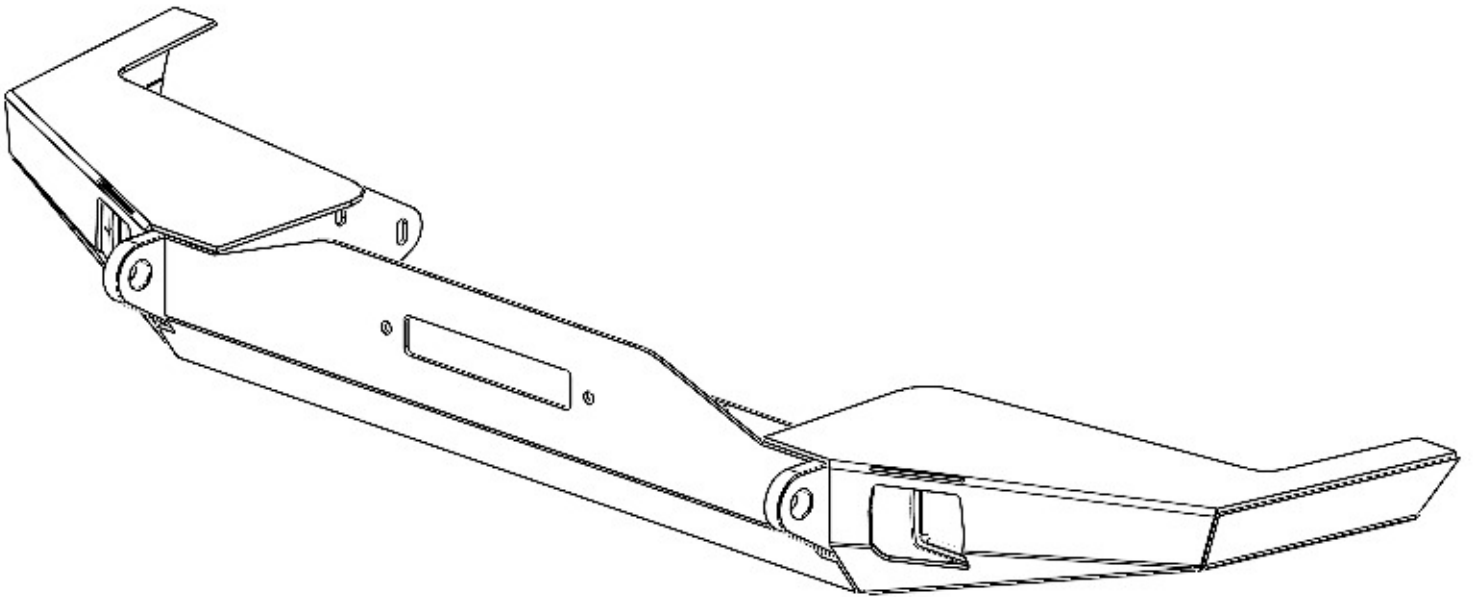




# JEEP CHEROKEE XJ DIY FRONT WINCH BUMPER

## INSTALL INSTRUCTIONS



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

**Be sure to check out the install video on the product page, if available.**

Thank you for purchasing from JCR Offroad! Checkout our website, [victory4x4.com](http://victory4x4.com) for other great off-road products. Be sure to rate and review our product online. If you have any questions or are missing parts, please don't hesitate to call us at 269-353-1184!

# INCLUDED HARDWARE

## INCLUDED BOLT PACK(S) N/A

Note: Hardware is not supplied, and will require customer to supply their own hardware.

Below is a list of hardware you will need.

However, if you plan to purchase our unibody tie-in kit this will include all hardware needed to install the tie-in kit and the bumper (recommended for heavy winching).

