Step 1 Cherokee XJ DIY Front Bumper Install Instructions



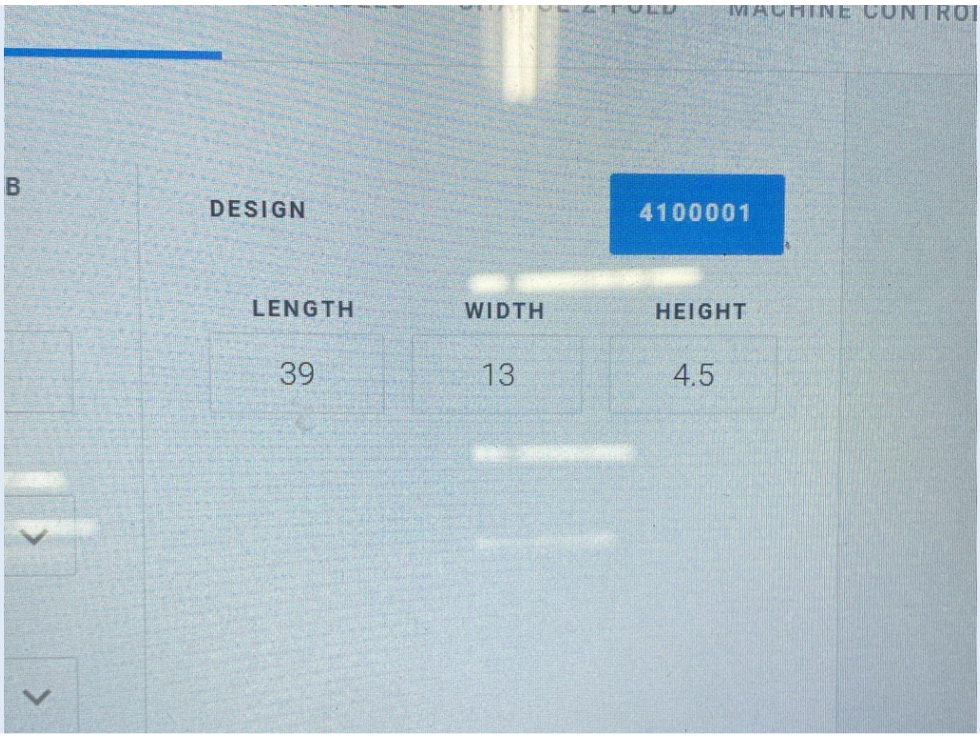


Step by step on how to install the Cherokee XJ DIY Front Bumper. Please read all steps carefully before starting the install.

Installation Video: https://www.youtube.com/watch?v=De6yu8Z_ltI

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

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: XJDIY01 center section, two XJDIY02 wings, two XJDIY03 side protection parts, XJDIY04 winch plate/frame mounts, XJDIYUNF Uni-Frame plates, and the DIY-DRT D-ring tabs. Test fit before painting, and keep paint away from all threads.

Video timestamp: 0:33

Step 4 Bend Center Section



Clamp the center section to a table and bend up the first 90 degree angle, then re clamp it and bend the second 90 degrees. It does not matter which side becomes the front.

Video timestamp: 1:36

Step 5 Bend Wings



Bend each of the two wings with a top and bottom 90 degree bend, making one left and one right so they end up as opposites.

Video timestamp: 4:36

Step 6 Bend Side Protection



Bend each side protection part in a vise if you can. Make the long 65 degree bend first, then fold the small back flap over to meet it, tweaking the part for a good fit.

Video timestamp: 4:54

Step 7 Tack Wings to Center



Lay the center section face down with the left and right wings face down on each end, then clamp each wing in place and tack it. Only tack the bumper together at this stage.

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Step 8 Tack Side Caps



Clamp the side protection caps to the bumper and tack weld each side.

