



# RUST BUSTER

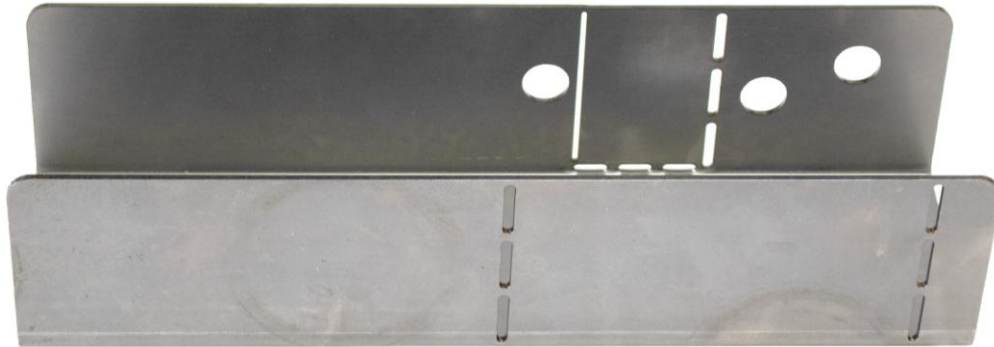
## RB7524L & RB7524R

### Rear Frame Section

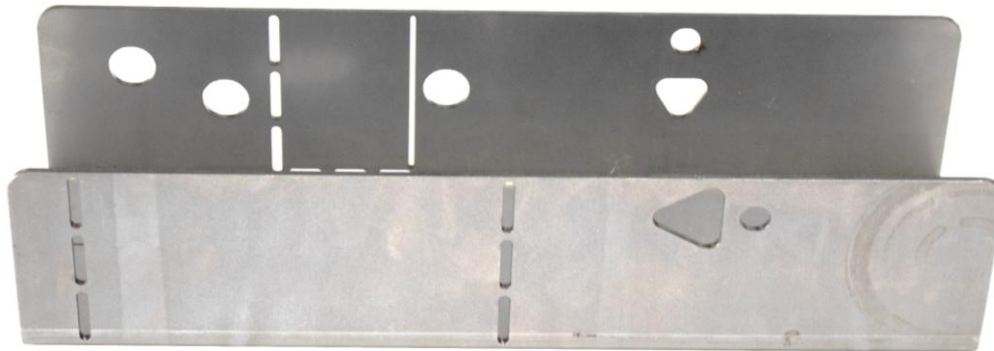
### 2002-2009 Chevy Trailblazer & GMC Envoy



VIDEO AVAILABLE



Driver – RB7524L



Passenger – RB7524R

#### 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  
Marker or Chalk  
Mallet  
C-Clamps  
Crescent Wrench or Pliers

#### KIT CONTAINS

Rear Frame Section

#### QTY

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## RB7524L & RB7524R Rear Frame Section 2002-2009 Chevy Trailblazer & GMC Envoy

### 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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## RB7524L & RB7524R Rear Frame Section

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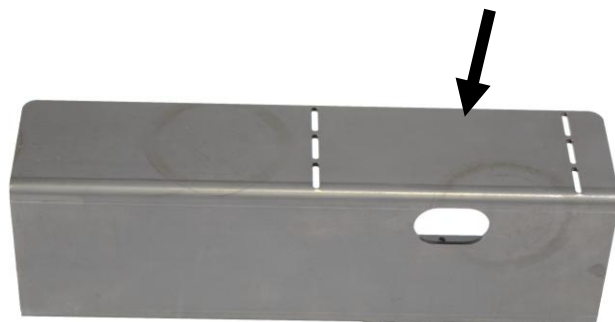
### 3) PREPARING FOR YOUR INSTALL

Lift up your vehicles body. Remove or protect any fuel lines, brake lines, and wiring harnesses.

With a 10mm socket, remove the bolt retaining your EVAP canister.



Our part features a perforated plate on the front of your frame section to fit over your existing rear body mount. If you decide to keep your mount, remove the plate at this time. If not, cut off your mount.



Our part also features a plate you can cut and bend to fit around your crossmember. To do this, cut the side of your perforation closest to the rear of your frame section as well as the bottom of the perforation. Leave the side closest to the front intact so you are able to bend it. Then, with a crescent wrench or a pair of pliers, bend the perforation back towards the front of your frame section.

### 4) CUT

Hold your frame section up to the frame and mark off its coverage. Draw a line approximately 1/2 inch above the bottom of the frame and cut along it.



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 development.





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### 5) WELD

Take your replacement rear frame section and slide it onto the frame using the frame holes to help with the alignment. Tap it into place using a mallet.



You can use c-clamps to secure your part, ensuring a tight fit.

Following proper welding procedures, tack weld your rear frame section onto the frame before welding it on fully. Weld 100% around all edges.



### 6) REINSTALL

If you removed your rear body mount, we show you how to reinstall it with the installation videos from our YouTube channel:

- Rear Body Mount – RB7539

### 7) 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).



### 8) REINSTALL

Reinstall your EVAP canister and its bolt with a 10mm socket, followed by reinstalling your vehicle's body.