



**RUST
BUSTER**
FRAMEWORKS

RB5051L & RB5051R

**Jeep® JK Wrangler
Rear Frame Section**



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
Large C-Clamps
Dead Blow Hammer
Body Clip Removal Tool

KIT CONTAINS

Rear Frame Section
Flanged Hex Bolt

QTY

1
4



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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 and support your rear axle with jack stands.



LIFT IS NOT REQUIRED, BUT RECOMMENDED

Remove your rear bumper, rear wheels, any inner fender liners, and any factory or aftermarket accessories that would pose as a fire hazard or prevent access to the work area.

Remove your muffler.

With a 10mm socket, remove the bolt for your brake line bracket and push it out of the way.



With a 5/8 socket, remove the 2 bolts from each sway bar bracket, and press it down and out of the way.



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



Hold the part up to the frame by roughly lining up the hole locations. Mark your intended cut line, removing as much rust as possible, while retaining a safe and weld-able margin.





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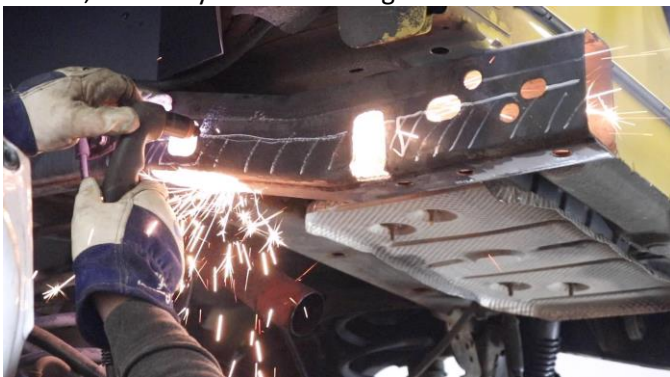
Jeep® JK Wrangler Rear Frame Section



4) **CUT**

NOTE: Our part assumes the customer wants to repair the rear crossmember, rear body mount, and muffler bracket too. If you do not wish to, you will need to alter our part to fit around these areas without damaging them.

Begin cutting along the drawn line while avoiding damage to the frame rail, shock mount, coil spring bucket, and body mount bushings.



6) **WELDING PREP**

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

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



5) **TEST FIT PART**

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

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

Compare the fitment to the frame on the opposite side, while ensuring the frame holes line up.



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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 frame section 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 starting with your body mount bushing and bolt.

Reinstall your sway bar brackets.

Reinstall your brake line.

Reinstall your wheels and any accessories.

Reconnect your battery.