



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)

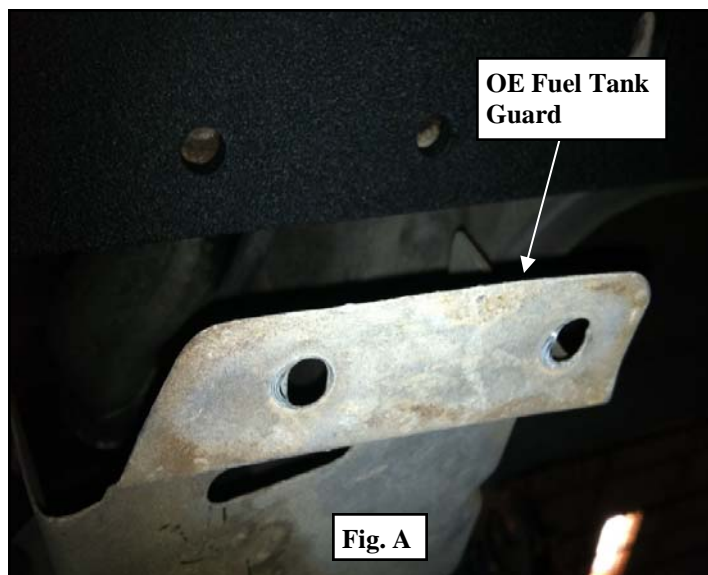


Fig. A

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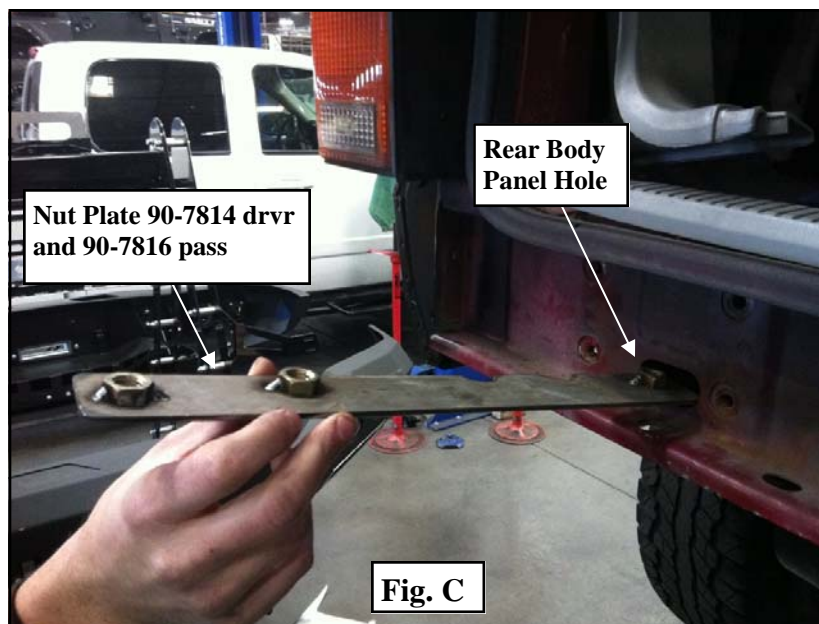
Rear Bumper

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 drvr 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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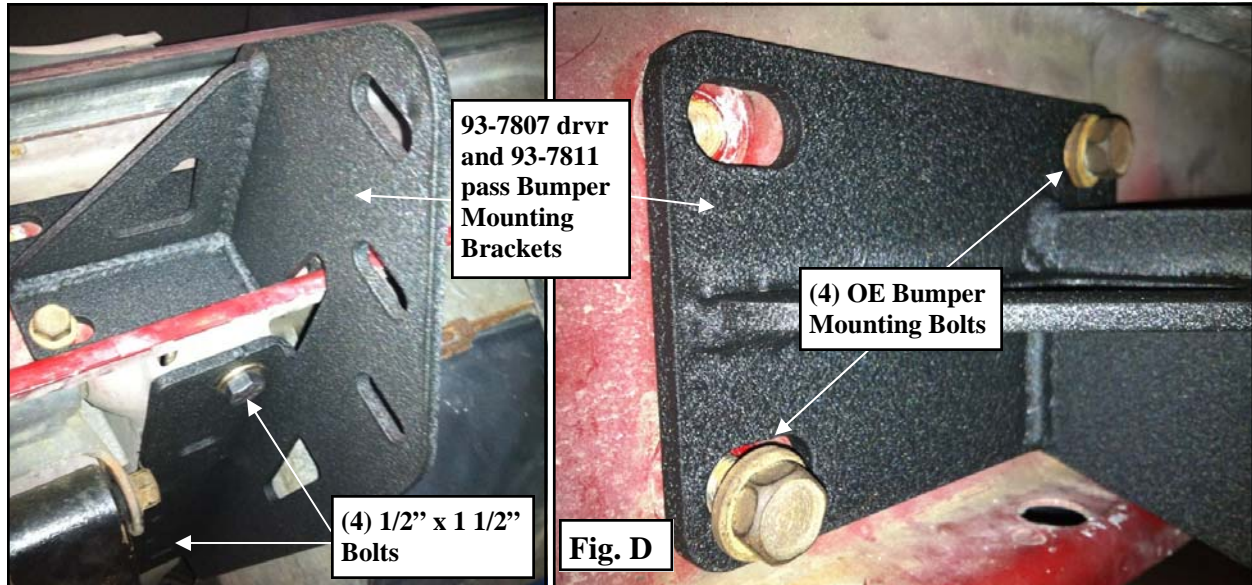
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Step 5: Install the frame mounting brackets (93-7807 **drv**r and 93-7811 **pass**) to the body. Secure using the (3 **per side**) supplied 1/2" X 1 1/2" bolts and 1/2" SAE washers, through bottom holes, into the previously installed nut plates. Install 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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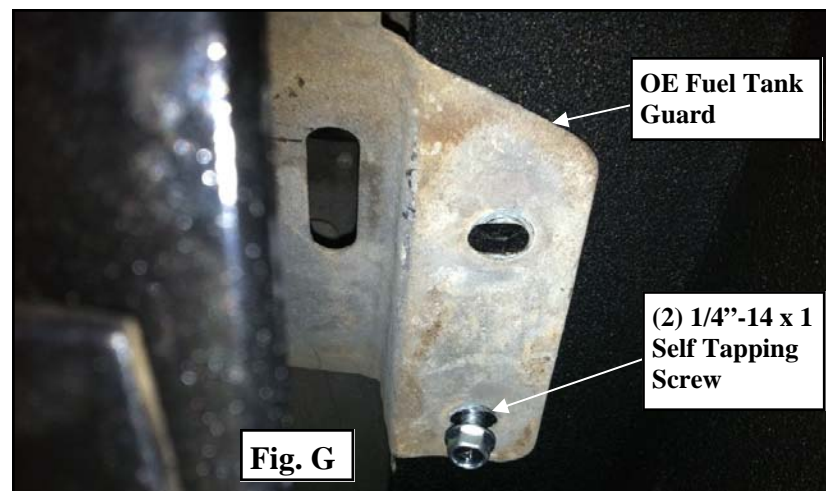
1984-2001 XJ Jeep Cherokee XRC Rear Bumper