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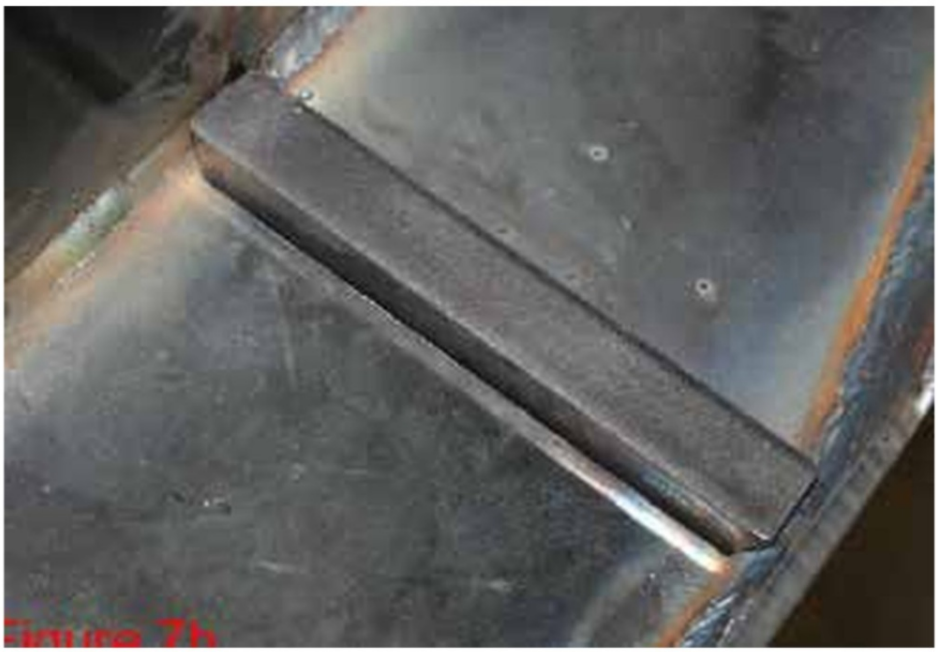
Step 9 Weld Bumper



With the bumper tacked together, fully weld it, starting with the back side. Let it cool, then grind the shell before the D ring tabs go in.

Video timestamp: 6:31

Step 10 Install D-Ring Tabs



Insert the D ring tabs from the back and tap them in with a dead blow hammer so they stand about 3/8 inch proud. Tack them only on the inside, toward the middle of the bumper.

Video timestamp: 7:04

Step 11 Tack Bumper Mounts



Tack the bumper mounts to the outside of the D ring tabs, square with the front of the bumper and 33.5 inches apart. Then fully weld the tabs to the mounts and to the bumper from the back.

Video timestamp: 7:41

Step 12 Test Fit and Bumper Spacers



Test fit the bumper now if you like. If you are not running the Uni-Frame Tie In with Steering Spacer kit, use the bumper spacers to take up the gap between the uniframe and the bumper mounts. They are not needed with the Front Reinforcement Bracket kit.

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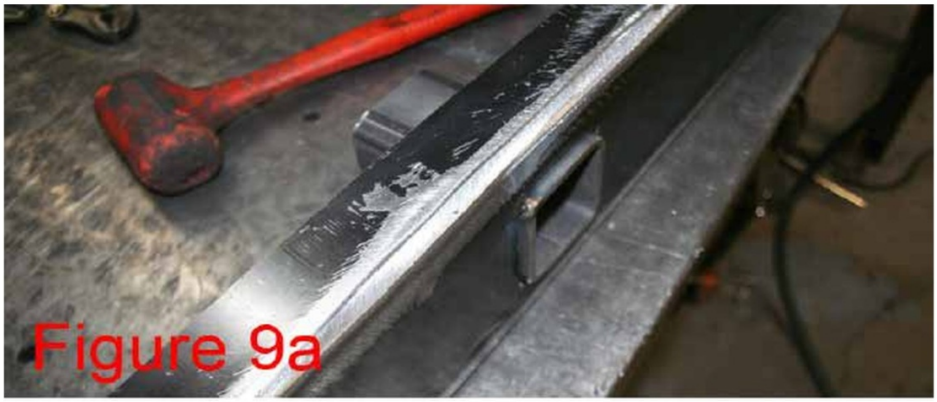
Step 13 Weld Hitch Slots (No Hitch)



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: 12:20

Step 14 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.

Video timestamp: 12:35

Step 15 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: 12:51

Step 16 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 17 Install Bumper on Vehicle



Support the factory front bumper, remove the bolts holding it to the frame and take it off, keeping the factory hardware. Lift the new bumper into place and line the mounts up with the factory frame mounting holes. If you are not running the Uni-Frame Tie In kit, put the bumper spacers between the uniframe and the mounts. 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 18 Installation Complete



Congratulations, you have completed the install of your new Cherokee XJ DIY Front Bumper! Enjoy your new product.

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