



Assembly Instructions For

1999-2004 WJ Jeep Rear Bumper Kit

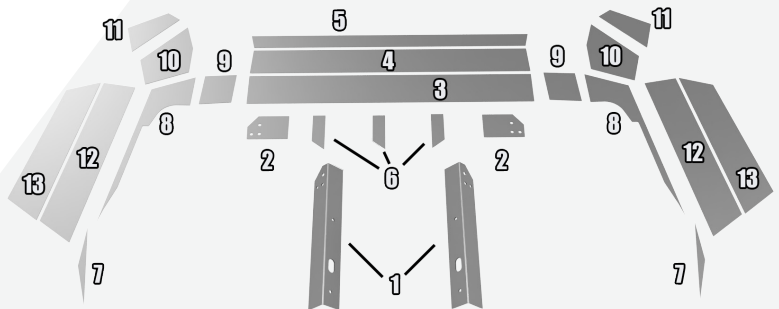


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Assembly Instructions For 1999-2004 WJ Jeep Rear Bumper Kit

- Mounting Bracket Assembly
- Right Angle Mounting Braces
- Mounting Brackets
-
- Center Section Assembly
- Top Center Filler Plate
- Middle Center Plate
- Bottom Center Filler Plate
- Center Section Gussets
-
- Wing Section Assembly
- End-cap Wing Section Plates
- Top Wing Section Filler Plates
- Top Wing to Center Section Filler Plate
- Middle Quarter Panel
- Bottom Quarter Panel
- Middle Wing Side Panels
- Bottom Wing Side Panels



99-04 WJ REAR BUMPER KIT

These WJ rear bumper kits are great for the "Do It Yourself" off road enthusiast who wants to fabricate their own off road bumper. Choose the standard rear bumper kit or the tire carrier version.

This DIY kit comes with all the steel needed to construct the rear bumper along with 3"x3"x3/16" mounting rail with holes and cut outs for right and left sides.

* The rear tire carrier ready bumper is designed to be used with a double sheer spindle or hinge.

PARTS LIST

TOOLS NEEDED

- 1/2" Metal Drill Bit
- Hand Drill
- Welder
- Grinder

HARDWARE INCLUDED

- 10x 1/2-13 x 1.500"
- Grade 5
- 10x 1/2" Lock Washers
- 6x Flat Washers

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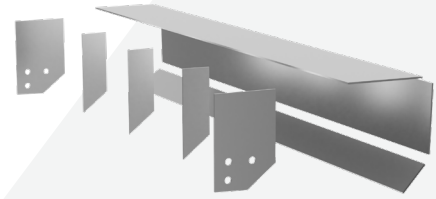
ATTENTION: REVIEW INSTRUCTIONS BEFORE INSTALLING 99-04 WJ REAR BUMPER KIT

STEP
1

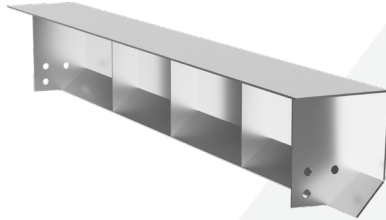
Remove the stock bumper from the frame.

STEP
2

Tack weld the center section plates to the mounting brackets



STEP
3

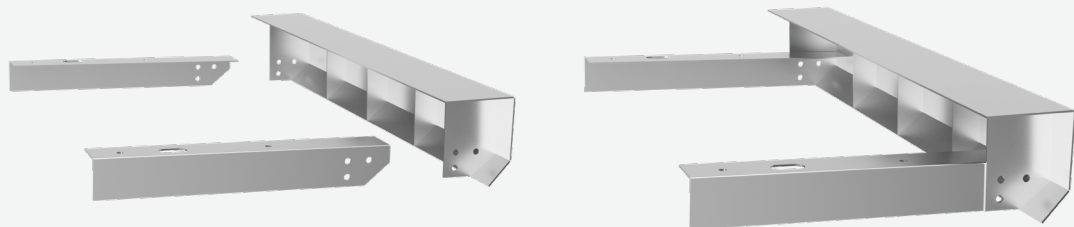


Tack weld center section gussets between the two mounting brackets.

STEP
4

Loosely bolt mounting braces to brackets.

Note: Mounting brackets will angle up (toward the front of the vehicle) approximately 2 degrees from bumper level.



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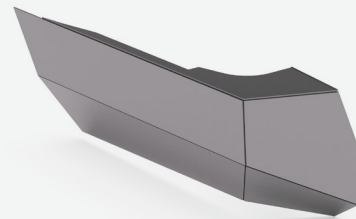
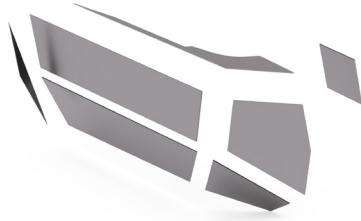
STEP
5

Take the Center Section with mounting braces and attach to the vehicle. Make adjustments to mounting bracket position as needed. It is recommended that you remove the bumper from the vehicle when the test fit is complete.

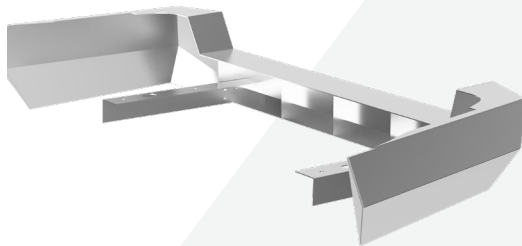


STEP
6

Weld the wing plates to form the wing assemblies.



STEP
7



Mate the wing sections align with the center section wings.

STEP
8

Once again test fit the bumper to the vehicle and make sure the bumper with the wing sections fit.



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STEP
9

Weld the bumper 6-8 inches at a time.

Note: To prevent warping, alternate welding on different sides of the product and allow parts to cool before welding again. After welding is complete, proceed to clean up the product using wire wheels, sanding discs, and grinding wheels.