



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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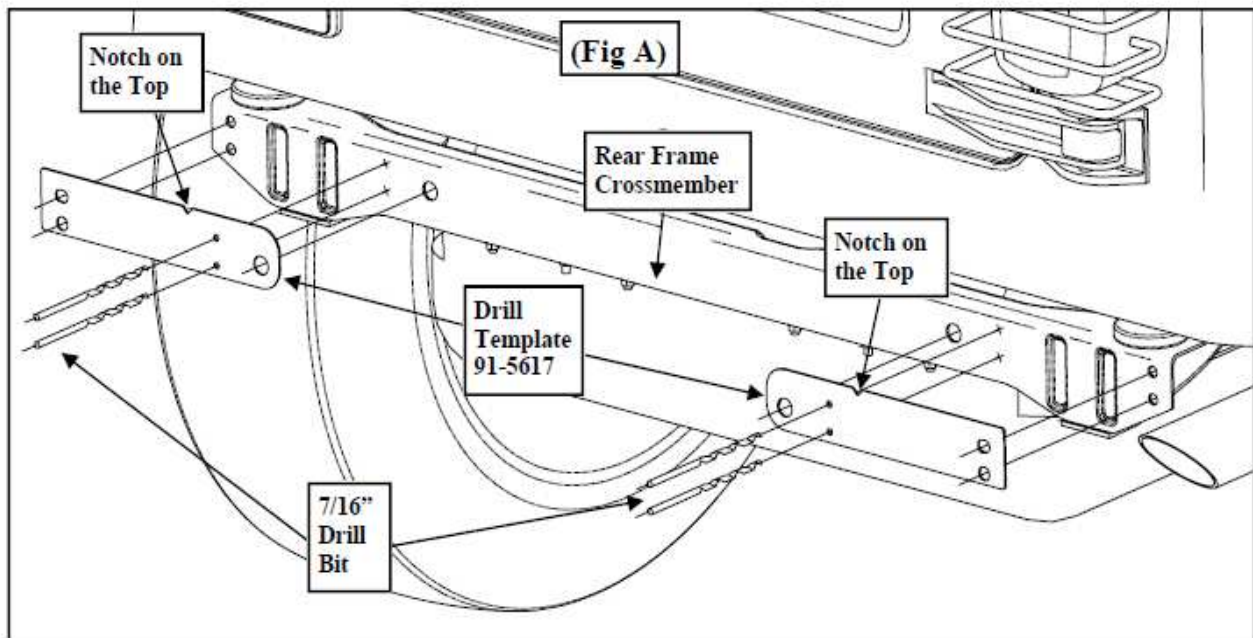
INSTALLATION INSTRUCTIONS

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 passenger 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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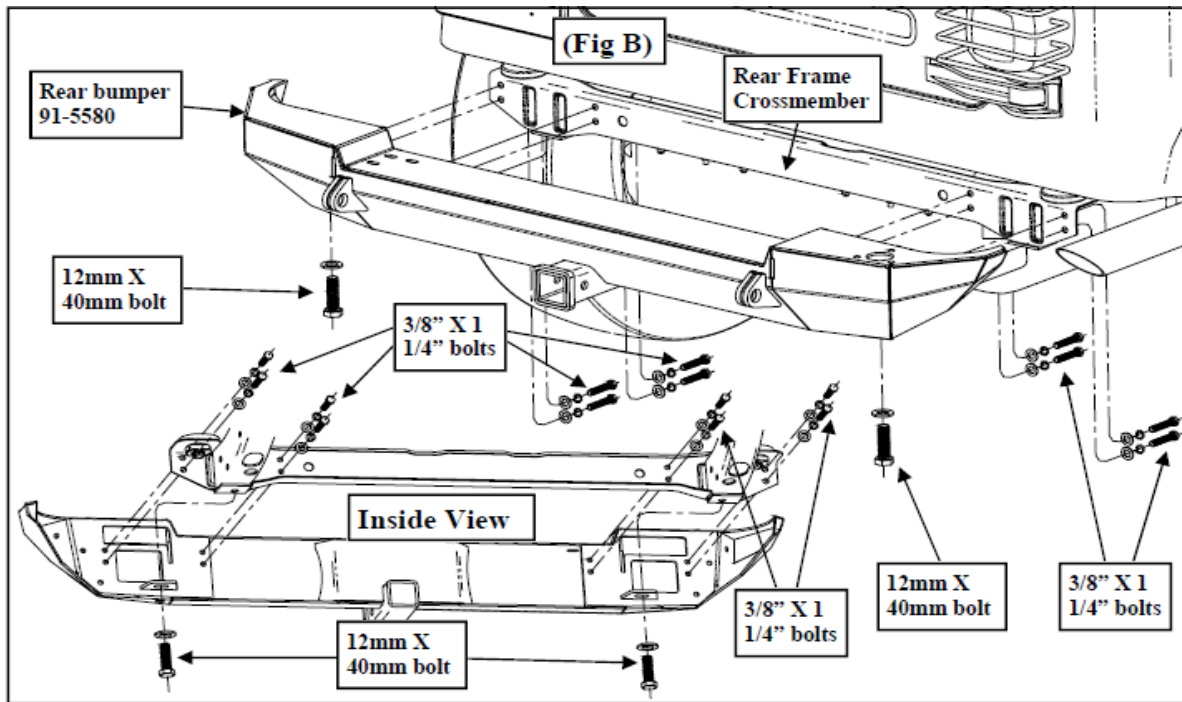


