Step 1 Cherokee XJ DIY Rear Bumper Install Instructions



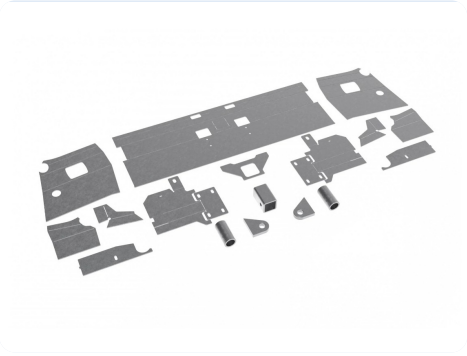


Step by step on how to install the Cherokee XJ DIY Rear Bumper. Please read all steps carefully before starting the install.

Questions or Support:
Phone: 269-353-1184
Email: info@jcroffroad.com

Step 2 Included Parts

1x #1 Center Section	**2x** #2 Frame Mounts
2x #3 Top Bumper Corner Piece	**2x** #4 Wing Piece
2x #5 Outside Wing Piece	**2x** D-Rings
2x Cube Light Brackets	**1x** Hitch
1x Hitch Bracket	**2x** Spindle Sleeve



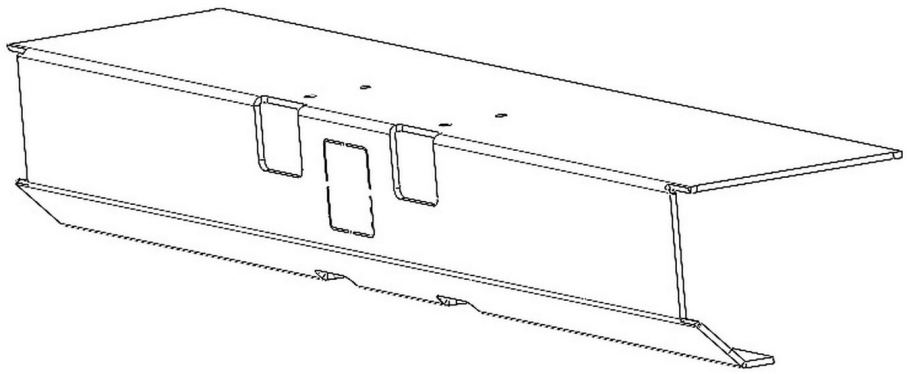
Check that you have all of the parts listed and shown before starting.

Step 3 Hardware Needed

Hardware is not included with this DIY kit. You will need:

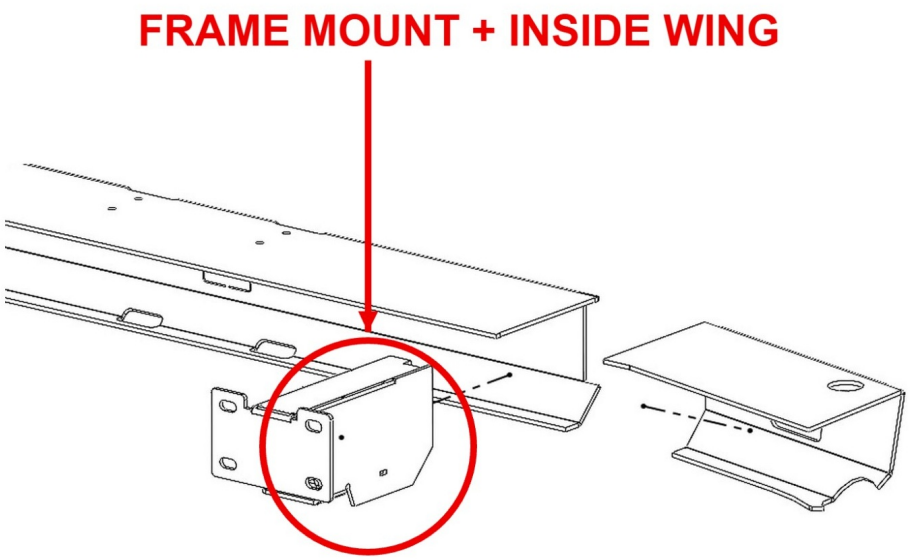
- 4x 7/16 x 1-1/2 in hex bolts
- 4x 7/16 nuts
- 10x 3/8 washers
- 2x 10 mm x 30 mm hex bolts

