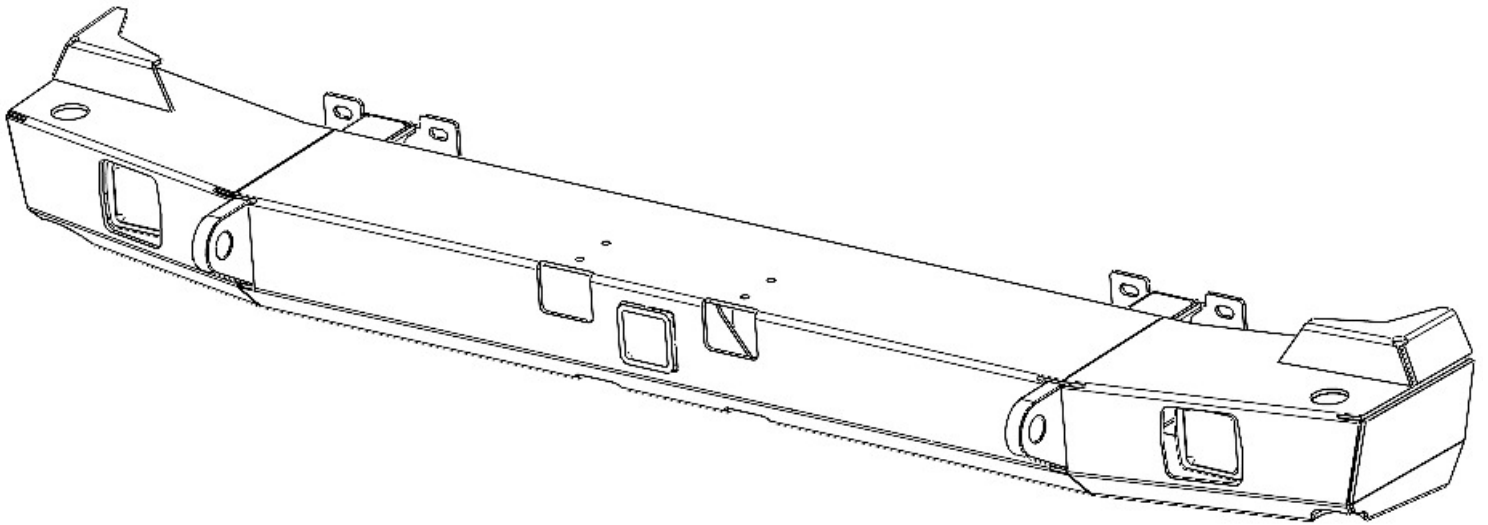




# JEEP CHEROKEE XJ

# DIY REAR BUMPER

## INSTALL INSTRUCTIONS



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

**Be sure to check out the install video on the product page, if available.**

Thank you for purchasing from JCR Offroad! Checkout our website, [victory4x4.com](http://victory4x4.com) for 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!

# INCLUDED HARDWARE

## INCLUDED BOLT PACK(S) N/A

Note: Hardware is not supplied, and will require customer to supply their own hardware.  
Below is a list of hardware you will need.  
However, if you plan to purchase our unibody tie-in kit this will include all hardware needed to install the tie-in kit and the bumper (recommended for heavy winching).

