

JEEP CHEROKEE XJ DIY FRONT BUMPER ASSEMBLY INSTRUCTIONS



Please read the mounting instructions below carefully before attempting to install.

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P Before you start assembling, use the following photo to make sure you have all your parts.

Contact JcrOffroad if you have any questions.



Parts List

XJDIY01: Center Section/ Front Face

XJDIY02: Side Wings

XJDIY03: Side Protection

XJDIY04: Winch Plate/Frame Mounts

XJDIYUNF: UNF Frame Plates

DIY-DRT: Dring Tabs

JcrOffroad can not be held responsible for miss-assembly or faulty assembly. It is your responsibility to be able to properly weld this product together. Extreme care should be taken to ensure that the person welding is duly qualified and has experience with the process.

1 The first piece you will want to bend will be the (1) front Center Section. You will be bending two 90* angles. It doesn't matter which side you make the front.

A Clamping the Center Section to a table, bend up the first 90° angle. (see figure 1a)

B You may can clamp it either way, figure 1b shows the other option.



2 Set the bent Center Section (1) off to the side. Next you will need to bend the two Bumper Wings (2). Both the top bend and bottom bend both will be bent to 90*. *****You will need to bend a Right and Left, which will end up having two wings that are opposites.*****

A Clamp one of the Bumper Wings to the table. Bend up the first 90* angle. Re-clamp the wing and bend the second 90* angle. (see figure 2a)

B Repeat on the second Bumper Wing.



3 You will now be bending the two Side Protection parts (3). The long angle will be bent to 65* and the small back flap will be bent over to butt against the other bend. *****You will need to bend a Right and Left, which will end up having two wings that are opposites.*****

A If available, it's best to bend these in a vice. Clamping as shown in Figure 3a, you will bend the 65* angle first.

B Next bend the smaller flap over to meet the angle. You may need to tweak the part for a perfect fit.



4 With all the parts bent, you will now tack together the Center Section (1) and the Bumper Wings (2).

A Lay the Center Section face down on the table. Lay out the right and left Bumper Wing face down on each end. (Figure 4a)

B Clamp one wing to the center section and tack weld it in place. (Figure 4b) Repeat on other side.



Figure 4a



Figure 4b

*****Be sure to only tack the bumper together at this point.*****

- 5** The next parts to be tack on will be the Side Protection caps (3). Clamp the caps to the bumper and tack weld each side (Figure 5a and 5b)



- 6** With the bumper tacked together, it is now time fully weld the bumper together. We recommend welding the back side first.

- 7** After the bumper has cooled off some, this is where we recommending doing the grinding. You may want to do preliminary grinding here and finish grinding at the end, but the shell of the bumper is easier to grind before the dring tabs are welded in.

- 8** With the bumper welded together and ground, it is now time to tack in the Dring tabs (7).
- A** Insert the tabs from the back (Figure 7b) and tap them into place with a dead blow hammer. The tabs will sick up around 3/8" in the back. This is correct. (Figure 7a)
 - B** Only tack the Dring tabs on the inside (towards the middle of the bumper). The mounts are next to go on and they will be butting up to the tabs.



9 The Bumper Mounts (4) will now need to be tacked into place before you can fully weld in the Dring Tabs (7) that were tacked in Step 8.

A Make sure the Bumper Mounts are on the **OUTSIDE** of the Dring Tabs. Make sure they are **SQUARE** with the front of the bumper. (Figure 8a)

B The Measurement between the mounts should be 33.5”.



10 If you choose, you can test fit your bumper at this point.

A If you didn't opt for the Uni-Frame Tie In with Steering Spacer kit, you will need to use the Bumper Spacers (6) to take up the extra space between the Jeep's uniframe and the Bumper mounts. These spacers are not necessary if you installed the Front Reinforcement Bracket kit. If you choose to add the kit at another date, you will only need to remove the spacers.

11 After verifying the 33.5” measurement, you can now completely weld the Dring Tabs and Bumper mounts to the bumper. The Dring Tabs need to be welded to the bumper mount and the bumper on the back.

- 12** If not installing the front hitch, you can weld the precut slots in the center of the bumper and grind it.
- 13** The bumper is now complete. It is highly recommend that you test fit the bumper before painting, as some adjustments may need to be made. If you are opting to install the front Receiver, please move onto the next steps.
- 14** If you choose to install the front hitch, you will need to cut the perforated hitch plug out of the center section. A sawzall or die grinder work best for this.
- 15** If you did not choose the optional hitch tube from our company, you will need to source your own. Our hitch tube is already cut to length and drilled. If you buy one from another source, you will be responsible for any cutting and drilling needed to make it fit properly.
- 16** Our hitch is made to hide the hitch pin behind the bumper. So place the hitch through the hole cut out leaving approximately 1/4" sticking out. Tack the receiver in one corner and square the hitch to the bumper face. Once square, take the opposite corner. (Figure 9a)



- 17** After the hitch is tacked in, set the bumper face down. Place the Receiver Reinforcement (5) bracket over the receiver and against the bumper. (Figure 9b)

