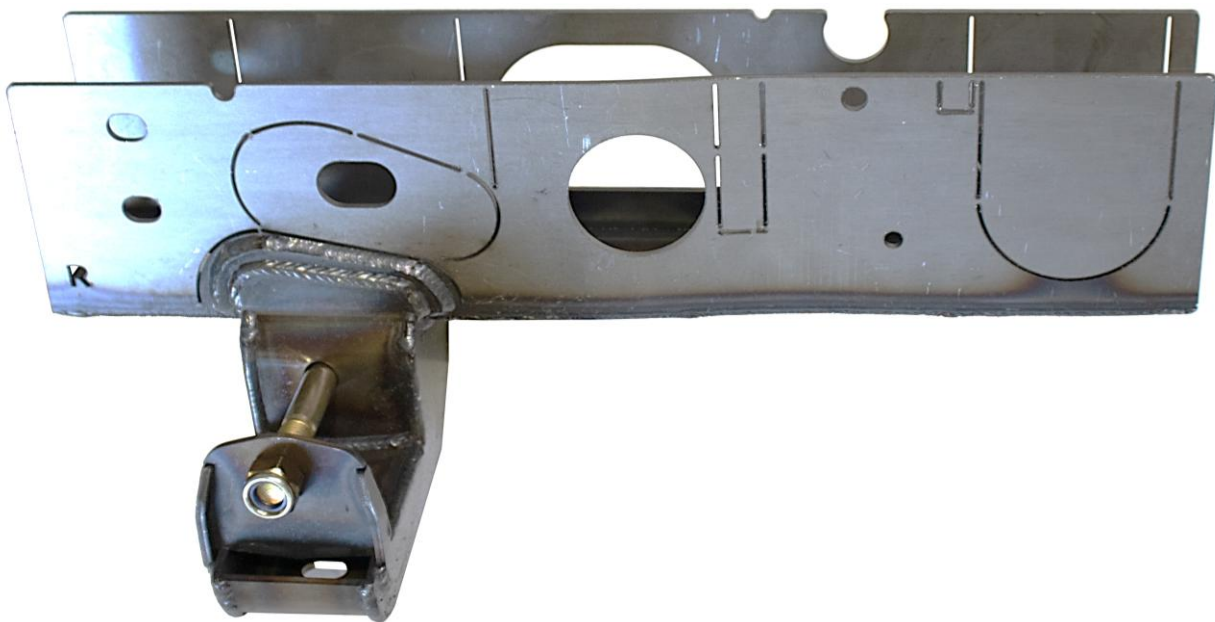




# RUST BUSTER

**RB7821L & RB7821R**  
**Rear Frame Section**  
**2011-2019 Chevy/GMC**  
**Silverado & Sierra 2500HD & 3500HD SRW**



## 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 or Chalk  
C-Clamps  
Mallet

## KIT CONTAINS

Rear Frame Section  
M18 Locknut  
M18 Flanged Hex Head Screw

## QTY

1  
1  
1



# RUST BUSTER

## RB7821L & RB7821R Rear Frame Section 2011-2019 Chevy/GMC

### Silverado & Sierra 2500HD & 3500HD SRW

#### 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.**



# RUST BUSTER

## RB7821L & RB7821R Rear Frame Section 2011-2019 Chevy/GMC

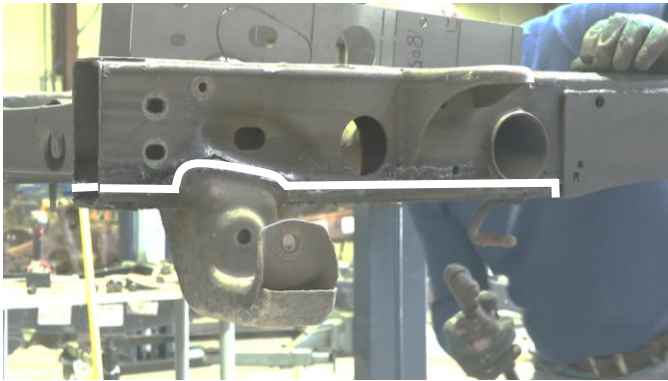
### Silverado & Sierra 2500HD & 3500HD SRW

#### 3) PREPARING FOR YOUR INSTALL

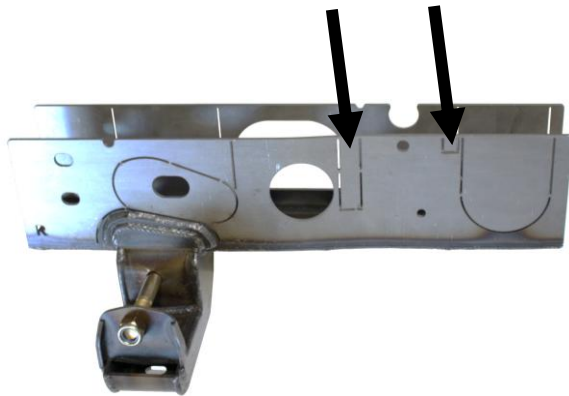
Lift up or remove your bed. Unbolt your leaf spring with a 27mm socket and wrench and push it out of the way.

