

MJ DO-IT-YOURSELF REAR BUMPER ASSEMBLY INSTRUCTIONS

TOOLS NEEDED

- Welder
- Various Clamps
- Sander

OPTIONAL TOOLS

- Hammer
- Sawsall or grinder with cutting wheel

HARDWARE

(NOT INCLUDED)

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

Thank you for purchasing your new rear bumper from JcrOffroad! Checkout our website, www.jcroffroad.com for more deals and 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!

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.

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.

P The following will explain each part and the lingo we will be using throughout this assembly guide to explain which part.

MJDIY01: Bumper Face/ Center Section (1)

MJDIY05: Bumper Mounts part 2 (2)

MJDIY02: Bumper Wings (2)

MJDIY06: Hitch support (1)

MJDIY03: Side Caps (2)

DIY-DRT: Dring Tabs (2) (Might Vary)

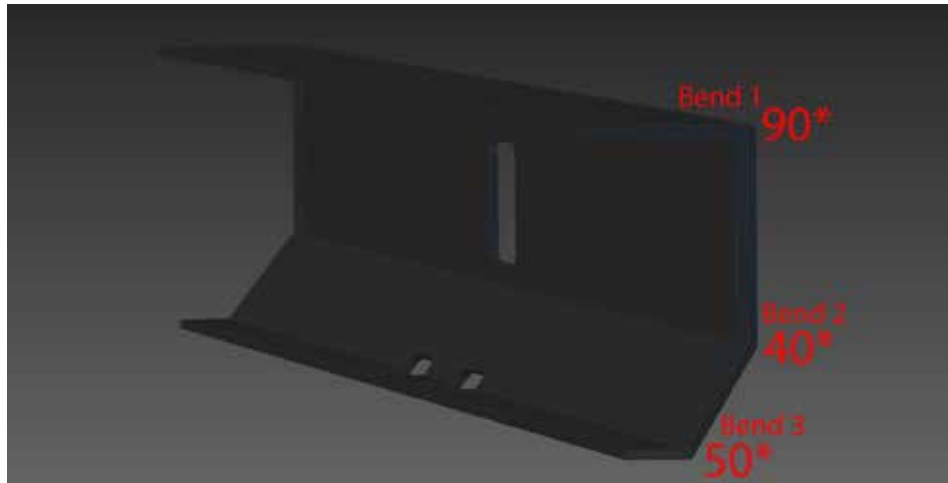
MJDIY04: Bumper Mounts part 1 (2)

DIY-RTUBE: Receiver Tube (Not Shown)



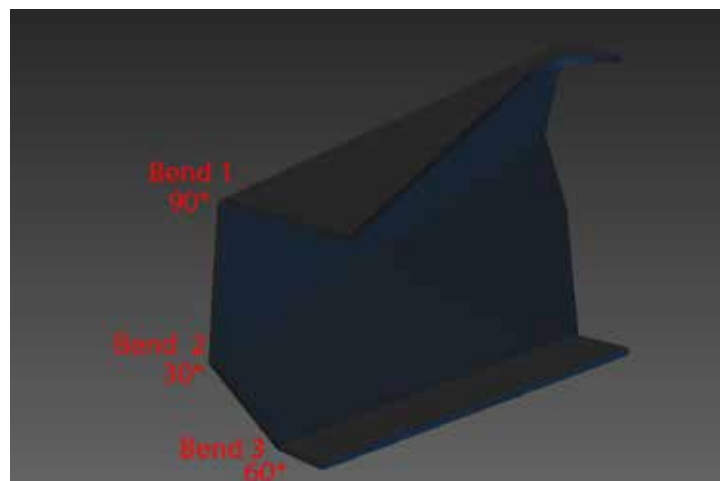
1 The first piece you will want to bend will be the (MJDIY01) Bumper Face / Center Section. You will be bending 3 angles. It doesn't matter which side you make the front face.

