



**RUST  
BUSTER**  
FRAME REPAIR

**RB2007**

**Jeep® YJ Wrangler  
Center Cross Member w/ Gas Tank Support**



**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  
Center Cross Member Body-  
Mount Bushings (Pair)

**KIT CONTAINS**

Center Cross Member w/  
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**QTY**

1

NOTE: New body mount  
bushings are required.



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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 rear wheels and set them out of the way.

Support your rear axle using two jack stands for the driver and passenger sides.

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 fire hazard during installation.



Using a 5/8" socket, remove the two body mount bolts just below the support.



Depending on the exhaust routing, it may need to be removed or loosened to allow freedom of access to the tank support.



Depending on how you intend to cut, clean the cut zones free of rust and down to bare metal.

**4) CUT**

Begin cutting away the Gas Tank Support as close to the frame rails as possible.



We recommend cutting the centermost support free first to allow easy access to the left and right support flanges, as well as the body mount bushings.

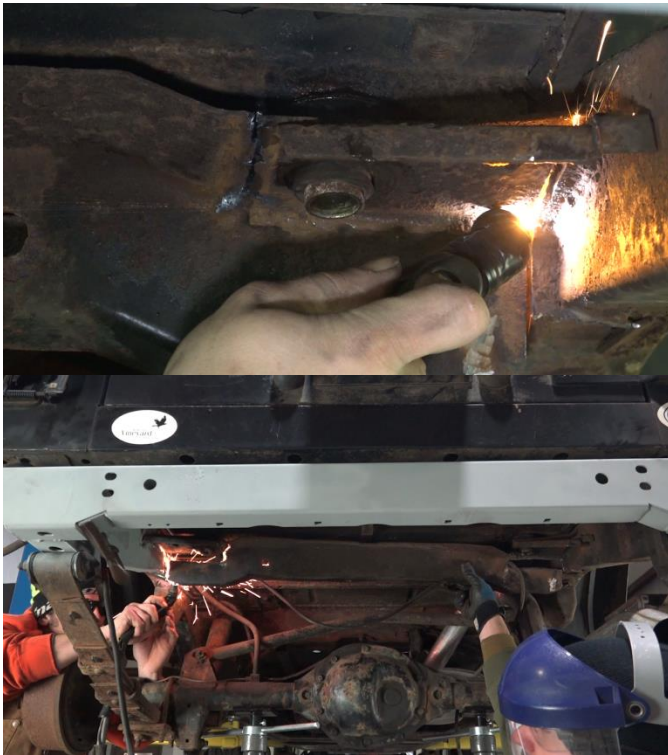




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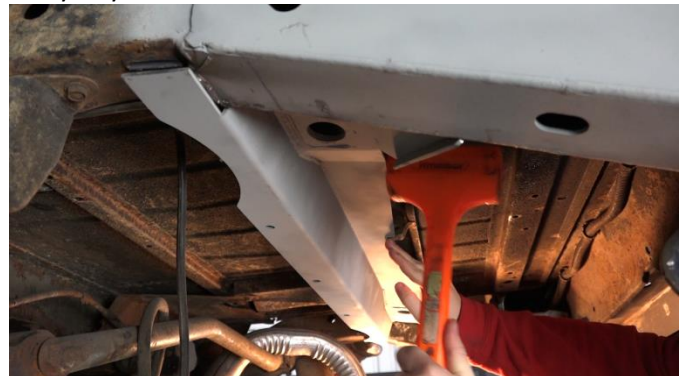


Cut away the left and right flanges and remove any remaining material until the frame rails are flush.



5) **TEST FIT PART**

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



The part may fit snugly and require force. Ensure the frame rails are flush and the body mount bushing holes are aligned with the body.

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



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frame may be required.



Install a new set of body mount bushings into the support according to the manufacturer's instructions as the area will be inaccessible afterwards.



**6) WELDING PREP**

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



Replace the part and C-clamp and tack weld it into place to prevent it from moving later.



(OPTIONAL): Coat the part with a weld-able primer or other rust inhibitor to help prevent or reduce the risk of rust formation.



**7) WELD**

Remove any remaining potential fire hazards on both the vehicle and surrounding area. Following proper welding procedures begin welding the part onto the frame rails.





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Reinstall your gas tank, cords, and tubes.

Reinstall your wheels.

Reconnect your battery.

100% weld around all edges.

**8) PAINT AND PROTECT**

If you chose not to protect your support in (Step 6), coat the part and work area with a primer or other rust inhibitor to help prevent or reduce the risk of rust formation.

**9) REASSEMBLE VEHICLE**

Begin reassembling your vehicle by starting with the body mount bolts and a 5/8" socket.