**4x** 7/16" x 1.5" Hex Bolts

**4x** 7/16" Nuts

**10x** 3/8" Washers

**2x** 10mm x 30mm Hex Bolts

# INCLUDED PARTS

**1x** #1 Center Section

**2x** #2 Frame Mounts

**2x** #3 Top Bumper Corner Piece

**2x** #4 Wing Piece

**2x** #5 Outside Wing Piece

**2x** D-Rings

**2x** Cube Light Brackets

**1x** Hitch

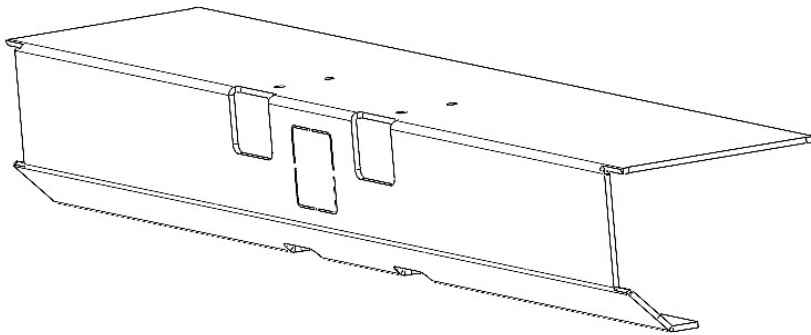
**1x** Hitch Bracket

**2x** Spindle Sleeve

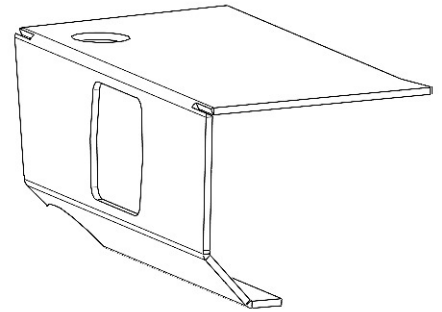
# ASSEMBLY

1. Before you start, bend all of your parts that need bent on the slit lines. Below you will see each part and how they should look after they are bent. Each of the parts will have the bend angle etched on the slit line for each bend.

