



RB5046
Jeep® JK Wrangler
Rear Crossmember



REQUIRED TOOLS

Jack Stands or Lift
Mig Welder
Paint/Primer
Locking Pliers
Hand Grinder
Cutting Wheel or Torch
Welding Gloves
Welding Hood/Shield
Ear & Eye Protection
Sockets & Ratchet
Fire Extinguisher
Large C-Clamps
Dead Blow Hammer
Body Clip Removal Tool

KIT CONTAINS

Rear Crossmember

QTY

1



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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 and water 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.

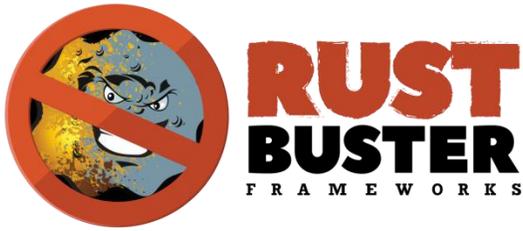
Always use appropriate welding eye protection, ear protection, and work and fire safety gloves during the installation and within the work area.



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 your vehicle and support your rear axle with jack stands.



Remove the rear bumper, rear wheels, any inner fender liners, and any factory or aftermarket accessories that would pose as a fire hazard or prevent access to the work area.

Remove your muffler.

With a 10mm socket, remove the bolt for your brake line bracket and push it out of the way.



With a 5/8 socket, remove the 2 bolts from each track bar bracket and push it down and out of the way.



Depending on how you intend to cut, clean the cut zones free of rust and down to bare metal.



NOTE: WHEN THE REAR CROSSMEMBER IS REMOVED, THE FRAME RAILS WILL SHIFT. PRIOR TO THIS, TAKE AN OUTSIDE MEASUREMENT OF THE DRIVER FRAME RAIL TO THE PASSENGER RAIL, TO ENSURE THE INSTALLATION POSITION REMAINS CONSISTENT





RUST BUSTER

FRAMEWORKS

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4) CUT

Begin cutting away the rear crossmember while taking care to not damage the frame rails or body mounts.



proper welding procedures begin welding the part onto the frame rails.



100% weld around all edges.

5) TEST FIT PART

Attempt to push the part into place. Take note of any difficulties and cut away any obstructions.

NOTE: If other frame repair components have been installed previously, additional modifications to the frame may be required.

NOTE: Before tack welding the part in place, double check the measurement and alignment of the rails.

6) WELDING PREP

Once the part has been fitted, prepare your weld zones by clearing away any rust or debris, revealing bare metal.

(OPTIONAL): Coat the part with a weld-able primer or other rust inhibitor to help prevent or reduce the risk of rust formation.

Replace the part and C-clamp and tack weld it into place to prevent it from moving later.

7) WELD

Remove any remaining potential fire hazards on both the vehicle and surrounding area. Following

8) PAINT AND PROTECT

If you chose not to protect your frame section in (Step 6), coat the part and work area with a primer or other rust inhibitor to help prevent or reduce the risk of rust formation.



9) REASSEMBLE VEHICLE

Begin reassembling your vehicle.

Reinstall your track bar brackets.

Reinstall your brake line.

Reinstall your muffler.

Reinstall your wheels and any accessories.

Reconnect your battery.