Step 4 Bend Parts



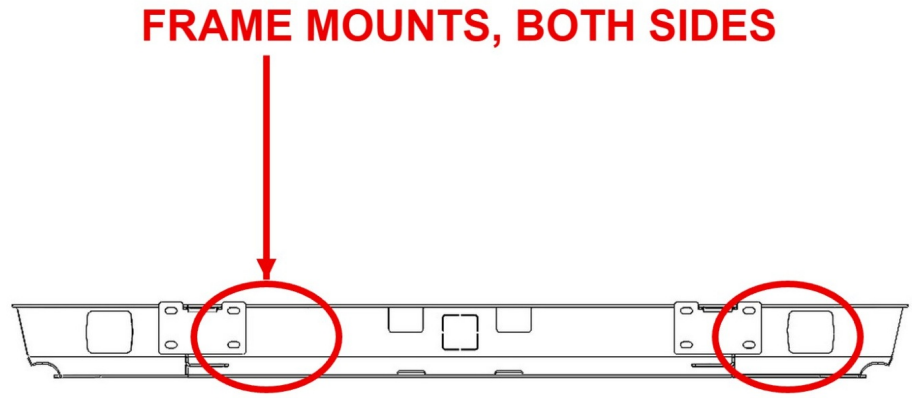
Bend all parts on their slit lines before welding. The bend angle is etched on each slit line, and each part is shown as it should look once bent.

Step 5 Tack Main Section



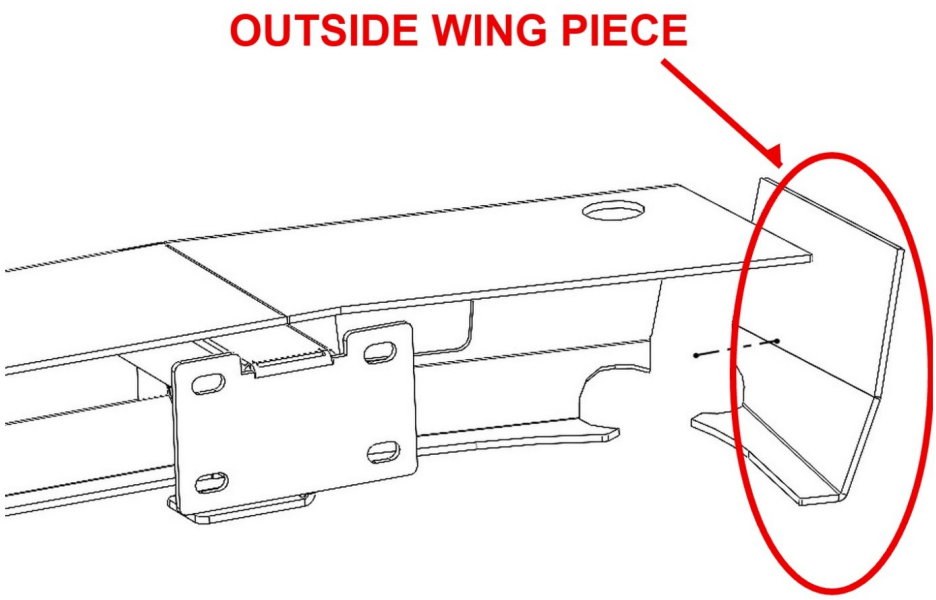
Tack the majority of the parts together first so you can adjust. Take the 4 provided pieces, 2 per side, and weld them into the formation shown, aligning profiles and angles. Leave a gap for the D-rings. Weld the seams and keep everything level and square.