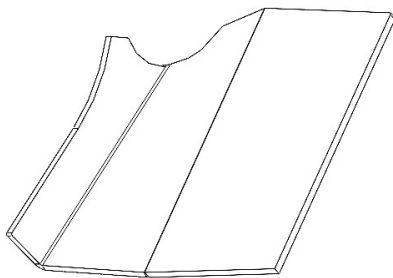
**1x**



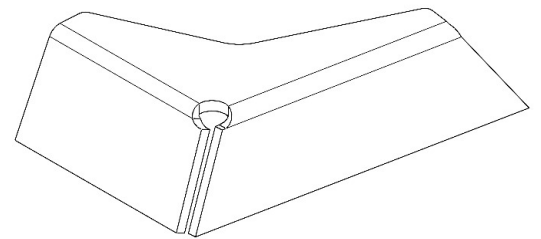
**1L&1R**



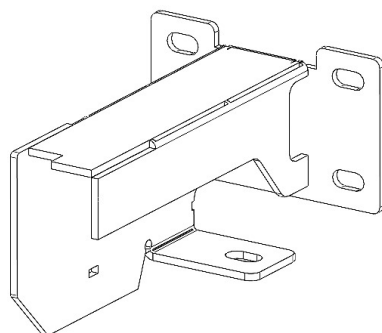
**1L&1R**



**1L&1R**

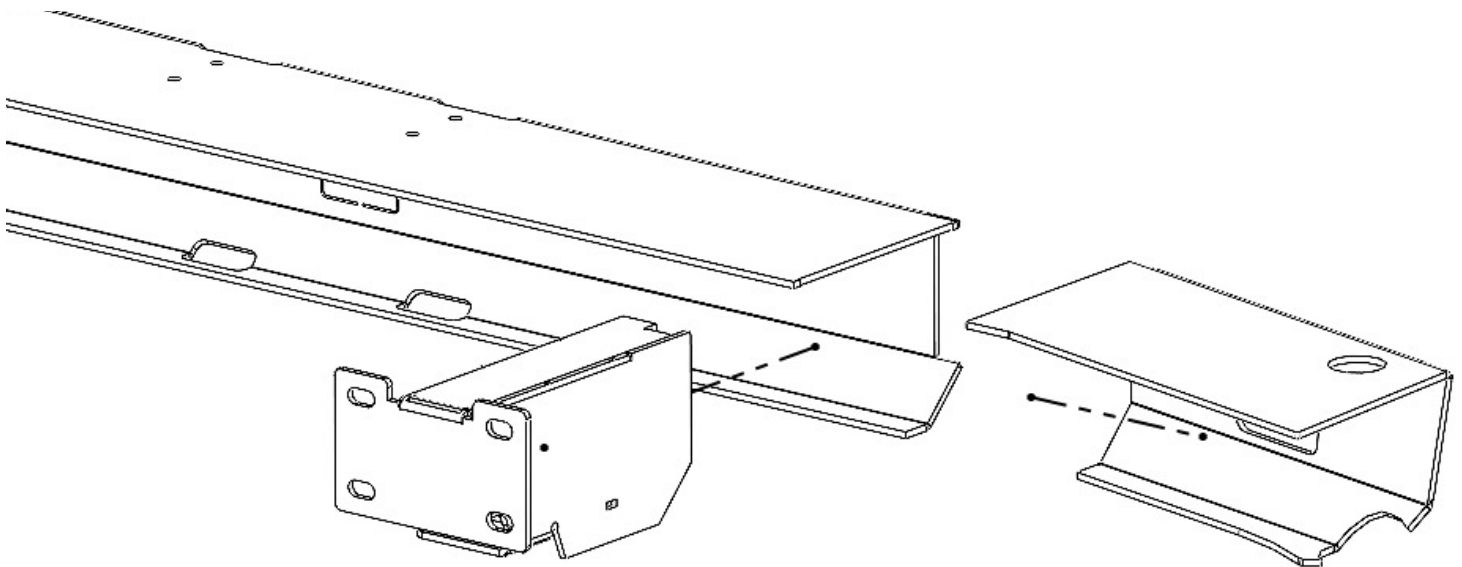


**1L&1R**



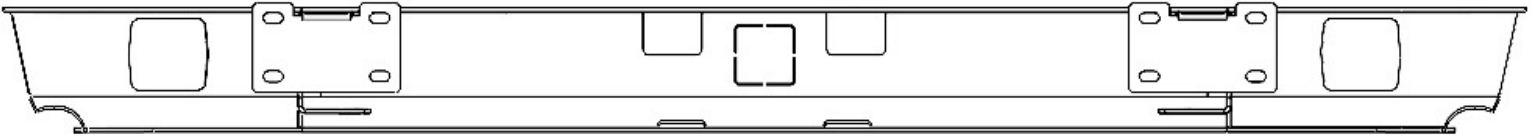
# ASSEMBLY

2. Before fully welding the heavily tact pieces together, we recommend you solidly tack the majority of these parts together incase you need to adjust or change anything. Take the (4) provided pieces as shown below, (2) per side, and weld them into the formation shown, aligning the profiles and angles to one another. Also be sure to leave a gap as shown below to add in the D-rings later. Weld the seams and make sure everything is level and square.



