



# Installation Instructions:

*Bumper (Part # SB76850)*  
*1984-2001 XJ Jeep Cherokee XRC*  
*Rear Bumper*

**NOTE: Carefully read entire instructions thoroughly before attempting to install this part.**

Parts Included	Qty
93-7789 XJ XRC Rear Bumper	1
93-7807 Bumper Mount Bracket: Drvr	1
93-7811 Bumper Mount Bracket: Pass	1
90-7814 Nut Plate: Drvr side frame rail	1
90-7816 Nut Plate: Drvr side frame rail	1
90-6865 Hardware Pack: Bumper	1
1/2" X 1 1/2" HEX BOLT GR. 8	6
1/2" SAE HARDENED FLAT WASHER	6
1/4"-14 X 1" SELF TAPPING SCREW	2

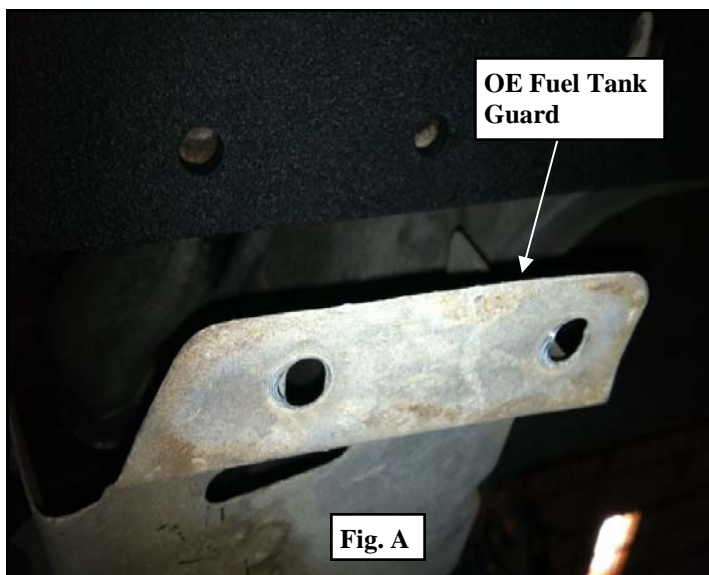
Parts Included	Qty
1/2" X 1" HEX BOLT GR. 8	1
1/2" X 1 1/4" HEX BOLT GR. 8	6
1/2" USS HARDENED FLAT WASHER	6
93-7869 XRC Rear Fender Skin: Drvr	1
93-7870 XRC Rear Fender Skin: Pass	1
90-6869 Hardware Pack: Bumper	1
90-4332 1/8" x 3/8" Rivet	16
90-4440 1/8" DRILL BIT	1

## INSTALLATION:

**Step 1:** Unbolt and remove the factory rear bumper and hardware from the vehicle. Save the hardware for reinstallation.