Step 6 Check Fit



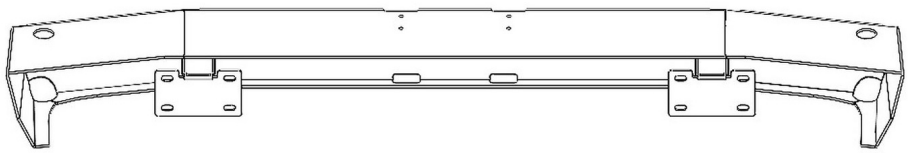
This is how it should look after the 2 pieces are tacked to both sides of the bumper, 4 in total, viewed from the back inside of the bumper.

Step 7 Tack Outer Wings



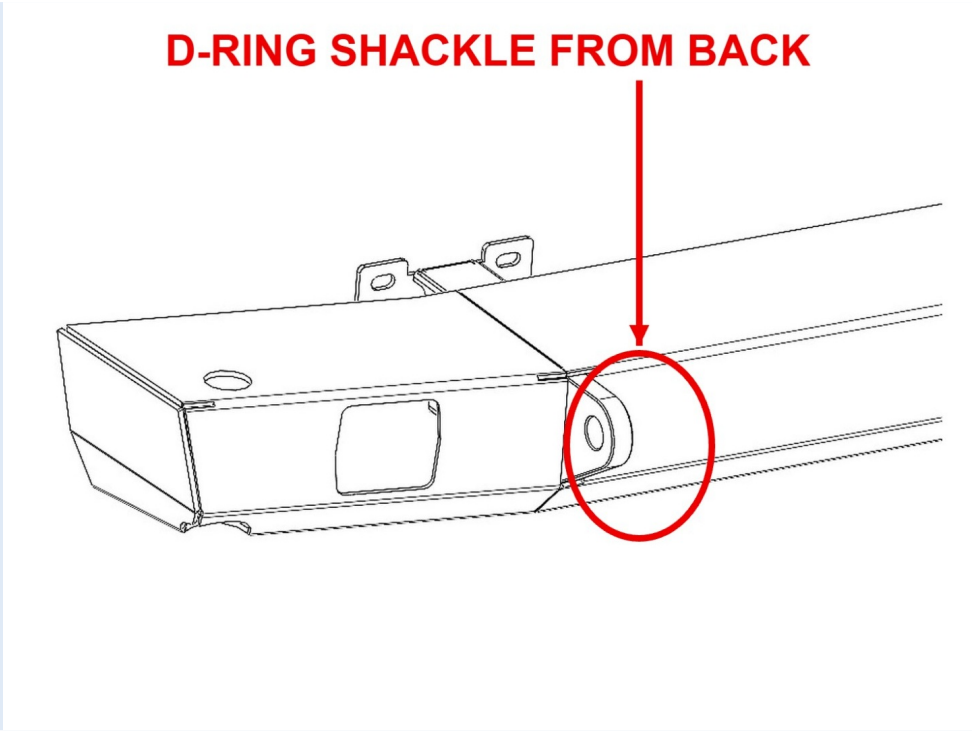
With the frame mounts and inside wing pieces in place, tack the outside wing pieces into place as shown. Do both sides of the bumper.