**4x** 7/16" x 1.5" Hex Bolts

**4x** 7/16" Nuts

**10x** 3/8" Washers

**2x** 10mm x 30mm Hex Bolts

# INCLUDED PARTS

**1x** #1 Winch Plate

**2x** #2 Frame Mounts

**1x** #3 Front Bumper Piece

**2x** #4 Wing Piece

**2x** #5 Outside Wing Piece

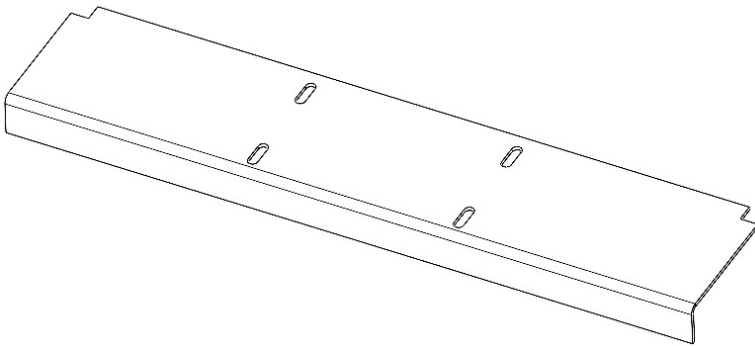
**2x** D-Rings

**2x** Cube Light Brackets

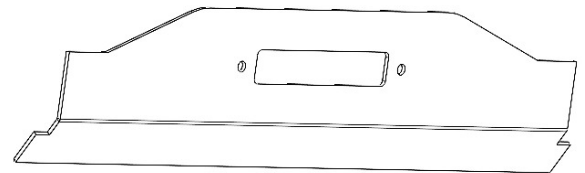
# ASSEMBLY

1. Before you start, bend all of your parts that need bent on the slit lines.  
Below you will see each part and how they should look after they are bent.  
Each of the parts will have the bend angle etched on the slit line for each bend.

