



JK FRONT DIY BUMPER ASSEMBLY INSTRUCTIONS

**Please read the mounting instructions below
carefully before attempting to assemble.**

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DIY-JK-F – DIY FRONT BUMPER – JK WRANGLER

Item Code Legend

EX: *DIY-JK-F*

- DIY : Do It Yourself
- JK : JK Wrangler
- F : Front



Main (Part #01) X1, Gussets (Part #02) X2

Photo

Needed

Lower Skid (Part #03) X1

Photo

Needed

Wing Outer (Part #04) X2

Photo

Needed

Wing Face (Part #05) X2

Photo

Needed

Dring Tabs (Part DRG) X2

Bolt Pack:

JK STRIKE BP:

- o 8 - 1/2 x 2 Button Head
- o 8 - 1/2 Flange Nuts

Tools Needed

- Adjustable wrench X2
- Welder
- Welding Tools and Mask
- Sander
- Angle Finder

Tools Needed Cont.

- Marker
- Tape Measure

It is always best to trial install before painting/finishing to ensure proper fit. If using a bed liner type product, you may need to use a drill or file to open holes or openings to the proper size. Be sure to keep any and all paint or bed liner products away from all threads.

1 Using a sander or grinder, clean all parts. Then sort the parts into the main bumper (Part #01) and gussets (Part #02), the skid (Part #03), and the two wings consisting of the one wing outer (Part #04) and one wing face (Part #05).

2 Clamp the main bumper (Part #01) to your table and using an adjustable wrench bend both sides to 90 degrees.



- 3** Clamp the main bumper (Part #01) on the top side, the side with the four winch mounting holes. Using the two adjustable wrenches on the bottom and bend to a 90 degrees, the sides should just meet the top at this time. Tack the top to the sides.



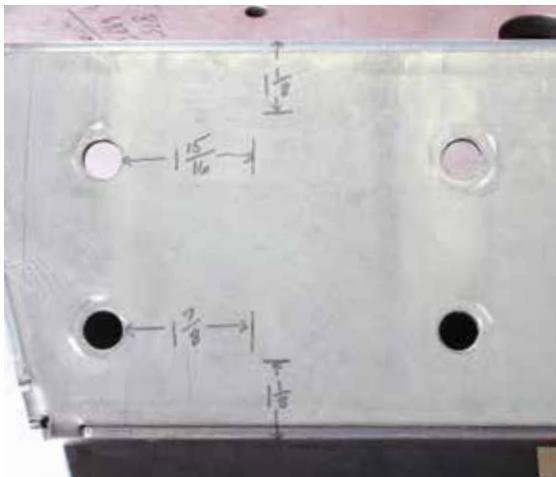
- 4** Keeping the top clamped to the table, bend the bottom of the bumper to 90 degrees and tack to the sides.



- 5** Unclamp and place the bumper on its face. Place the gussets (Part #02) by lining up the gusset tabs with the slots in the top and bottom of the bumper. Tack the gussets at each of the four corners of the gussets.



- 6** Place the bumper with the face up. Using a marker and tape measure you will measure and mark where to mount your Dring Tabs. From the inside edge of the top outer mounting hole, measure in $1 \frac{15}{16}$ inches. From the inside edge of the bottom outer mounting hole, measure in $1 \frac{7}{8}$ inches. From the top and bottom edges, measure down $1 \frac{1}{8}$ inches. See photo for example. Line up the Dring tab with those measurements and tack into place.



7 Its now time to test fit the bumper on you JK to make sure that it mounts as intecded.

8 If everything mounts corectly, and you are wanting the stuby bumper, then your done with the asseply and now its time to weld the bumper fully. Weld and grind any gap until your happy with the bumper.

If you want the wider bumper, continue with the following instructuions.

9 Take one wing outer (Part #04) and one wing face (Part #05). You are going to bend these so that you have both a right and left wing.

10 Clamp the large part of the wing face (Part #05) to your table. Bend the small peice up to a 20 degree angle. In the photo below, bend down for passenger side and bend up for drivers side.



- 11** Take the wing outer (Part #04) and place on the tabel with the widest portion towards you. Place your clamp so it is just past the bend line, as shown below. This bend is at 15 degrees.



- 12** Unclamp and slide the wing outer (Part #04) towards you until you can place your clamp just past the next bend line. Bend in the same direction to 90 degrees. You can use the wing face as a guide if you wish.



- 13** Unclamp and slide the wing outer (Part #04) towards you until you can place your clamp just past the next bend line. Bend in the same direction to 74 degrees. You can use the wing face as a guide if you wish.



- 14** Unclamp, double check all the bends with your angle finder and the wing face (Part #05). If everything lines up and is good, tack the wing face to the wing outer (Part #04).



15 Repeat steps 11 - 14 with the bends going in the opposite direction for the other side wing.

16 Tack the wings to the main bumper at all four corners.



17 Clamp the skid (Part #03) so that you can bend the top mounting tabs. Bend these to 35 degrees. The lower mount is bent the other direction to 42 degrees.

18 It is now time to weld all gaps and grind as necessary. If you wish to add a hoop, this would be the best time to attach it.

19 Coat the bumper, install and enjoy!