Step 8 Check Assembly



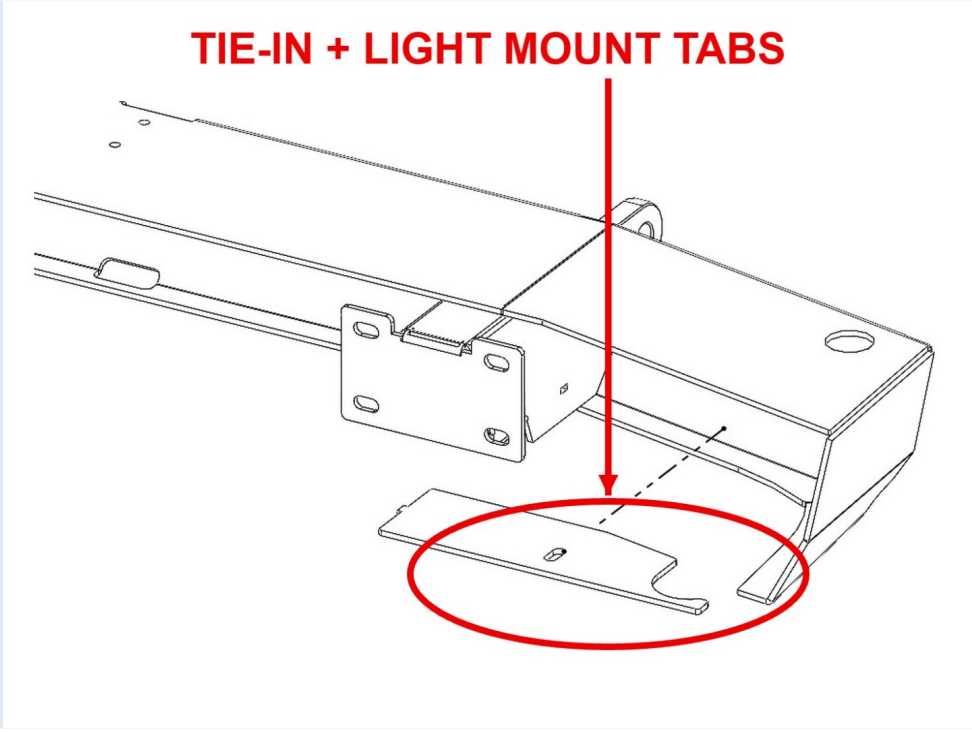
After both wings are tacked together and onto the rest of the bumper, it should look like this.

Step 9 Weld D-Ring Shackles



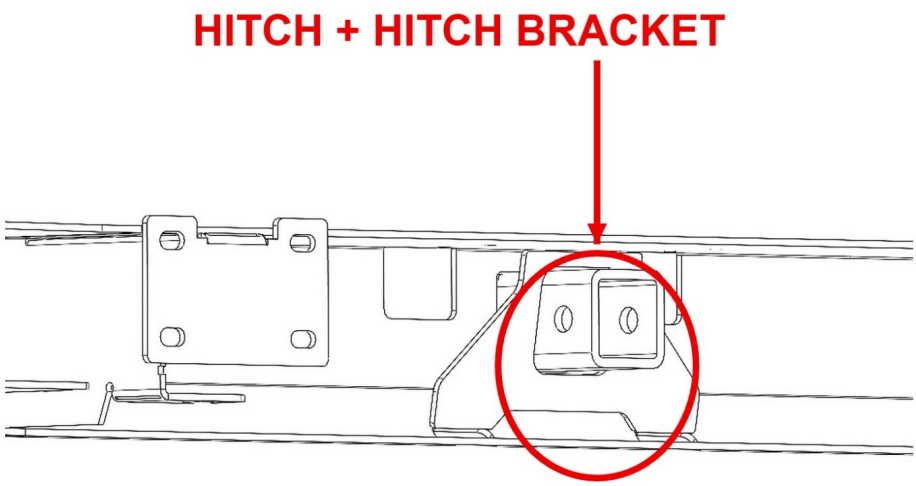
Weld in the D-ring shackles on each side, inserted from the back. Before fully welding, make sure everything is square and the shackle is out as far as possible in the slot.