*NOTE: Be sure to unclip the factory light wiring harnesses if equipped*

**Step 2:** On the driver's side of the vehicle, remove the guard covering the fuel tank filler hoses. (Fig A)

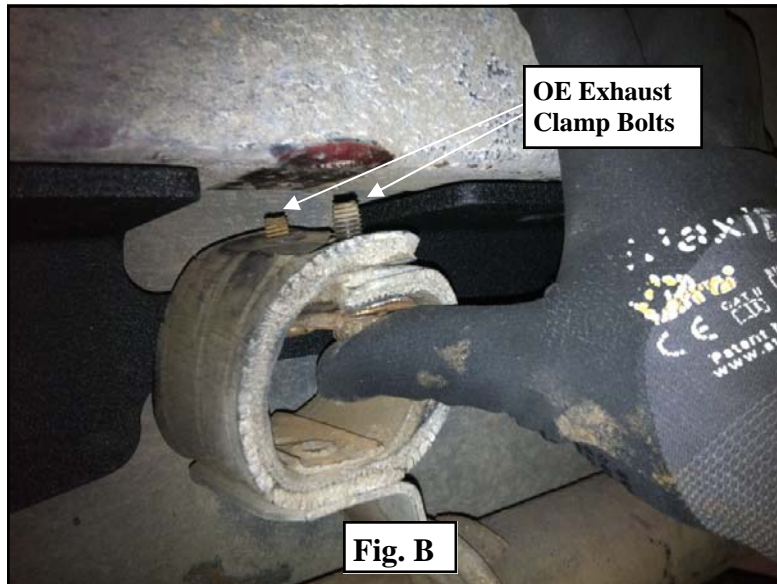




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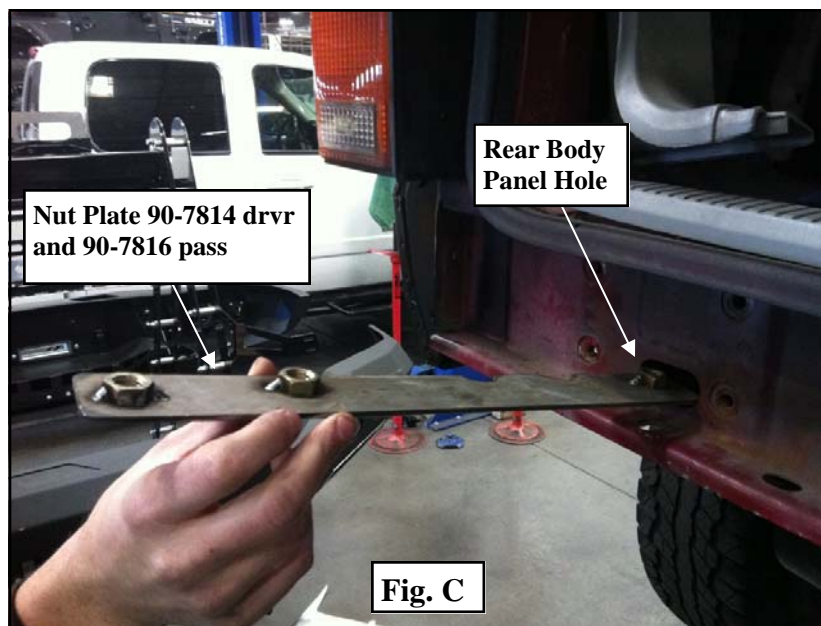
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**Step 3:** On the passenger side of the vehicle, remove the (2) OE bolts that secure the OE exhaust hanger to the tail pipe. (Fig B)



**Step 4:** On the both sides of the vehicle, insert the nut plates (90-7814 *drv*r and 90-7816 *pass*) into the holes in the rear body panel near the OE rear bumper mounting bolt holes. Align the holes in the nut plates with the (3) lower mounting holes in the body. (Fig C)

*NOTE: Be sure that the nuts on the nut plates are facing up .*





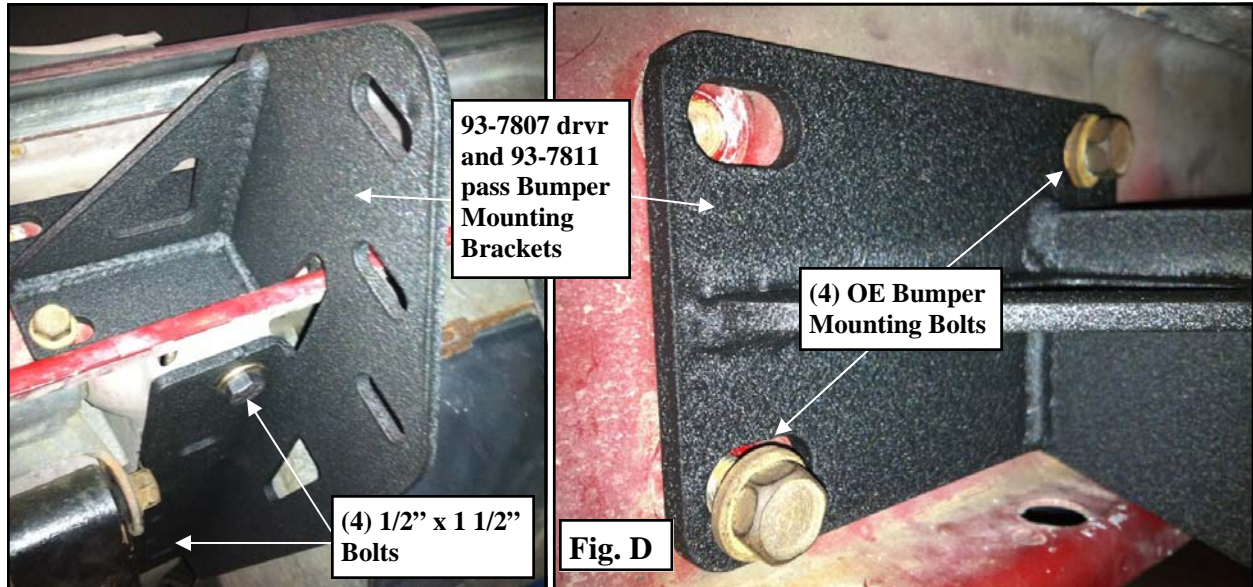


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**Step 5:** Install the frame mounting brackets (93-7807 **drv**r and 93-7811 **pass**) to the body. Secure using the (3 **per side**) supplied 1/2" X 1 1/2" bolts and 1/2" SAE washers, through bottom holes, into the previously installed nut plates. Install the (4 **per side**) previously removed **OE** bolts in the rear facing holes. Center the heads of the bolts in the slots in the brackets and tighten them down. (Fig D)

