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# **R-SPEC FRONT BUMPER**

## **INSTALLATION GUIDE FOR JL/JT**

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**PTN/S: -14Z5Z6-2RSK-\_\_ - \_\_ - \_\_**

PLEASE READ THE FULL WARNING SECTION OF THIS INSTALL GUIDE BEFORE PROCEEDING

*R-SPEC, OFF ROAD CONCEPTS, AND ALL VERSIONS OF THE OFF ROAD CONCEPTS LOGO ARE TRADEMARKS OF ORC DESIGN LLC.*

# STOP!



## WARNING

### **READ BEFORE CONTINUING WITH YOUR INSTALLATION**

The installation of a frame chop bumper is an irreversible modification that removes the OEM front crash structure. It could potentially void your vehicle's factory warranty. This product is designed for off-road use only. As such, it may not comply with DOT or road safety regulations in your state, and is not intended for use on public roads and highways. By purchasing and installing this bumper, you assume all risks and responsibilities that come with modifying your vehicle in this way. ORC Design LLC, DBA Off Road Concepts is not responsible for the injury or death of the driver, occupants of his or her vehicle, the driver or occupants of another vehicle that collides with the vehicle this product is installed on, or any bystanders, both on and off road.

This installation requires multiple tools and advanced skills. Only professionals and experienced fabricators should install this product. If this is not you, please email us at: [support@offroadconcepts.com](mailto:support@offroadconcepts.com) to locate an ORC licensed installer near you.

# SECTION A: REMOVING THE STOCK BUMPER AND PROTECTING YOUR VEHICLE

## A1: REMOVE THE STOCK BUMPER.

If you are unfamiliar with this process, here is a great video to guide you through.  
JL: [https://www.youtube.com/watch?v=U2CFjGSGi3g&ab\\_channel=Northridge4x4](https://www.youtube.com/watch?v=U2CFjGSGi3g&ab_channel=Northridge4x4)

## A2: REMOVING THE GRILLE

We highly recommend removing the grille to install this bumper. Although not technically necessary, the sparks from cutting the frame can very easily damage paint and plastic on your grille.

Here are some videos on how to do this if you are unfamiliar with the process.  
JL: [https://www.youtube.com/watch?v=ILleBtsSjQ&ab\\_channel=Quadrattec](https://www.youtube.com/watch?v=ILleBtsSjQ&ab_channel=Quadrattec)

## A3: PROTECTING YOUR HEADLIGHTS

As with the paint on the grille, the plastic headlight covers can be easily damaged by the sparks. Simply cover them with some blue painters tape.

## SECTION B: MODIFYING THE FRAME

### B1: MEASURING THE FRAME

Measure 4 inches out from the front of the front body mount gusset. At the 4 inch mark draw a line around the entire frame to guide your cut. The image below shows how the frame should look once cut.



*TIP: Measure twice and cut once\**

## **B2: CUTTING THE FRAME**

Cut all the way down your cut mark.

*TIP: We recommend using a sawzall with a new metal blade. You can also use an angle grinder with a sharp and thin cutting blade, however this will take much longer and is harder to keep the cut straight\**

## **B3: CUTTING STOCK SWAY BAR SUBFRAME**

Cut along the lines shown below to remove the stock sway bar subframe. Grind down the remaining sheet metal and welds until they are smooth.



## **B4: STRENGTHENING THE FRAME**

If your Jeep is going to see heavy trail use we highly recommend strengthening the notches from the removed sway bar subframe.

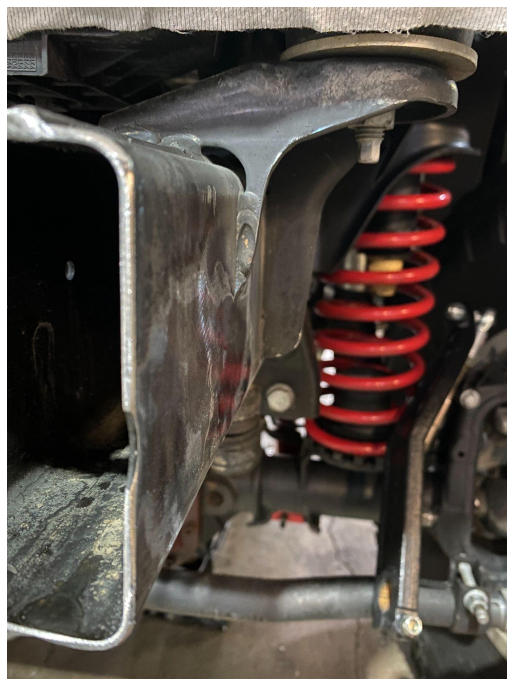
These notches are weak areas that could crumple in a serious impact or rollover. Weld in these notches and grind them smooth as shown below.





