

INSTALLATION INSTRUCTIONS

RUFFSTUFF DIY XJ FULLWIDTH FRONT WINCH BUMPER

PART#: R2606



KIT INCLUDES

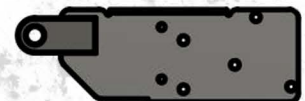
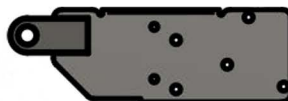
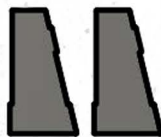
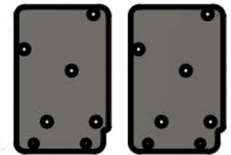
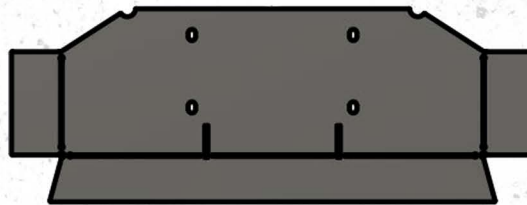
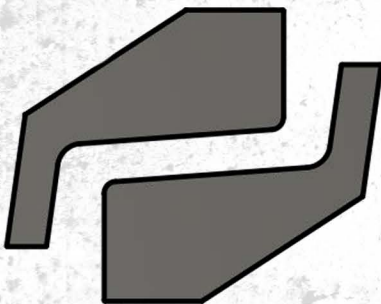
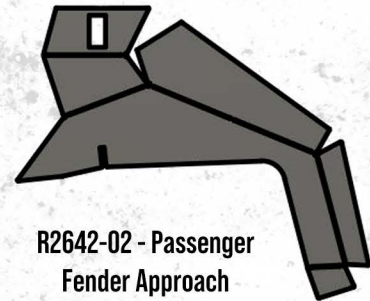
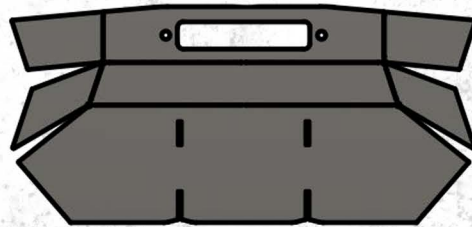
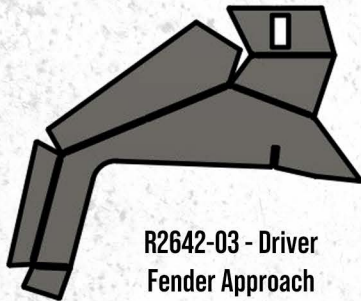
Things You'll Need

- Welder
- Square
- Angle Finder
- Grinder
- Safety gear
- Welding C-Clamps
- Vice Grips or Adjustable Wrench

WARNING

- It is recommended to have this bumper professionally assembled.
- RuffStuff Specialties is not responsible for any bumper failures or the resulting damage or injury occurring from impacts or winching.
- This bumper is for off-highway use only.

What's Included

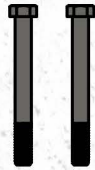


KIT INCLUDES

Hardware



R2630 - 7/16" - 14 x 4.50"
Bolts (2x)



R2629 - 7/16" - 14 x 4.00"
Bolts (2x)



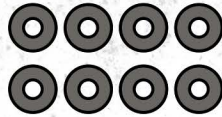
R2628 - 7/16" - 14 x 1.25"
Bolts (4x)



R2509 - M10 - 1.50mm x 30mm
Bolts (2x)



R2631 - 3/8" - 16 x 1.00"
Bolts (4x)



R1949-01 - 7/16" Washers
(8x)



R2591-09-W - Inner Nut Plate
2.82" (2x)



R2591-10-W - Inner Nut Plate
4.46"



R2006-02 - 3/8" Washers
(4x)



R2551-02 - 3/8" - 16 Nylock
Nuts (4x)



R2510 - M10 Washers
(2x)

INSTALLATION INSTRUCTIONS

R2642 bend sequence is to start with R2642-01 by clamping the bottom to a table or in a vice with the part number facing down make the two bends on the face which are bend 1 & 2 and check your angles make sure your bend degrees are good then move on to the bend 3,4,5,6 and check degrees again if all degrees are good then tack bends together to hold in place.