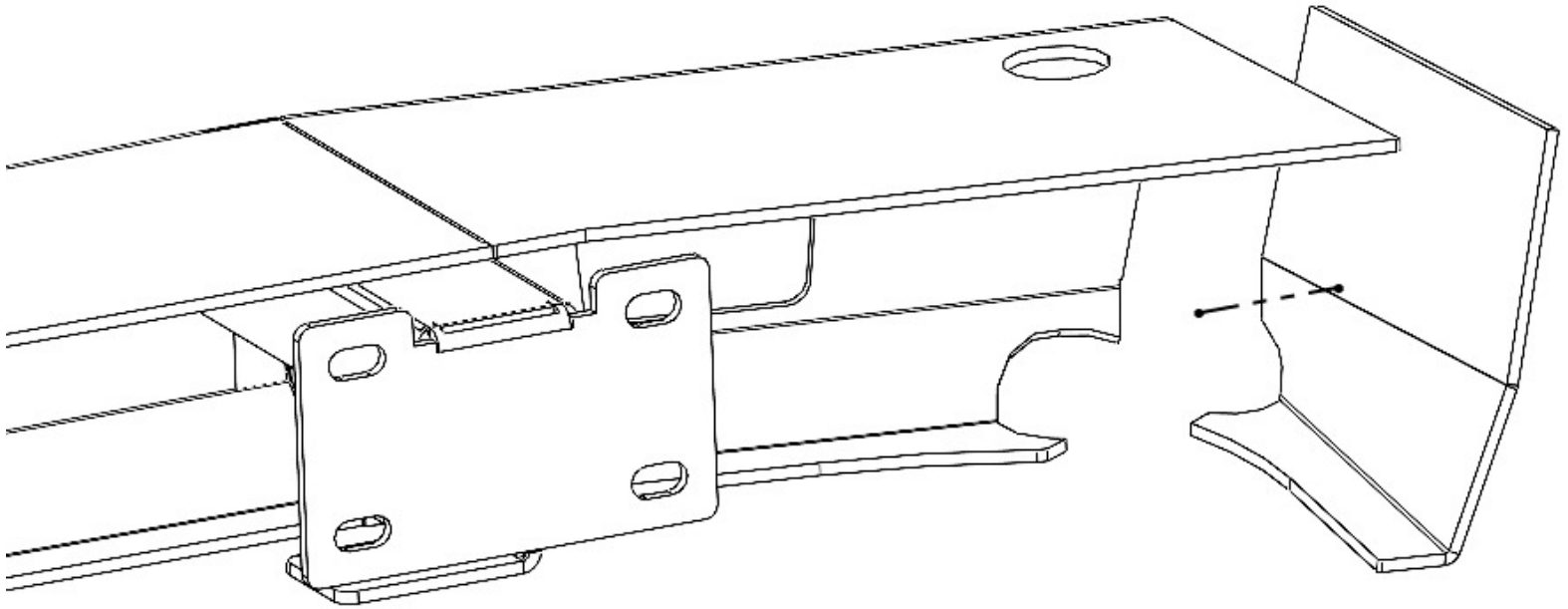
# ASSEMBLY

- 2b.** How it should look after the (2) pieces are tacked to both sides of the bumper, (4) in total (viewing from the back inside of the bumper).



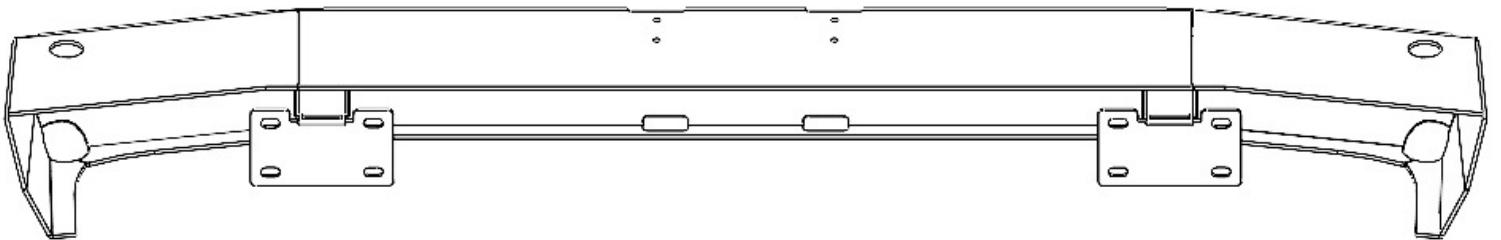
# ASSEMBLY

- 3a.** With the frame mounts and inside wing pieces in place, take the outside wing pieces and tack them into place, as shown below. Make sure to do this on both sides of the bumper.



