



TJ/YJ/CJ 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 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.

SWBRDIY01: Bumper Face/Center (1)

SWBRDIY05: Lower Frame Mounts (2)

SWBRDIY02: Bumper Wings (2)

DIY-DRT: Weld in Shackle Tabs (2)

SWBRDIY03: Universal Bumper Mounts (2)

DIY-RTUBE: Receiver Tube (Not Shown)

SWBRDIY04: Hitch Reinforcement (1)



1 The first piece you will want to bend will be the (01) 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 1b)



Figure 1a



Figure 1b

2 Set the bent Center Section (01) off to the side. You will now be bending the two side wings (02). 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.) 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 2b.



Figure 2a



Figure 2b

3 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.



4 With the bumper tacked together, it is now time to fully weld the bumper together. We recommend welding the back side first.

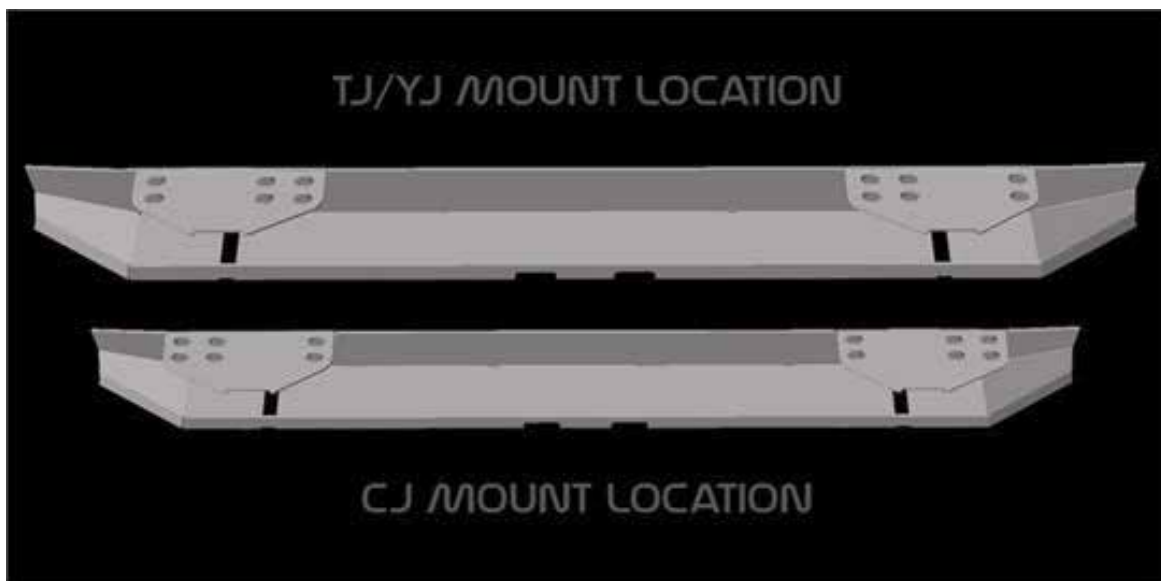


5 After the bumper has cooled off some, this is where we recommending doing the grinding. You may want to do preliminary grinding here and finish grinding at the end, but the shell of the bumper is easier to grind before the dring tabs are welded in.