*NOTE: Adjustment of these brackets may be needed for perfect alignment of the bumper.*



**Step 6:** Measure the distance between the frame mounting brackets. The measurement should be slightly less than 34". If not, readjust the mounting brackets at this time. (Fig E)





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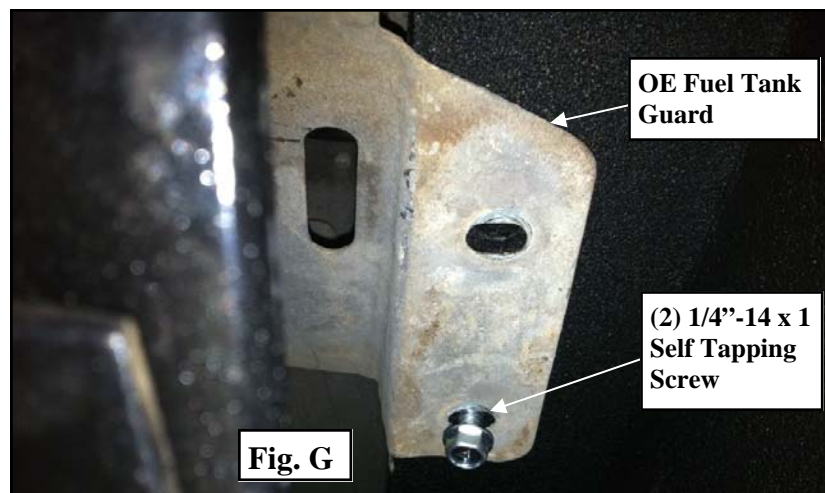
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**Step 7:** *NOTE: This step might require 2 people.* Raise the new XRC rear bumper (93-7789) up into place and align the bumper mounting holes with holes on the bumper mounting brackets. Secure using the supplied (3 per side) 1/2" X 1 1/4" bolts and 1/2" USS washers. (Fig F)



**Step 8:** Level the bumper and torque all mounting hardware according to the chart on page 7 or manufacturers specifications.

**Step 9:** On the driver's side of the vehicle, reinstall the guard covering the fuel tank filler hoses using the (2) supplied 1/4"-14" X 1" self tapping screw. (Fig G)



**Step 10:** On the passenger side of the vehicle, reinstall the (2) OE bolts that secured the OE exhaust hanger to the tail pipe. (Fig B)

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## Installation Instructions: Bumper (Part # SB76850) 1984-2001 XJ Jeep Cherokee XRC Rear Bumper

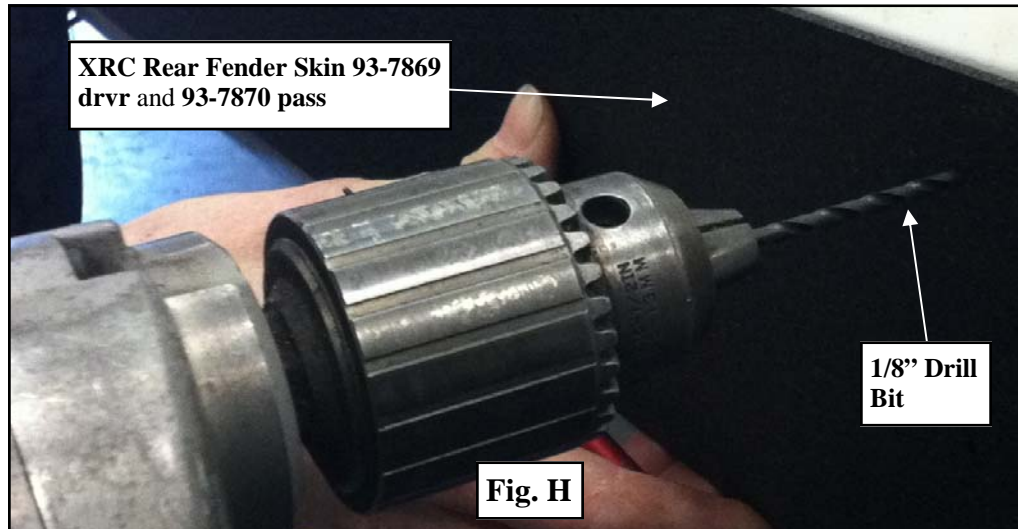
**Step 11:** Install the remaining 1/2" X 1" bolt as load bolt on the hitch. Doing this will reduce noise when operating the vehicle.

