

Rusty's XJ Cherokee Rear Corner Cut Panels RA-2000-XJ/RA-2001-XJ INSTALLATION INSTRUCTIONS

Last Revised: 12/4/2017

Introduction:

Rusty's recommends that this installation be performed by a certified automotive technician or a person with professional mechanical knowledge. Installing this kit without this expertise may jeopardize the handling and safety of the vehicle.

Read instructions several times before starting. Be sure you have all the needed parts and know where they install. Read each step completely as you go. Exhaust modifications may be necessary. Prior to drilling or cutting, check behind the surface being worked on for any wires, lines, or hoses that could be damaged. After any drilling or cutting, remove burrs and grind smooth any surfaces. An inclinometer or similar tool may be needed to measure driveshaft angles before and after the installation.

Warning:

- It is the owners' responsibility to inspect all Rusty's products for proper torque specs to prevent loosening of components.
- Seat belts and shoulder harnesses should be worn at all times.
- Re-check all bolts and nuts after the first 100 miles and after any off-road usage during the first 300 miles.
- Although all of our products are made from the highest quality materials possible, they are not a substitute for Safe and Careful driving. In other words, have good safe on-road / off-road sense. Know the terrain, the speed limitations, and any obstacles that may lie ahead. Please remember to preserve our right to enjoy public land through the proper use of off-road vehicles.

Before Starting Installation:

1. Carefully Read all warnings and instructions completely before beginning.
2. Verify all parts have been received in this kit by checking the parts list on page#2 of this document.
3. Only install this kit on the vehicle for which it is specified.
4. Park the vehicle on a clean, dry, flat, level surface and block the tires so the vehicle cannot roll in either direction.
5. Be certain the vehicle is safely secured on jack stands or a vehicle lift prior to working around or under a vehicle. Never rely on a jack alone to support a vehicle's weight; use appropriately rated stands to support the vehicle's frame and any other heavy components.

Parts List:

Note: Please be sure that you have all the provided parts listed below before continuing with the installation.

Part #	DESCRIPTION:	Quantity
RA-2000-XJ-PS	Rusty's XJ Cherokee Rear Corner Cut Panels Passenger Side	1
RA-2000-XJ-DS	Rusty's XJ Cherokee Rear Corner Cut Panels Driver Side	1
08411266	1/4"-20 Knurled Threaded Nut Insert	8
67483762	1/4"-20 Serrated Flange Nut	6
67563080	1/4"-20 x 3/4" Length Button Head Cap Screw	14
09331745	1/4"-20 UNC Manual Threaded Insert Installation Tool	1

Installation Instructions

Note: Save all factory components and hardware for reuse, unless noted.

1. Remove any body trim molding from the rear corner on 84-96 models. Remove the rear bumper caps on 97-01 models.
2. Locate the bracket that is riveted on the side of the rear corner shown below. Drill out the rivets in order to remove this bracket.



3. Remove the fuel filler line skid plate by removing the four bolts accessed on the inside of the rear driver side corner. Save all hardware for re-use.
4. Remove the rear interior side panels and position them towards the center of the rear cargo area. Pull interior carpet from the edges towards the center to allow access for installation hardware in future steps and to prevent any damage to interior panels.



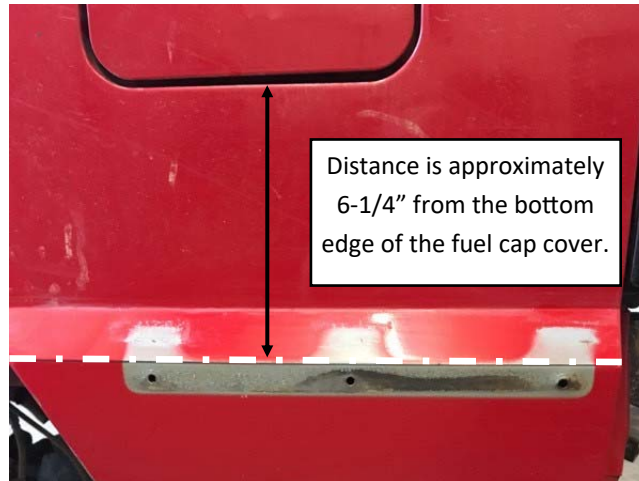
For Questions or Suggestions, contact our Tech Department (256-442-0607)

Installation Instructions (Continued)

Note: Save all factory components and hardware for reuse, unless noted.