Step 10 Test Fit



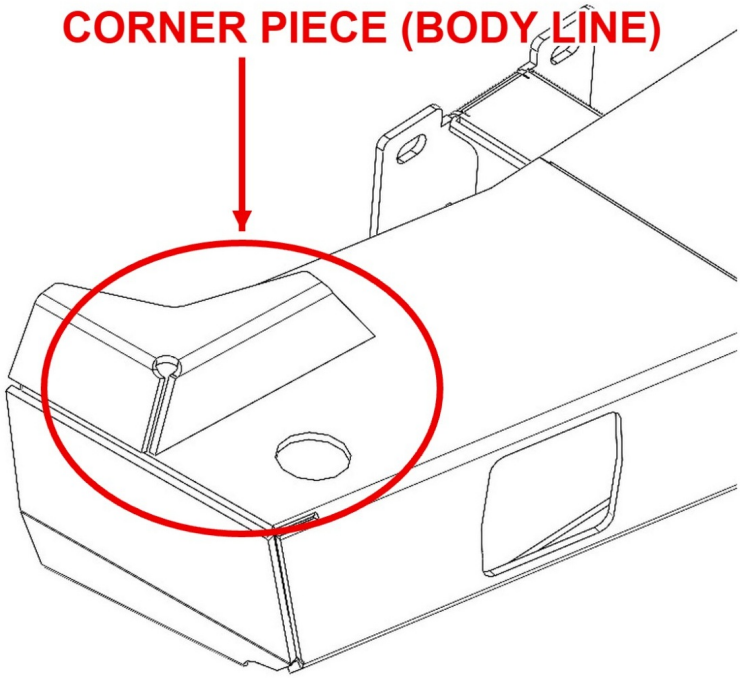
Bolt the bumper onto the truck to check alignment and fitment with the body. If you are happy, fully weld the bumper together. Then weld in the provided tie-ins and light mounts as shown, with the tab on the end of each bracket slotted into the frame mount and the back face flush with the inside of the bumper face.

Step 11 Install Optional Hitch



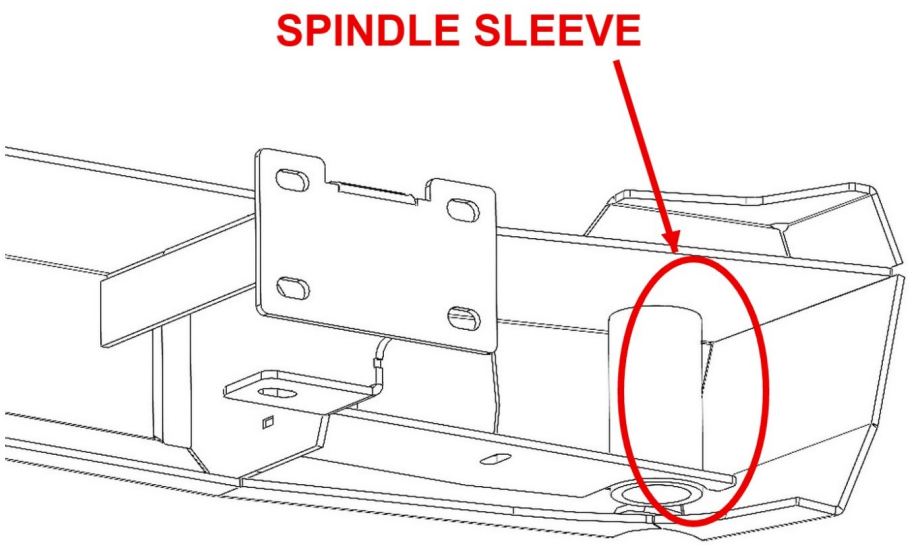
If you plan to add a hitch, cut out the hitch hole and weld in the provided hitch and hitch bracket, shown from inside the bumper. Leave only 1/4 to 3/8 inch of the hitch sticking out the front. The bracket is welded on an angle with its bottom legs right above the holes.

Step 12 Weld Corner Pieces



Bolt the bumper back onto the truck and weld the corner pieces on, using the truck as a guide for the body line. Once the look and alignment are right, fully weld them on both sides.

Step 13 Weld Spindle Sleeves



If you will run a carrier, weld in the spindle sleeves in the corner for the side you want. The top of each sleeve sits flush with the bottom face of the bumper and concentric with the hole in the top face. Fully weld when aligned.

Step 14 Installation Complete



Make sure everything is fully welded. Congrats! Your XJ DIY Rear Bumper is now complete and ready for cube lights, a tire carrier or other customizing. Enjoy!