



## PART #'S JJ8021 & JJ8022

### JK/JL/JT BANTAM SERIES FROM BUMPER



#### ESTIMATED INSTALLATION TIME

3 to 4 hours

#### REQUIRED SKILLS

- General Mechanics Skills
- Cutting and Drilling Skills
- Measuring Skills

#### REQUIRED TOOLS & SUPPLIES

- 3/4" socket
- 9/16" socket
- 7/32" allen wrench
- 18mm socket
- 16mm socket
- 15mm socket
- 10mm socket
- 15mm wrench
- Sawzall/Grinder with cutting disc
- Grinding disc/flap disc
- Square/tri square
- Marker
- Paint (for post cut frame)
- Unibit/drill bit set
- Safety glasses
- Center punch
- Hammer
- Measuring tape/ruler

#### NOTES:

- Component appearance in instructions may vary from those received

## WARNING MESSAGES

This product demands a basic understanding of mechanical procedures and should only be installed by individuals proficient with mechanic's tools. Any tasks involving welding or cutting parts should be performed by trained professionals. Artec Industries disclaims responsibility for mishaps arising from improper installation, or any damage or accidents resulting from cutting or welding tasks. Exercise caution and seek professional help as required

## SAFETY

1. We've furnished a written installation guide, along with relevant details, to aid you in making safety-conscious decisions.
2. While these guidelines will highlight potential risks, it's crucial to exercise your personal judgment when performing any required steps.
3. Before initiating any tasks, it's essential to conduct a job safety analysis to identify specific hazards in your situation and take measures to eliminate or protect against them.
4. Before commencing the installation of this product, make sure you familiarize yourself with and fully understand all safety warnings and guidelines.

## DISCLAIMERS

All Artec Industries products should be installed by a competent, certified individual following the intended installation instructions for each product. Incorrect installations not only nullify any warranties but could also lead to product damage or even damage to the vehicle it's installed on. Prior to installation, carefully read all provided instructions or manuals, and watch any associated videos. For any doubts or queries, reach out to Artec Industries before beginning the installation process.

Many products necessitate lifting and supporting the vehicle off the ground. It is the installer's responsibility to ensure this can be done safely and that the right equipment is at hand to carry out the installation. Artec Industries installation instructions presume the installer is competent to lift the vehicle safely and correctly.

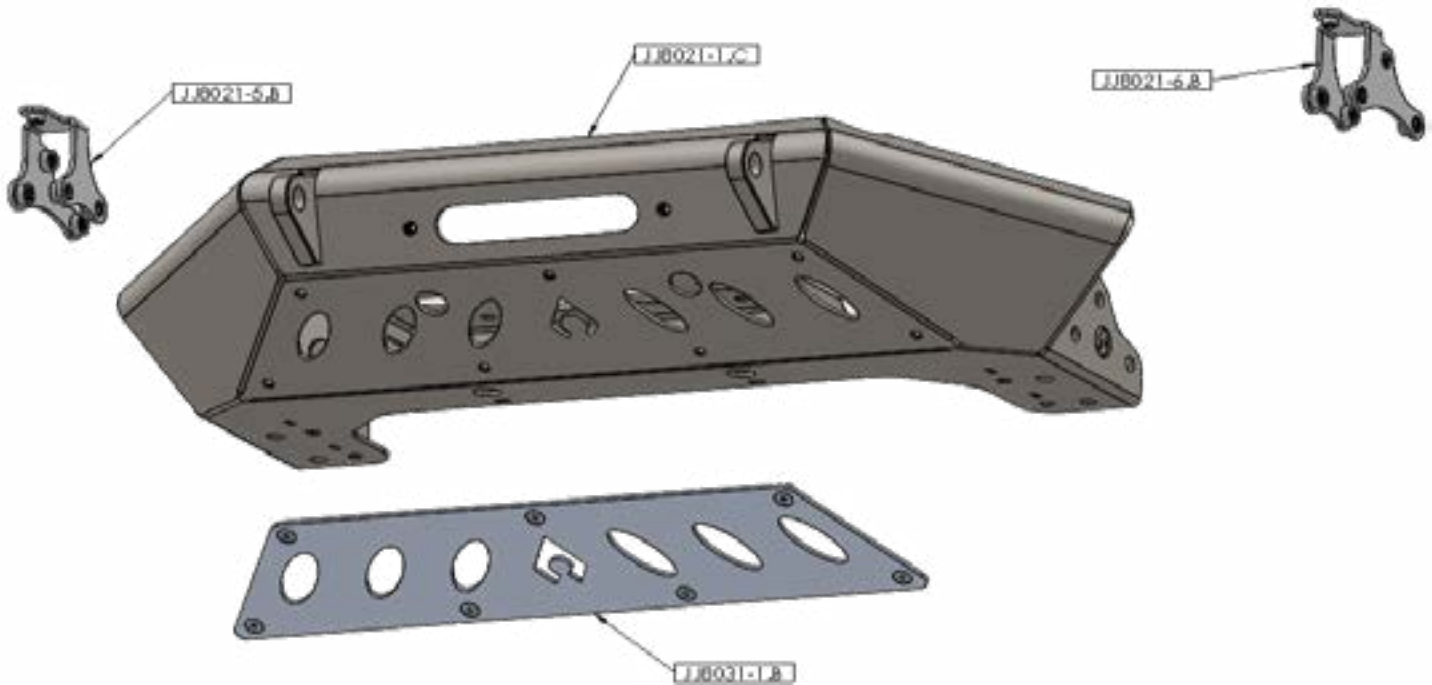
Modified vehicles won't perform identically to their stock counterparts. It's incumbent upon the vehicle owner to understand the alterations such modifications will bring to the vehicle's driving dynamics. These might encompass (but aren't limited to): changes in handling, braking, rollover angle, and potential incompatibilities with the factory-installed anti-lock braking systems, stability control systems, or traction control systems.

## SPECIAL NOTES

- This part will require you to modify your frame to install.

## JL5606/JL5614 PARTS BILL OF MATERIALS

Please confirm you have all the listed parts below BEFORE beginning your installation. If any parts are damaged or missing, KEEP ALL ORIGINAL BOXES and PACKAGING and contact us.



NOTE: The part numbers indicated above end in a "." and "letter" which indicate the revision number for the part. The etched part number on your physical parts do not need to match the above drawing revision exactly.

