



## Installation Instructions:

(Part # SB76653)

97-06 Jeep TJ XRC Rear Bumper

87-95 Jeep YJ XRC Rear Bumper

**NOTE: Please read instructions entirely and thoroughly before assembling and installing this product**

This bumper is rated with a Class IV receiver. (9,000lbs GVWR)

Note: Check with OEM towing specifications and operation before towing anything with your vehicle.

Parts Included	Qty	Parts Included	Qty
91-5580 REAR BUMPER	1	90-6707 HARDWARE PACK: BUMPER	1
91-5601 BUMPER BRACE: DRVR	1	3/8"-16 X 1 1/4" HEX BOLT GR. 8	12
91-5604 BUMPER BRACE: PASS	1	3/8" HARDENED FLAT WASHER	12
91-5607 FRAME BRACKET: DRVR- TJ ONLY	1	3/8" SPLIT-LOCK WASHER	12
91-5610 FRAME BRACKET: PASS- TJ ONLY	1	7/16"-14 X 1" HEX BOLT GR. 8	4
90-5613 NUT PLATE: TJ- FRAME BRACE	2	7/16" FLAT WASHER	4
90-5615 NUT PLATE: FRAME BRACKET- TJ ONLY	2	1/2"-13 X 1" GR. 8 HEX BOLT	2
90-5612 BUMPER COVER PLATE	1	1/2" HARDENED FLAT WASHER	2
90-6706 HARDWARE PACK: COVER PLATE	1	12mm-1.75 X 40mm HEX BOLT Gr. 10.9	2
3/8"-16 X 1" STANLESS BUTTON HEAD BOLT	3	12mm FLAT WASHER	2
3/8" STAINLESS FLAT WASHER	3	96-5617 DRILL TEMPLATE	1
		90-3946 NUT PLATE- YJ- FRAME BRACE	2



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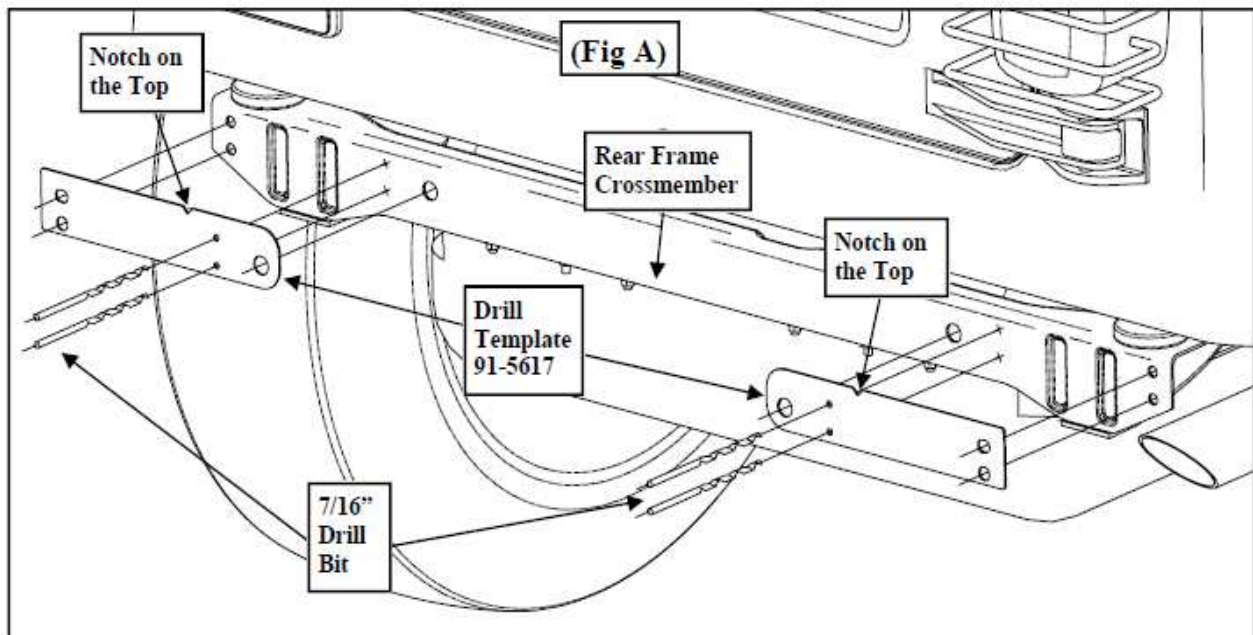
### INSTALLATION INSTRUCTIONS

**Step 1:** Ensure that your work space is of adequate size and the work surface is level. Place the vehicle in park and set parking brake.

