

JEEP CHEROKEE XJ DIY REAR BUMPER ASSEMBLY INSTRUCTIONS



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

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

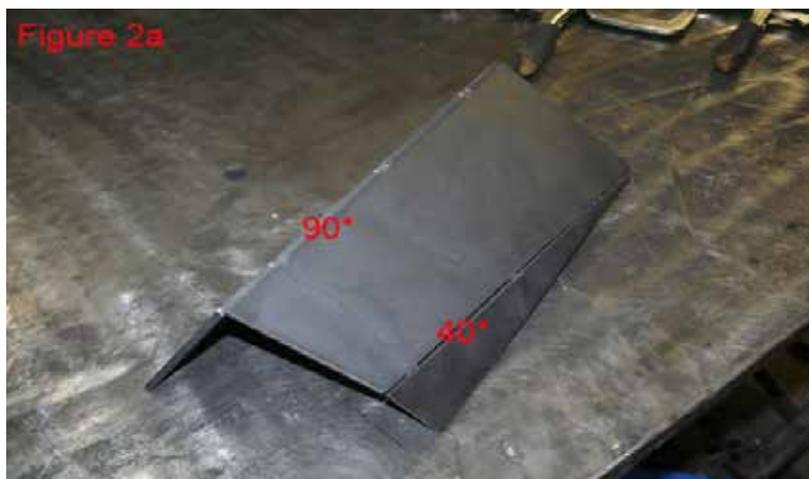
B You may can clamp it either way, figure 1b shows the other option.



2 Set the bent Center Section (1) off to the side. Next you will need to bend the two Bumper Wings (2). The Top bend will be at 90* and the bottom at 40*. ***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 bottom to a 40* angle. (see figure 2a)

B Repeat on the second Bumper Wing.



3 You will now be bending the two Side Caps (3). There is only one angle to bend and it's at 20*.

*****You will need to bend a Right and Left, which will end up having two side caps that are opposites.*****

A If available, it's best to bend these in a vice. Clamping as shown in Figure 3a, you will bend the part to 20*.



4 The next parts to be bent will be the filler caps for under the tail lights, part #4. *****You will need to bend a Right and Left, which will end up having two caps that are opposites.*****

A The long side is bent at 70* and the short side is bent at 60*.

B It's best to bend these in a vice, but you can also clamp them to a table if a vice is not available.



- 5** With all the bumper parts bent, the last thing to bend will be the rear bumper mounts. These mounts require four 90° bends. *****You will need to bend a Right and Left, which will end up having two mounts that are opposites.*****



- 6** After both mounts have been bent, you can tack the mounts together and weld them solid. Be sure that you have your angles right at 90°! If the mount is not square, mounting your bumper square will be an issue.



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

- 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.



- 8** With the bumper welded together and ground, it is now time to tack in the Dring tabs (7).

A Insert the tabs from the back (Figure 7b) and tap them into place with a dead blow

B Only tack the Dring tabs on the inside (towards the middle of the bumper). The mounts are next to go on and they will be butting up to the tabs.



9 With the shell of the bumper tacked together, it's now time to weld it completely.

A The bumper below shows the receiver already installed, you will notice that we don't show installation until the last step of the instructions. You may choose to skip ahead to get it installed, or wait until later in the process.



Figure 8

10 After the bumper has cooled off some, this is where we recommend 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.



Figure 9

- 11** After finish grinding the bumper, you can now install the under tail light caps (4). In order to get them to sit flush and correct, the bumper needs to be ground. After tacking each side into place, you will now fully weld them in place. Once you finish welding, grind the exposed welds.

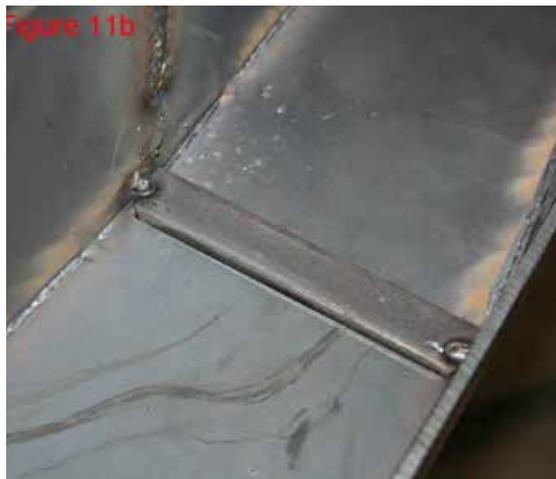


- 12** With the bumper welded together and ground, it is now time to tack in the Dring tabs (7).

With the bumper welded together and ground, it is now time to tack in the Dring tabs (7).

A Insert the tabs from the back (Figure 11a) and tap them into place with a dead blow hammer. The tabs will stick up around 1/8" in the back. This is correct. (Figure 11b)

B Only tack the Dring tabs on the inside (towards the middle of the bumper). The mounts are next to go on and they will be butting up to the tabs.



13 The Bumper Mounts (5) will now need to be tacked into place before you can fully weld in the Dring Tabs (7) that were tacked in the previous step.

A Make sure the Bumper Mounts are on the **OUTSIDE** of the Dring Tabs. Make sure they are **SQUARE** with the front of the bumper. (Figure 12)

B The Measurement between the mounts should be 31”.



Figure 12

14 If you choose, you can test fit your bumper at this point.

15 After verifying the fit on your Jeep, you can now completely weld the Dring Tabs and Bumper mounts to the bumper. The Dring Tabs need to be welded to the bumper mount and the bumper on the back.

16 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.

15 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.

16 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)



17 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)