## HK5606.A HARDWARE BILL OF MATERIALS

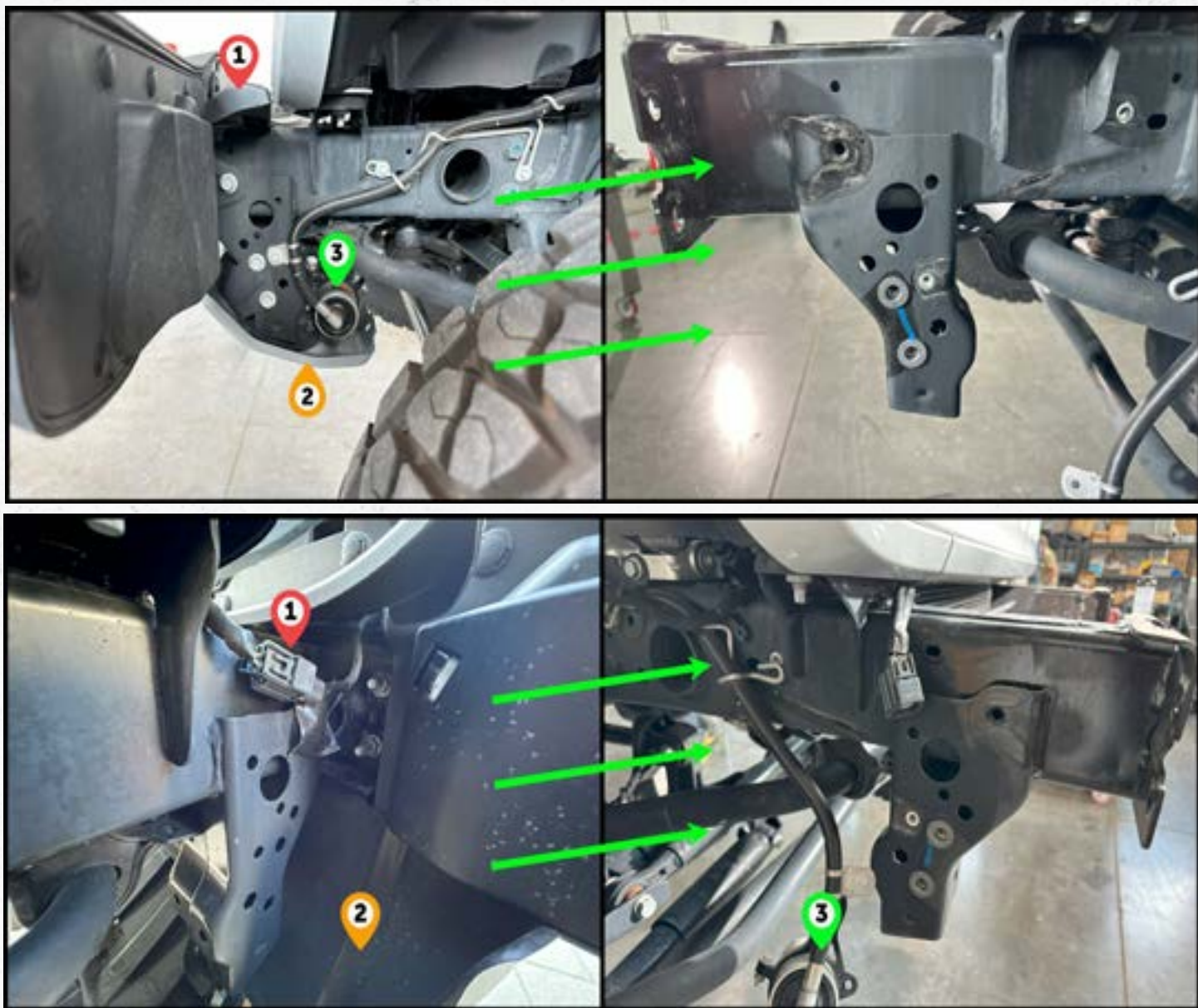
### HK8021

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	HW0012	1/2"-13 x 1 1/4" Grade 8 Hex Head Cap Screw Yellow Zinc	10
2	HW0034	3/8 x 16 x 1 Button Head Cap Screw Alloy Steel	2
3	HW0058	3/8"-16 x 1.0" Long Grade 8 Hex Head Cap Screw Yellow Zinc	4
4	HW0066	1/2" F436 Flat Washer Type I Yellow Zinc	10
5	HW0122	3/8" Flat USS. Washer Zinc	4
6	HW0147	.375" Countersunk Aluminum Washer	2
7	HW0185	3/8" x 1.5 Countersink Allen Head Bolt - Zinc	2