BEND 1



BEND 2



BEND 3



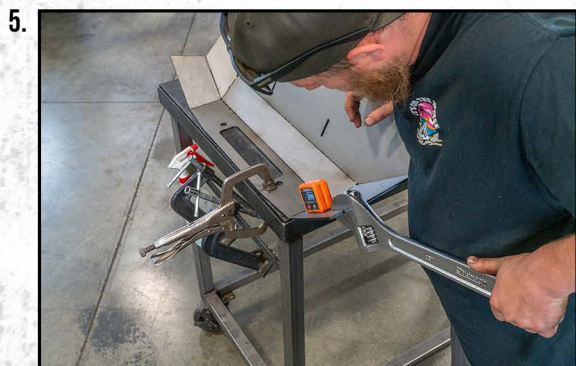
BEND 4



BEND 5



BEND 6



INSTALLATION INSTRUCTIONS

Next move on to R2642-02 by clamping the bottom to a table or in a vice with the part number facing down make bends 1&2 then check your degrees before moving on to bend 3 make bend 3 check your degree if its good tack bend 3 to bends 1&2 then make bends 4&5 check your degrees if they are good then tack them together to hold in place.



BEND 1



BEND 2



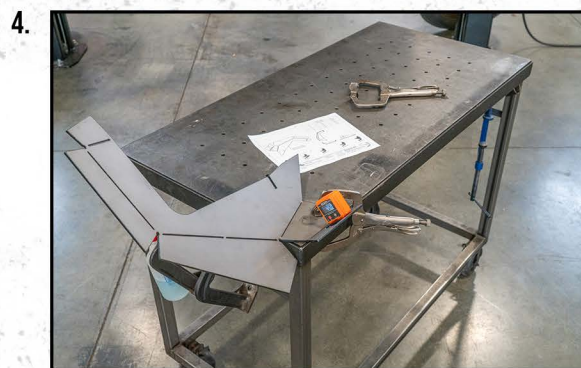
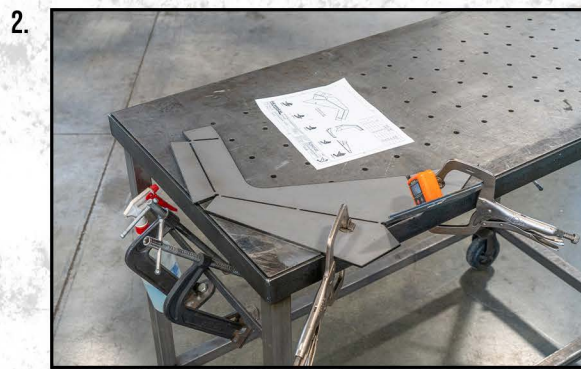
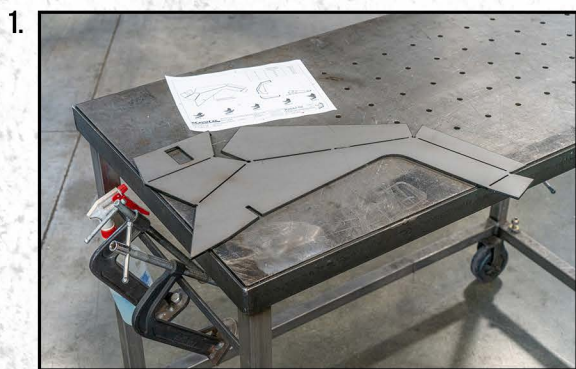
BEND 3



BEND 4



BEND 5



INSTALLATION INSTRUCTIONS

Next move on to R2642-03 which is the same bend sequence as R2642-02 just mirrored check all degrees before tacking together to hold in place.



