



**RUST
BUSTER**
FRAME REPAIR

RB2002R

Jeep® YJ Wrangler

Rear Shackle Mount Section – Passenger Side



VIDEO AVAILABLE



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 & Water
Rear Spring Shackle
Bushings (Pair)

KIT CONTAINS

Rear Shackle Mount Section – Passenger
Side

QTY

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 left 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.



4) DISCONNECT SPRING SHACKLE

Using two 19mm sockets loosen the upper most bolt on the spring shackle and remove it from the shackle mount.



Loosen the lower bolt enough to rotate the shackle down and out of the way, exposing the frame.



5) ESTABLISH CUTTING ZONE

Hold the Rust Buster part up to the frame and take note of its measurements. Using a grinding wheel, grind the zone down to bare metal as best as possible. Measure 1.5" from the top of the vehicle's frame and draw a line, tracing the edge. Draw a second perpendicular line just left of the left most slot.



Continue to draw the line around to the inside of the frame, following the gas tank support, 1.5" from it and the top edge.



6) CUT

Begin cutting away the metal along the drawn line, and cutting as close to the bushing, as possible.



Cut as close as possible to the rear cross member and remove the remaining shackle mount material inside it.



7) TEST FIT PART

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



The part may fit snugly and require force. Ensure the bushing hole is visually aligned with the right side of the frame.

The part should fit over the remnants, and inside the rear cross member.

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

8) WELDING PREP

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



Tack weld and/or clamp the part into place.





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9) WELD

Remove any remaining potential fire hazards on both the vehicle and surrounding area.

100% weld around all edges including the rear cross member.



10) PAINT AND PROTECT

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



11) REASSEMBLE VEHICLE

Begin reassembling your vehicle by resecuring your spring shackle and mount. Insert a new bushing according to the manufacturer's instructions.



Using two 19mm sockets, rotate the shackle into place, send the bolt through, and secure the nut onto it. Reinstall your gas tank, cords, and tubes.



Reinstall your wheel. Reconnect your battery.