

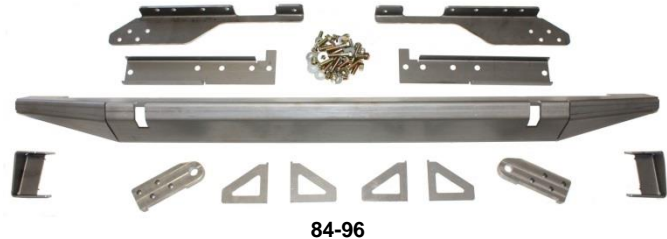
IRON ROCK OFF ROAD

DIY XJ Rear Bumper
Instructions

1-877-919-JEEP www.ironrockoffroad.com

Parts List:

- Instructions
 - Bumper main body 84018 (1)
 - Unibody mount left 84019 (1)
 - Unibody mount right 84020 (1)
 - D-ring mount 84021 (2)
 - Main body gusset 84022 (4)
 - End cap right 84054 (1)
 - End cap left 84055 (1)
 - Unibody brace left 84058 (1)
 - Unibody brace right 84059 (1)
 - Optional: 97-01 Model Years**
 - Taillight filler right 84056 (1)
 - Taillight filler left 84057 (1)
 - Filler mount 84060 (2)
- #156 - XJ Rear Bumper Hardware (1)**
- 7/16-14 x 2" Hex bolt gr8 (8)
 - 7/16 USS washer (16)
 - 7/16-14 Hex nut zinc (8)
 - 1/2-13 x 1-1/2" Hex bolt gr8 (10)
 - 1/2 USS washer (10)
 - 1/2-13 Hex nut plain (10)
 - #14X1 Self-drilling screw (4)



Safety Warning: *Important! Read Before Installation. *****

We recommend that all welds be performed by a certified welder. A weld failure may result in serious injury or death, in addition to vehicle damage. Care must be taken during installation. Improper assembly and mounting to the vehicle could result in failure of the tow points causing serious injury or death.

Before you begin:

- Read all safety warnings.
- Read and understand installation instructions.
- Contact Iron Rock Off Road with any questions before, during, or after installation.
- Ensure that all parts are present and in good condition using the included shipping checklist.
- Be sure you have the following tools and supplies:
 - Welder
 - Angle grinder
 - Basic hand tools
 - Square
 - Primer and paint

Main Bumper Assembly:

1. Begin by assembling the end caps onto the bumper. Tack weld in place. **(Figure 1)**
2. Insert the d-ring mounts into the slots provided and tack weld in place. **(Figure 2)**
3. Insert the bumper gussets into the slots provided and tack weld in place. **(Figure 3)**
4. You now have the main bumper shell tacked together. **(Figure 4)**

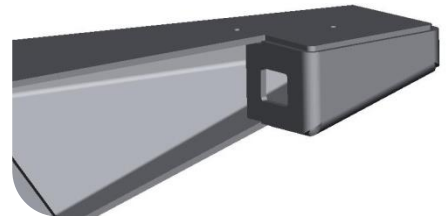


Figure 1

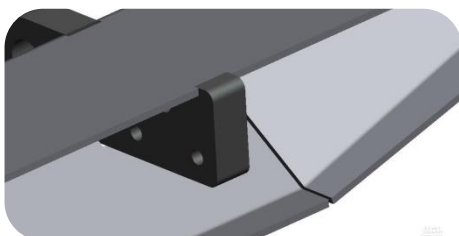


Figure 2

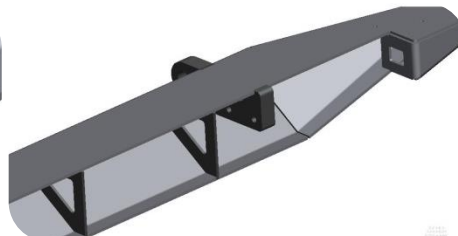


Figure 3

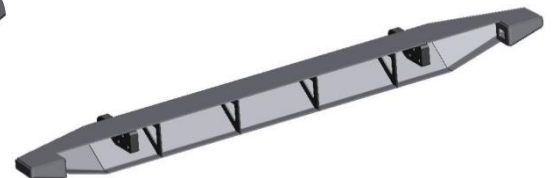


Figure 4

Unibody Mount Assembly:

5. Locate unibody mounts and 1/2-13 plain hex nuts from hardware kit 156.
6. Tack weld two sides of 1/2-13 plain nut on top side of unibody mounts. Each mount gets 5 hex nuts. Clamp or bolt in place to prevent warpage. Weld two flat sides of each nut. **(Figure 5)**
7. Clean, prime, and paint the unibody mounts. Be careful not to paint the threads.

97-01 Filler Panel Assembly:

8. Locate filler mounts and taillight fillers.
9. Position filler mount with angled edge matched to the short leg of the taillight filler and flush to the bottom.
10. Tack in position. **(Figure 6)**
11. Repeat for opposite side.
12. Stitch weld filler mount to taillight filler panel.
13. Clean, prime, and paint the filler panel assemblies.

Test Fit Bumper Before Welding:

14. Remove rear bumper and brackets.
15. Remove trailer hitch and/or fuel tank skid plate if equipped.
**If equipped with trailer hitch/ fuel tank skid plate: remove original nut plate from inside the uniframe rail.
16. From the back of the vehicle, cut rectangle openings through to the inside of the uniframe rails.
17. Bolt unibody mounts onto main bumper assembly with mounts on the outer surface of d-ring mounts using 7/16" hex bolts, washers, and nuts. Tighten hand tight. **(See figure 7)**
18. Slide unibody mounts into uniframe rails and line them up with holes in bottom of rails.
19. Install using 1/2" hex bolts but do not tighten at this time.
20. Ensure bumper is lined up with body and tighten lower mount bolts.
21. We recommend welding as much of the bumper on the vehicle if possible to reduce chance of warping.
22. Weld in small sections and move around the bumper to keep heat concentration to a minimum.
23. Remove bumper and finish welding anything that was not accessible.
24. Grind welds smooth if you desire a smooth look.
25. Paint/powdercoat bumper to protect from rust.
26. If installing on a 97-01, install the taillight filler panels using the predrilled holes in the main bumper assembly and secure using the #14 screws.
27. Insert bumper into the uniframe rails.
28. Install unibody braces under uniframe rails using 1/2" hex bolts.



Figure 5
Unibody Mount



Figure 6



Figure 7