**STEP LOCATION GUIDE**

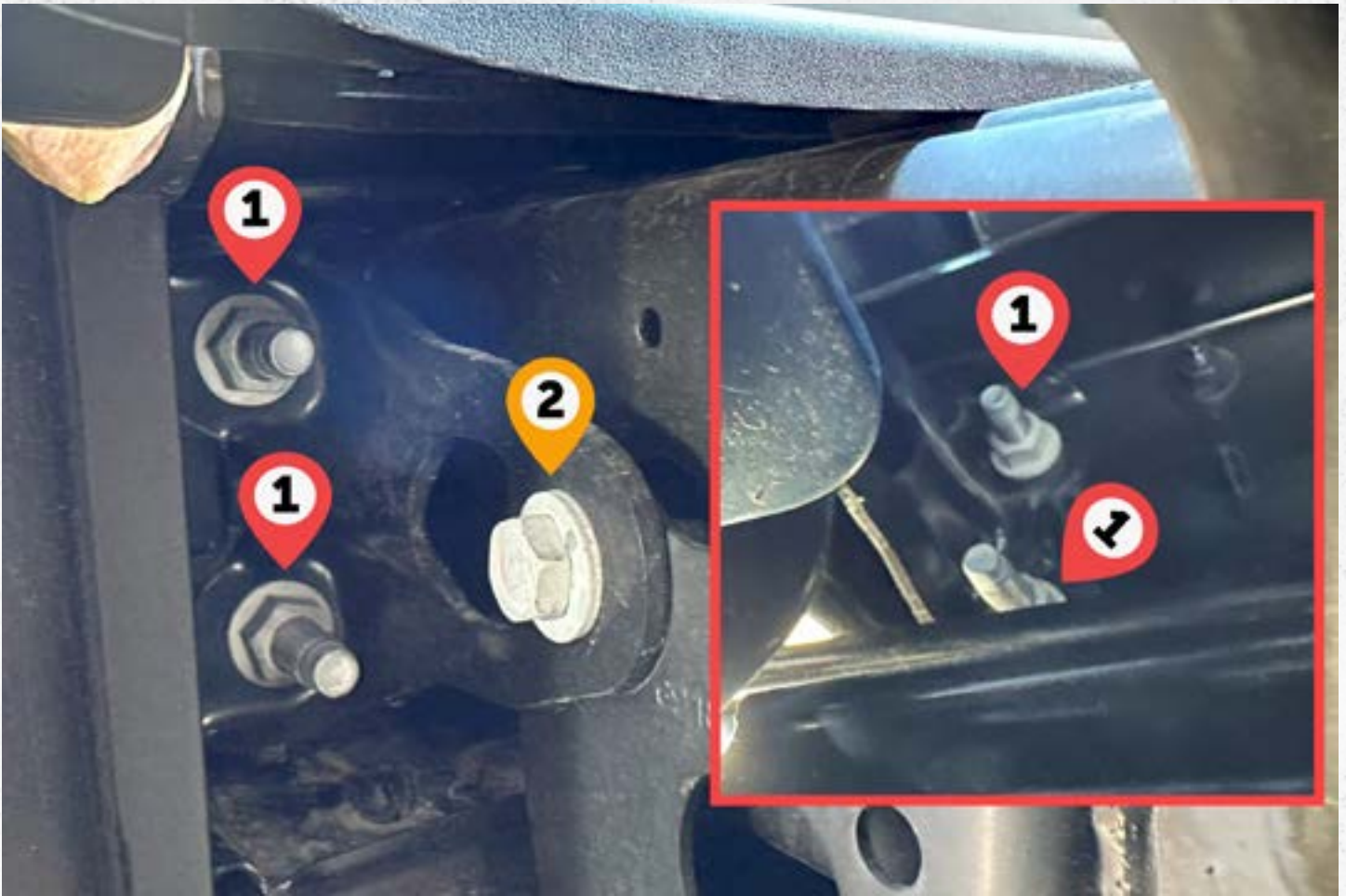


## DISASSEMBLY INSTRUCTIONAL GUIDE



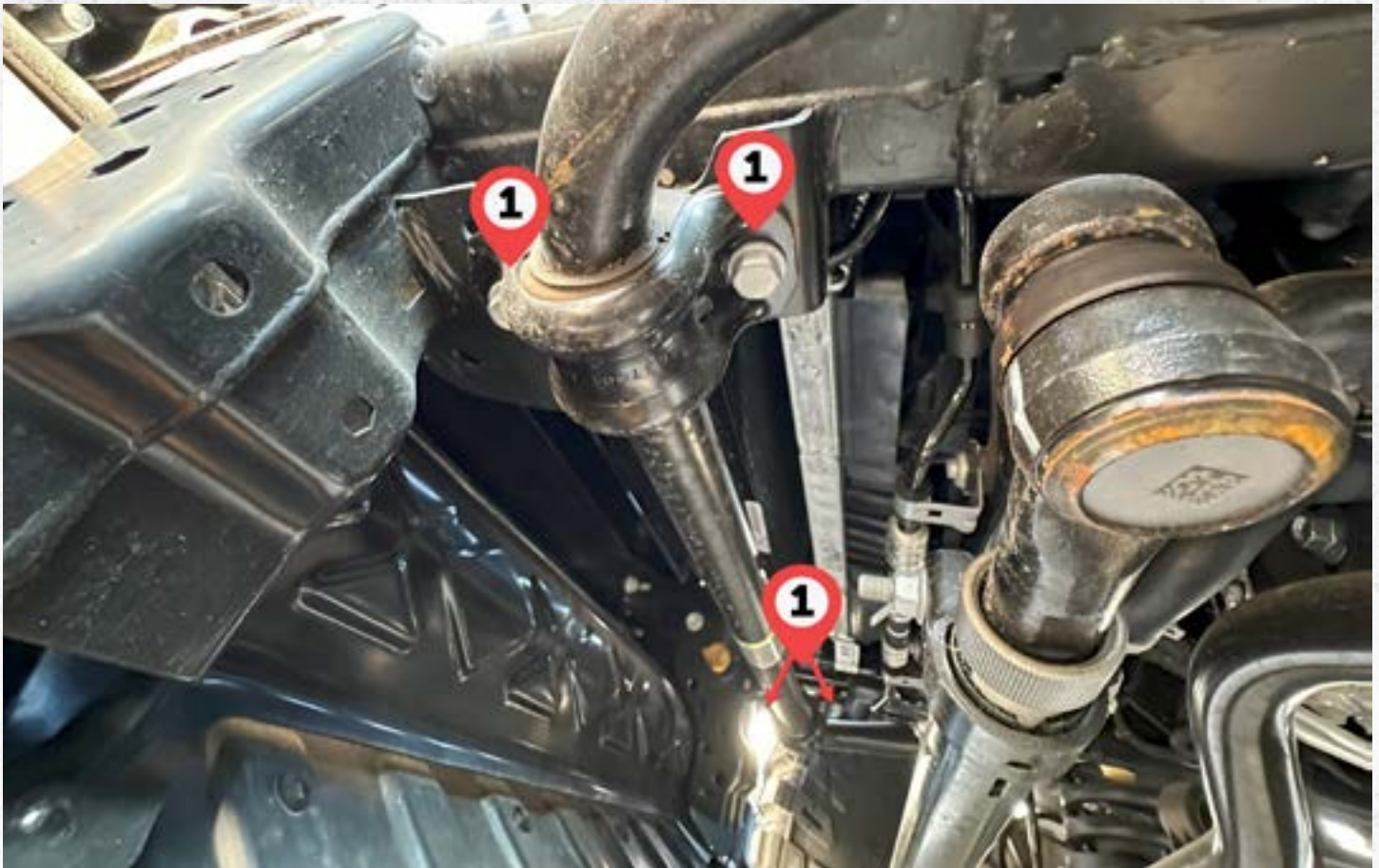
### Step 1:

Depending on your particular configuration, you will need to remove any hardware/components attached to the front bumper, and the front skid plate support pillar. IE the lights, remote resevoirs, front skid plate. Your front frame sections should look like the images on the RIGHT when you're done.



**Step 2:**

To disassemble the front bumper, using a 18mm socket to remove the 8 - ❶ M12 OEM nuts and the 4 - ❷ M12 bolts.



**Step 3:**

Disconnect the sway bar from the frame using 15mm socket remove the 4 - ① M10 OEM bolts.



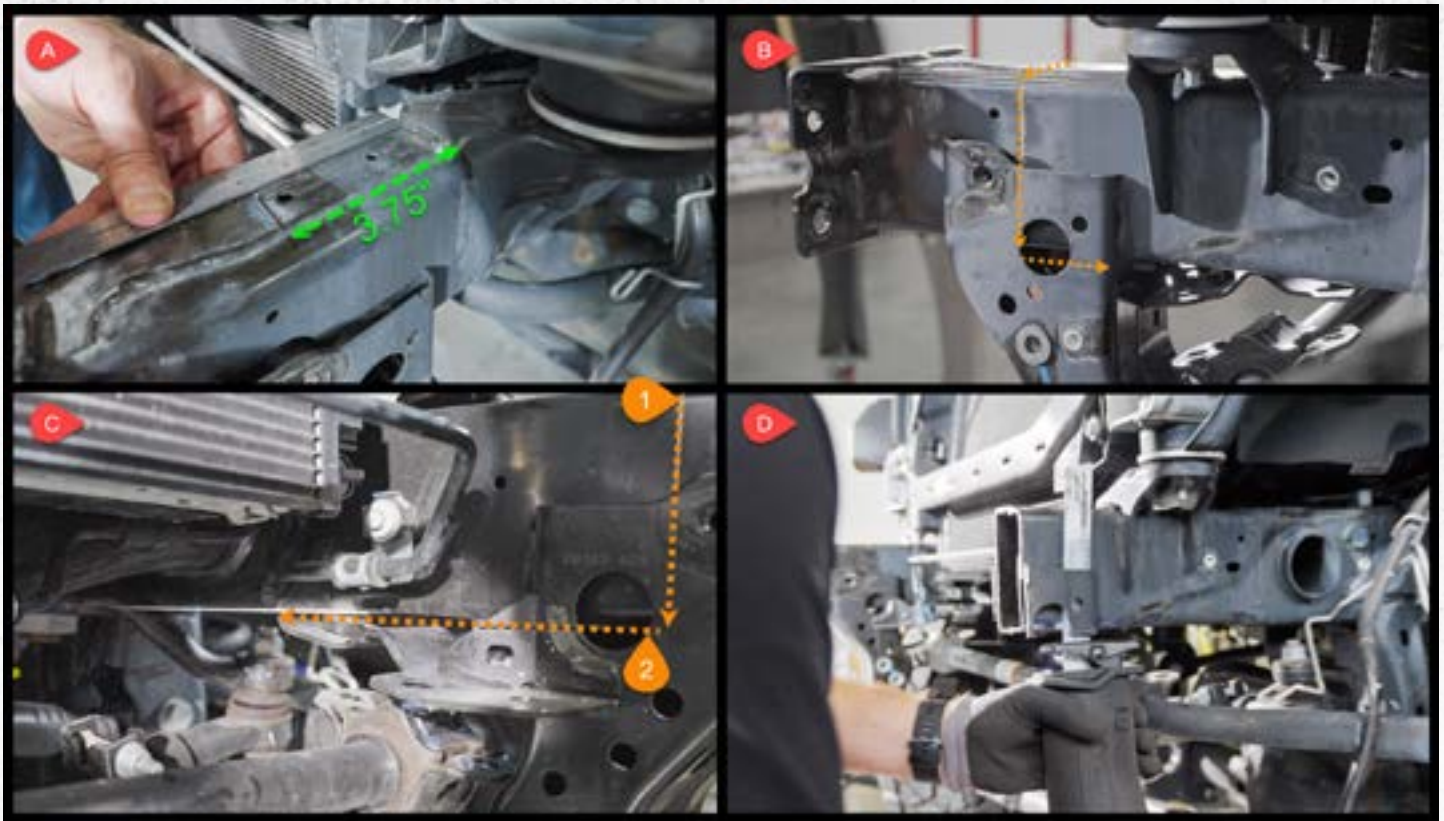
#### Step 4.

A: To allow enough room to work, remove the grill by first pulling the 6 - ① push pin retainer clip retainers. You will need either a trim tool or a small to remove these retainers.

B: Once the 6 retainers are removed, you can detach the grill by pulling at the base as shown, and then lifting it off.

NOTE: This should go pretty smoothly, however there are times the metal clips at the base of the grill will detach in the process but you can usually reattach them.





#### Step 5:

**A:** Once you have removed the front bumper, any additional equipment, and the grill you are ready to mark the frame and cut it. The key measurement is **3.75"** from the FRONT CORE SUPPORT as shown above.

