

JEEP CHEROKEE DIY WINCH BUMPER ASSEMBLY INSTRUCTIONS

HARDWARE

XJDIY01: Center Section/ Front Face

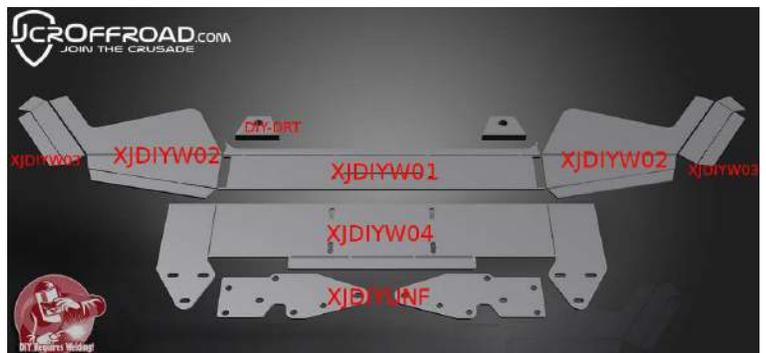
XJDIY02: Side Wings

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.

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

Thank you for purchasing your new DIY 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!

1 The first piece you will want to bend will be the (1) front Center Section. You will be bending one 90° angle. 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 (2) off to the side. Next you will need to bend the Winch Plate and Mounts (1) There will be three bends, all will be bent to 90°.

A Clamp the bumper to the table to bend one of the bumper mounts. Bend up the first mount to a 90° angle. Bend the other mount up to a 90° angle. (see figure 2)

B The last bend will be the 1" flange on the back of the winch plate. Bend up to 90°.



3 Set the bent Winch Plate (1) off to the side. Next you will need to bend the two Bumper Wings. 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 3)

B Repeat on the second Bumper Wing



4 You will now be bending the two Side Protection parts (4). 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(s) 4, 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.



5 With all the parts bent, you will now start to tack the bumper together. First you will want to tack together the Winch Plate (1) and Front Center Section (2).

A The bend on the Center Section (2) will be the top of the bumper.



6 With the center of the bumper tacked together, you will now tack on the outer Wings (3)

A Lay the center of the bumper top down on the table. Lay out the right and left Bumper Wing face down on each end. (Figure 6a)

B Position one wing to the center section and tack weld it in place. (Figure 6b) Repeat on other side.



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

7 Once you have the wings tacked on, carefully flip the bumper over. With the bumper right side up, you will need to position the top of the Bumper wings and tack them in place



8 The next parts to be tack on will be the Side Protection caps (4). Clamp the caps to the bumper and tack weld each side (Figure 8)



- 9** After every part is securely tacked , it would be wise to test fit the bumper on your Jeep before final welding, grinding, and finishing.



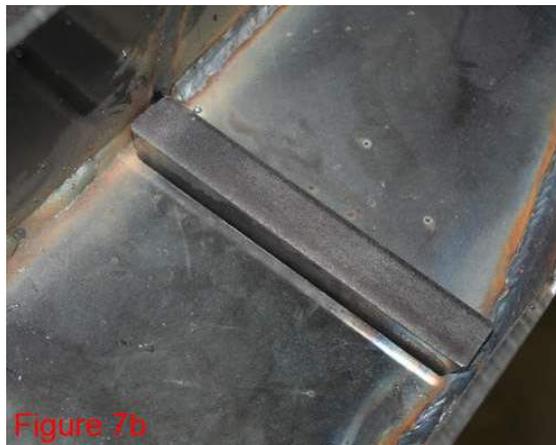
- 10** With the bumper tacked together and fit checked, it is now time to fully weld the bumper together. We recommend welding the back side first.

11 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 d-ring tabs are welded in.

12 With the bumper welded together and ground, it is now time to install in the D ring tabs.

A Insert the tabs from the back (Figure 7a) 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 7b)

B Once the alignment of the tabs is verified, weld them completely front and back.



The Front Uniframe Reinforcement kit will need to be installed before installing the bumper. Without the additional plates, the bumper mounts will be too wide for the front factory frame rails. If you have your own or another brand of Uniframe tie in brackets, you will need to remove the front three bumper mounts in order to install the bumper.