



RUST BUSTER

RB7403L & RB7403R Over Axle Frame Section

2002-2013 Chevy Avalanche 1500, 2000-2014 Chevy
Suburban, 2000-2014 GMC Yukon XL, 2003-2013
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
C-Clamps
Hammer/Punch
Wrench
Paint Marker

KIT CONTAINS

Over Axle Frame Section

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 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. Using a 21mm socket, remove the lug nuts.



CUT

Hold the part up to the frame and mark off its coverage. If you wish to remove the factory bump stop, remove it now.

Remove the lower bit of metal on your frame that retains your bump stop, leaving the main frame rail untouched.



If you are working on the left side of your vehicle, you will need to remove the bolt holding the sway bar in place using an 18mm socket.





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4) WELD

Slide the over axle frame section onto the frame using c-clamps if needed. Remove any potential fire hazards from the work area. Following proper welding procedures, tack weld the part onto the frame before welding it on fully. Weld 100% around all edges.



5) PAINT AND PROTECT

Coat the part and work area with a primer or other rust inhibitor to help prevent or reduce the risk of rust formation.



6) REINSTALL

Reinstall your bump stop.



To hold your bump stop in place, you'll need to punch down the tabs located inside the frame section. Set your punch above the spring and using a hammer, punch down the tabs.



On the left side of your vehicle, reinstall your sway bar using an 18mm socket.



Then, using a 21mm socket, reinstall your wheel.