**IMPORTANT NOTE:** make sure you don't measure from the core support weld, but the core support itself.

**B:** Using a square, transcribe the measurement around the frame as shown above.

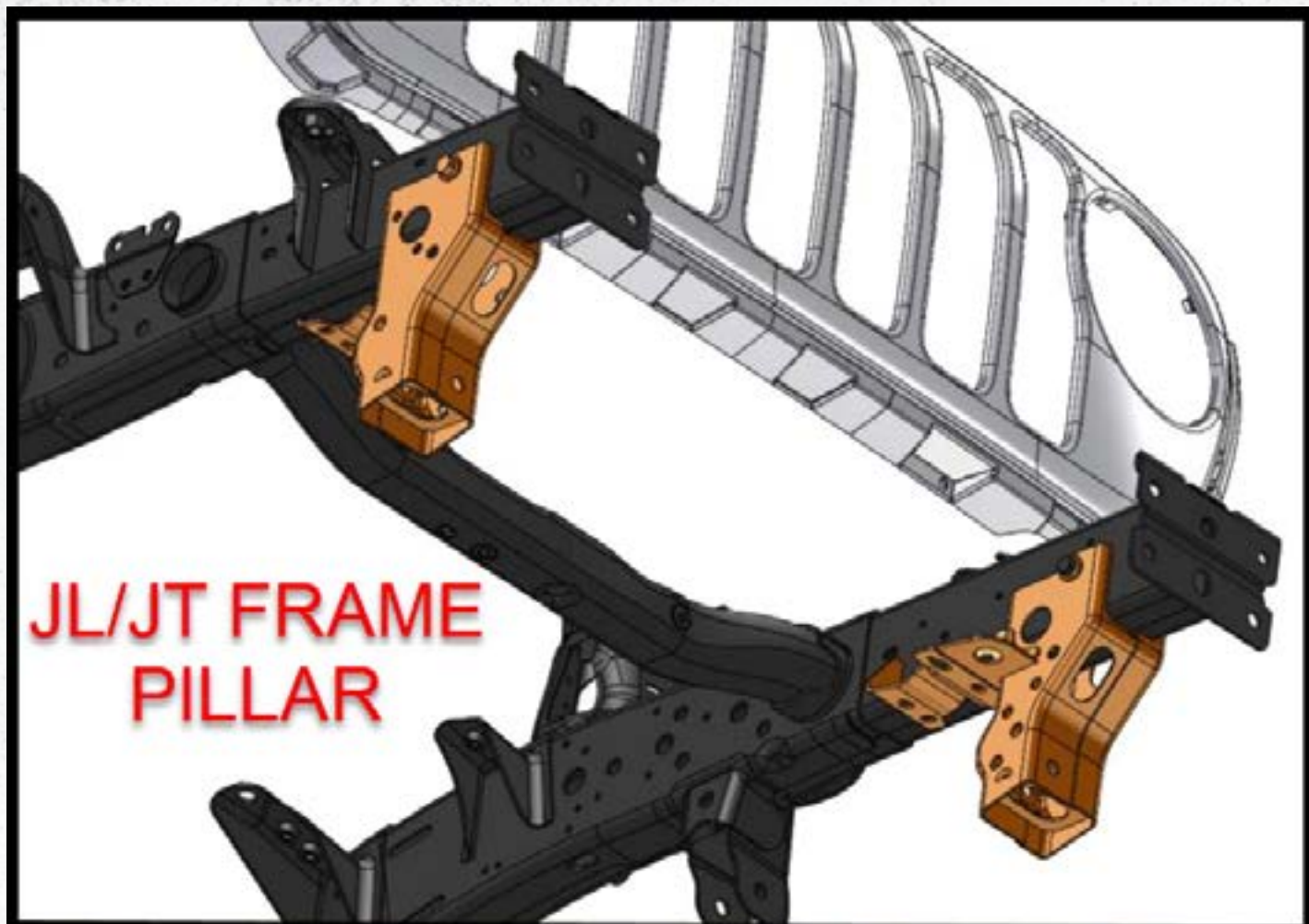
**C:** Using a sawzall (preferred) or cutting wheel, **1** make the vertical cut down. It *should* end in that large hole in the pillar for the JL/JT. *The JK pillar is different and will require you to cut the pillar off separately.* **2** cut horizontally to remove what is left of the pillar and remove the sway bar frame mount.

**IMPORTANT NOTE:** Suggest you cut the frame a little long leaving you some extra material to work with when squaring the face and cleaning it up.

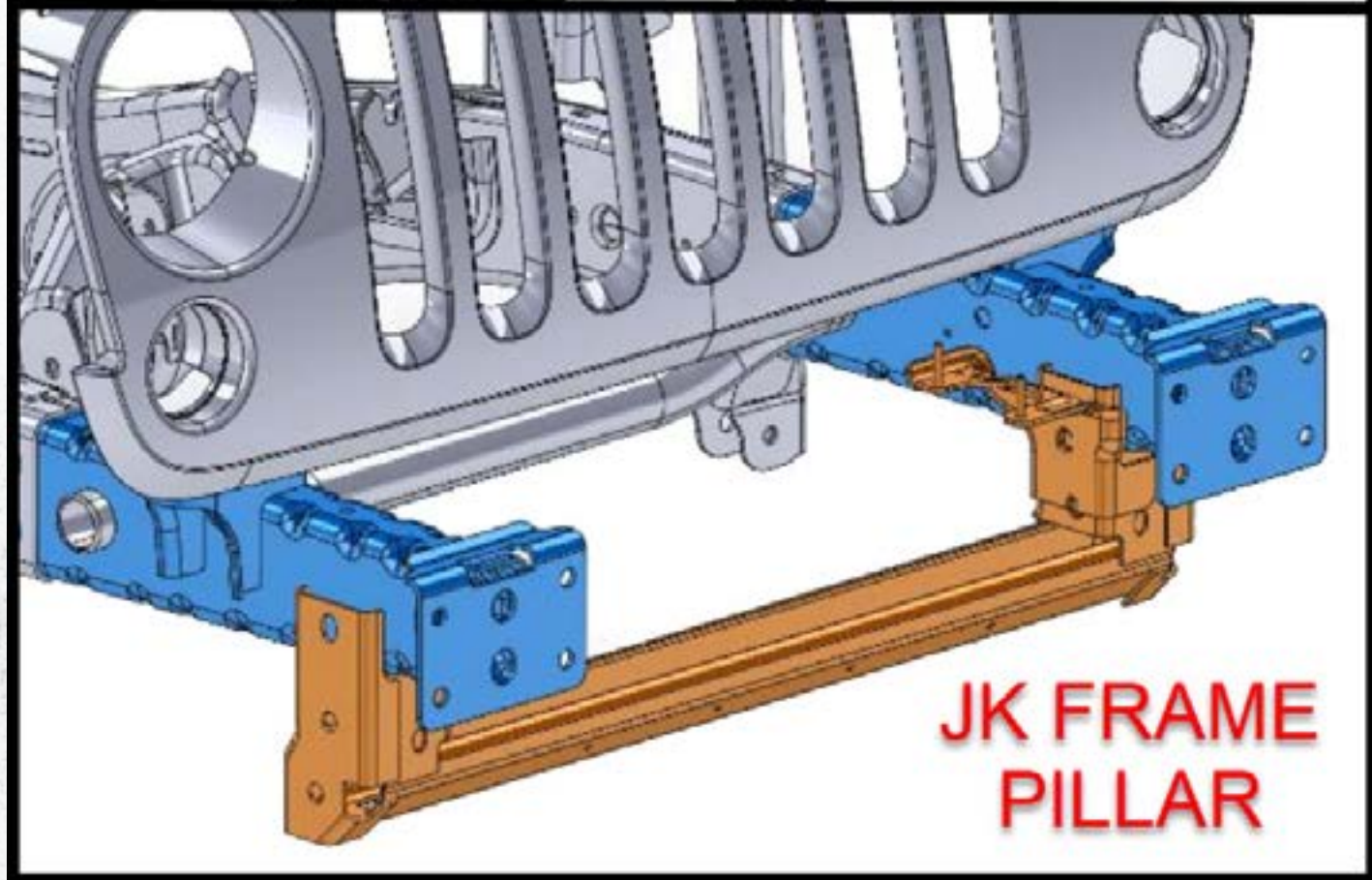
**D:** Clip off the remnants.

**NOTE:** You will disconnect the power steering hard line at a later step. Leaving it mounted will keep it out of your way during the cutting and prepping process.