# ASSEMBLY

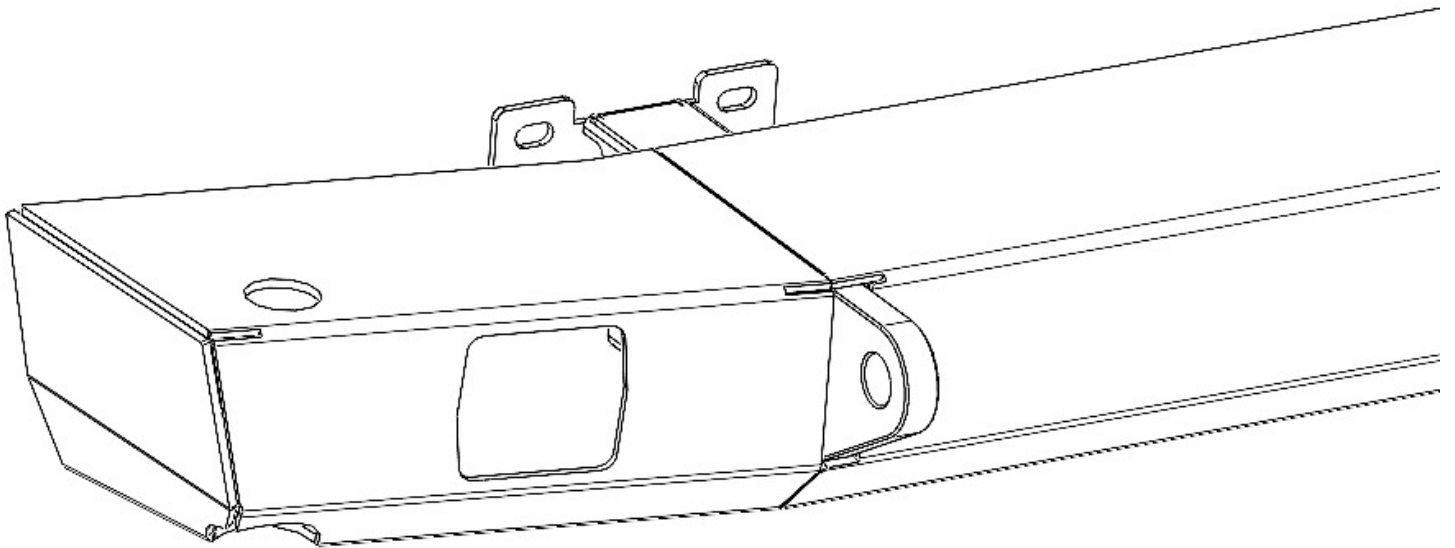
- 3b.** This is how your bumper should look at this point after both of the wings are tacked together and onto the rest of the bumper.