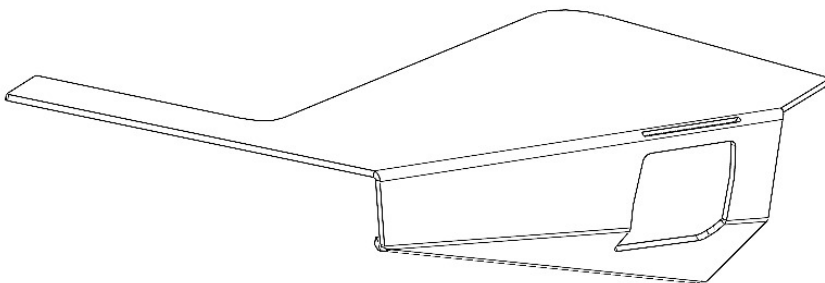
**1x**



**1x**



**1L&1R**

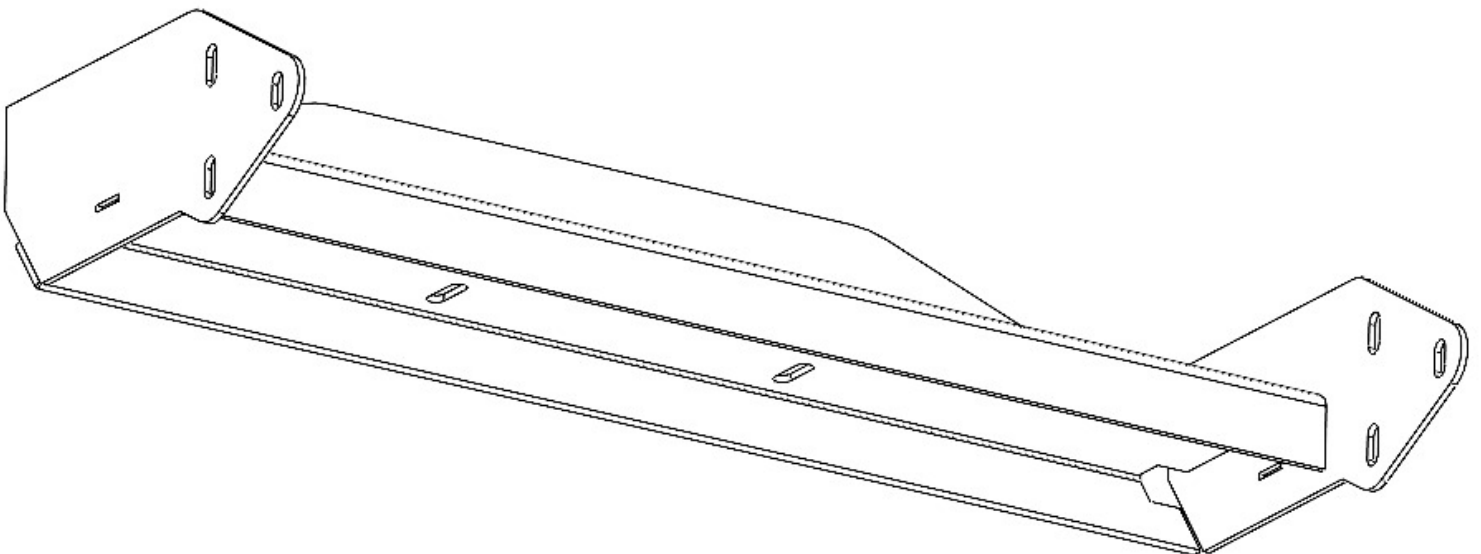
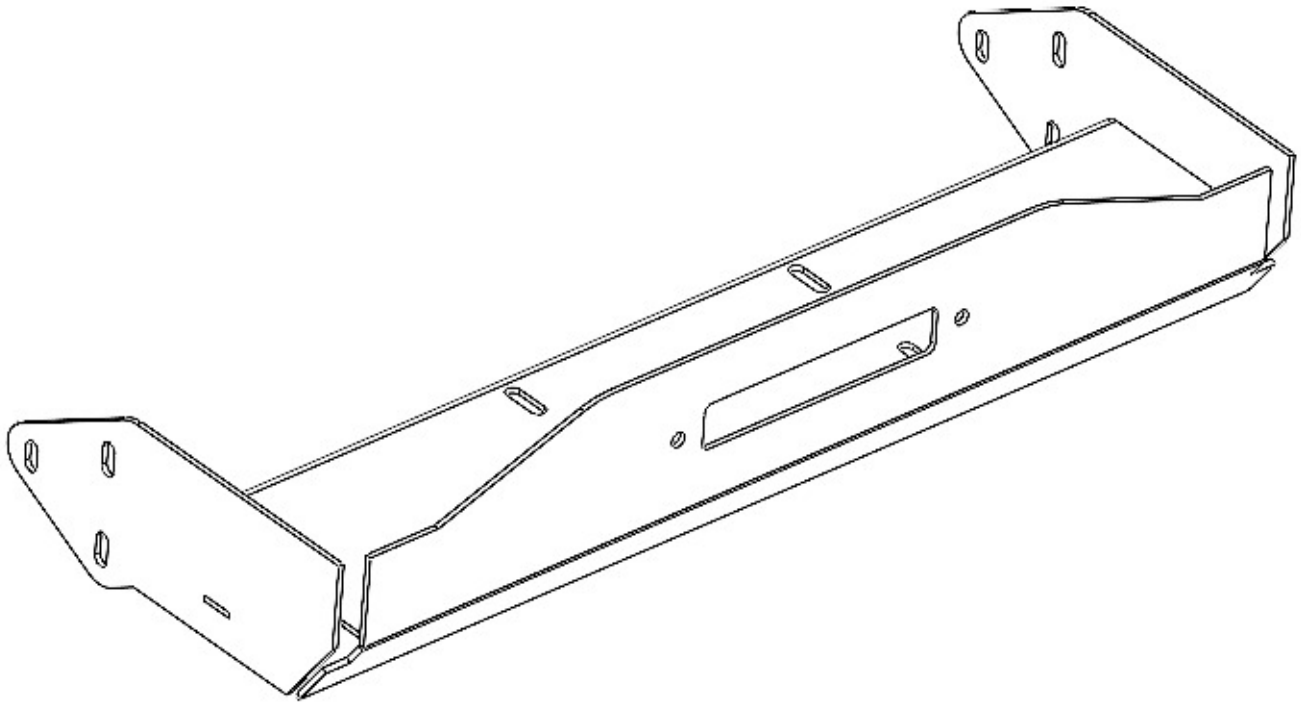


