Step 1 Comanche MJ DIY Rear Bumper Install Instructions





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

Installation Video: https://www.youtube.com/watch?v=FS0mvjlnlxc

Questions or Support:
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Step 2 Included Parts & Hardware



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

Step 3 Lay Out Parts

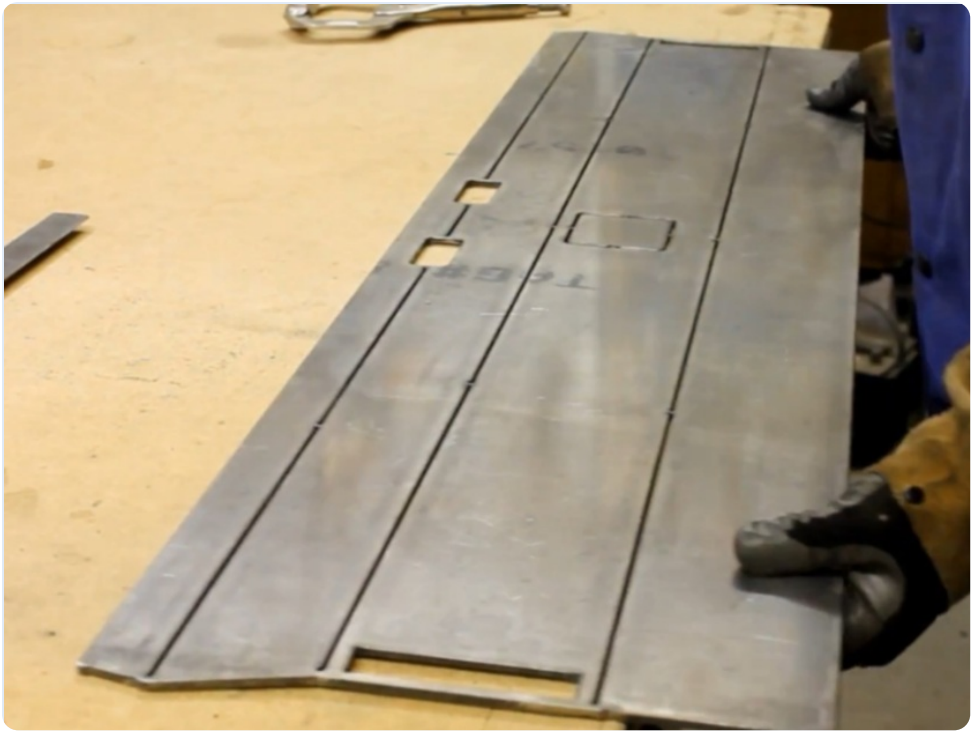


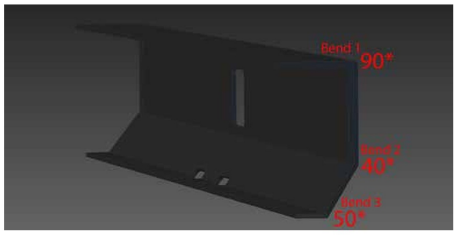


Lay out the parts and learn the names: MJDIY01 center section, two MJDIY02 wings, two MJDIY03 side caps, MJDIY04 and MJDIY05 mounts, MJDIY06 hitch support, and the D ring tabs. Test fit before painting, and keep paint and bed liner off all threads.

Video timestamp: 2:37

Step 4 Bend Center Section



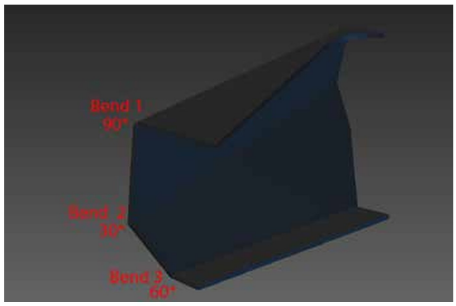


Clamp the center section (MJDIY01) to a table and make three bends: 90 degrees, then 40 degrees, then 50 degrees, re clamping between each bend.

