



# RUST BUSTER

**RB7703L & RB7703R**  
**Leaf Spring Frame Section**  
**1997-2004 Dodge Dakota**  
**Club Cab – 6.5 ft. Bed**



**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  
Sockets & Wrench  
Fire Extinguisher  
Hammer  
Punch  
Come-Along (Recommended)

### KIT CONTAINS

Leaf Spring Frame Section  
Backing Plate  
M10 Hex Head Screw  
M10 Washer  
M10 Insert Flange Locknut

### QTY

1  
1  
6  
6  
6



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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 or remove the bed from your frame. Remove or protect any fuel lines, brake lines, and wiring harnesses. Remove your fuel tank.

### 4) CUT

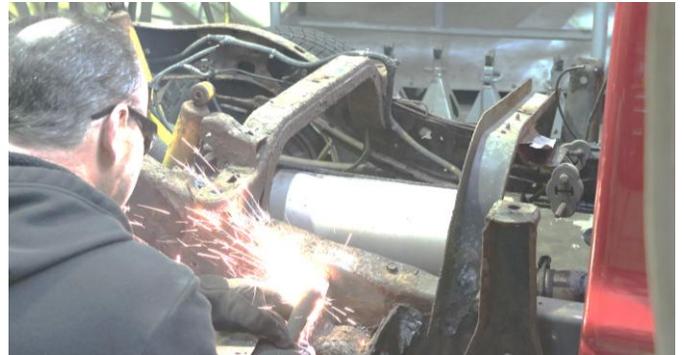
Cut and punch out the rivets retaining your front and rear fuel tank crossmembers.

**NOTE:** We recommend leaving the two bolts shown below intact unless you plan to replace your crossmember and its bolts. Our frame section features perforated plates that you can remove to fit over the existing bolts. If you decide to remove the bolts, they will most likely be rusted due to the age of the vehicle. If so, you will need to cut out the bolts.



Once you have removed the rivets and bolts, set your crossmembers aside.

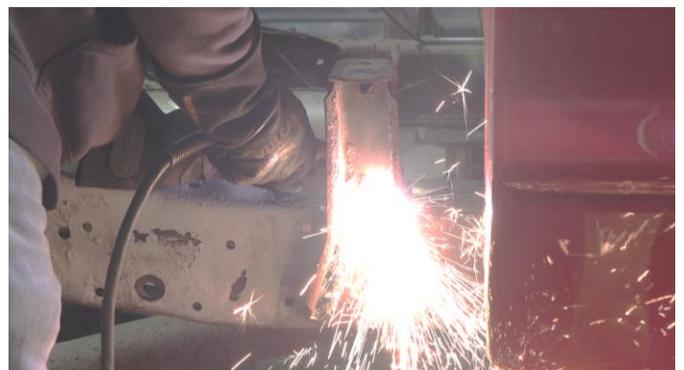
Then, remove the rivets retaining your leaf spring hanger.



Lift your frame to separate your hanger from the frame, leaving you enough room to install your frame section.



Then, cut off your front bed mount and any obstructions in the work area.





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



Spray the work area with a weld-through primer to help prevent against rust development.



Once you have your frame section in place, take the included backing plate and hold it up to the inner side of the frame rail. Since the frame rail has several curves and bends, you will need to remove a small amount of material from the backing plate so it fits properly against the inner contour of the frame rail.



### 5) **ALIGN YOUR FRAME SECTION**

If you didn't remove the bolts shown in step 4, take your leaf spring frame section and cut out the two perforated plates. This will allow your frame section to fit over the existing bolts. Set the plates aside.

Next, slide your leaf spring frame section onto the frame using the frames holes to help with the alignment.

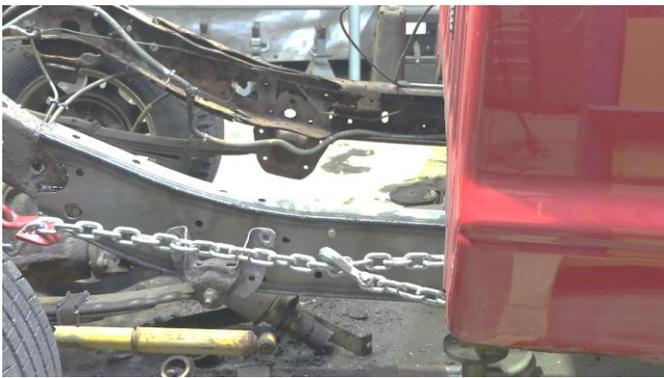
Once you have your backing plate in place, lower your truck down and realign the leaf spring hanger with your frame.



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If your frame drifts away from your leaf spring hanger to where the holes don't align, you can use a come-along and attach it from the rear cab mount to the rear end of your frame rail to bring them together. You can use a punch to help with the alignment as well.



Once aligned, screw in four of the included bolts, washers, and nuts, followed by tightening the hardware with a 14mm socket and 15mm wrench. This will hold everything together while welding on the frame section.



### 6) REINSTALL YOUR CROSSMEMBERS

If you removed either of your crossmembers, you can reinstall them at this time. We show you how using the installation videos on our YouTube channel:

- Fuel Tank Crossmember: RB7707 Installation Video
- Front Fuel Tank Crossmember: RB7711 Installation Video

### 7) WELD

If you kept the factory fuel tank crossmembers bolts and removed the perforated plates in step 4 and 5, hold the plates you removed up to the two bolts retaining the factory fuel tank crossmember. Make sure the holes are aligned.

Tac weld your frame section to the frame before welding it on fully. Then finish welding on the perforated plates.

### 8) REINSTALL

After welding your frame section into place, you will need to reinstall your front bed mount. We show you how to do this with the installation video on our YouTube channel:

- Front Bed Mount: RB7708 Installation Video



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### **9) PAINT**

Paint the part with primer or other rust inhibitor to help prevent or reduce the risk of rust formation.

We recommend our Rust Buster Rust Converter & Primer Spray Paint (RB9917).



### **10) REINSTALL**

Reinstall your fuel tank.