

## Rusty's XJ Rear Trail Bumper w/ Receiver RA-BM20-XJ INSTALLATION INSTRUCTIONS

Last Revised: 10/18/2019

### 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.

<b>Part #</b>	<b>DESCRIPTION:</b>	<b>Quantity</b>
RA-BM20-XJ	Rusty's XJ Rear Trail Bumper w/ Receiver	1
RA-BM20-XJ-DM	Rusty's Rear Trail Bumper Driver Side Mounting Bracket	1
RA-BM20-XJ-PM	Rusty's Rear Trail Bumper Passenger Side Mounting Bracket	1
05728159	1/2"-13 x 1-1/2" Length Grade 8 Hex Head Cap Screw (Pre-Installed)	4
74254285	1/2"-13 x 1/2" Length Grade 8 Hex Head Cap Screw (Pre-Installed)	1
05724646	1/2" SAE Flat Washer (Pre-Installed)	5
67444729	M10 x 1.50mm x 30mm Length Hex Head Cap Screw	8
87919635	3/8" x 1" O.D. Flat Washer	8



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

## Installation Instructions

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

- 1.) Remove the factory or existing bumper at all mounting points. Retain the factory hardware at the frame mounting points. (4 per side, 8 total). If these bolts were removed you will need (Qty:8) 10mm x 1.5 x 30mm bolts.
- 2.) Remove the hitch if equipped. (optional)
- 3.) Install the driver and passenger side bumper mounting brackets with the factory hardware removed in step#1. The brackets are slotted for right to left adjustment. Center the slotted holes and torque all 8 mounting points to 55-60 ft. lbs.
- 4.) Place the bumper to the mounting brackets and using the supplied 1/2"-13 x 1-1/2" Length Grade 8 Hex Head Cap Screws and 1/2" SAE Flat Washers to fasten the bumper to the mounting brackets. (**Note:** Do not fully tighten.)
- 5.) Check the right to left alignment of the bumper, you will have slight adjustment in the bumper, if more is needed loosen the bumper brackets and adjust accordingly.
- 6.) Locate to the bottom of the rear frame connection plate (directly below the receiver hitch). There will be one existing hole that lines up the bottom mounting point.
- 7.) Start the 1/2 x 1/2 bolts & washer (do not fully tighten). In the receiver hitch support.
- 8.) Torque the outside facing hardware (4 bolts) to 85 ft. lbs.
- 9.) Torque the lower receiver hitch support bolt (1) to 85ft lbs.
- 10.) Installation is now completed!

## 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 300 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. Thank you for choosing Rusty's Off Road Products.



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