BEND 1



BEND 2



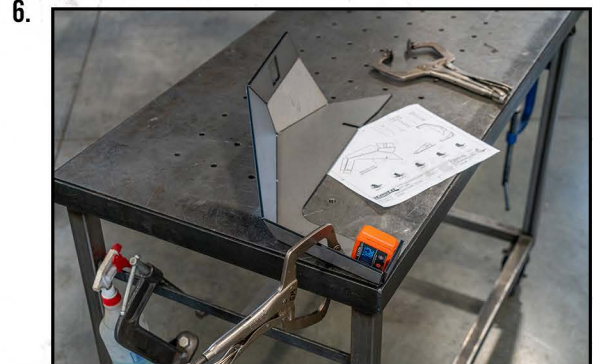
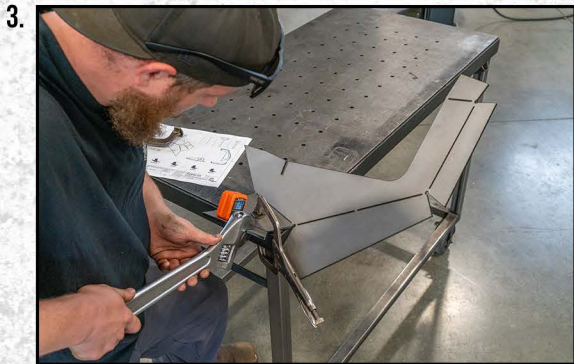
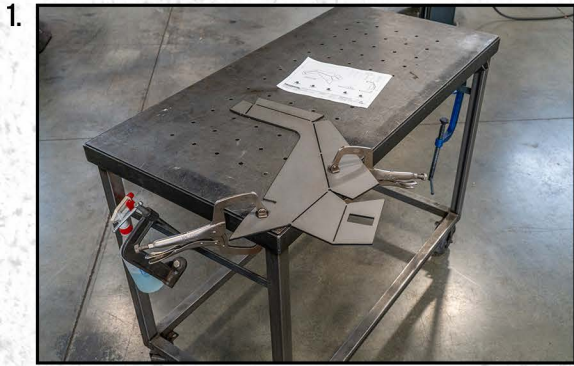
BEND 3



BEND 4

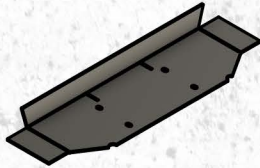


BEND 5

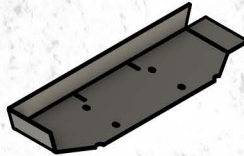


INSTALLATION INSTRUCTIONS

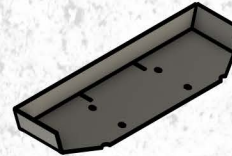
Now move on to R2642-04 clamp the bottom to a table or in a vice make bend 1,2,3 checking degrees if degrees are good tack them together to hold them in place.