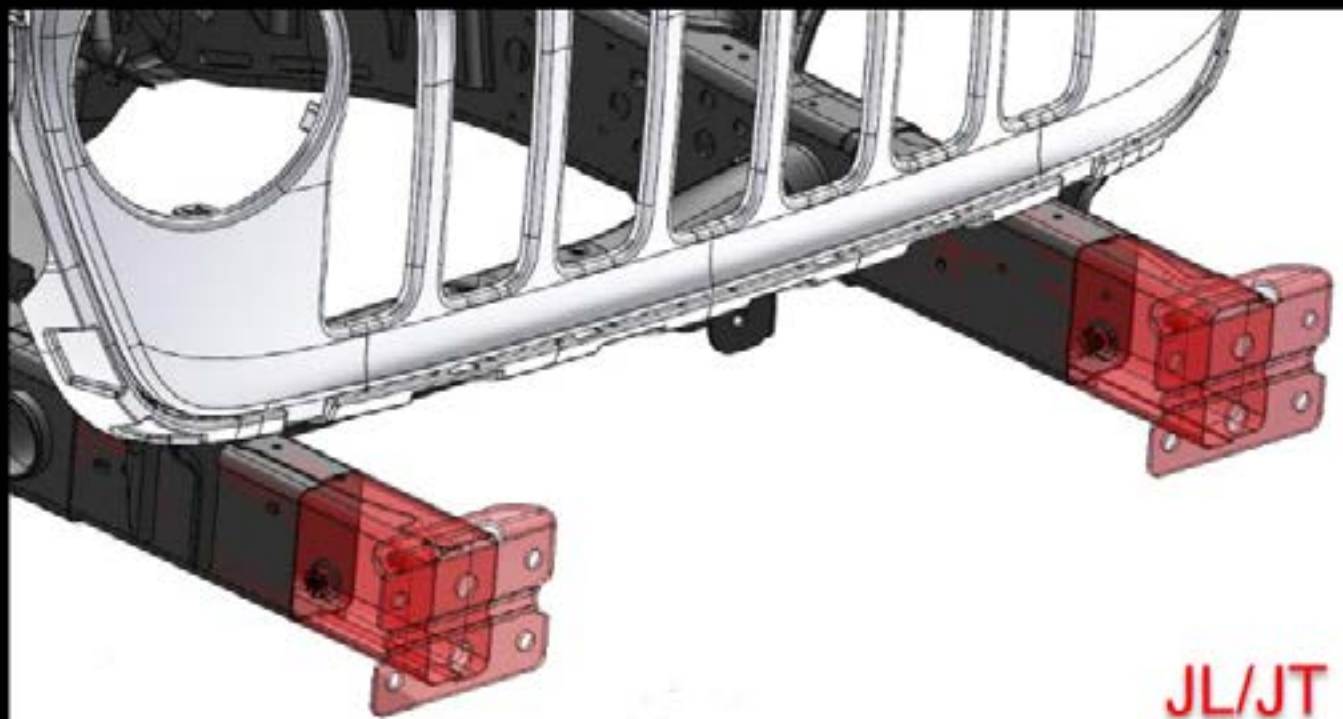
SEE THE FOLLOWING REFERENCE MODELS FOR MORE INFORMATION



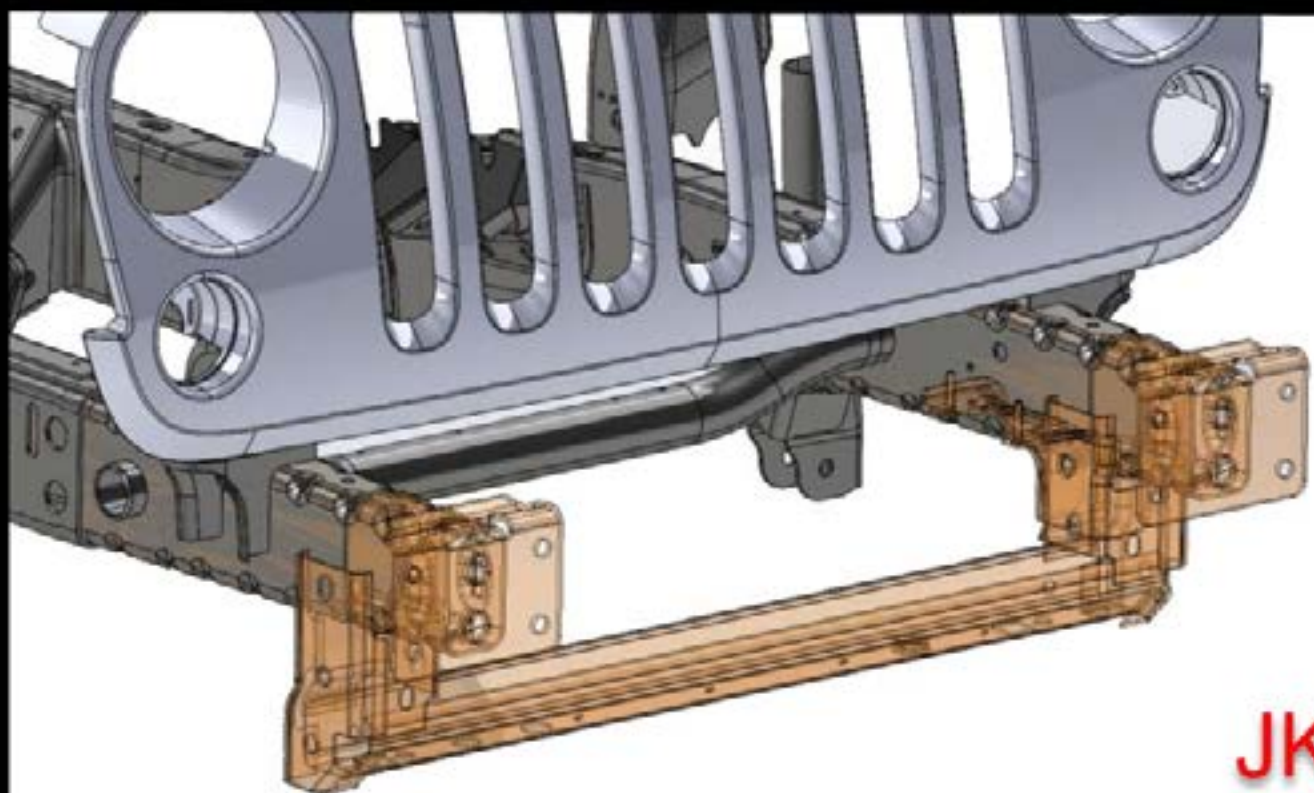
