

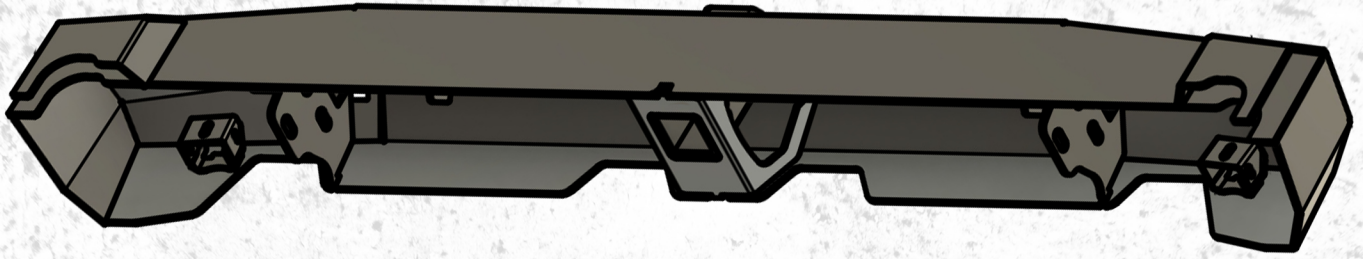
# INSTALLATION INSTRUCTIONS



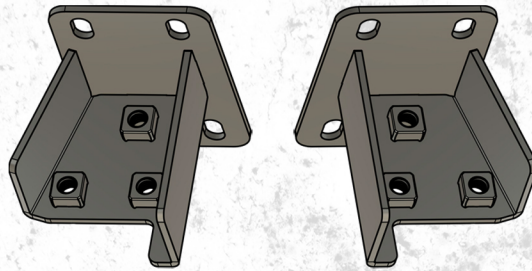
## RUFFSTUFF XJ REAR BUMPER

PART#: R2803

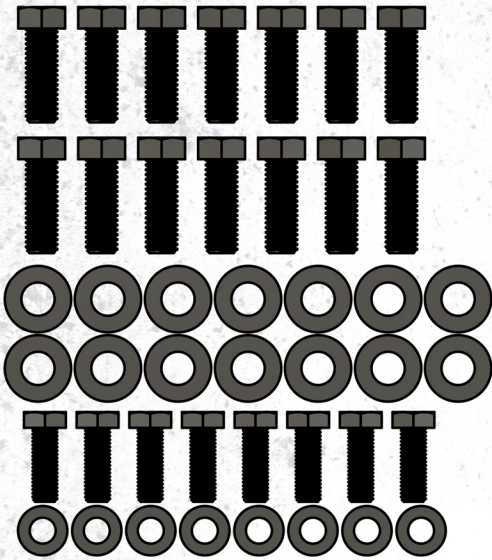
# KIT INCLUDES



R2803-WA



R2803-WD & R2803-WE



Mounting Hardware



R2803-WB & R2803-WC

# INSTALLATION INSTRUCTIONS

1. Remove factory bumper and mounts
2. Open the tailgate of the XJ
3. Cut the rear crossmember to fit the frame tie in brackets

To get the frame tie-in brackets installed, you'll need a few tools: a pneumatic body saw or a die grinder with a cutting wheel, along with the usual safety gear like gloves and safety glasses.

First, locate the two oval holes on the rear crossmember of the frame—they're right between the bumper mounting holes. These are the cutouts you'll be enlarging. Use your body saw or die grinder to carefully cut the sheet metal. Follow the inside edge of the frame rail as your guide. The key here is to make sure there's no leftover material obstructing the bottom or sides of the cutouts. The frame tie-in brackets need to bolt flush against the frame, so take your time and make the cuts clean and precise. A little extra attention here makes the final assembly much easier.