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Step 5 Bend Wings

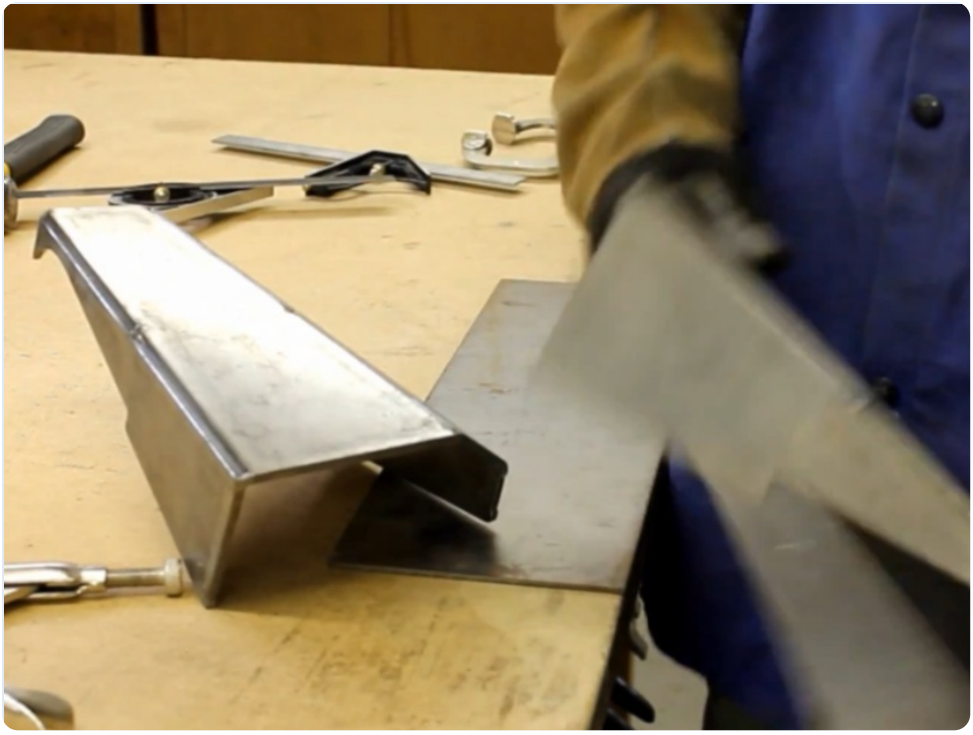




Bend the two wings (MJDIY02) the same way, making one left and one right so they end up as opposites.

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Step 6 Bend Side Caps



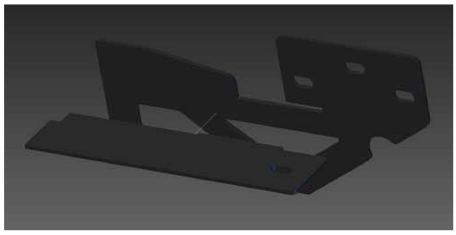


Clamp each side cap (MJDIY03) in a vise or to a table and bend it to 15 degrees, making a left and a right.