- A.) Clamping the Center Section to a table, bend up the first 90° angle. (Bend 1)
- B.) Re-clamp the Center Section and bend the second angle to 40°. (Bend 2)
- C.) Re-clamp the Center Section one last time and bend the last angle to 50°. (Bend 3)



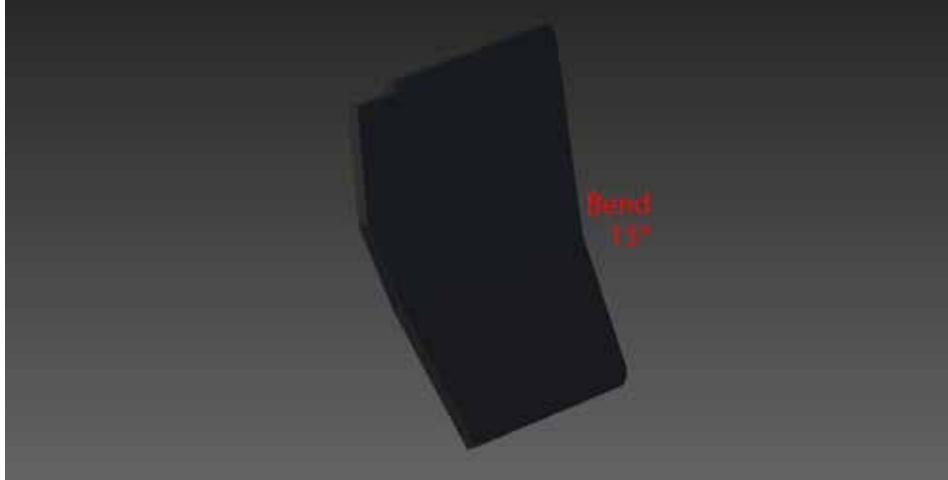
2 Set the bent Center Section (MJDIY01) off to the side. Next you will need to bend the two Bumper Wings (MJDIY02). *****You will need to bend a Right and Left, which will end up having two wings that are opposites.*****

- A.) Clamping the Center Section to a table, bend up the first 90° angle. (Bend 1)
- B.) Re-clamp the Center Section and bend the second angle to 40°. (Bend 2)
- C.) Re-clamp the Center Section one last time and bend the last angle to 50°. (Bend 3)



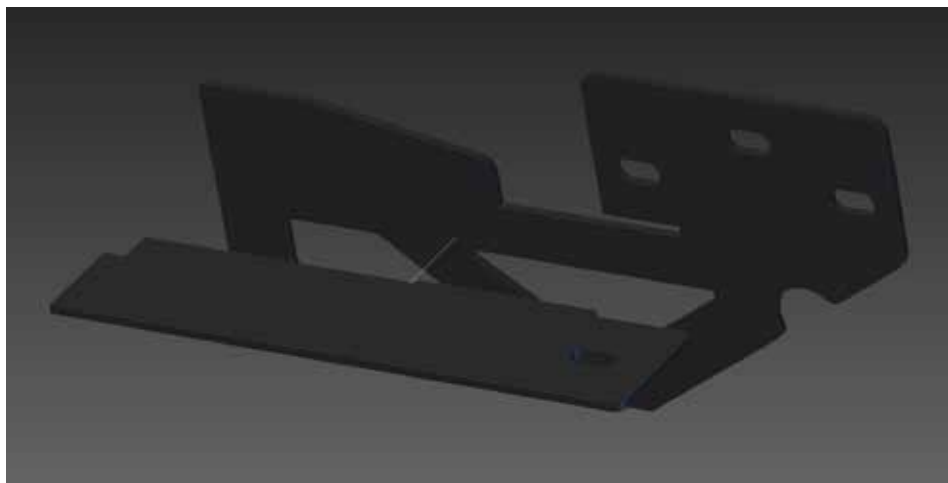
3 You will now be bending the two Side Caps (MJDIY03). *****You will need to bend a Right and Left, which will end up having two wings that are opposites.*****