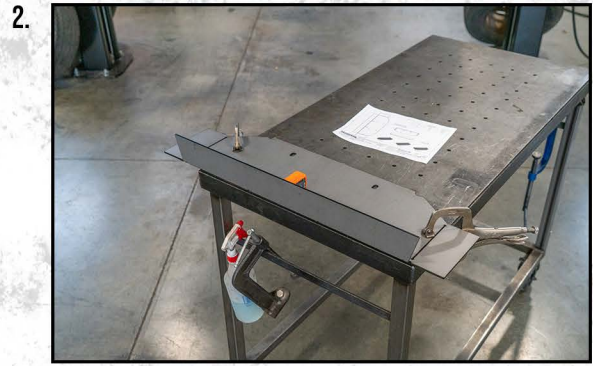
BEND 1



BEND 2

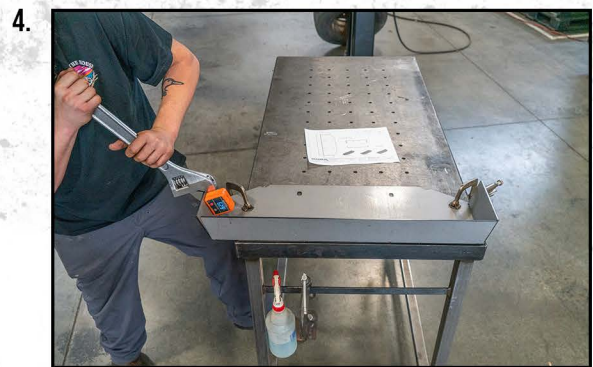
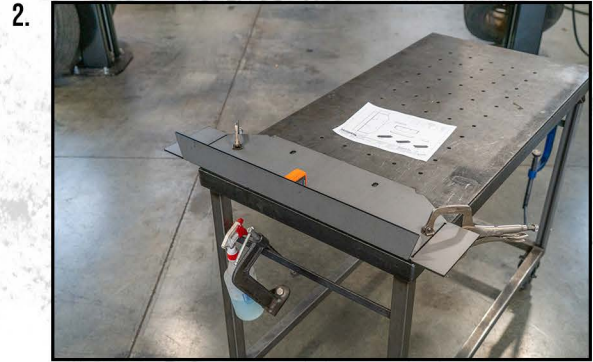


BEND 3



INSTALLATION INSTRUCTIONS

Now to start putting the pieces together start by clamping the middle piece R2642-01 in a vice or on a table take the first side piece part R2642-02 and line it up with -01 and make sure all bends are lining up then tack together.

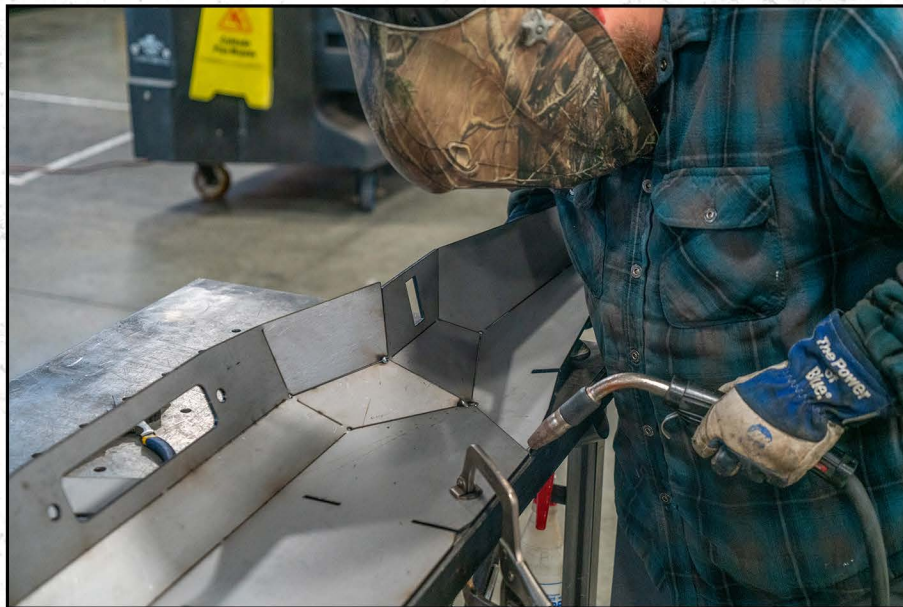


What you should have at this point.



INSTALLATION INSTRUCTIONS

Now to start putting the pieces together start by clamping the middle piece R2642-01 in a vice or on a table take the first side piece part R2642-02 and line it up with -01 and make sure all bends are lining up then tack together. Then grab part R2642-03 for the other side and repeat by lining up the bends and tacking them together to hold them in place.



INSTALLATION INSTRUCTIONS

Once the middle and sides are tacked together and held in place grab part R2591-04 the side top piece start by tacking it on the back outside corner then work your way forward while tacking the corners then do the same for the other side until both are lined up and tacked firmly in place.



