



RUST BUSTER

RB7084

**Rear Spare Tire Crossmember
2004-2008 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 & Wrench
Fire Extinguisher
Hammer

KIT CONTAINS

Rear Spare Tire Crossmember
Frame Plate

QTY

1
4



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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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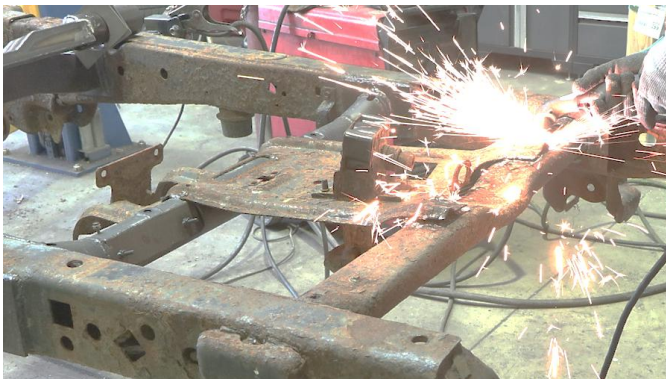
Rear Spare Tire Crossmember 2004-2008 Ford F-150

3) PREPARING FOR YOUR INSTALL

Remove or lift your bed out of the way. Unbolt your leaf spring.

4) CUT

Begin by cutting around the inside of your factory spare tire crossmember. Then, relieve the welds between your spare tire plate and the factory rear spare tire crossmember.



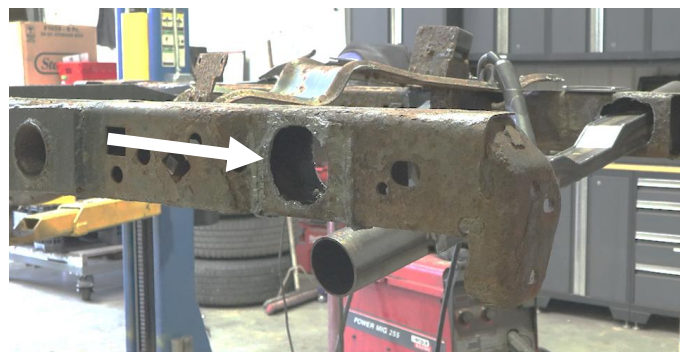
Due to the crossmember going completely through the frame rail, we will need to cut off and remove the two leaf spring mounts on both sides of your frame. You can reuse these mounts later or replace them with new ones.



After removing the two leaf spring hangers, cut around the outer portion of your crossmember on the outside of your frame rail, followed by removing the crossmember.



Next, remove any extra material from either side of your frame rail where the replacement crossmember will slide into place. You **DO NOT** need to do this on both sides of your vehicle. One side will provide enough clearance to fit the crossmember.





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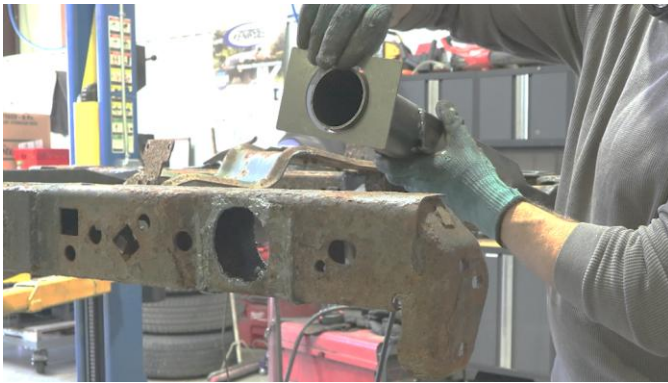
Grind the frame free of rust and debris, revealing bare metal.

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

5) **WELD**

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

NOTE: On the side that has the wider cut, you won't be able to slide on the frame plate before installing the crossmember. Instead, you'll need to cut the plate in half and weld it in place when welding the crossmember later.



Slide your crossmember into place, one side at a time.



Once you have your crossmember in place, you can push your inner plates to where they'll sit against the inner side of your frame rail.

Then, slide the remaining plates onto the outer side of your frame rail over your crossmember.



Following proper welding procedures, tack weld your crossmember and its plates into place before welding them on fully. Weld 100% around all edges.





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After welding on your crossmember, take your leaf spring mounts and hold them up to where they were originally located. Once you have them in place, tack weld them onto the frame before welding them on fully.



Finally, weld your spare tire plate onto your crossmember.



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 leaf springs bolt.