Weld 100% of all edges.



After welding on your crossmember, take the two included rear shock mounts and slide them onto each end of your crossmember.

NOTE: Your shock mount should be facing towards the rear of your vehicle.



Once you have them in place, tac weld them onto the crossmember before welding them on fully.





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6) **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).



7) **REINSTALL**

Reinstall your shock with a 15mm socket, as well as your fuel tank and fuel tank strap.