



# RUST BUSTER

**RB7731L & RB7731R**  
**Over-Axle Frame Section**  
**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

Over-Axle Frame Section

### 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 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 wheel, coil spring, and track bar from the work area, and remove any lines or power harnesses that may be in the way.



Our part features perforated plates that, when removed, allow the part to install around the nearby sway bar crossmember, sway bar link, track bar bracket, and coil spring bucket. If you do not intend on replacing these parts, remove the correlating plates from the frame section. Additionally, after removing certain plates, nearby flanges may need to be temporarily bent to fit on the frame. C-Clamping the section to the frame rail will help correct this modification.



If you are not replacing these suspension parts, but want to retain as much of the over-axle section as possible, you will have to carefully remove the factory parts while limiting damage to them so that they can be reinstalled later.

### 4) CUT

Hold the part up to the frame and take note of its coverage. Measure 3/4" from the bottom of the frame and mark off your cut line. Begin cutting away the bottom of the frame rail.





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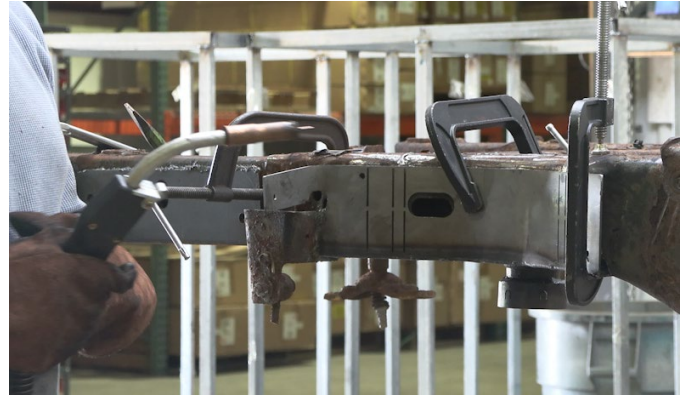
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Grind the work area free of rust and debris, revealing bare metal.

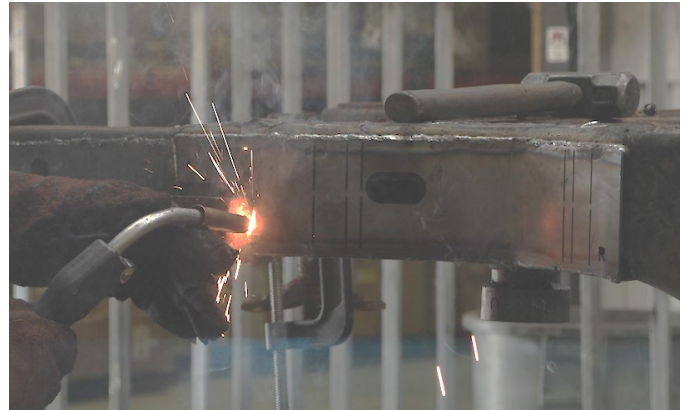
Coat the work area with a weld through primer to help prevent against further rust development.

Push the part onto the frame while using the frame holes and curves to help with alignment. Secure the part with C-Clamps.



- 5) **WELD**  
Tack weld the part, and verify the part's alignment. Remove the C-Clamps.

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





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If you removed your suspension parts or are replacing them, (re)install them at this time.



### 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 suspension and wheel.