



**RUST
BUSTER**
FRAMEWORKS

**RB7319L & RB7319R
RB7349L & RB7349R
Chevy/GMC® 99-06 1500
Rear Frame Section**



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 & Water

KIT CONTAINS

Rear Frame Section
M10x1.50,30mm Flanged Hex Bolt
M10 Nyloc Hex Nut

QTY

1
4
4



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F R A M E W O R K S

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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) REMOVE YOUR VEHICLE'S BED

After you have prepared your workspace and assembled all of the required tools for your frame repair, begin by removing the bed of your truck from the frame. Click this [link](#) to view our supplemental video outlining how to complete this step of the process.



4) DISCONNECT THE SUSPENSION

Next, use a 21mm socket or wrench to remove the hardware connecting the shock to the rear frame section.



After the shock has been disconnected, begin removing your rear spring hanger with your cutting wheel or torch by cutting off and prying out its rivets.

Once you have freed the rear spring hanger from the rear frame section, the two components should separate from each other providing unrestricted access to the area needed for the frame replacement.





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5) PREPARE THE RELACEMENT AREA

After the rear spring hanger has been disconnected from the rear frame section, begin cleaning the area that the replacement component will cover using a hand grinder until it is free of rust and debris, revealing the bare metal beneath.



Coat the part and work area in a weldable primer to help prevent future rust and corrosion to the frame.

6) ALIGN THE REPLACEMENT FRAME SECTION

Place the part up to the frame and loosely secure it with C-Clamps and the included hardware with (2) 15mm sockets or wrenches. This will help align the part and reduce weld spacing. Ensure all parts and frame holes align before continuing, and check to confirm a snug fit to the frame rail.



7) WELD

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

area is clear, begin Tac welding the replacement component to the frame following proper welding procedures.



Make sure to weld completely around all edges to prevent future rust and corrosion to the frame rail.

8) REINSTALL REAR SUSPENSION COMPONENTS

After the replacement frame section has been completely welded to the frame rail, begin reinstalling the rear spring hanger to the frame of your vehicle using the included replacement hardware.



After the rear spring hanger has been reattached to the frame, begin reinstalling the rear shock to the rear spring hanger.



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After the suspension has been completely reattached to the frame rail, reinstall the bed of your truck which was removed in Step 3.

9) PAINT AND PROTECT

To ensure lasting protection for your frame rail the work area, we recommend applying our Rust Converter and Primer Spray Paint [RB9917](#) to prevent rust and corrosion.