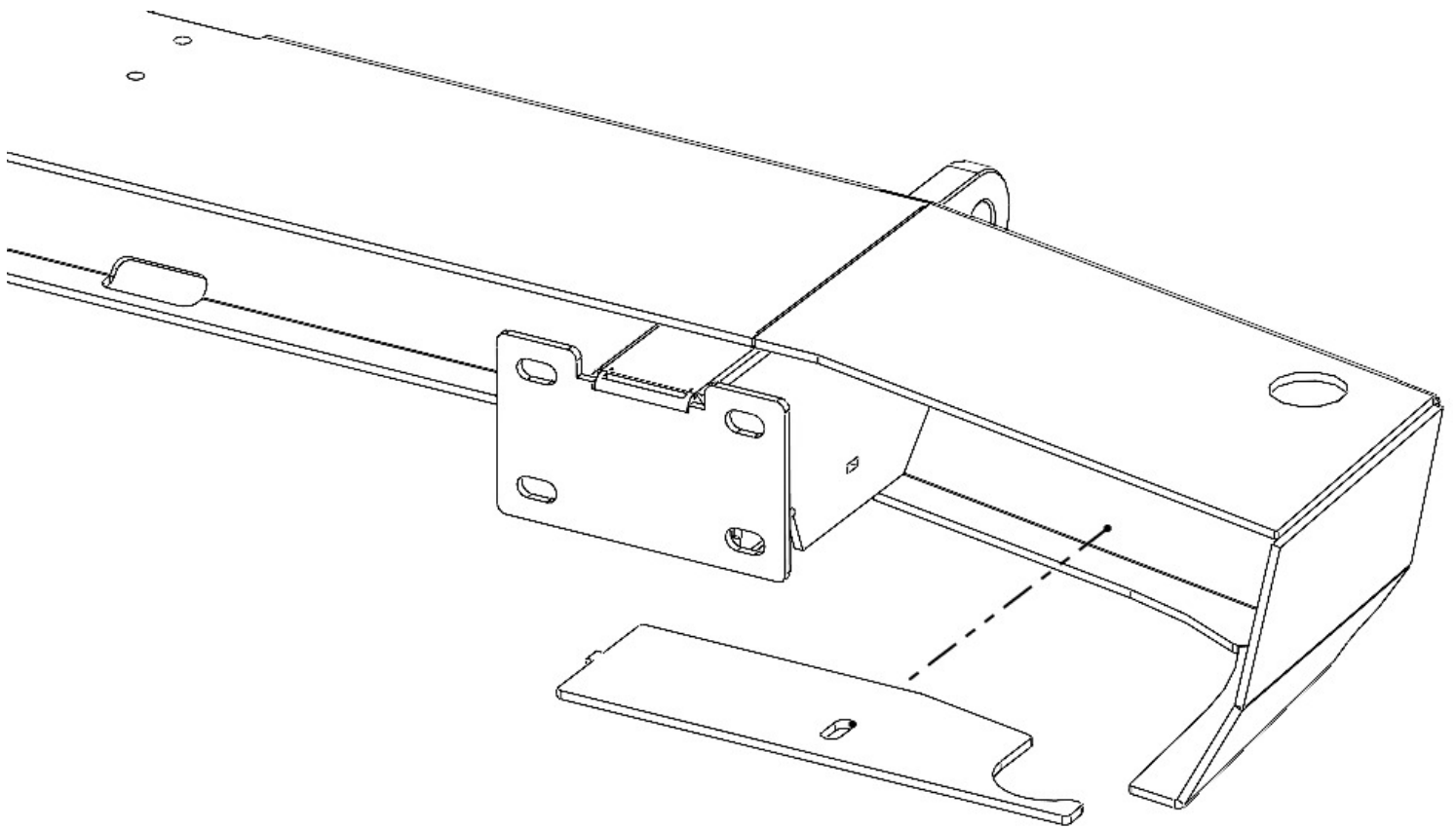
# ASSEMBLY

4. You can now weld in the D-ring shackles into each side of the bumper, as shown below. These will need to be inserted in through the back. Before fully welding into place, make sure everything is square and the shackle is out as far as possible in the slot.



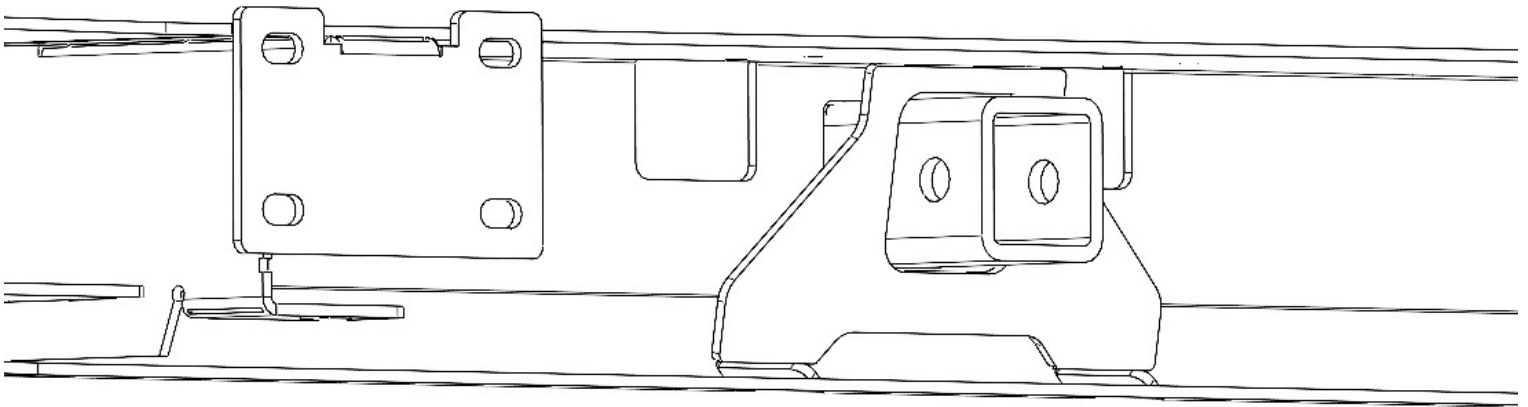
# ASSEMBLY

5. At this point, bolt the bumper onto the truck to check and verify alignment and fitment with the body and make sure there are no crazy gaps. If you are happy with the look and alignment, you can now go through and fully weld the bumper together. After welded, take the provided tie-ins and light mounts and weld them into place, as shown in the location below. There will be a tab on the end of the bracket that will slot into the frame mount, and then make sure the back face is flush with the inside of the bumper face.