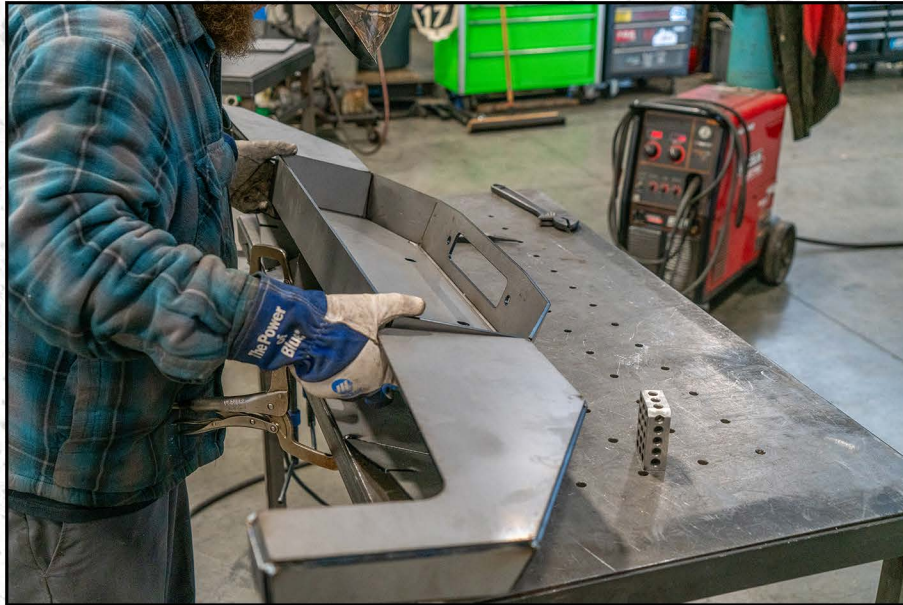
INSTALLATION INSTRUCTIONS

Once done with that grab part R2591-08 winch supports and correctly lock them into place with the key way slots in the bumper center piece. Use a square to get them squared to 90 degrees and tack them into place.



INSTALLATION INSTRUCTIONS

Then take part R2642-04, the winch plate and insert it into the bumper locking it into place with the key way slots in it. Get it lined up then tack it into place to secure it.



INSTALLATION INSTRUCTIONS

Then take parts R2642-05&06 bolt them on the jeep before putting them on the bumper. If they don't have frame stiffeners on the jeep they have to use part R2591-11 as a spacer for the mounting brackets.