**1L&1R**



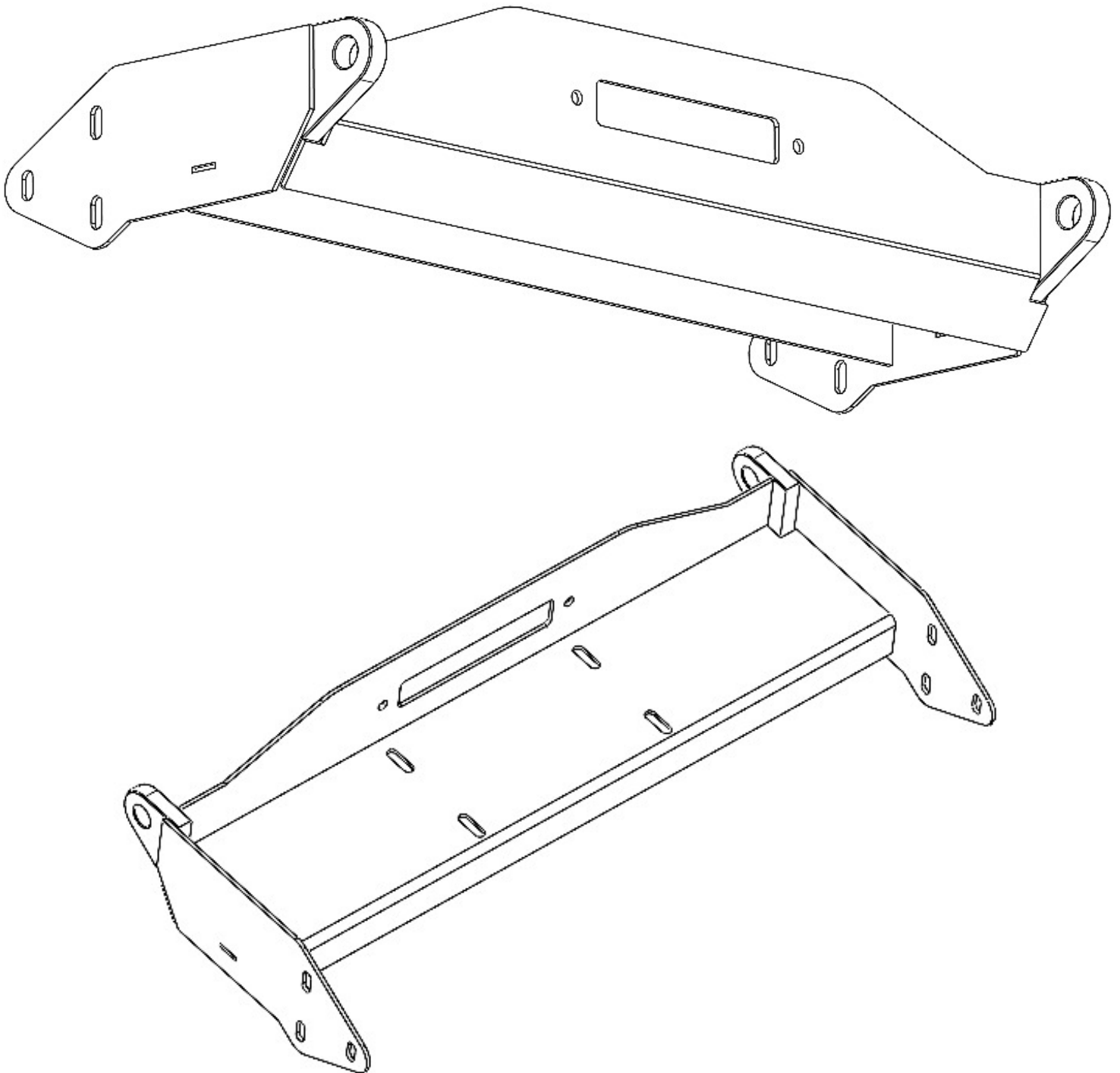
# ASSEMBLY

2. Before fully welding the heavy tack pieces together, we recommend you solidly tack the majority of these parts together in case you need to adjust or change anything. Take the (4) provided pieces as shown below, and weld them into the formation shown, aligning the profiles and angles to one another. Also be sure to leave a gap as shown below to add in the D-rings later. Weld the seams and make sure everything is level and square.



