



TJ/YJ/CJ DO-IT-YOURSELF FRONT 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 front bumper from JcR Offroad! 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.

SWBFDIY01: Bumper Face/ Center Section

SWBFDIY03: Bumper Wings (Stubby)

SWBFDIY02: Bumper Wings (51.5" width)

DIY-DRT: Weld in Shackle Tabs (Might look different)



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 down the first 90° angle. (see figure 1a)

b.) Re-clamp the Center Section and bend the second 90° angle. (see figure 2b)



2 Set the bent Center Section (1) face down on a table, verify the inside width at the mounts to be 4-1/8" on both sides. After the Center Section has been correctly bent, you can set it off to the side until later in the assembly process. (shown in figure 1c)



Each DIY Kit includes wings for a standard width bumper (~ 51.5 wide, Part 2) and stubby width (~ 41.5 wide, Part 3). If you are choosing to build a standard width bumper, follow the following steps. If you are choosing to build a stubby bumper, please advance to Step 4.

3 You will now be bending the two side wings (2). Both top and bottom will be bent to 90° angles. ***You will need to bend a Right and Left, which will end up having two wings that are opposites.***

a.) Clamping down the wing to the table, bend down the first 90° angle. Reposition, Re-Clamp and bend the second angle to 90°. If a vice is available, you may choose to use a vice instead of clamping to a table. (see figure 2a)

b.) Shown in Figure 2b, both angles have been bent to 90°.

c.) Once the top angle and bottom angle has been bent to 90°, you will now bend back the side piece to meet top and bottom lips. Fully bent wing shown in Figure 2c.

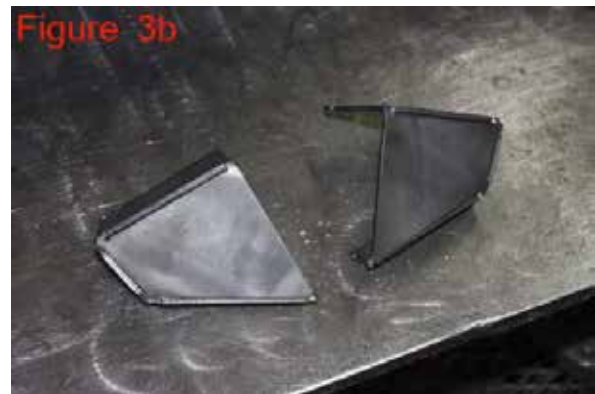


Each DIY Kit includes wings for a standard width bumper (~ 51.5 wide, Part 2) and stubby width (~ 41.5 wide, Part 3). If you are choosing to build a standard width bumper, follow the following steps. If you are choosing to build a stubby bumper, please advance to Step 4.

4 You will now be bending the two side wings (3). Both top and bottom will be bent to 90° angles. ***You will need to bend a Right and Left, which will end up having two wings that are opposites.***

a.) Clamping down the wing to the table, bend down the first 90° angle. Reposition, Re-Clamp and bend the second angle to 90°. If a vice is available, you may choose to use a vice instead of clamping to a table. (see figure 3a)

b.) Once the top angle and bottom angle has been bent to 90°, you will now bend back the side piece to meet top and bottom lips. Fully bent wing shown in Figure 3b.



- 5** Setting the Center Section on your work table, line up and tack weld the wings in place.
- a.) You may need to manipulate the bends slightly to get everything lined up. Be sure to adjust the wings to the center section and do not disturb the width of the center section.
 - b.) Standard Width Wings shown in Figure 4a.
 - c.) Stubby Width Wings shown in Figure 4b.



- 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.



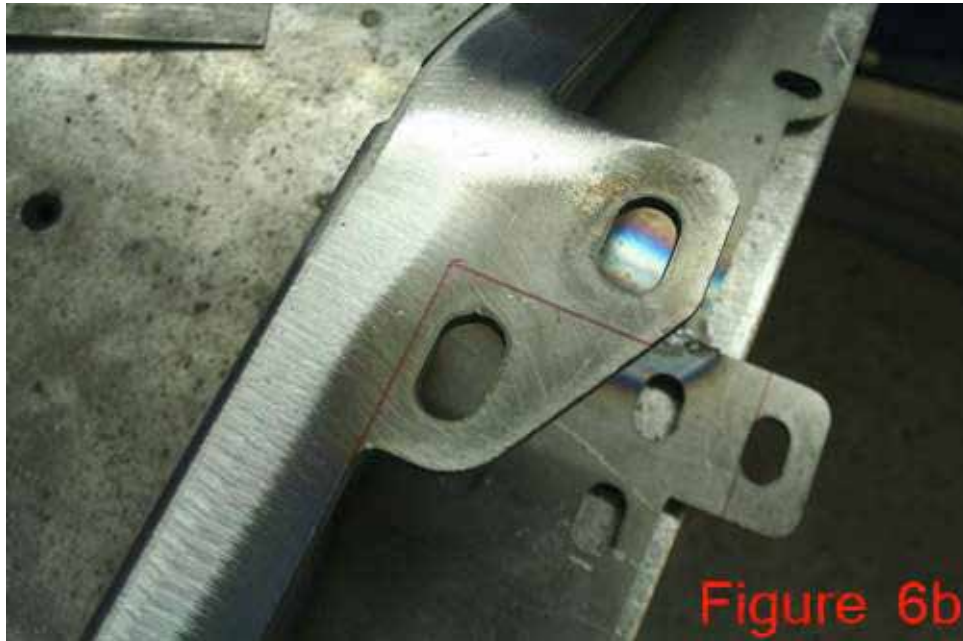
- 7** After the bumper has cooled off some, this is where we recommending doing the grinding.
You may want to do preliminary grinding here and finish grinding at the end, but the shell of the bumper is easier to grind before the dring tabs are welded in.

Modifications needed for mounting bumper to TJ or YJ. These kids are designed to work with a TJ, YJ or CJ, therefore, a couple of modifications need to be made to properly fit on each model.

- 8** Mounting on a Jeep TJ. The back tab will need to be removed from the top of the bumper mount to allow for proper installation on a TJ (marked in Figure 6a). This can be cut off using man number of tools; Sawzall, Angle Grinder or a Bandsaw.



9 Mounting on a Jeep YJ. The lower tab will need to be trimmed to allow for clearance with the front leaf spring shackles. The area needing trimmed is pictured in Figure 6b.



10 The final step to assembly is to weld in the shackle tabs. Our tabs (which we use for all of our products) are slightly larger than the bumper faces on our DIY SWB bumpers. Therefore, you will need to center the tab top to bottom (shown in Figure 7a) or you can choose to grind a little off the top and bottom. We recommend that you weld the tab front and back.



11 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.