**JL/JT FRAME  
PILLAR**



**JK FRAME  
PILLAR**

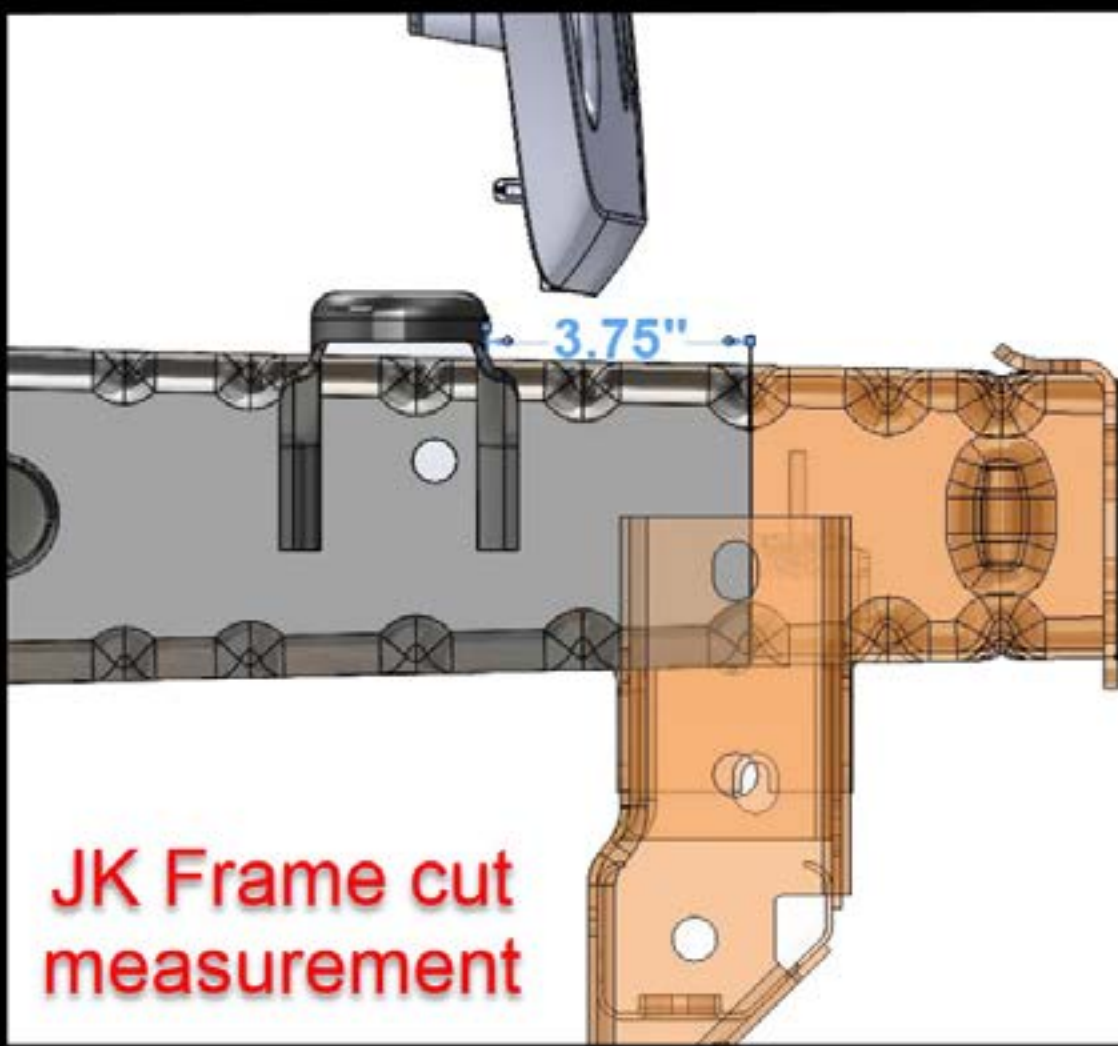
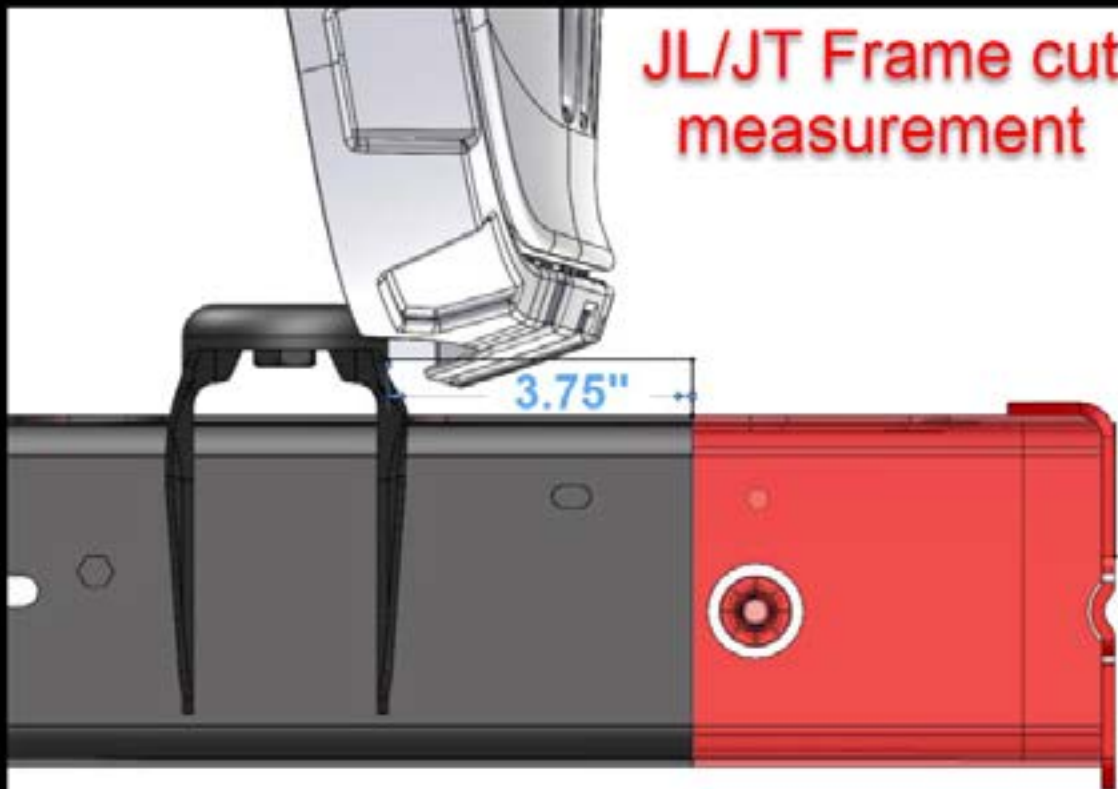