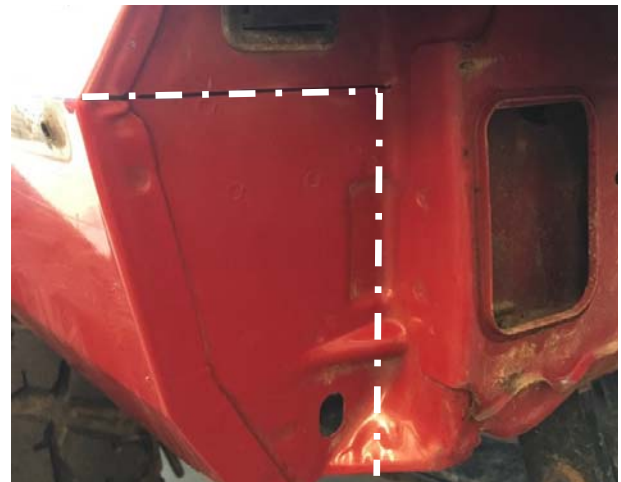
5. Mark your cut lines using a straight edge and permanent marker.

A.) The first cut line will be marked approximately 6-1/4" below the bottom of the gas cap door by aligning a straight edge with the center of body line shown below. (Note: Remember that your cut line will be on the bottom side of the line marked.)



B.) Extend the marked cut line around the back of the quarter panel, under the rear taillight as shown below. Use a straight edge and a level to keep the cut line even with the first marked line.

C.) Mark a vertical cut line that follows the line where the inward body seam meets the rear cross member as shown below.



D.) Mark the cut line located on the front side of the rear corner and the inner fender well using a similar process as in the previous step. Masking tape can be used to match the contour of the metal to ensure a straight cut line is made. (**Note:** Find where the inner fender and the floor meet prior to marking your cut line to ensure you do not cut through the floor. This area should be about 1/4" above the bottom edge of the inner fender.)



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Installation Instructions (Continued)

6. Apply masking tape along your marked trim lines from step 5 to create a seamless cut line. We suggest applying the tape on the top side of the lines marked to protect the painted surfaces.



7. With the use of a cut off wheel or your preferred cutting method, trim along the cut lines marked. It is suggested to begin the trimming from the inner fender well area working towards the rear. Once the long portion of the trim line is completed you can simply cut downward to get the majority of the material out of your way. This will allow you to carefully trim the area under the tail light. You will find that the outer portion of the rear corner is still held into position by the inner sheet metal. This material must be trimmed to remove the sheet metal where the cut lines have been trimmed. You need to trim the inner sheet metal until there is about 1" of material left below the floor board pan (**Note:** Use caution not to cut into the fuel lines or to cut into the floorpan during the trimming of this area.)
8. With the corner sheet metal trimmed and removed you can now cut vertical cuts in the 1" lip left of the sheet metal seam along the floor board pan. Take precautions to avoid cutting too high on the vertical cuts. Use a hammer and pliers to bend the sheet metal upward to create the required clearance to mount the Rusty's XJ Cherokee Rear Corner Cut Panels to the vehicle so that the mounting surface is flat.