Before:



After:



# INSTALLATION INSTRUCTIONS

4. Slide the frame tie in brackets into the frame.



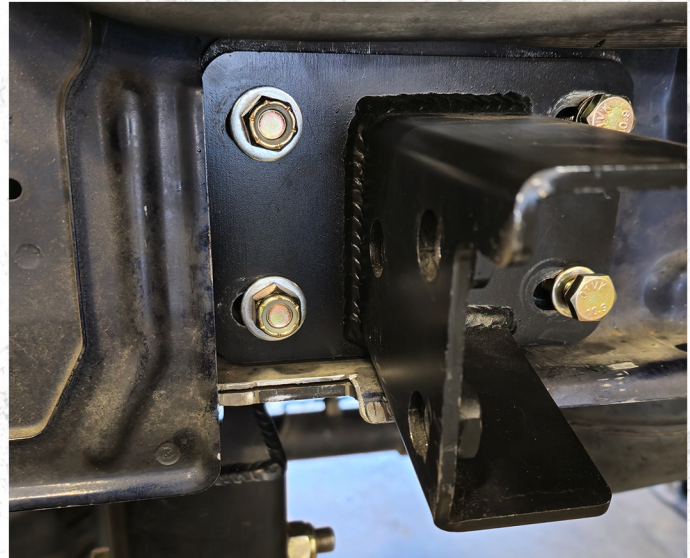
5. Hand thread the x8 M10 bolts through the bumper brackets and into the rear crossmember 2-3 turns.



# INSTALLATION INSTRUCTIONS

6. At this point you can make a small notch on the rear crossmember to aid with installation if necessary.

Depending on the year of your XJ trimming a small notch of the rear crossmember will make rear bumper installation easier.

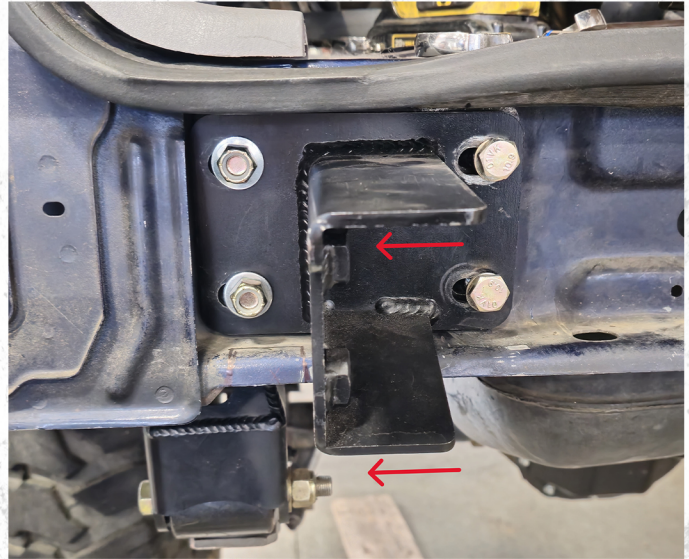


The notch will allow easier access for tools.



# INSTALLATION INSTRUCTIONS

Hand tighten the bumper bracket to the rear crossmember and slide towards the outside of the vehicle.

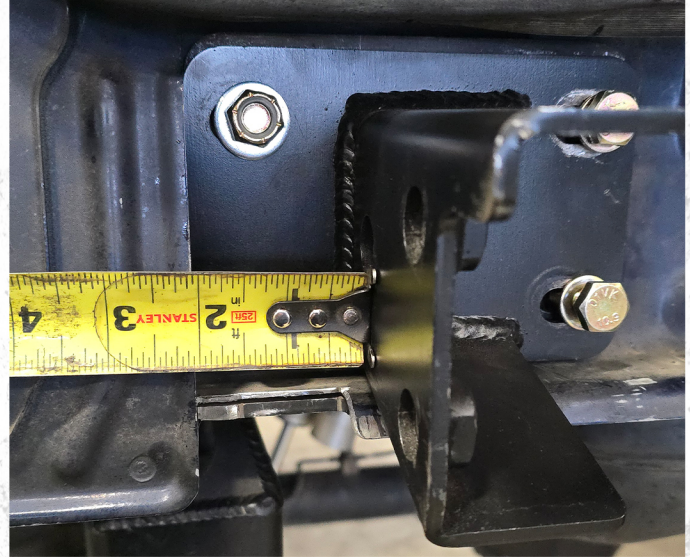


Mark flush with the outside of the bumper bracket.