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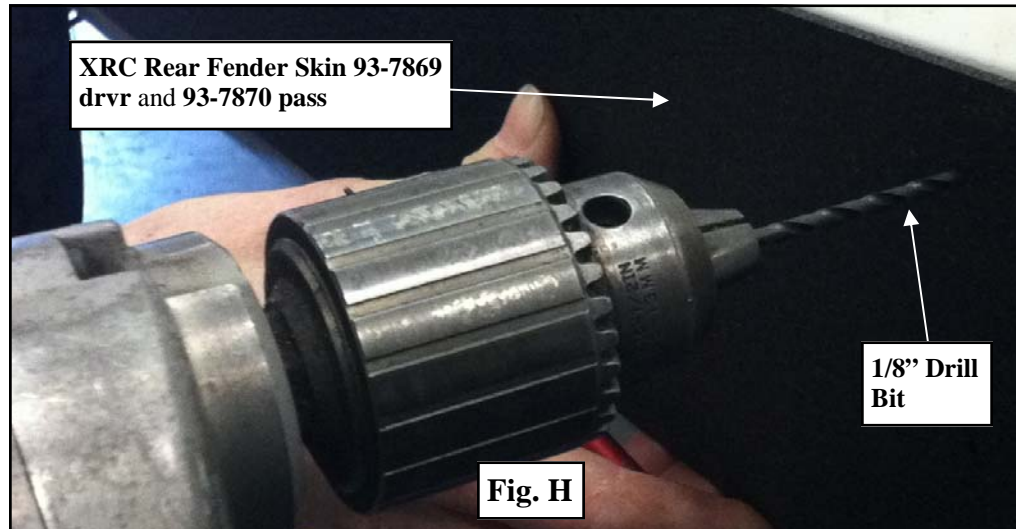
Step 11: Install the remaining 1/2" X 1" bolt as load bolt on the hitch. Doing this will reduce noise when operating the vehicle.

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 drvtr 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.

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Bolt Torque and ID						
Decimal System			Metric System			
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

<p style="text-align: center;">1/2-13x1.75 HHCS Grade 5 Grade 8 (No. of Marks + 2)</p> <p style="text-align: center;"> D T L X </p>	<p style="text-align: center;">M12-1.25x50 HHCS</p> <p style="text-align: center;"> D T L X </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

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.

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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

Limited Lifetime Warranty on Stainless Steel Products -

Smittybilt stainless steel products carry the foregoing limited repair or replacement warranty against workmanship and defects in the material so long as the original purchaser retains the original stainless steel parts.

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.

Limited Three (3) Year / 36,000 Mile Pro-Rata Warranty (whichever occurs first) on Chrome Products-

Smittybilt chrome products finished carry the foregoing limited repair or replacement warranty for a period of three (3) years or 36,000 miles against workmanship and defects in the material (whichever occurs first) from the date of purchase.

To assure product quality, Smittybilt reserves the right to change product design, material, specification and finishes without prior notice to customers. This limited warranty gives you specific legal rights and you may also have other rights, which may vary from state to state. Some states do not allow limitations on how long an implied warranty lasts, so the above limitations may not apply as to you. Also, some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitations or exclusions may not apply to you. Smittybilt reserves the right to discontinue product lines and substitute products, or provide other remedies than those listed in this limited warranty for those discontinued products.

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