JL/JT

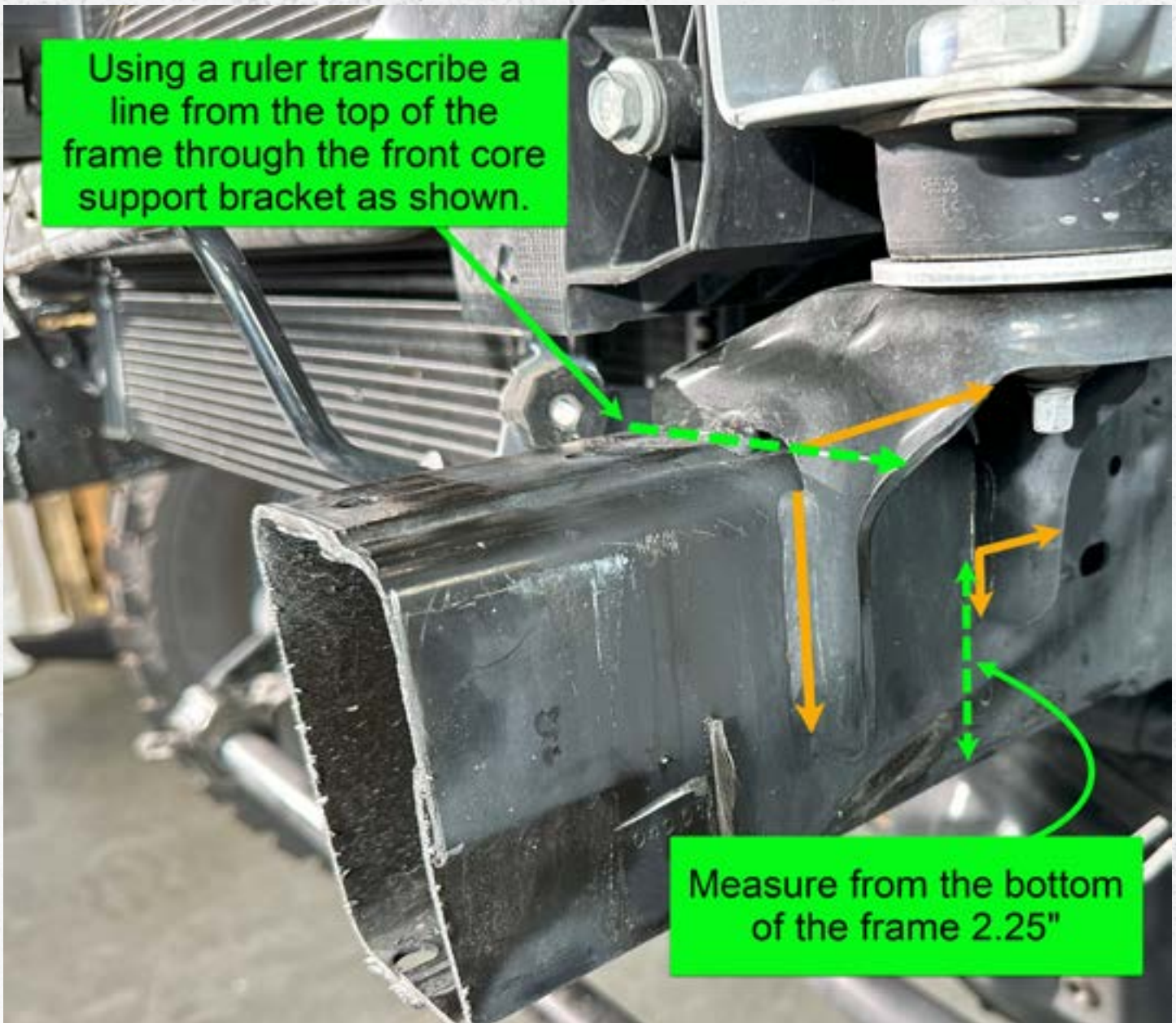


JK

**JL/JT Frame cut measurement**



**JK Frame cut measurement**

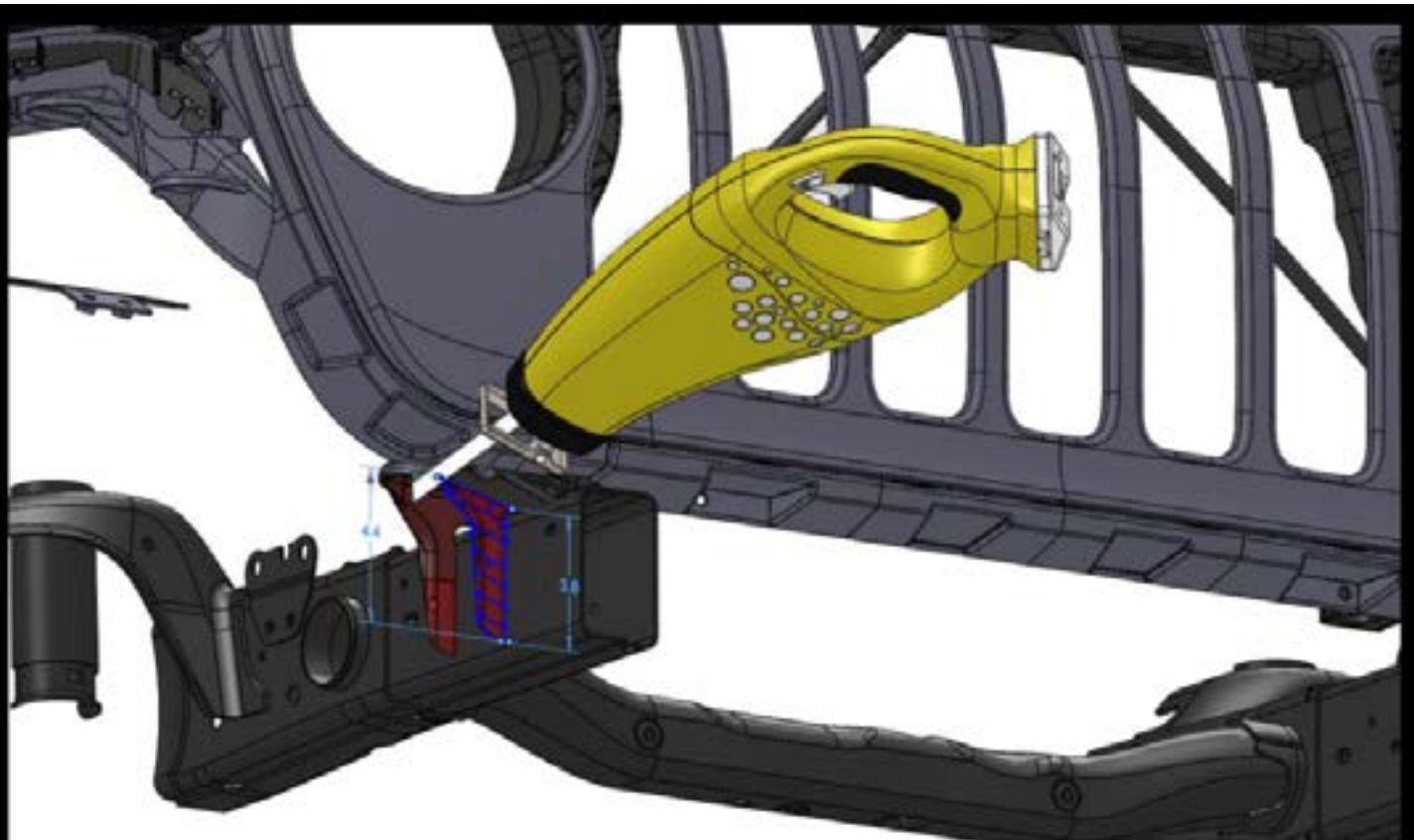


**Step 6:**

Now that you have removed the front frame section, pillar and sway bar support you are ready to trim the core support as shown above.

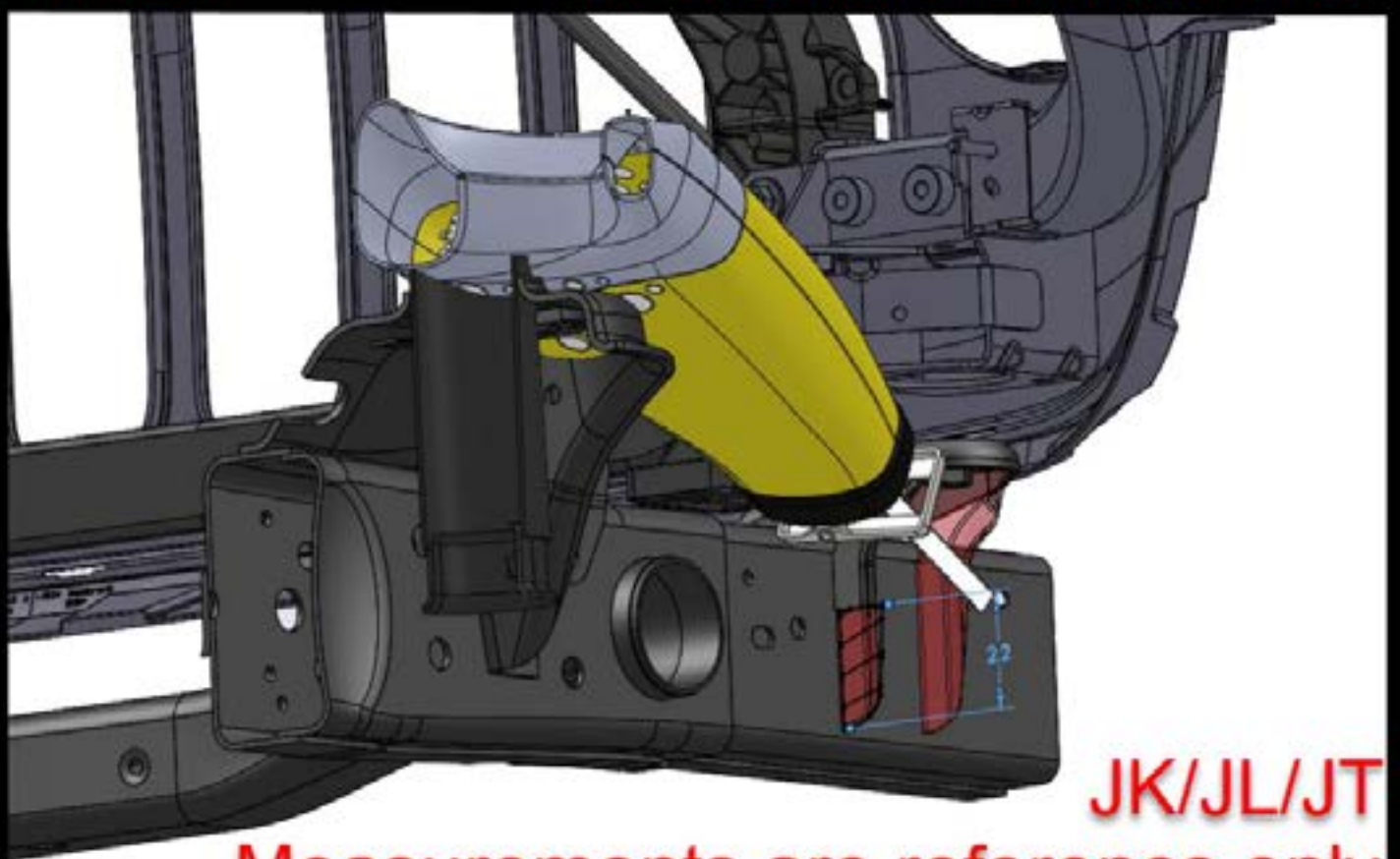
**GREEN** dash marked lines are for reference, **ORANGE** lines are where you will cut. For this cut using a right angle grinder will be the best. Do your best to avoid getting into the frame itself when making your cut. SEE THE NEXT STEP FOR A POST CUT VIEW OF THE CORE SUPPORT.