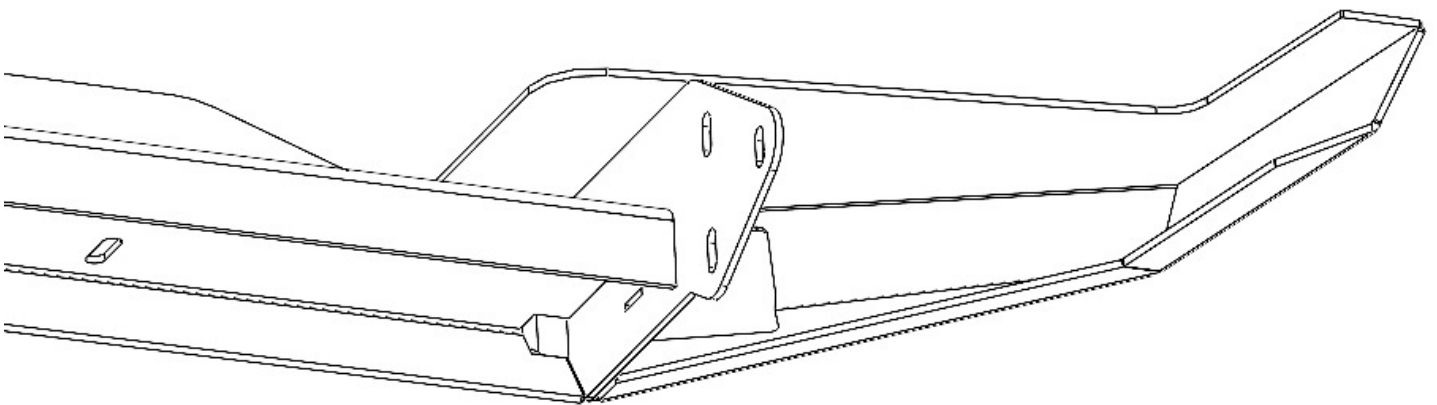
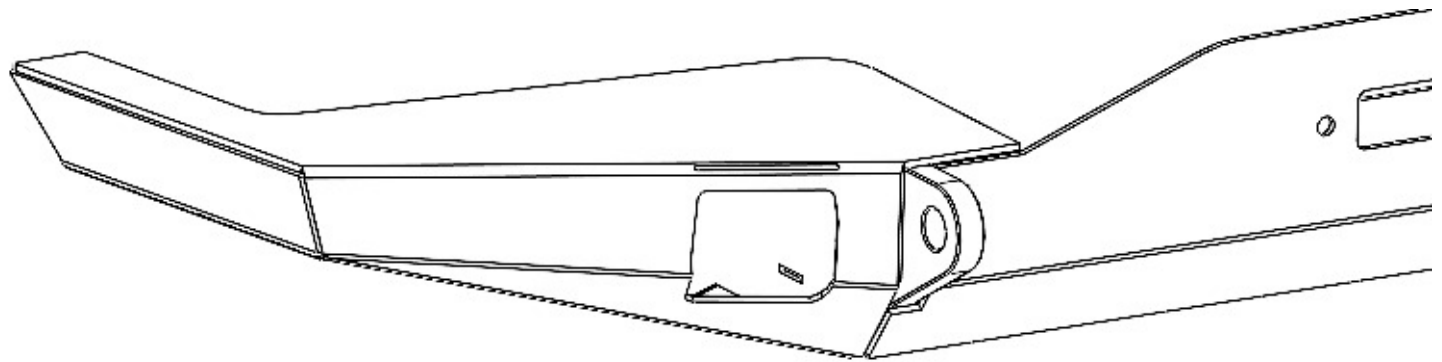
# ASSEMBLY

3. Now that the main piece is tacked together, it is now a good time to weld in the provided D-rings into place, as shown below. Be sure the back face of the D-ring is square to the cut out in the winch plate and the top face is level with the center section top face.



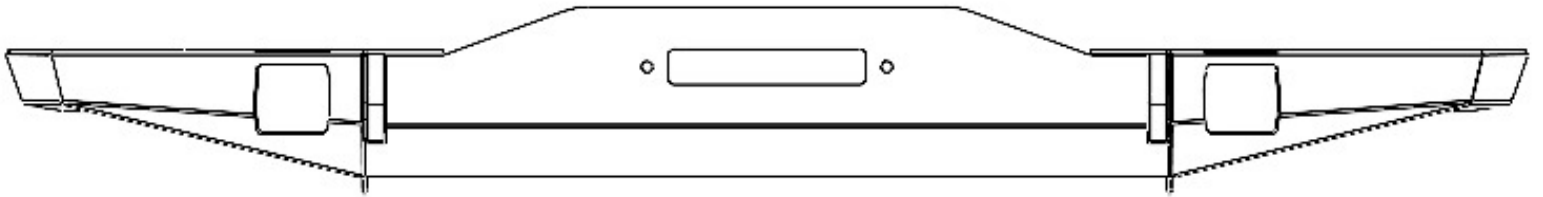
# ASSEMBLY

- 4a.** Once the D-rings are welded into place on the base, take the (2) supplied wing pieces for each side brackets and weld them onto the center section (as shown below), with the top face flush over the D-rings and nesting in the corner before it jogs up. The outside wing piece should nest and fit right into the other as long as the angles are correct. Once both wings are tacked on, you can loosely bolt it onto the truck to check alignment.