**Step 2:** Remove the factory rear bumper and hardware from the vehicle.

**Step 3:** Raise the frame drill template (96-5617) into place by locating it on the rear frame crossmember OE bumper mounting holes. *NOTE: The notch will be on the top and the drill template will be flipped for use on both the driver and pass side.* Using the supplied drill template, drill the (4) holes in the frame using a 7/16" drill bit. (Fig A)

**IMPORTANT!:** Be ***VERY CAREFUL*** not to drill into the fuel tank. Use a drill stop on the drill bit to prevent the drill bit from over penetrating.



**Step 4:** *NOTE: This step might require 2 people.* Raise the new XRC rear bumper (91-5580) up into place and install the (2) 12mm-1.75 X 40mm bottom bolts and hardware into the OE holes. Temporarily install the (4) 3/8" X 1 1/4" and hardware into the OE outer mounting holes in the rear frame crossmember bolts. Leave these bolts finger tight. (Fig B)

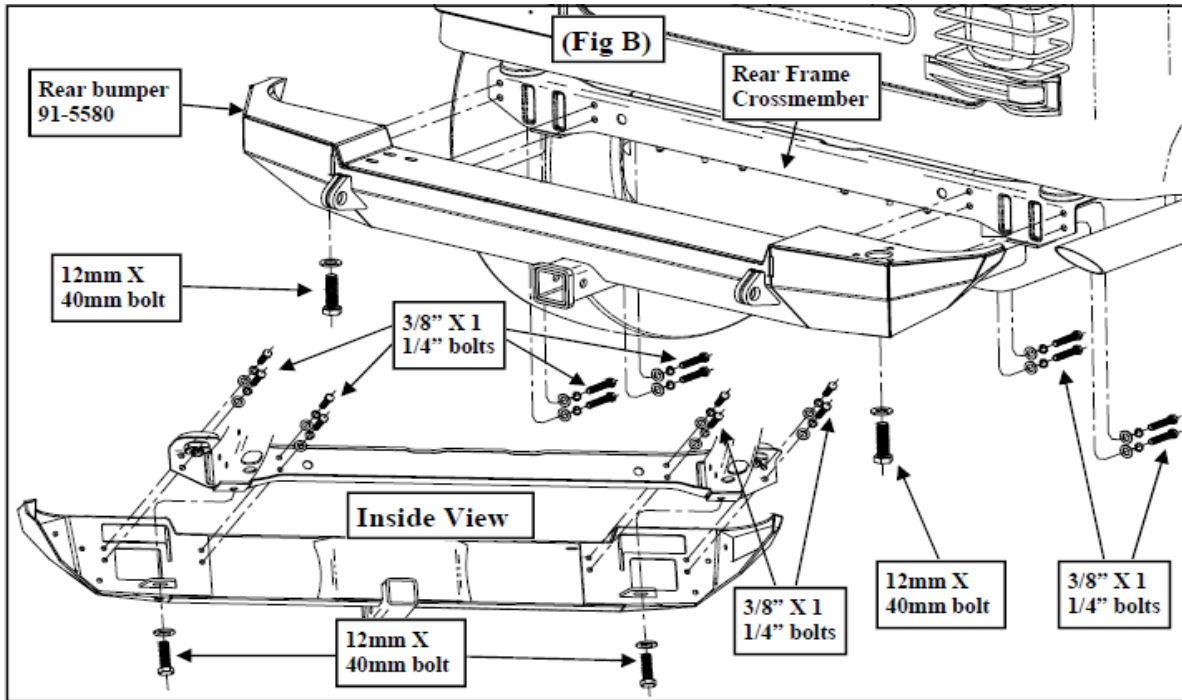


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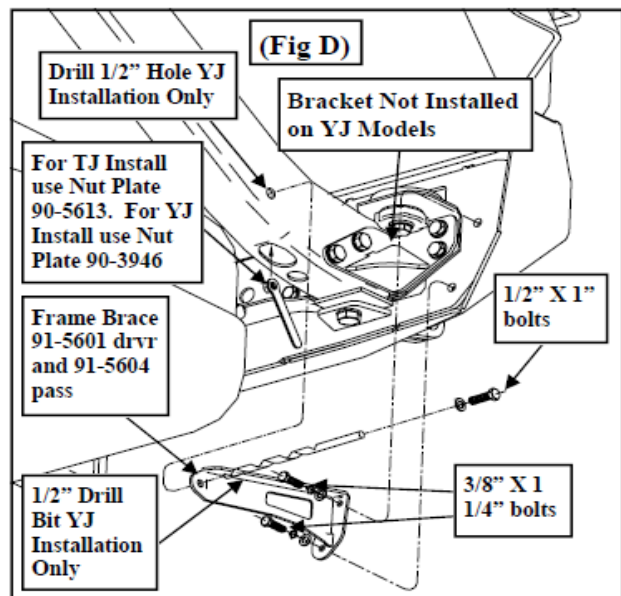