# INSTALLATION INSTRUCTIONS

Mark two inches from the bumper bracket



Mark 5/8" deep on crossmember.



# INSTALLATION INSTRUCTIONS

Cut out area.



Deburr sharp edges.



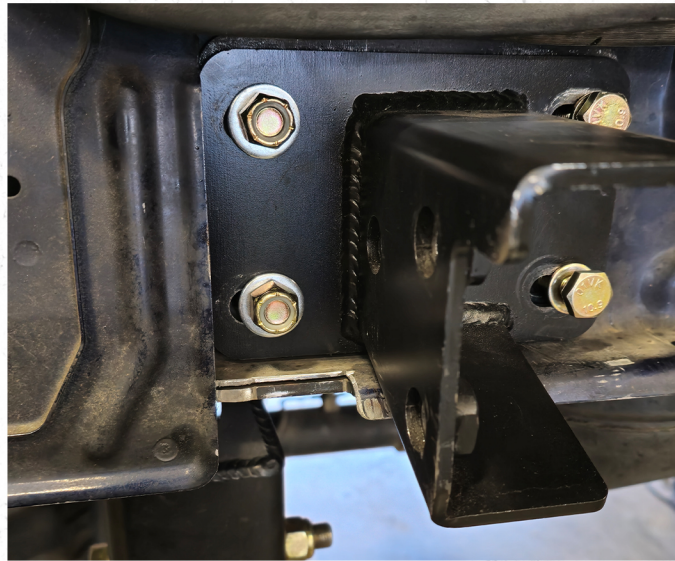


# INSTALLATION INSTRUCTIONS

The notch should look like this when done.

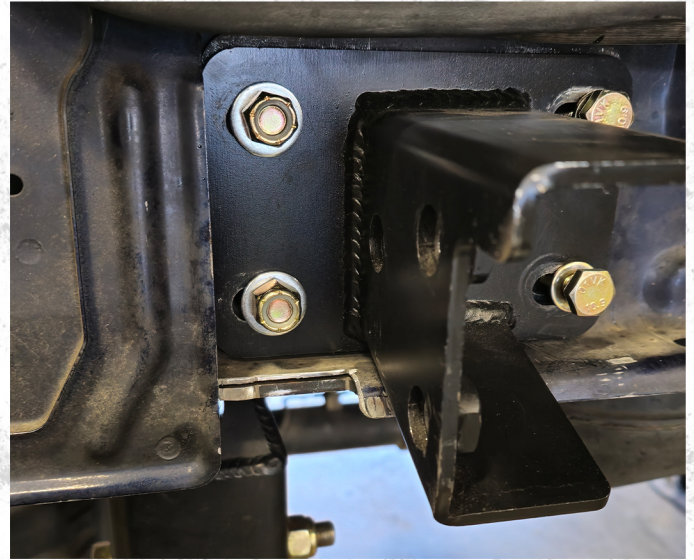


7. Install reverse lights into the light pockets of the bumper if applicable.



# INSTALLATION INSTRUCTIONS

The notch should look like this when done.



7. Install reverse lights into the light pockets of the bumper if applicable.
8. Set the rear bumper onto the bumper brackets and hand tighten the 6x 1/2" bolts into the bumper brackets.



# INSTALLATION INSTRUCTIONS

9. Hand thread the x8 ½" bolts in the bottom of the frame into the frame tie in brackets



10. Tighten the bolts for the frame tie in brackets
11. Close the tailgate
12. Align the bumper side to side and tighten the 8x M10 bolts in to the rear crossmember.



# INSTALLATION INSTRUCTIONS

13. Adjust the height of the bumper.

A. It is easiest with two people. Lift one side up, snug the bolts down. Repeat for the other side.

B. Check that the tailgate closes and adjust if necessary. A large soft face hammer works well for small adjustments here.

C. If a second person is not available, use a floor jack with a cut piece of lumber to slowly raise the bumper into position.

14. Tighten the remaining the bolts