#### 4) CUT

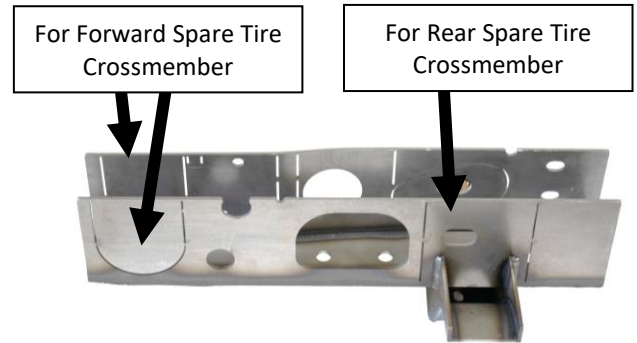
Hold your replacement rear frame section up to the frame and mark off its coverage. Then, draw a line approximately 1/2 inch above the bottom of the frame and around the leaf spring hanger. Then, cut around and remove the bottom of the frame along with the leaf spring hanger.



Our part features a perforated plate that you can remove to fit over your existing rear bed mount. If you decide to keep your mount, remove the plate at this time. If not, cut off your mount.



Our part also features plates you will need to remove to fit over your forward and rear spare tire crossmembers. (If you plan to replace your rear spare tire crossmember, you may leave the plate intact).



After removing your plates, we will need to remove some extra material from the inside of your frame rail. This is because our part is designed to slide up inside the crossmember.

With a tape measure, make a mark at approximately 4 1/4 inches and 8 1/4 inches from the rear end of your frame rail.

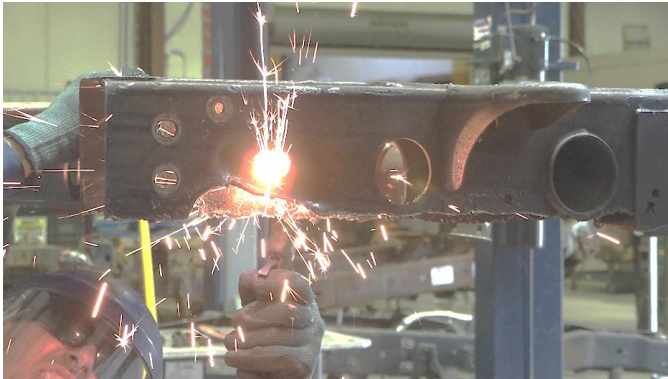




# RUST BUSTER

## RB7821L & RB7821R Rear Frame Section 2011-2019 Chevy/GMC Silverado & Sierra 2500HD & 3500HD SRW

Then, cut and remove the extra material.



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

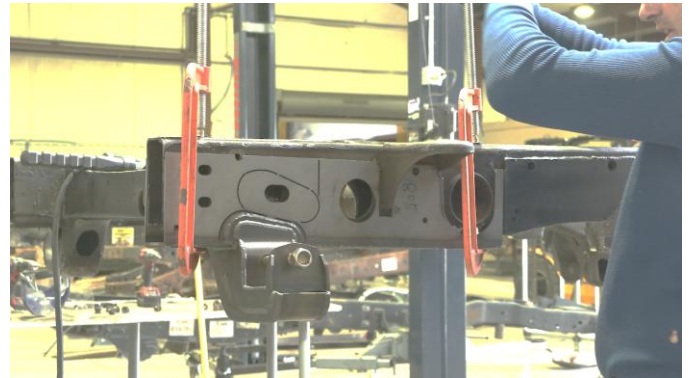
Spray the work area with a weld-through primer to help prevent the risk of rust development.

### 5) **WELD**

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



You can clamp your part into place with c-clamps to ensure a tight fit.



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



### 6) **REINSTALL**

If you decided to remove your rear bed mount, we show you how to reinstall it with the installation video on our YouTube channel.

- RB7827L/R – Rear Bed Mount



# RUST BUSTER

## RB7821L & RB7821R Rear Frame Section 2011-2019 Chevy/GMC

### Silverado & Sierra 2500HD & 3500HD SRW

#### 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 leaf spring with a 27mm socket and wrench.