



RUST BUSTER

RB7140 Fuel Tank Crossmember 1988-1995 Toyota Hilux / Pickup Trucks



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
Tape Measure
Paint Marker

KIT CONTAINS

Fuel Tank Crossmember
Exhaust Hanger Hooks
Gas Tank Mount
Reinforcement Plates

QTY

1
2
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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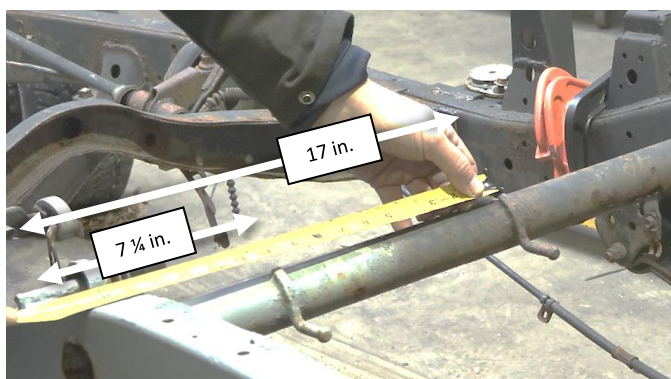
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3) PREPARING FOR YOUR INSTALL

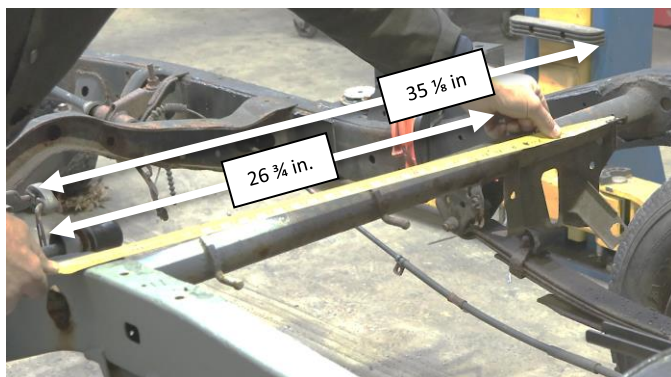
Remove or lift your bed out of the way. Remove your fuel tank.

Begin by measuring the distance from the outer edge of the frame rail to the edges of both the exhaust hangers and the gas tank mount. We measured from the driver's side of the vehicle.

For the exhaust hangers, we measured $7\frac{1}{4}$ in. and 17 in.



For the gas tank mount, we measured $26\frac{3}{4}$ in. and $35\frac{1}{8}$ in.



4) CUT

Cut out the factory fuel tank crossmember. You may need to cut your crossmember in half to make it easier to remove.



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

Spray the work area with a weld-through primer to help prevent the risk of rust formation



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5) WELD

Take two of your reinforcement plates and slide them onto your replacement fuel tank crossmember. Push them towards the center so your crossmember is able to slide into place.

Then, slide your crossmember into place, one side at a time.



Push the inner plates to where they sit against the inner side of your frame rail.

NOTE: The inner plates should line up with the holes on your frame rail.



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



Following proper welding procedures, tack weld the inner and outer reinforcement plates into place, followed by welding them on fully.





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After welding on your crossmember and its plates, we will need to weld on the gas tank mount and exhaust hanger hooks. To do this, take your tape measure and mark the measurements that we took from the factory crossmember.



Once you have made your markings, hold your gas tank mount up to the crossmember and line it up with the two markings closest to the passenger's side. Make sure your mount is facing vertically. Tac weld it into place before welding it on fully.



Then, take your two exhaust hangers and hold them up to the two remaining markings on your frame, followed by welding them on fully.

NOTE: Your hangers should be angled up slightly.





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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 fuel tank and bed.