**Step 12:** Remove the rear fender moldings, glue, or riveted tabs in the area to be armored.

**Step 13:** Raise and test fit the driver side rear fender skin (93-7869 drvr and 93-7870 pass) to the rear fender. Center the rear fender skin in the middle of the rear fender. Use the top edge of the rear fender skin to position the panel along the contour of the body line.

**IMPORTANT!:** Pay special attention to its alignment with the rear body skin.

**Step 14:** With the rear fender skin held firmly in place, starting in the upper corners **ONLY**, drill out the corner holes, using the supplied 1/8" drill bit (90-4440). (Fig. H)



**Step 15:** Remove the rear fender skin and put sealant on the back to keep out dirt and water. (Fig. I)

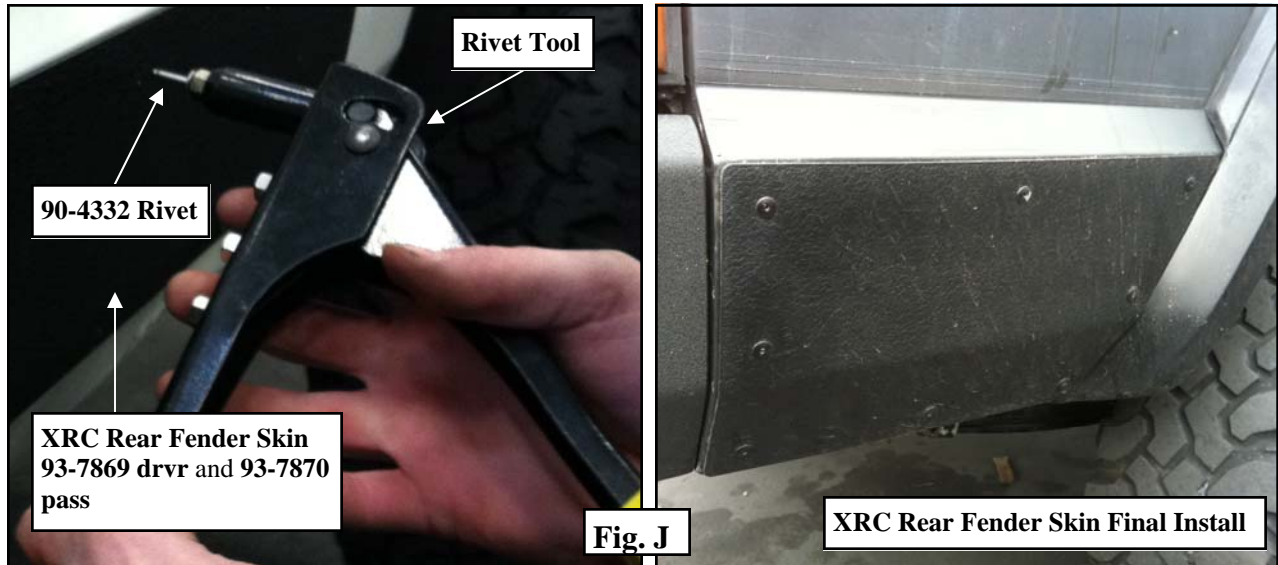




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**Step 16:** Reinstall the rear fender skin and rivet the upper corners in place using the supplied 1/8" X 3/8" rivets (90-4332). You may now proceed with drilling and riveting the rest of the holes in the rear fender skin. (Fig. J)



**Step 17:** Installation is now complete.



# Installation Instructions:

## *Bumper (Part # SB76850)*

### *1984-2001 XJ Jeep Cherokee XRC*

### *Rear Bumper*

<b>Bolt Torque and ID</b>						
<b>Decimal System</b>			<b>Metric System</b>			
All Torques in Ft. Lbs.						
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

**1/2-13x1.75 HHCS**

**Grade 5    Grade 8**

(No. of Marks + 2)

D T L X

G = Grade (Bolt Strength)  
D = Nominal Diameter (Inches)  
T = Thread Count (Threads per Inch)  
L = Length (Inches)  
X = Description (Hex Head Cap Screw)

**M12-1.25x50 HHCS**

**P**

D T L X

P = Property Class (Bolt Strength)  
D = Nominal Diameter (Millimeters)  
T = Thread Pitch (Thread Width, mm)  
L = Length (Millimeters)  
X = Description (Hex Head Cap Screw)

#### Product cleaning and maintenance instructions

**Stainless Steel Finish** – Aluminum polish may be used to polish small scratches and scuffs on the finish. Mild soap, window or glass cleaner may be used to clean the finish. **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. **Chrome Finish** – Mild soap, window or glass cleaner may be used to clean the finish. In order to protect the finish you should 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.