



RUST BUSTER

RB7741
Spare Tire Crossmember
2009-2018 Ram 1500



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

KIT CONTAINS

Spare Tire Crossmember
Support Bracket

QTY

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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

Remove your vehicle's spare tire and bed, along with moving any lines or power harnesses from the work area.



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

Place the main crossmember onto the frame while using factory remains and Support Bracket as reference points for proper alignment. Keep pushing the crossmember towards the rear of the vehicle with the Support Bracket until the ends of it rests on the factory weld point on the track bar crossmember and on the wall of the main crossmember.



4) CUT

Begin removing the crossmember by cutting along its retaining welds on each frame rail and track bar crossmember.



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



5) WELD

Tac weld the Support Bracket to the track bar crossmember and main crossmember, followed by the main crossmember to the frame rails. Confirm its alignment at this time.

Remove any potential fire hazards from the work area. Following proper welding procedures, weld 100% around all edges of the crossmember.





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6) **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. **We recommend our Rust Buster Rust Converter and Primer Spray Paint (RB9917).**



Finally, reinstall your spare tire and bed.