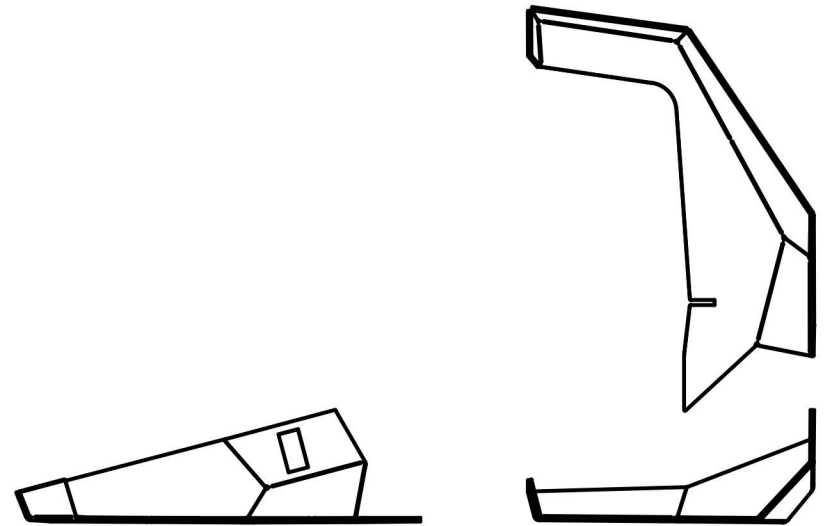
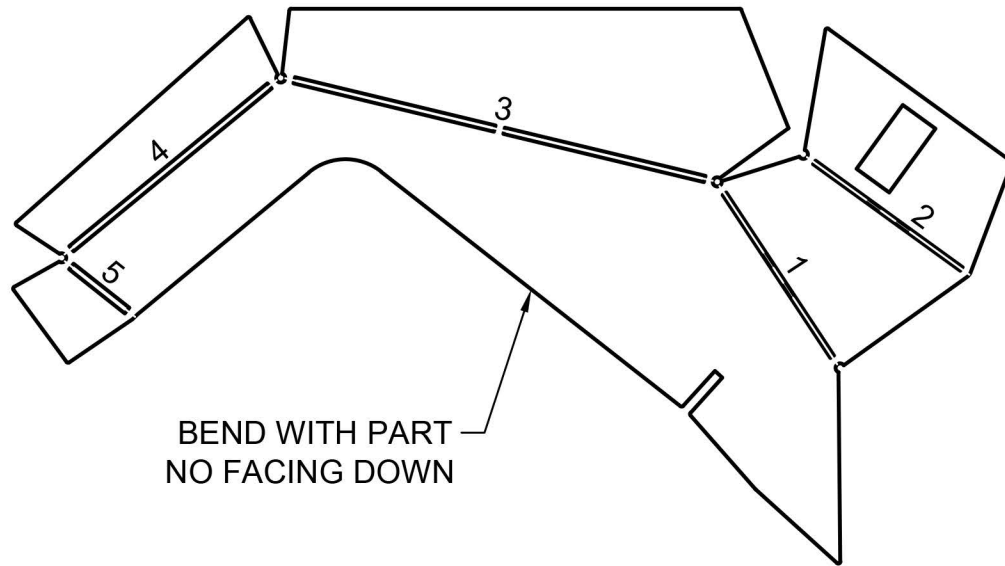
INSTALLATION INSTRUCTIONS

Once the mounting brackets are bolted to the jeep then take the bumper and slide it over the mounting brackets and make sure it gets pushed all the way on then tack the bumper to the mounting brackets.



Once they are all firmly tacked into place you can remove the bumper to completely weld everything together and grind everything smooth and you are done building the ruffstuff diy xj bumper.

