



RUST BUSTER

F R A M E W O R K S

RB8419L & RB8419R
2003-2009 Toyota® 4Runner
Rear Frame Section



REQUIRED TOOLS

Jack Stands or Lift
Mig Welder
Paint/Primer
C-Clamp
Hand Grinder
Cutting Wheel or Torch
Welding Gloves
Welding Hood/Shield
Ear & Eye Protection
Sockets & Ratchet
Fire Extinguisher

KIT CONTAINS

Rear Frame Section
M12 Flanged Hex Screw

QTY

1
2



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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

Start by making room for your body mount. If you're keeping your existing body mount, remove the shown perforated plate.



Hold the part up to the frame and mark off its coverage. Bend the opening on your rear frame section to create the contour of your frame. Then, mark your cutline $\frac{3}{4}$ inch above the bottom of the frame.



4) CUT

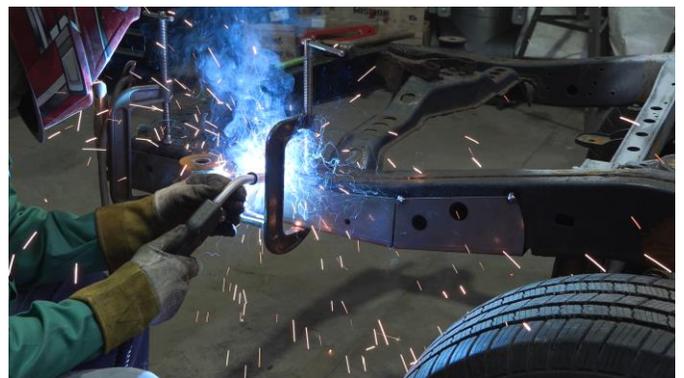
Begin cutting on the marked line and remove the bottom of the frame.



Then, grind down the zones free of rust and debris, revealing bare metal.

5) WELD

Remove any potential fire hazards from the work area. Tack weld the part to the frame using c-clamps as needed. Following proper welding procedures, begin welding the part. 100% weld around all edges.





**RUST
BUSTER**
FRAMEWORKS

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6) PAINT AND PROTECT

Coat the part and work area with a primer or other rust inhibitor to help prevent or reduce the risk of rust formation.



You can reinstall your hitch or any tow hooks that were mounted in the hole previously.