



**RUST
BUSTER**
FRAME REPAIR

RB3012L

**Jeep® TJ Wrangler
Full Center Frame w/ Rear Control Arm Mounts**



REQUIRED TOOLS

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

KIT CONTAINS

Full Center Frame w/ Rear Control Arm
Mounts

1.5" Flat Washer
M14 Flat Washer
M14 Nyloc Nut
1.5" Hex Bolt
M10 Hex Bolt
M14 Hex Bolt

QTY

1

3
2
1
3
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 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 wheel and set it 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 a fire hazard during installation.



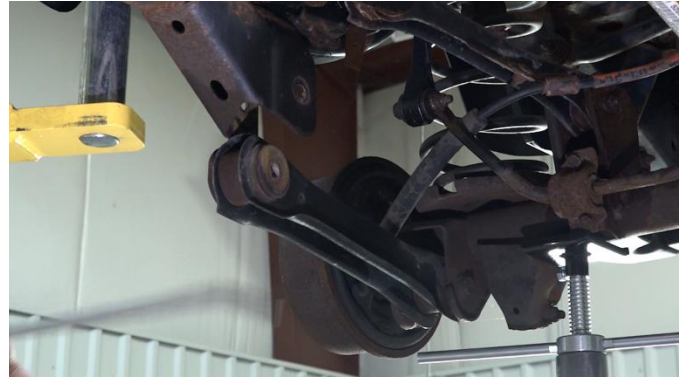
Remove any factory or aftermarket steps or guards.

Remove lower control arm bolt using a 21mm socket and 21mm wrench.



Remove upper control arm bolt using 15mm socket.

Rotate control arms down and out of the way. This may require you to loosen the axle side bolts.



Remove upper sway bar end link bolt using an 18mm socket.

Remove the six transfer case skid plate bolts using an 18mm socket. Remember to support both the skid plate and the transfer case.

Remove the rear section of the exhaust.



Mark down 1.5 inches from the top of the frame rail, on the inside and outside. You will do this from the front most body mount bracket to the bend at



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the rear frame section.



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 frame rail along the drawn line. Remove cut sections in between the body mount brackets.



Grind all cut edges smooth for easier fitment.



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.



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

6) WELDING PREP

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



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

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



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.

100% weld around all edges.

8) PAINT AND PROTECT

If you chose not to protect your part 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.



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9) REASSEMBLE VEHICLE

Reinstall lower control arm bolt.



Reinstall upper control arm bolt.



Reinstall upper sway bar end link bolt.



Reinstall the six transfer case skid plate bolts.

Reinstall the rear section of the exhaust.

Reinstall your gas tank, cords, and tubes.

Reinstall any factory or aftermarket steps or guards.

Reinstall your wheels.

Reconnect your battery.