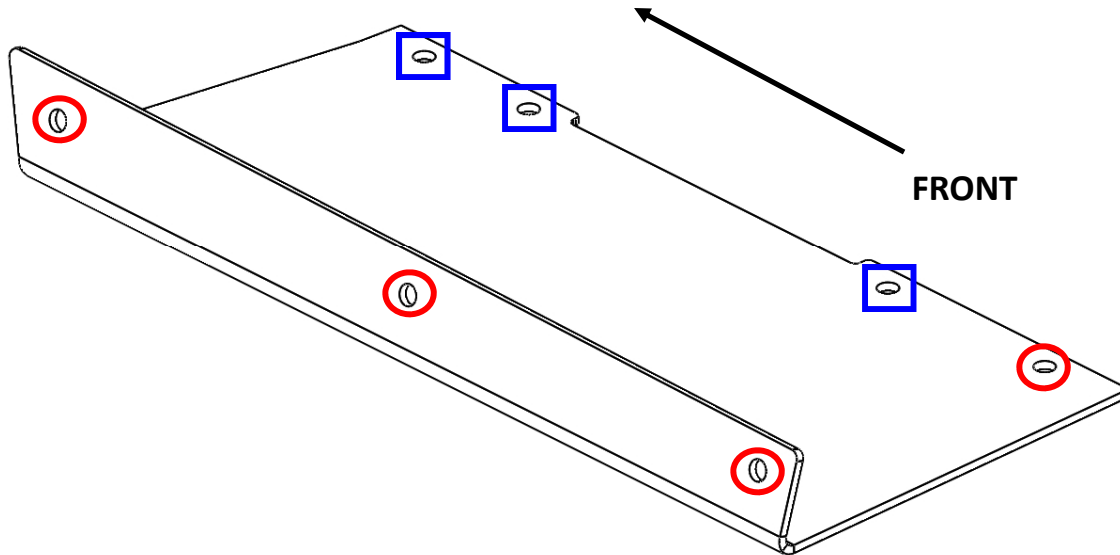
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Installation Instructions (Continued)

9. Place the supplied Rusty's XJ Cherokee Rear Corner Cut Panels into position. Check-fit the panels to ensure that there is not more trimming needed before continuing.
10. Once satisfied with the fitment of the panels, hold the panels firmly in place to complete the following steps. It may be helpful to have an assistant. Reference the diagram on the following page for the remainder of the installation process.
 - A.) Mark and center punch the three hole locations on side of the quarter panel.
 - B.) Mark and center punch the four hole locations on the bottom side mounting points.
11. Drill the three side hole locations to 3/8" (.375") marked in step 10-A. Take precautions to make sure you do not drill the holes too large. Using the correct drill bit is critical for this step.
12. Drill the four hole locations located on the bottom side in step 10-B. The first 3 hole locations starting from the front of the vehicle working towards the rear will be drilled to 5/16". The furthest hole location towards the rear of the vehicle will be drilled to 3/8" (.375").
13. Clean and deburr any sharp edges left from the trimming process.
14. Paint any exposed metal surfaces and let dry before continuing with the installation.
15. Install the supplied 1/4"-20 Knurled Threaded Nut Inserts (Qty:4 Per Side) in the hole locations drilled to 3/8" (.375"). Follow the instructions provided with the included 1/4"-20 UNC Manual Threaded Insert Installation Tool.
16. Attach the Rusty's XJ Cherokee Rear Corner Cut Panels to the vehicle using the supplied 1/4"-20 x 3/4" Length Button Head Cap Screws (Qty:14). Start all the bolts to hold the panels in position, then evenly tighten all the hardware to seat the panel to the factory body panel. Do not exceed 8 ft.- lbs. of torque on each bolt.
17. Repeat these steps on the other side of the vehicle. Installation is now complete.



Rusty's XJ Cherokee Rear Corner Cut Panel Hardware Reference Diagram



○ Drill hole to 3/8" then install 1/4" thread insert and fasten with 1/4" x 3/4 SS button head cap screw.

□ Drill hole to 5/16" then fasten with 1/4" x 1 SS button head cap screw and 1/4" serrated flange nut.

WARNING

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