# ASSEMBLY

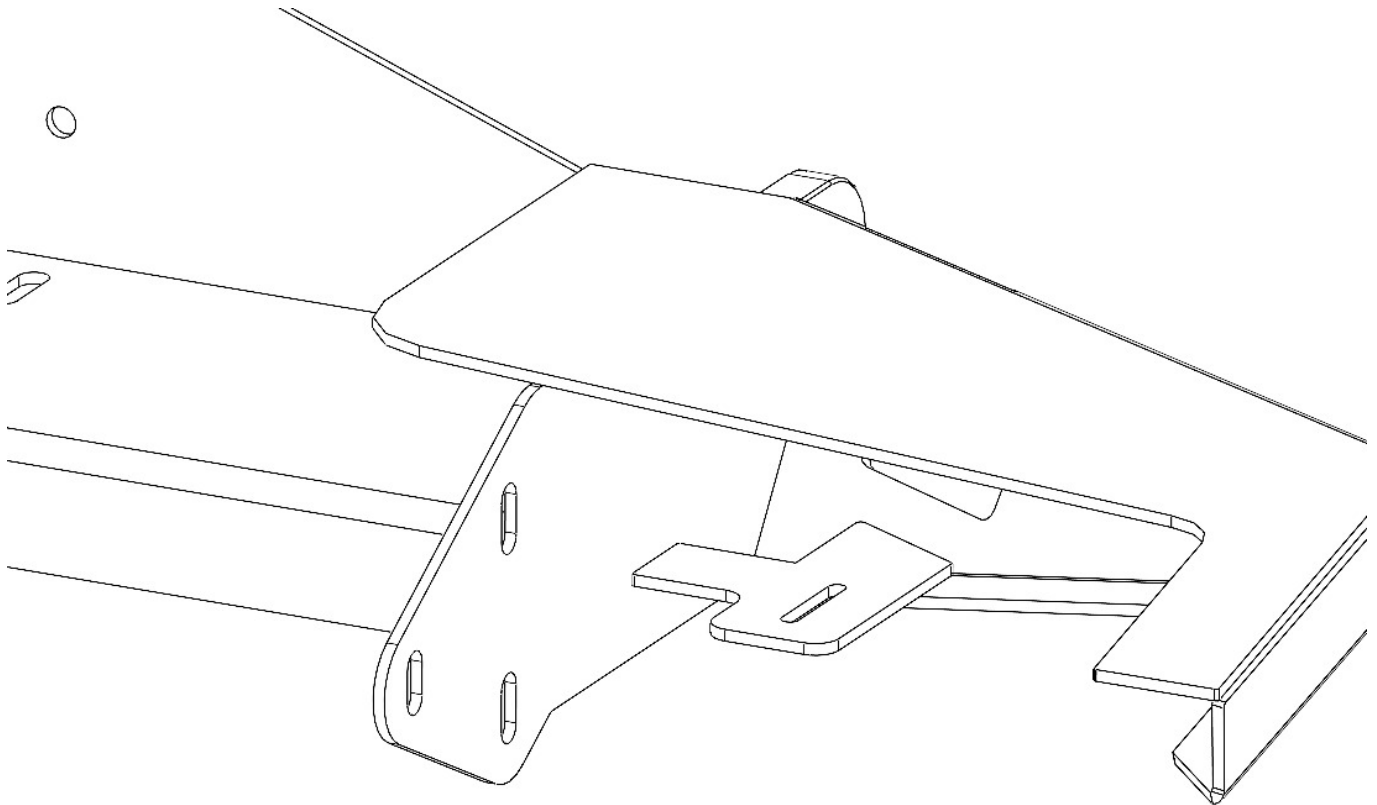
- 4b.** This is how your bumper should look at this point after both of the wings are tacked together and onto the rest of the bumper.





# ASSEMBLY

5. You can now choose to mount and weld the supplied cube light brackets into the bumper on both sides. There will be a tab on the outside of the part that fits into a hole on the inside of the bumper, as shown below, and the outside edge should match the angle of the wings. Once you have it in a good position, fully weld the bracket into place, repeat this on both sides of the bumper.



# ASSEMBLY

6. If you are happy with the look and alignment, you can now go though and fully weld the bumper to finish the assembly. You are now finished assembling your XJ DIY front bumper. At this time you are free to customize and set up the bumper to your liking, with a winch and cube lights etc. If you plan on doing any heavy winching, we recommend buying our unibody tie-in kit that can be found on our website [JCROffroad.com](http://JCROffroad.com), since the factory frame is not that strong. This will also include all hardware to install the tie-in kit and the bumper.