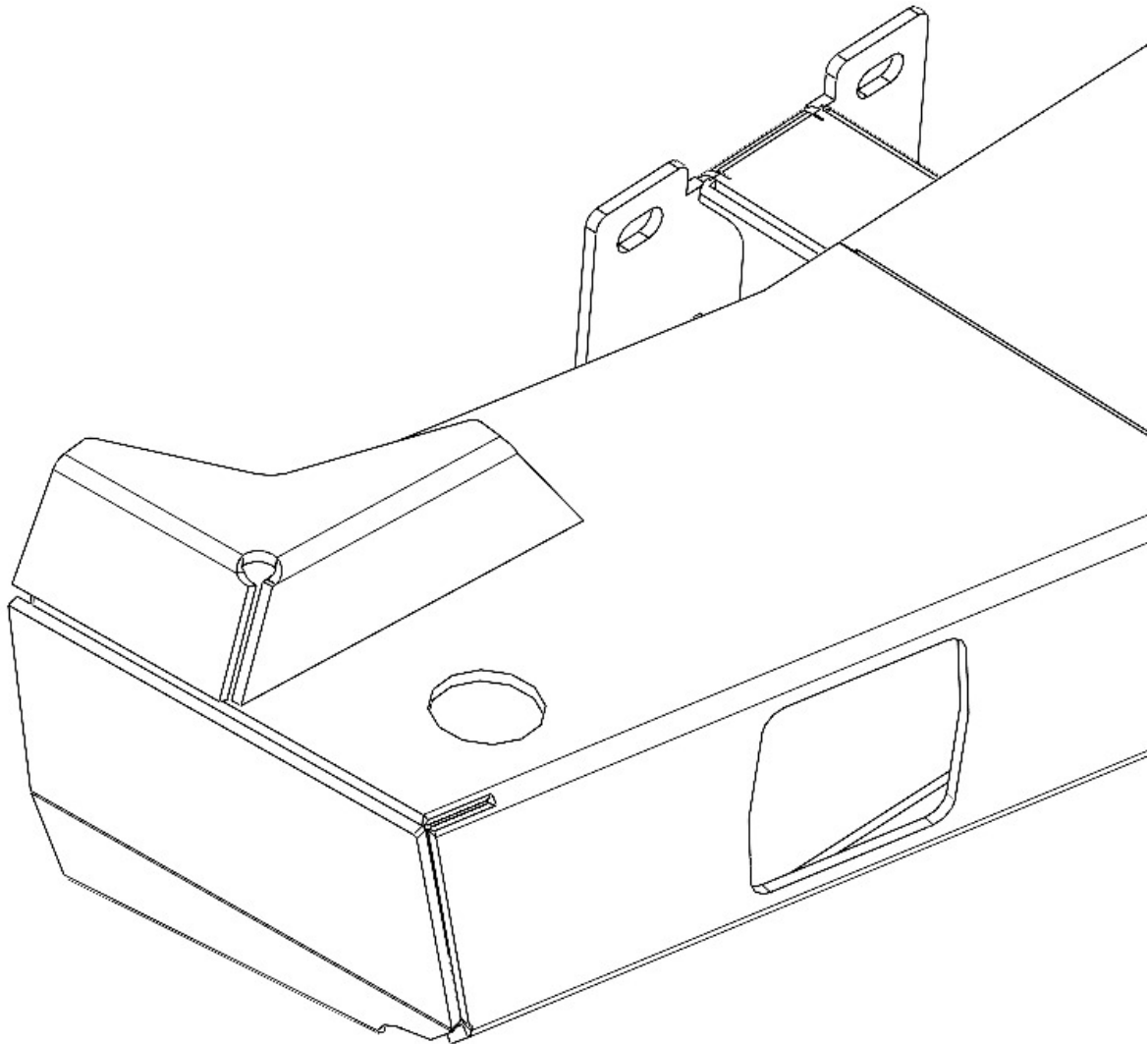
# ASSEMBLY

6. If you plan on adding a hitch, cut out the hitch hole and take the provided hitch and hitch bracket and weld them into place as shown in the orientation below (shown from the inside of the bumper). You only want about 1/4"-3/8" of the hitch sticking out of the front of the bumper, and the bracket will be welded on an angle, with the bottom legs right above the holes.



