



# RUST BUSTER

**RB7412**

**Fuel Tank Crossmember**

**2002-2013 Chevy Avalanche 1500,  
2000-2014 Chevy Suburban/Tahoe, 2000-2014 GMC Yukon/  
Yukon XL, 2002-2013 Escalade EXT, 2003-2014 Escalade ESV**



**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

## **KIT CONTAINS**

Fuel Tank Crossmember  
M8 Hex Nut  
M8 Steel Hex Screw

## **QTY**

1  
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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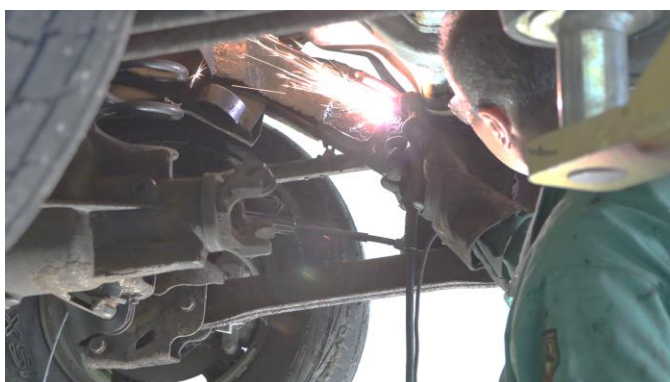
**3) PREPARING FOR YOUR INSTALL**

Lift up your vehicle. Remove any lines or power harnesses from the work area as well as your fuel tank.

Remove your EVAP can using an 13mm socket.

**4) CUT**

Cut out the factory fuel tank crossmember, as well as any obstructions in the work area.



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



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

**5) WELD**

Our part features two side plates to fit between the frame rail and the crossmember. Holding the plates up to the frame rail, use the factory crossmember's silhouette to help with the alignment.

C-clamp the plates into place on each side of the frame rail.

Once in place, tack weld the plates onto the frame, making sure the crossmember aligns correctly with the side plates.



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Hold your fuel tank crossmember up to the frame.  
Following proper welding procedure, tack weld the  
right side of your crossmember to the frame.



Use a hammer to tap the left side into place.



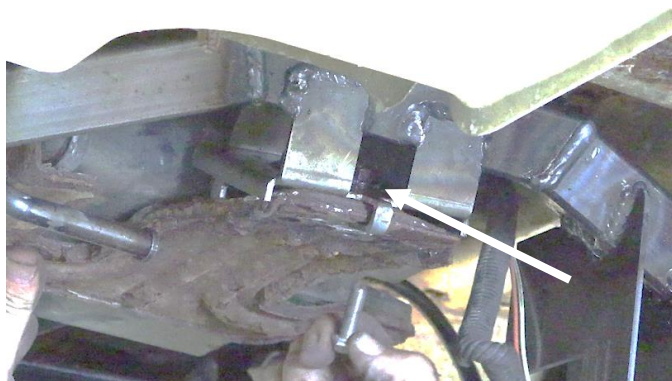
Once in place, finish tack welding the part onto the  
frame before welding the part on fully. Weld 100%  
around all edges.



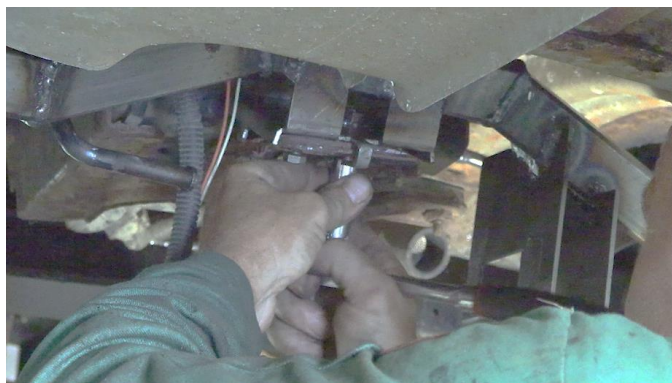
## 6) REINSTALL

Slide your EVAP can back onto your crossmember  
using the tongue in the center of your crossmember  
to hold the bracket in place.

NOTE: If the fit is too tight on your EVAP bracket, you  
will need to clean up and remove the rust before  
proceeding to ensure a good fit.



With the included hardware, reinstall your EVAP can  
with an 13mm socket.





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**7) PAINT AND PROTECT**

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 fuel tank.

