



# RUST BUSTER

RB7836

Forward Spare Tire Crossmember  
2011-2018 Chevy Silverado 2500HD & 3500HD  
2011-2018 GMC Sierra 2500HD & 3500HD



VIDEO AVAILABLE



## REQUIRED TOOLS

Jack Stands or Lift  
Mig Welder  
Paint/Primer  
Hand Grinder  
Cutting Wheel or Torch  
Welding Gloves  
Welding Hood/Shield  
Ear & Eye Protection  
21mm Socket  
22mm Socket  
Ratchet  
Fire Extinguisher

## KIT CONTAINS

Forward Spare Tire Crossmember  
Steel Frame Support Flange/Collar  
Class 10 Flange Hex Nut  
Class 10.9 Hex Screw

## QTY

1  
4  
1  
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 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 up your vehicle and support it with jack stands.

#### CUT

Cut out the factory forward spare tire crossmember. You can cut the crossmember in half to make it easier to remove. If you would like to keep your spare tire plate, simply relieve the welds between it and the factory crossmember.



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

### 4) WELD

Slide one of the included metal collars over the passenger end (end without the shock mount) of the new forward spare tire crossmember. Then, install the crossmember by sliding it through the holes left by the factory crossmember beginning with the passenger side.



Slide the remaining metal collars on to the ends of the crossmember on the outside of the frame rails.

#### NOTE:

Ensure the metal flange on the new crossmember is snug to the frame on the inner-driver's side frame rail. Also, ensure the shock mount on the crossmember is positioned properly. The top of the mount should be parallel with the top of the frame rail.



Following proper welding procedures, tack weld the part in place, before welding 100% around all edges.





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**5) 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 Rust Buster Rust Converter and Primer Spray Paint (RB9917).

