



# RUST BUSTER

## RB8015L & RB8015R Center Frame Repair Kit 1999-2016 Ford F250 Superduty



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  
Tape Measure  
Paint Marker or Chalk  
C-Clamps  
Mallet

### KIT CONTAINS

Center Frame Section  
M12 Flanged Head Bolt  
M12 Flange Locknut

### QTY

1  
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.**



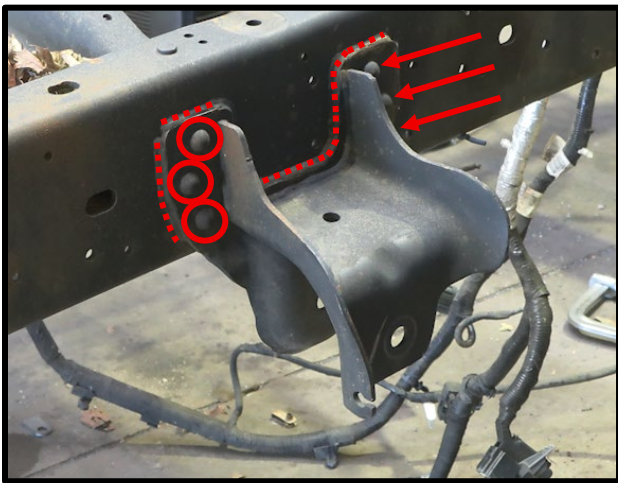
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### 3) PREPARING FOR YOUR INSTALL

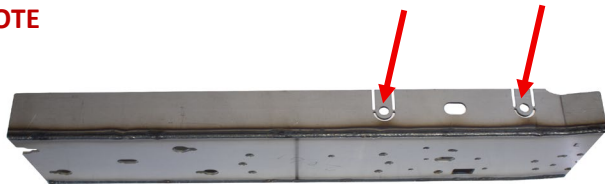
Remove your truck's **bed bolts**, then lift and **remove the bed**. Remove the **bed mount bushings**. Uninstall the leaf spring from the **rear forward leaf spring mount**.

### 4) CUT



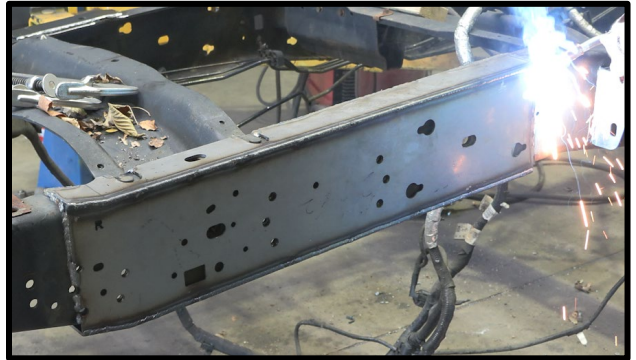
Cut the **rivet heads and welds** holding the **factory rear forward leaf spring mount**, and use a hammer and punch to **clear the studs from the rivet holes**. Take care to **avoid damaging the leaf spring mount**, as it will be **re-installed later** if you do not have a replacement.

#### NOTE



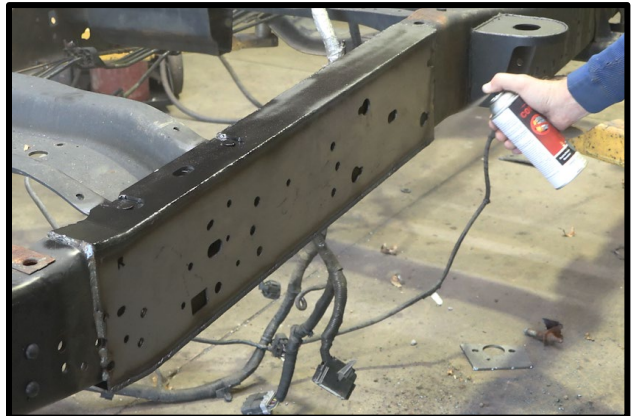
This part features **perforations** to accommodate the **carrier bearing crossmember rivets**. If you are **keeping this crossmember**, remove the **perforations** now. If you are **replacing this crossmember**, cut the **rivet heads and punch out the studs** now.

### 5) WELD



Remove any **frame rot, rust, or debris** from the **work area**, and **spray the work area with a weld-through primer**. Slide the frame section on to the frame rail, using the **frame holes** for alignment. **C-clamp the part in place**. Following proper welding procedure, **tac-weld the part in place** prior to welding all edges fully.

### 6) PAINT



Paint the **part and work area with rust inhibitor** to prevent or reduce future rust formation. We recommend our **Rust Buster Rust Converter and Primer Spray Paint (RB9917)**.

### 7) REINSTALL

Re-install or install a replacement **rear forward leaf spring mount**. Re-install the **leaf spring**. Lower the bed and re-install it to the frame.