



**RUST
BUSTER**
FRAME REPAIR

RB4020R

**Jeep® TJ Wrangler
Rear Frame Section – Passenger Side**



VIDEO AVAILABLE



REQUIRED TOOLS

Jack Stands or Lift
Mig Welder
Paint/Primer
Locking Pliers
Hand Grinder
Cutting Wheel or Torch
Welding Gloves
Welding Hood/Shield
Ear & Eye Protection
Sockets & Ratchet
Fire Extinguisher & Water

KIT CONTAINS

Rear Frame Section – Passenger Side

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 and water 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 your vehicle.

Remove the wheel and tire and set it out of the way.

Drop and remove the gas tank and all cords and tubes associated with it, and plug/cover the remaining tubes to prevent fume leakage. Place it safely outside of your workstation as it poses as a fire hazard during installation.

Remove rear bumper.



Remove two rear body mount bolts using 16mm.

Remove the body mount bushing.



Remove the rear cross member. (If you are not replacing it with the rear frame sections you will need to carefully cut it away from the frame rails.)

Measure in front the rear of the coil spring mount 1.5" and mark a line.



Measure 1.5" from the top of the vehicle's frame and draw a line. You will do this on the inside and outside of the frame rail.

4) CUT

Begin cutting away the metal along the drawn line.





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5) TEST FIT PART

Attempt to push the part into place and over the remaining frame. Take note of any obstructions and cut them away.



The part may fit snugly and require force.

NOTE: If other frame repair components have been installed previously, additional modifications to the frame may be required.

Once the part has been fitted, prepare your weld zones by clearing away any rust or debris, revealing bare metal.



Tack weld and/or clamp the part into place.



6) WELD

Remove any remaining potential fire hazards on both the vehicle and surrounding area.



100% weld around all edges including the rear cross member.





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7) PAINT AND PROTECT

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

8) REASSEMBLE VEHICLE

Reinstall your gas tank, cords, and tubes.

Reinstall your body mount bushing and bolt.

Reinstall your rear bumper.

Reinstall your wheel and tire.

Reconnect your battery.