BEND TABLE		
ID	DIRECTION	ANGLE
1	UP	46.9
2	UP	45.0
3	UP	67.3
4	UP	70.3
5	UP	76.2



BEND 1



BEND 2



BEND 3

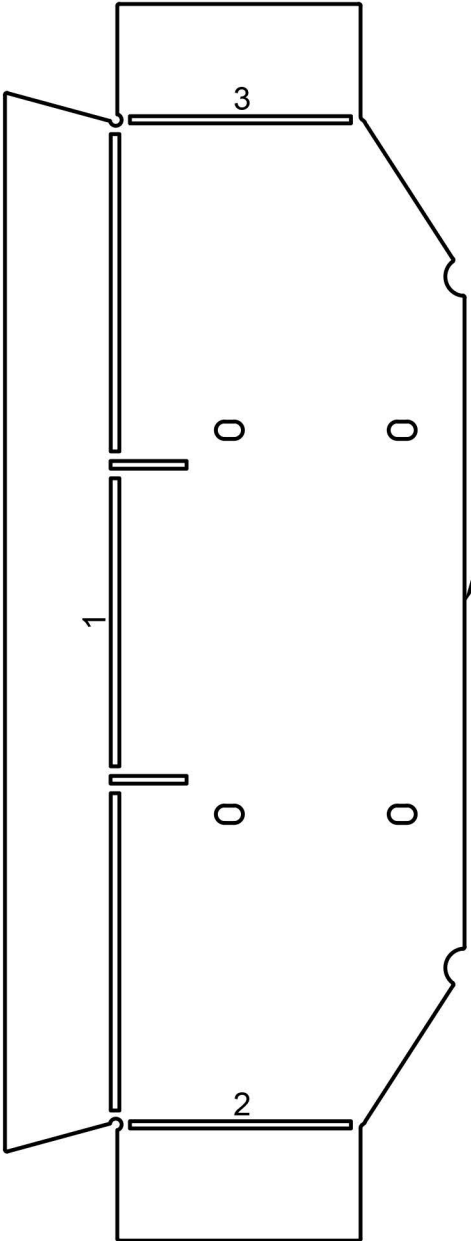


BEND 4

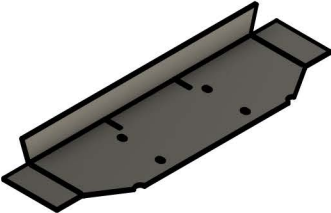
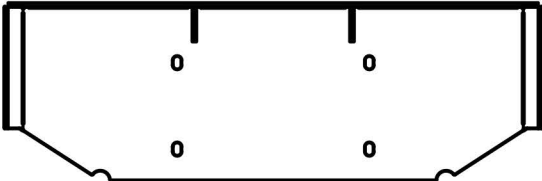


BEND 5

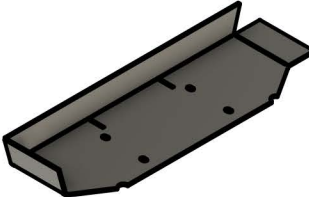
BEND TABLE		
ID	DIRECTION	ANGLE
1	UP	90.0
2	UP	74.8
3	UP	74.8



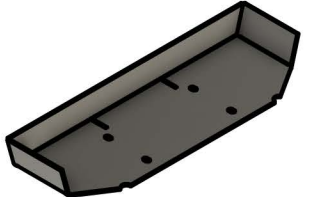
BEND WITH PART
NO FACING DOWN



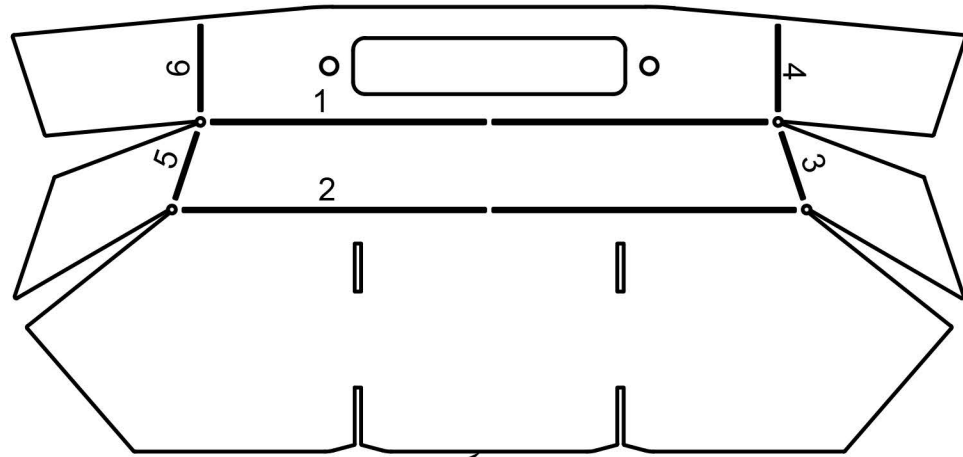
BEND 1



BEND 2

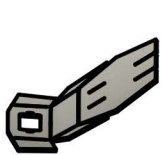
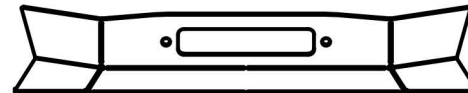
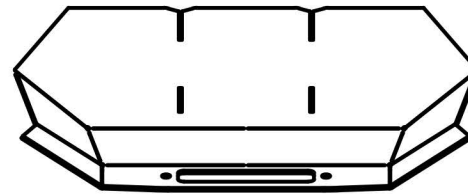