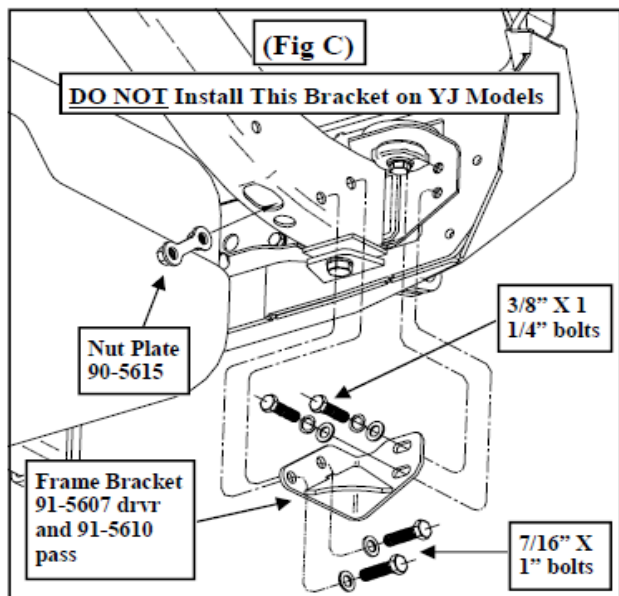
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**Step 5:** Install the (4) 3/8" X 1 1/4" bolts and hardware into the previously drilled inner mounting holes in the rear frame crossmember. (Fig B)

**NOTE:** These bolts are difficult to install and are easiest if installed at this time while the bumper can still be adjusted.





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**Step 6:** STEP 6 IS FOR TJ INSTALLATION ONLY: Remove the temporarily installed 3/8" X 1 1/4" and hardware into the outer bolts and install the frame brackets (91-5607 drvr and 91-5610 pass). Secure the frame brackets to the bumper mounting holes using the (4) previously removed 3/8" X 1 1/4" and hardware. Install the (4) 7/16" X 1" bolts into the inner frame mounting holes using the supplied nut plate (90-5615). (Fig C)

*NOTE: Do not install brackets (91-5607 drvr and 91-5610 pass) on 87-95 YJ Models.*

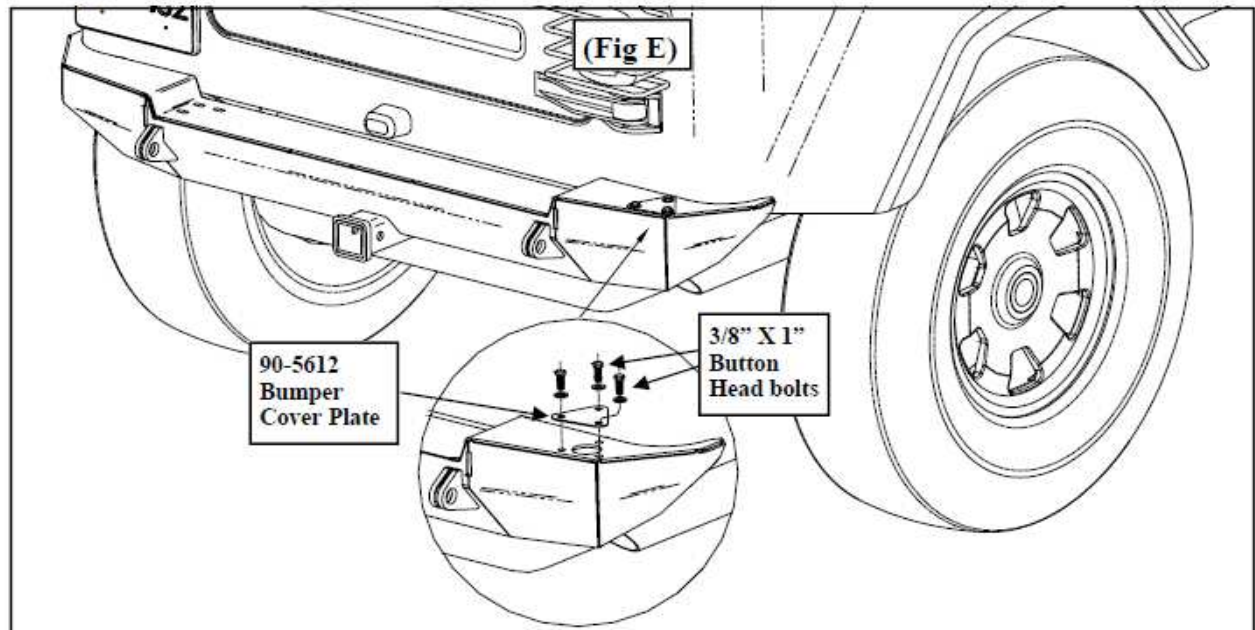
**Step 7:** Align and level the bumper. Tighten all bumper and bracket hardware at this time.