## B5: GRINDING BODY MOUNT GUSSETS

Grind down the body mount gussets as shown below.



## C: INSTALLING THE BUMPER

### C1: BUMPER FITMENT.

*NOTE: On road SUVs and light trucks like the Jeep Wrangler are designed to absorb energy in an accident on the road by deforming in key areas, the frame caps being one of them. This is great at keeping you safe in an accident, but very bad off road. A slight impact on your front bumper, or even a hard tug while being recovered can slightly tweak these frame caps. We have taken this into consideration.*

There is about 1/16" of a gap in the bumper to the outside of a factory fresh frame. Depending on the condition of your frame, we have found in most cases, this is perfect for fitment. The notes below are for your specific scenario.

A: Metal on metal "snug fit." You should have to use a rubber mallet to install the bumper.

This is perfect. You're good to go!

B: There is a slight gap between the bumper and the frame 1/64"-1/8".

In this scenario you only need to shim one or both sides of the bumper an incremental amount.

We recommend using different thickness M16 grade 8 or 10 zinc washers.

**DO NOT under any circumstances try to pull the frame and bumper together using the force of the bolts during install.**

**This will only pull the metal surrounding the bolt towards the bumper, making the situation even worse.**

C: There is a large gap between the bumper and frame 1/8" or more.

In this scenario there are only three options: If the gap is 1/4" or less, you can use thick washers to take up the gap. If the gap is more than 1/4" the only remaining options are to either cut the entire frame cap off and re-weld a new OEM frame cap in its place or have your local body shop to straighten the frame. The same is the case if the frame is bent outward, ie: the bumper won't fit between the frame caps.



## C2: MARKING THE HOLES

Slide the bumper onto the frame,  $\frac{7}{8}$ " from the front of the back body mount gussets, as shown below. Use a felt tipped pen to mark the holes to be drilled.



**IMPORTANT:** Please double check this distance for your winch. Different winches may require different spacing of the install. This measurement works for most BUT NOT ALL of Warns winches\*

## C3: DRILLING HOLES

Center punch the hole, and use a small drill bit to make a pilot hole  
Use a  $\frac{43}{64}$ " drill bit to make the final hole

## **C4: PAINTING THE FRAME**

The first step is to sand down the surface to remove any existing paint. After that, clean the surface thoroughly with isopropyl alcohol and let it dry completely. Choose the right type of paint for your frame and apply it with a spray gun or brush, being sure to follow the manufacturer's instructions. We recommend Steel It (Black). Allow the paint to dry as stated in the manufacturer's instructions.

## **C5: FINAL INSTALLATION**

To install this frame chop bumper, first slide it into place and align it with the pre-drilled bolt holes. Install the M16 bolts, reaching through the open grille to attach the nut on the inside of the open frame cap. Double-check the alignment and make adjustments if necessary. Torque the bolts to 100 ft/lb.

## **C6: RE-INSTALL THE GRILL**

Re-install the grill and remove the tape covering the headlights.

# **D: WRAPPING THINGS UP.**

## **D1: INSTALLING WINCH**

Place your winch on the bumper, directly above the pre drilled holes. The pre-drilled holes will accept most winches as the dimensions are 4.5" X 10". Make sure the nuts inside the winch are aligned properly. Next, reach through the open grille holes to install the winch bolts from the bottom. Torque to specifications listed by the winch manufacturer.

## **D2: INSTALLING GRILLES**

Insert with the flat portion of the u-nuts facing outwards. Use a pair of needle nose pliers to hold the grille in place while tightening the M8 dome heads. This should be done gently so as to not mar the surface of the grille.

Torque the dome head bolts to 10 ft/lb or snug with a  $\frac{3}{8}$  drive wrench.

### **D3: INSTALLING ANTIROCK SWAY BAR**

The frame chop bumper comes with pre-drilled holes to accept most aftermarket sway bar systems, but it is not guaranteed. The Antirock sway bar system from Rock Jock is a guaranteed fit. To install the Antirock sway bar, you should refer to the factory installation instructions provided by the manufacturer. Please note that you will have to deviate slightly from the factory instructions for one step. The Anitrock mounts that attach to the frame chop will need to be flipped 180 degrees to push the Antirock system closer to the front axle.



**THE INSTALLATION OF YOUR R-SPEC FRONT BUMPER IS COMPLETE. ✓**

Have any questions? Comments? Concerns?  
We love to hear feedback from our customers!

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