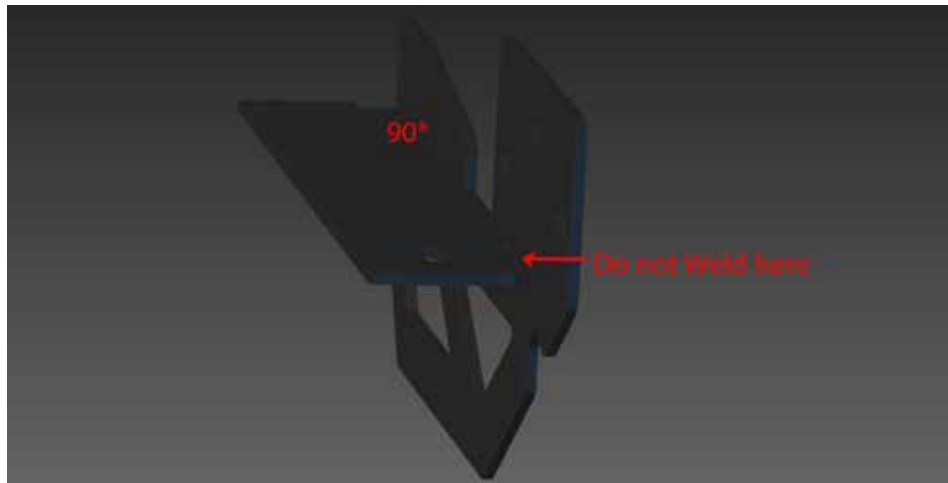
- A.) Clamping the wing to a table or in a vise, bend the Side Cap to 15*.
- B.) Repeat on the second Side Cap. (3)



4 With the main bumper parts bent, it's time to assemble the Bumper Mounts (1 &2) *****You will need to bend a Right and Left, which will end up having two wings that are opposites.*****

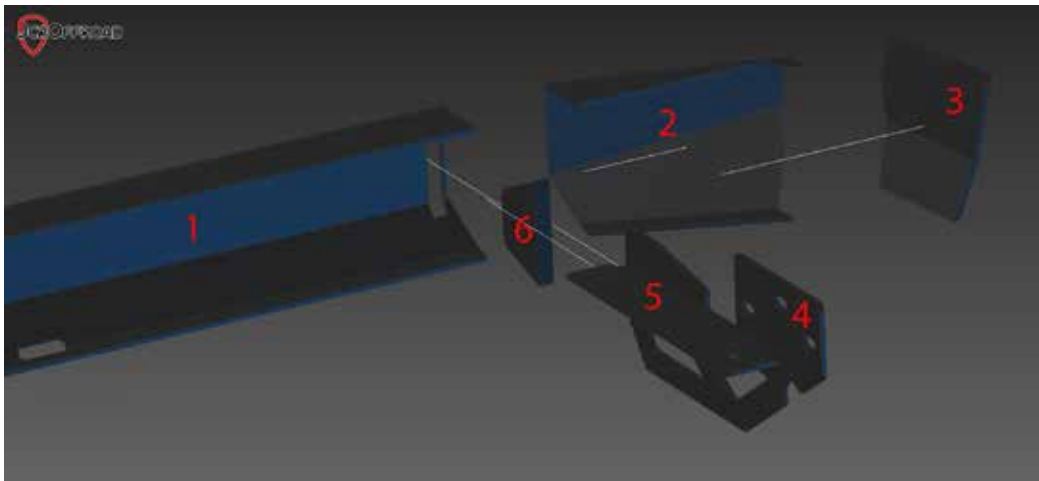
- A.) The main mount has a notch to accept the horizontal piece.
- B.) Tack each mount together and set off to the side.





5 With everything bent, it's time to start tacking everything together. It's best to weld and grind the shell of the bumper without the Dring tabs or Bumper mounts welded on first.

- A.) Laying the Center Section (MJDIY01) face down, tack weld the Bumpers Wings (MJDIY02) to the Center section.
- B.) Once the Bumper Wings (MJDIY02) are secure, tack weld the Side Caps (MJDIY03) to the Bumper Wings.
- C.) Weld and Grind the entire bumper before installing the Drings Tabs (6) or Mounts.



6 With the bumper Welded and ground, install the Dring Tabs (6) through the bumper from the back. The Tab will stick out the back about 1/2". Tack weld on the inside of the bumper, as the Bumper Mount will mount flush against the outside of the tab.

7 Slide the Bumper Mounts into place. You will notice a notch in the bumper mount to accommodate the Dring Tab (6). Tack weld the mounts into place, making sure they are square with the Center Section / Bumper Face (1)

8 At this point, it is recommended that you test fit the bumper on your Jeep.

9 If not installing the front hitch, you can weld the precut slots in the center of the bumper and grind them flat.

10 If you are opting NOT to install the Receiver 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 Receiver, please move onto the next steps

11 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.

12 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.

13 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)



14 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)