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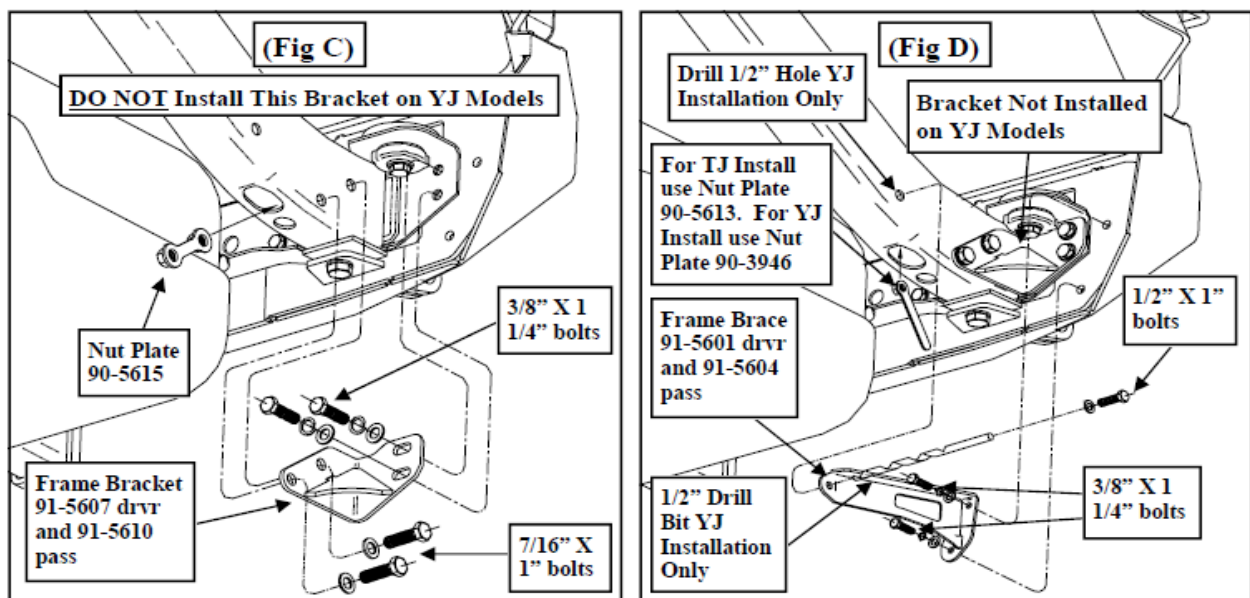
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Step 5: Install the (4) 3/8" X 1 1/4" bolts and hardware into the previously drilled inner mounting holes in the rear frame crossmember. (Fig B)

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.

