Rusty's Off-Road Products
7161 Steele Station Road
Rainbow City, AL 35906
1-256-442-0607
www.rustysoffroad.com

Rusty's JK Wrangler Rear Full Width Trail Bumper—Series 2
RJB5418JK
INSTALLATION INSTRUCTIONS

Last Revised: 5/25/23

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 an any other heavy components.

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Parts List:

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

Part #	DESCRIPTION:	Quantity
RJB5418JK	Rusty's JK Wrangler Rear Full Width Trail Bumper—Series 2	1
RC-ATN34	3/4" Angled Tab Nut	2
RC-DTN-10MM	3-1/8" Length Double 10mm Nut Washer	2
RC-RECTN-12	2" Square 1/2" Tab Nut	2
09889072	M10 x 1.50mm x 40mm Length Hex Head Cap Screw	4
87919635	3/8" x 1" O.D. Flat Washer	4
74454919	1/2"-13 x 1-1/2" Length Grade 8 Hex Head Cap Screw	2
02994929	1/2" SAE Flat Washer	2
67217901	3/4"-16 x 2" Length Hex Head Cap Screw (Silver)	2
02214427	3/4" SAE Flat Washer (Silver)	2

Parts List continued on next Page 3.

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Factory Rear Bumper Removal Instructions

1. Remove the two bolts from each side of the rear bumper brackets where they are attached to the frame rail using a 16mm Socket. (**Note:** Save these four 10mm bolts for reuse.)
2. Remove the two bolts located on the underside of the vehicle holding the rear plastic bumper to frame cross section (receiver hitch mounting point) using a 16mm Socket.
3. Open the vehicles rear door so that it is completely opened.
4. Carefully remove the rear bumper cover. (Note: It maybe necessary, in order to remove the rear bumper, to loosen or remove the two center mounting brackets to free the bumper.)
5. Remove the rear tow hook on the driver side frame rail if equipped by removing the two bolts on the side of the frame rail and the single one on the bottom side using a 19mm socket.

Installation Instructions

1. Install the supplied 3/4" Angled Tab Nuts into the frame rail as shown in the image below. Repeat for both driver and passenger sides. Position so that the tab can be accessed through the opening shown beside the rear body mount to allow for aligning the nut when installing.

Driver Side

Passenger Side

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Installation Instructions

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

2. With the help of an assistant. Position the Rusty's JK Wrangler Rear Full Width Trail Bumper and install the reinstall the factory 10mm in the forward most mounting holes. Do not fully tighten at this time, you will need to leave loose enough to adjust bumper fitment as needed. (**Please Note:** In some cases if you are running a receiver hitch it maybe required to cut the threads of the 4 bolts flush with the nut to allow for fitment.)
3. Install the supplied 3/4"-16 x 2" Length Hex Head Cap Screws and 3/4" SAE Flat Washers through the hole location towards the rear of the bumper mounting plates. Align the 3/4" Angled Tab Nuts to begin tightening the hardware.
4. Align bumper fitment at this time by looking at the side and rear views to ensure correct fitment. Once aligned tighten the installed hardware to hold securely into position. You do not have to tighten completely at this time since the hardware will be removed in the following steps.
5. On the bumper lower frame mounting locations you will need to mark and drill. We suggest using the bumper to help mark and help to pilot these holes. Drill 1/2" holes in each side of the frame rail.
6. Remove the rear bumper at this time by removing the installed hardware, leave the 3/4" Angled Tab Nuts inside both driver and passenger side frame rails as shown in the image below

7. Clean the metal shavings from the inside of the frame rail and position the supplied 2" Square 1/2" Tab Nuts inside the frame rail and align with the drilled hole location from the step 10.
8. Reinstall the rear bumper by repeating steps 6-7.
9. Install the supplied 1/2"-13 x 1-1/2" Length Grade 8 Hex Head Cap Screws and 1/2" SAE Flat Washer in the bumper lower frame mounting locations. Tighten to allow the bumper to pull close to the frame rail. Do not fully tighten at this time.

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Installation Instructions

10. Align bumper fitment at this time by looking at the side and rear views to ensure correct fitment. Once aligned tighten the installed hardware to hold securely into position.

11. Installation is now completed.

WARNING

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