**Step 8:** TJ INSTALLATION ONLY: Install the frame braces (91-5601 drvr and 91-5604 pass) using the (4) 3/8" X 1 1/4" bolts into the outer mounting holes on the bumper. Use the (2) 1/2" X 1" bolts and supplied nut plate (90-5613) into the forward outer mounting hole. (Fig D)

YJ INSTALLATION ONLY: Install the frame braces (91-5601 drvr and 91-5604 pass) using the (4) 3/8" X 1 1/4" bolts into the outer mounting holes on the bumper. Use the remaining forward outer mounting hole in the bracket as a drill template and drill through the frame using a 1/2" drill bit. Use the (2) 1/2" X 1" bolts and supplied nut plate (90-3946) into the forward outer mounting hole. (Fig D)

*NOTE: DO NOT drill through both sides of the frame. Be sure to check for wires or brake/fuel lines before drilling.*

*NOTE: If you are installing the Smittybilt tire carrier kit (SB76654) at this time, skip step 9.*





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**Step 9:** Install the tire carrier (90-5612) cover plate to the top of the bumper using the supplied 3/8" x 1" bolts and hardware. (Fig E)

**Step 10:** Torque all the bumper hardware according to the torque chart below.

Use this only as a guide for hardware without a called out torque specification in the instruction manual.

<b>Bolt Torque and ID</b>						
Decimal System			Metric System			
All Torques in Ft. Lbs. Maximums						
Bolt Size	Grade 5	Grade 8	Bolt Size	Class 9.8	Class 10.9	Class 12.9
5/16	15	20	M6	5	9	12
3/8	30	45	M8	18	23	27
7/16	45	60	M10	32	45	50
1/2	65	90	M12	55	75	90
9/16	95	130	M14	85	120	145
5/8	135	175	M16	130	165	210
3/4	185	280	M18	170	240	290

<p style="margin-top: 10px;">1/2-13x1.75 HHCS      <b>Grade 5    Grade 8</b> (No. of Marks + 2)</p> <p style="margin-top: 10px;"> <span style="border: 1px solid black; padding: 2px;">D</span> <span style="border: 1px solid black; padding: 2px;">T</span> <span style="border: 1px solid black; padding: 2px;">L</span> <span style="border: 1px solid black; padding: 2px;">X</span> </p>	<p style="margin-top: 10px;">M12-1.25x50 HHCS</p> <p style="margin-top: 10px;"> <span style="border: 1px solid black; padding: 2px;">D</span> <span style="border: 1px solid black; padding: 2px;">T</span> <span style="border: 1px solid black; padding: 2px;">L</span> <span style="border: 1px solid black; padding: 2px;">X</span> </p>
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<p>G = Grade (Bolt Strength)</p> <p>D = Nominal Diameter (Inches)</p> <p>T = Thread Count (Threads per Inch)</p> <p>L = Length (Inches)</p> <p>X = Description (Hex Head Cap Screw)</p>	<p>P = Property Class (Bolt Strength)</p> <p>D = Nominal Diameter (Millimeters)</p> <p>T = Thread Pitch (Thread Width, mm)</p> <p>L = Length (Millimeters)</p> <p>X = Description (Hex Head Cap Screw)</p>
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### **Product cleaning and maintenance instructions**

**Dual state powder coat finish** – Mild soap, window or glass cleaner may be used to clean the finish. In order to protect the finish, you may wax your product on a regular basis with pure carnauba automotive wax. Do not use any types of soap, polish or was that contains abrasive that could damage the finish. **Textured coated finishes** should be cleaned with a mild soap on a damp sponge. Do not apply polish or was that requires to be removed by means of buffing. This type of wax is commonly used at car wash facilities.

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