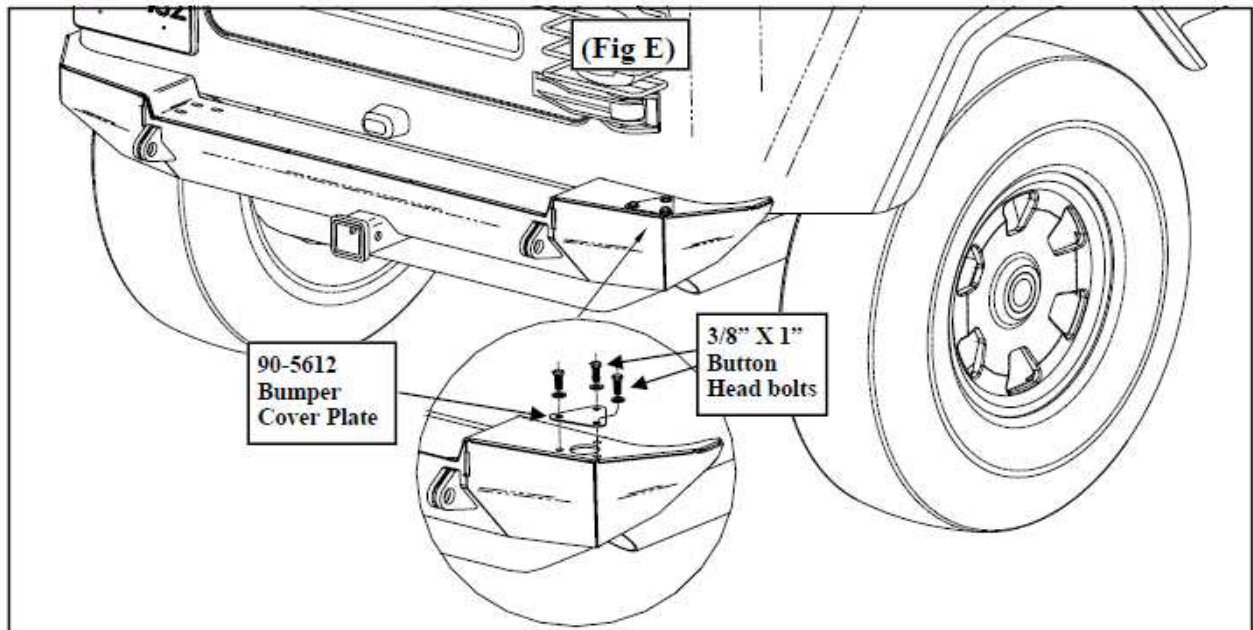
Step 7: Align and level the bumper. Tighten all bumper and bracket hardware at this time.

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.

Bolt Torque and ID						
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>1/2-13x1.75 HHCS</p> <div style="display: flex; justify-content: space-around;"> <div style="border: 1px solid black; padding: 2px;">D</div> <div style="border: 1px solid black; padding: 2px;">T</div> <div style="border: 1px solid black; padding: 2px;">L</div> <div style="border: 1px solid black; padding: 2px;">X</div> </div>	<p>Grade 5 Grade 8 (No. of Marks + 2)</p>
<p>G = Grade (Bolt Strength) D = Nominal Diameter (Inches) T = Thread Count (Threads per Inch) L = Length (Inches) X = Description (Hex Head Cap Screw)</p>	<p>M12-1.25x50 HHCS</p> <div style="display: flex; justify-content: space-around;"> <div style="border: 1px solid black; padding: 2px;">D</div> <div style="border: 1px solid black; padding: 2px;">T</div> <div style="border: 1px solid black; padding: 2px;">L</div> <div style="border: 1px solid black; padding: 2px;">X</div> </div> <p>P = Property Class (Bolt Strength) D = Nominal Diameter (Millimeters) T = Thread Pitch (Thread Width, mm) L = Length (Millimeters) 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 wax 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 wax that requires to be removed by means of buffing. This type of wax is commonly used at car wash facilities.

Limited Warranties

Smittybilt's products are covered under the following limited warranties only. Note that the duration of the limited warranty differs according to the material and finish of the product purchased. Subject to the duration and conditions of the limited warranty stated below, Smittybilt warrants to the original retail purchaser that its products are free from defects in material and workmanship. All other warranties and representations express or implied, are hereby disclaimed, including fitness for merchantability and buyer's intended use or purpose. All parts are sold "AS IS" except for the limited warranties granted herein. Buyer assumes all risks as to the selection, suitability and performance of all goods and products selected. This limited warranty does not cover damage or impairment in any part due to misuse, improper installation, accident or contact with on-road or off-road hazards, product modification, improper or inadequate cleaning and/or maintenance. Smittybilt is not responsible for items damaged during shipping. This warranty is not transferable from the original buyer. For the original Buyer to be eligible for the limited warranty coverage, the Buyer must provide proof of purchase. Smittybilt strongly recommends returning the warranty registration card.

Customer's remedy hereunder shall be limited only to repair or replacement (at Smittybilt's option) of any defective part(s) returned to Smittybilt at customer's expense. The determination of whether or not a returned part is defective or subject to coverage under the limited warranties stated herein shall be made at Smittybilt's sole discretion.

Duration of Limited Warranty

1. Limited Five (5) Year / 50,000 Mile Pro-Rata Warranty (whichever occurs first) on Dual-Stage Powder Coating Products -

Smittybilt dual-stage powder coated products carry the foregoing limited repair or replacement warranty for a period of (5) years or 50,000 miles (whichever occurs first) from date of purchase **against workmanship and defects in the material**, provided that any claim submitted after (2.5) years from date of purchase shall, if accepted, be satisfied by Smittybilt offering customer a credit on the purchase of a replacement product equal to fifty percent (50%) of customer's initial purchase price.

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