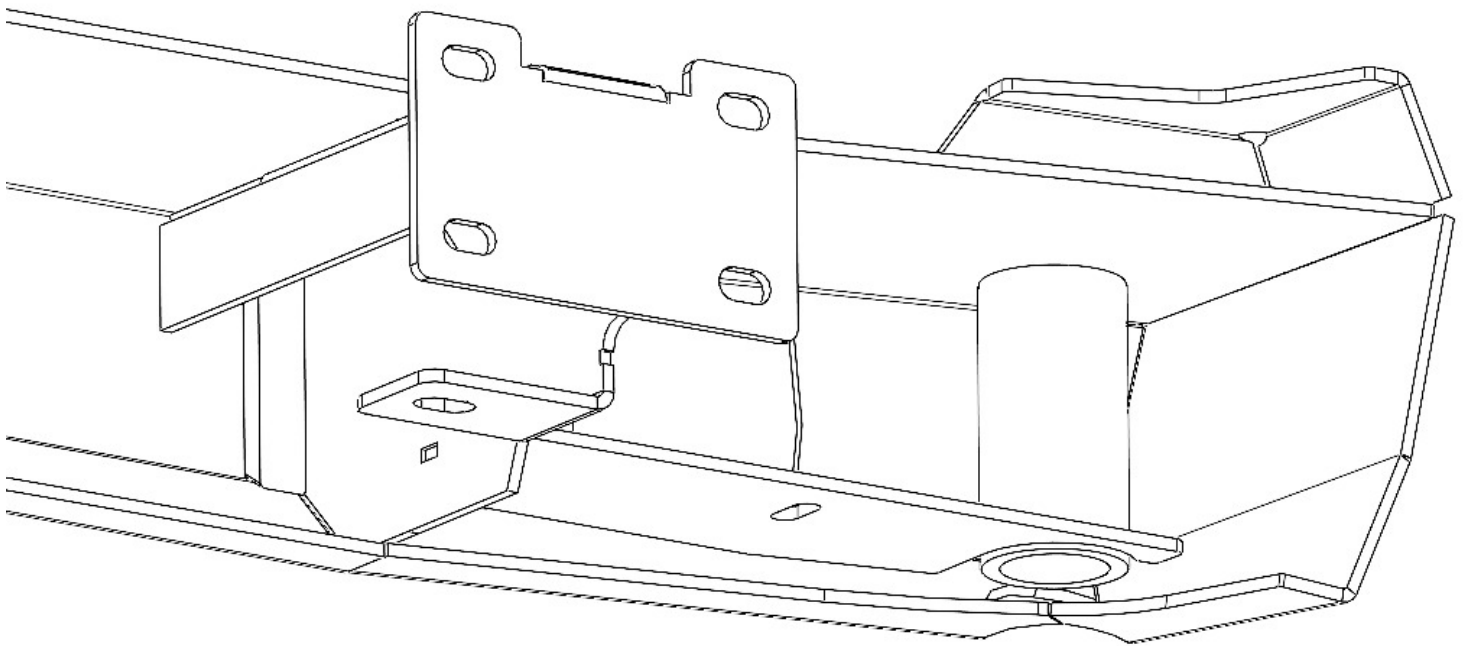
# ASSEMBLY

7. Bolt the bumper back onto the truck and take the provided corner pieces and weld them to the bumper using the truck as a guide to make the body line as best as possible. Once you are happy with the look and alignment, fully weld them into place on both sides of the bumper.



# ASSEMBLY

8. If you plan on running a carrier, you will need to weld in the provided spindle sleeves into the corner of the bumper (depending on which side carrier you will be running). Make sure the top of the spindle sleeve is flush with the bottom face of the bumper, as shown below, and the sleeve itself is concentric with the hole cut into the top face on the bumper. Fully weld into place once you are happy with the alignment.



# ASSEMBLY

9. If you are happy with the look and alignment of the bumper, make sure everything is fully welded to finish the install and assembly. You are now finished assembling your XJ DIY rear bumper. At this time you are free to customize and set up the bumper to your liking, with cube lights or a tire carrier etc.