BEND 3



BEND WITH PART
NO FACING DOWN

BEND TABLE		
ID	DIRECTION	ANGLE
1	UP	35.0
2	UP	31.7
3	UP	29.6
4	UP	32.5
5	UP	29.6
6	UP	32.5



BEND 1



BEND 2



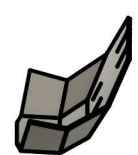
BEND 3



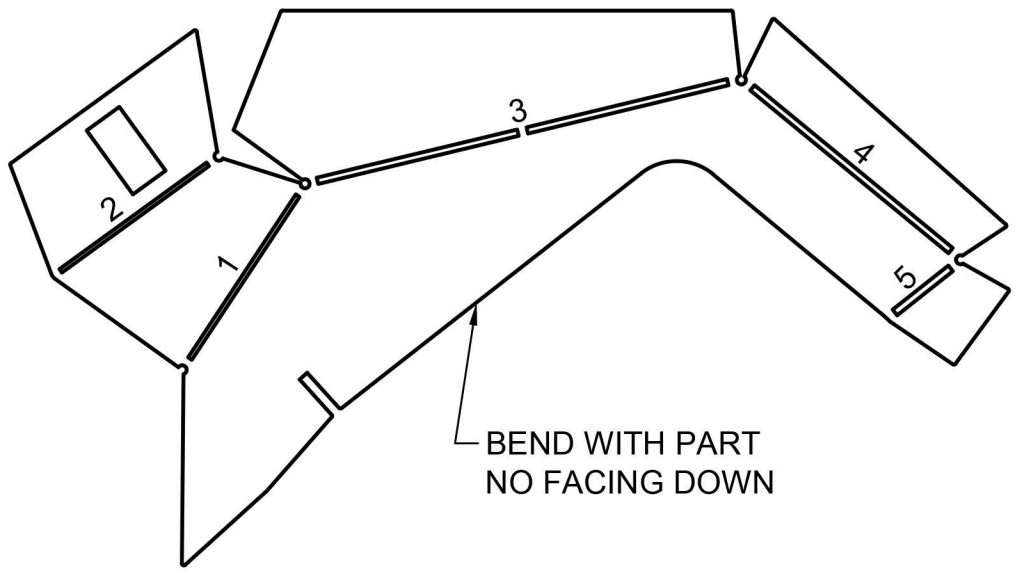
BEND 4



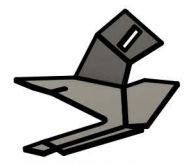
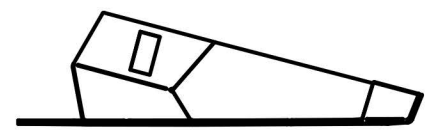
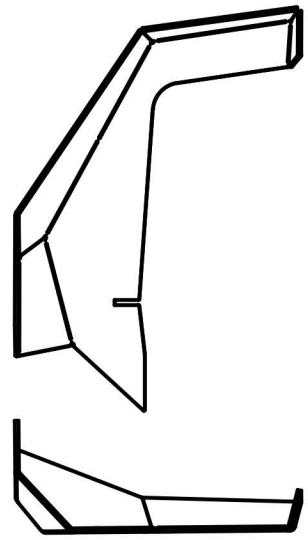
BEND 5



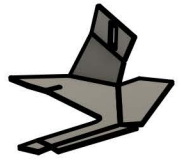
BEND 6



BEND TABLE		
ID	DIRECTION	ANGLE
1	UP	46.9
2	UP	45.0
3	UP	67.3
4	UP	70.3
5	UP	76.2



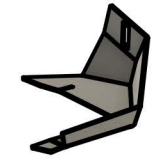
BEND 1



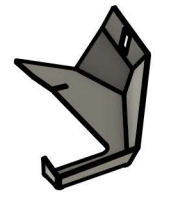
BEND 2



BEND 3



BEND 4



BEND 5