Video timestamp: 7:25

Step 7 Assemble Bumper Mounts

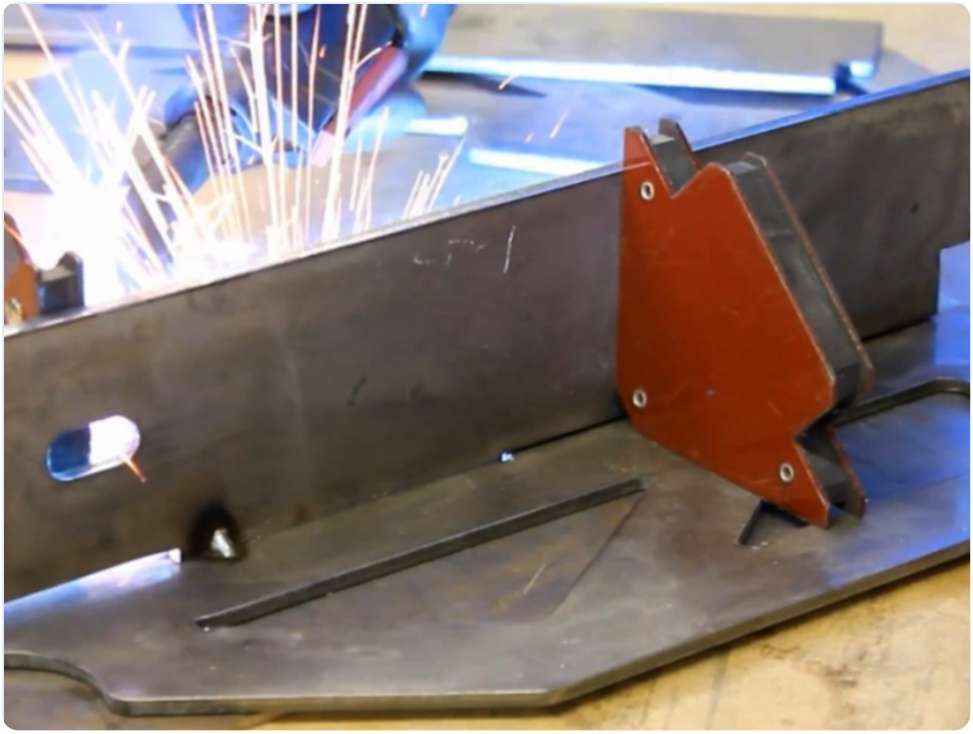


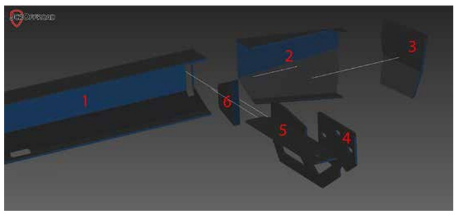


Assemble the bumper mounts by seating the horizontal piece in the notch of the main mount, then tack each pair together and set them aside.

Video timestamp: 7:42

Step 8 Tack and Weld Bumper





Lay the center section face down and tack the wings to it, then tack the side caps to the wings. Weld and grind the whole shell before adding the D ring tabs or mounts.

Video timestamp: 9:10

Step 9 Install D-Ring Tabs



Insert the D-ring tabs through the bumper from the back so they stick out the back about 1/2 inch. Tack weld them on the inside of the bumper only, since the bumper mounts sit flush against the outside of the tabs.

Video timestamp: 12:44

Step 10 Install Bumper Mounts



Slide the bumper mounts into place. The notch in each mount fits around the D-ring tab. Tack weld the mounts, keeping them square with the center section.

Video timestamp: 12:59

Step 11 Test Fit Bumper



Test fit the bumper on your Jeep now, before final welding and painting, in case adjustments are needed.

Video timestamp: 14:40

Step 12 Weld Hitch Slots (No Hitch)



If you are not installing the front hitch, weld the precut slots in the center of the bumper closed and grind them flat. Without the receiver, the bumper is now complete.

Video timestamp: 15:27

Step 13 Install Optional Hitch





For the optional hitch, cut out the perforated plug and set the receiver tube through the opening with about 1/4 inch sticking out. Tack one corner, square it to the bumper face, then tack the opposite corner. If you are not using the JCR hitch tube, you are responsible for cutting and drilling your own tube to fit.

Video timestamp: 15:40

Step 14 Install Receiver Reinforcement





Set the bumper face down and place the receiver reinforcement bracket over the receiver and against the bumper, then weld it in.

Video timestamp: 16:00

Step 15 Paint or Coat Bumper



Once all welding and grinding is done and the test fit is good, paint or bed-line the bumper. Keep all coating off threads, and open up any holes the coating closes with a drill or file.

Step 16 Install Bumper on Vehicle



Support the factory rear bumper, remove the bolts holding it to the frame and take it off, keeping the factory hardware. Lift the new bumper into place, line the bumper mounts up with the factory frame mounting holes and start the factory bolts by hand. Center the bumper, then tighten all bolts to factory torque. Recheck the hardware after the first few drives.

Step 17 Installation Complete



Congratulations, you have completed the install of your new Comanche MJ DIY Rear Bumper! Enjoy your new product.

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