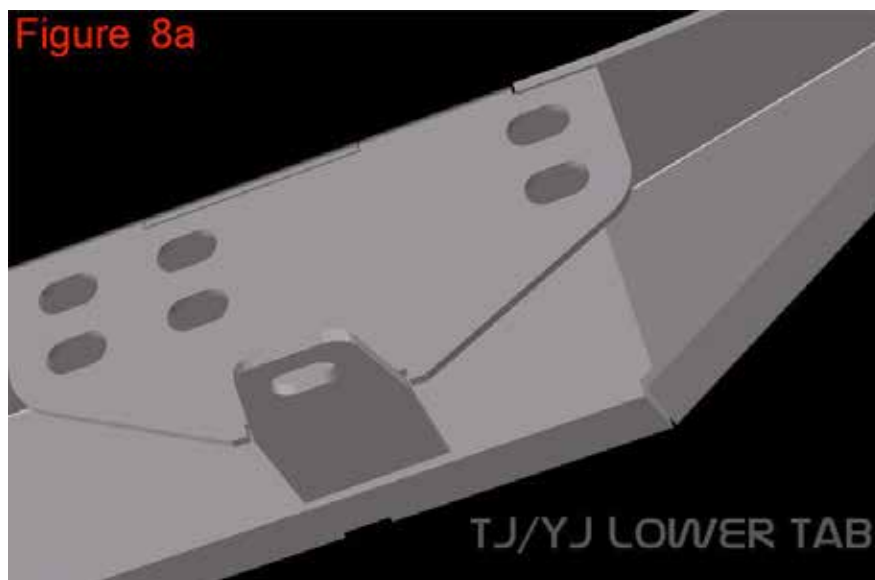
6 After the bumper has been grounded, it's now time to weld on the Shackle Tabs (DIY-DRT). Our tabs (which we use for all of our products) are slightly larger than the bumper faces on our DIY SWB bumpers. Therefore, you will need to center the tab top to bottom (shown in Figure 7a) or you can choose to grind a little off the top and bottom. We recommend that you weld the tab front and back.

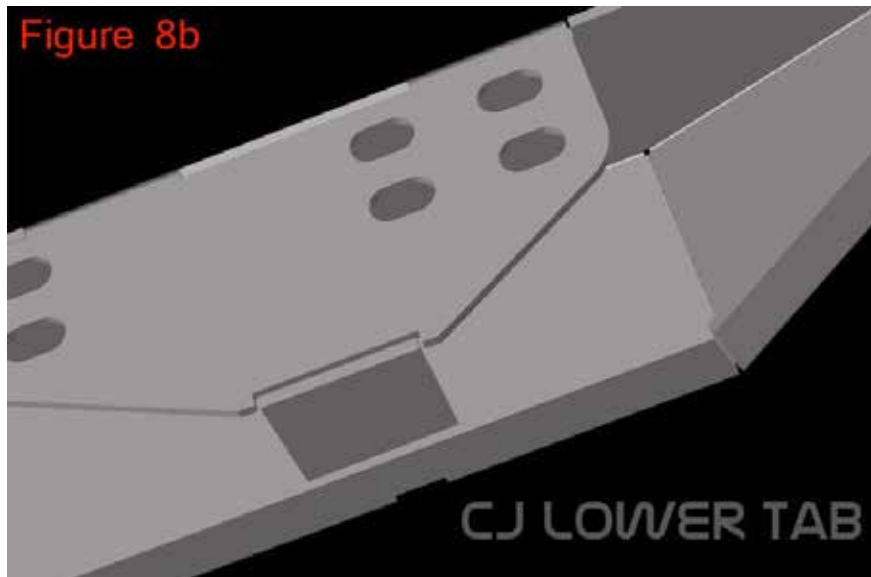


Setting up the Mounts for TJ/YJ or CJ. These kits are designed to work with a TJ, YJ or CJ. Included in this kit are universal mounts that will fit both TJ/YJ and CJ. Look very carefully at the diagram below to see how to properly set up your DIY bumper to fit your Model Jeep.



- 7** The Lower Frame Mounts (04) will be installed along with the Universal Bumper Mounts (03). Lower Tab mounting for TJ/YJ shown in Figure 8a. Lower Tab mounting for CJ shown in Figure 8b. The Universal Mounts need to be flush with the top edge of the bumper. This will leave a gap on the top of the bumper to butt weld them together. (Shown in figure 8c)





- 8** With the mounts square, you may want to test fit the bumper to ensure a good fit. Once you are sure everything is square and correct, you can weld the mounts in permanently. The Lower tabs get welded to the bumper and to the Universal Mounts. The Universal mounts get welded to the top of the bumper and weld the back of the top edges of the brackets to the bumper.

- 9** 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.