SEE THE FOLLOWING REFERENCE MODELS FOR MORE INFORMATION



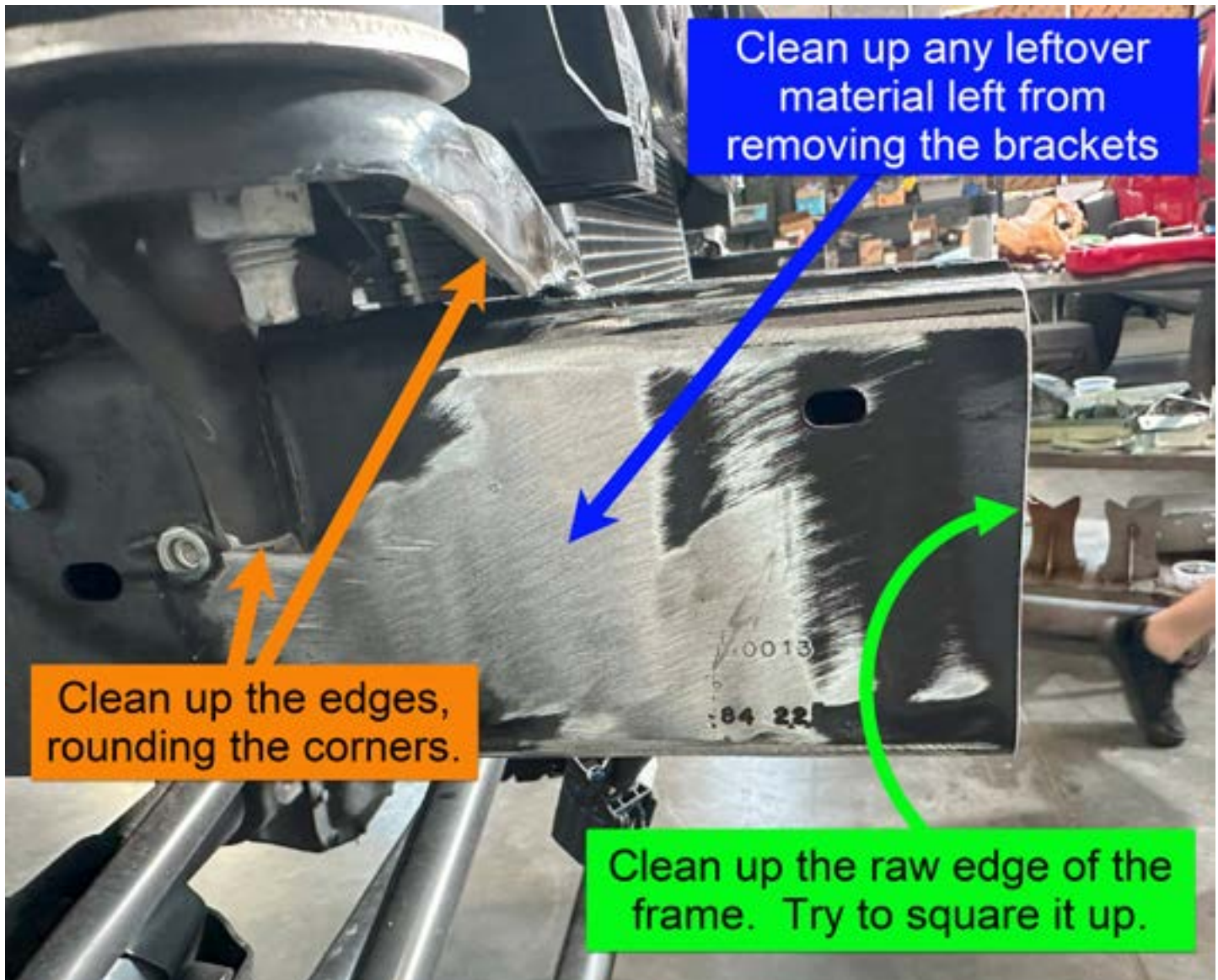
JK/JL/JT

Measurements are reference only



JK/JL/JT

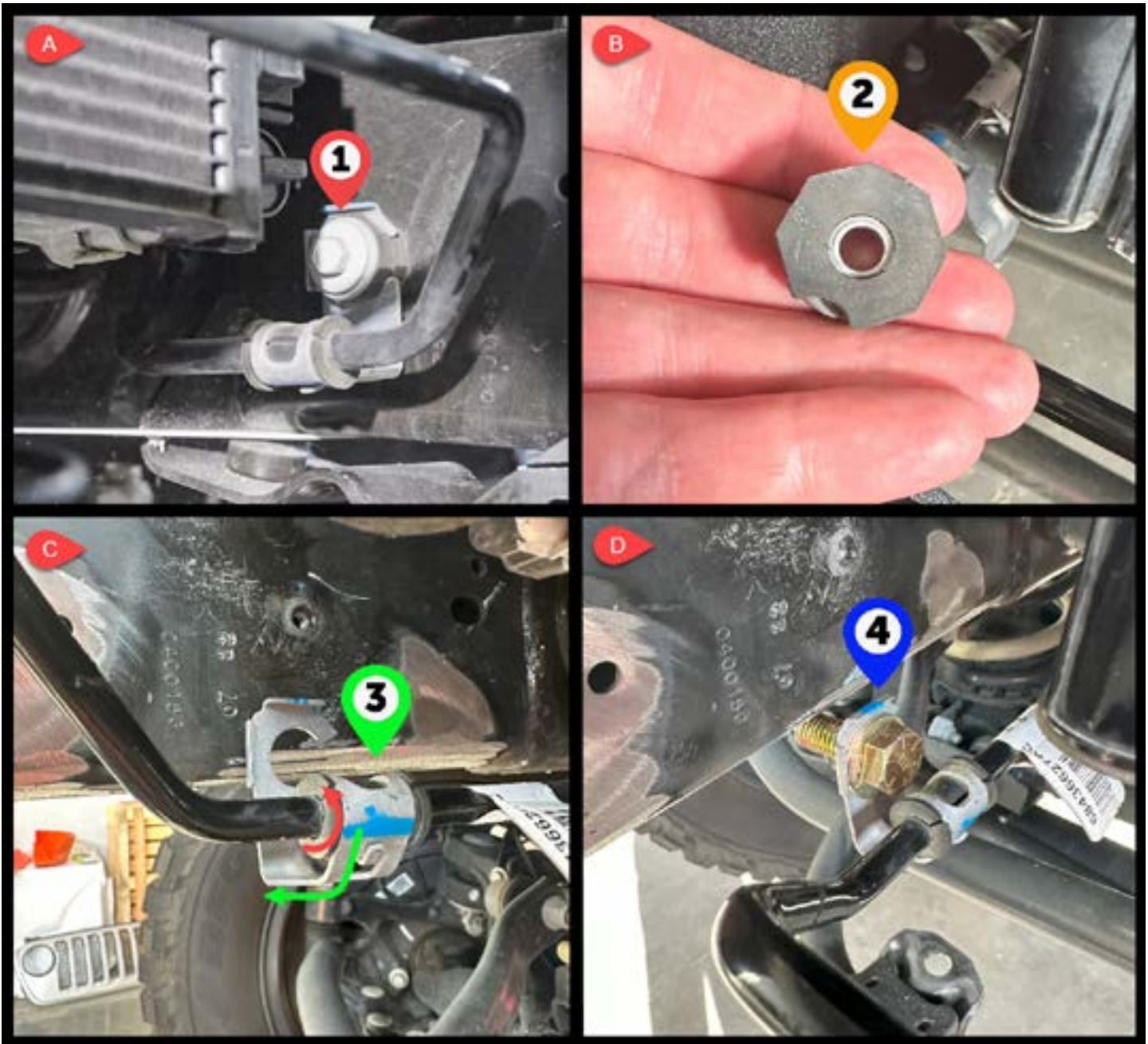
Measurements are reference only



**Step 7:**

In this step you will clean up your cut surfaces. A couple guidelines for completing this step. First, do your best not to remove material from the frame itself. Second, use a right angle grinder with a flap disc for the best results.

With the grinder, remove the sharp edges, square the front frame face and smooth the frame sides as shown above.



**Step 8:**

If you have the stock power steering equipment, you will need to slightly modify the existing bracketry.

**A:** Using 13mm socket remove the 2 - **1** M8 OEM bolts.

**B:** Remove the rubber grommet. You will not be reusing the grommets.

**C:** First, rotate the bracket approximately 45 degrees in the direction shown above. Then bend the bracket as shown above aligning the bracket face and the frame.

**D:** You will be using the provided **4** 1/2 x 1" bolts and washers to attach this bracket to the frame, through the new BANTAM bumper.

**NOTE:** Ziptie the line up and out of the way for bumper fitment and drilling. You will assemble this on final assembly.

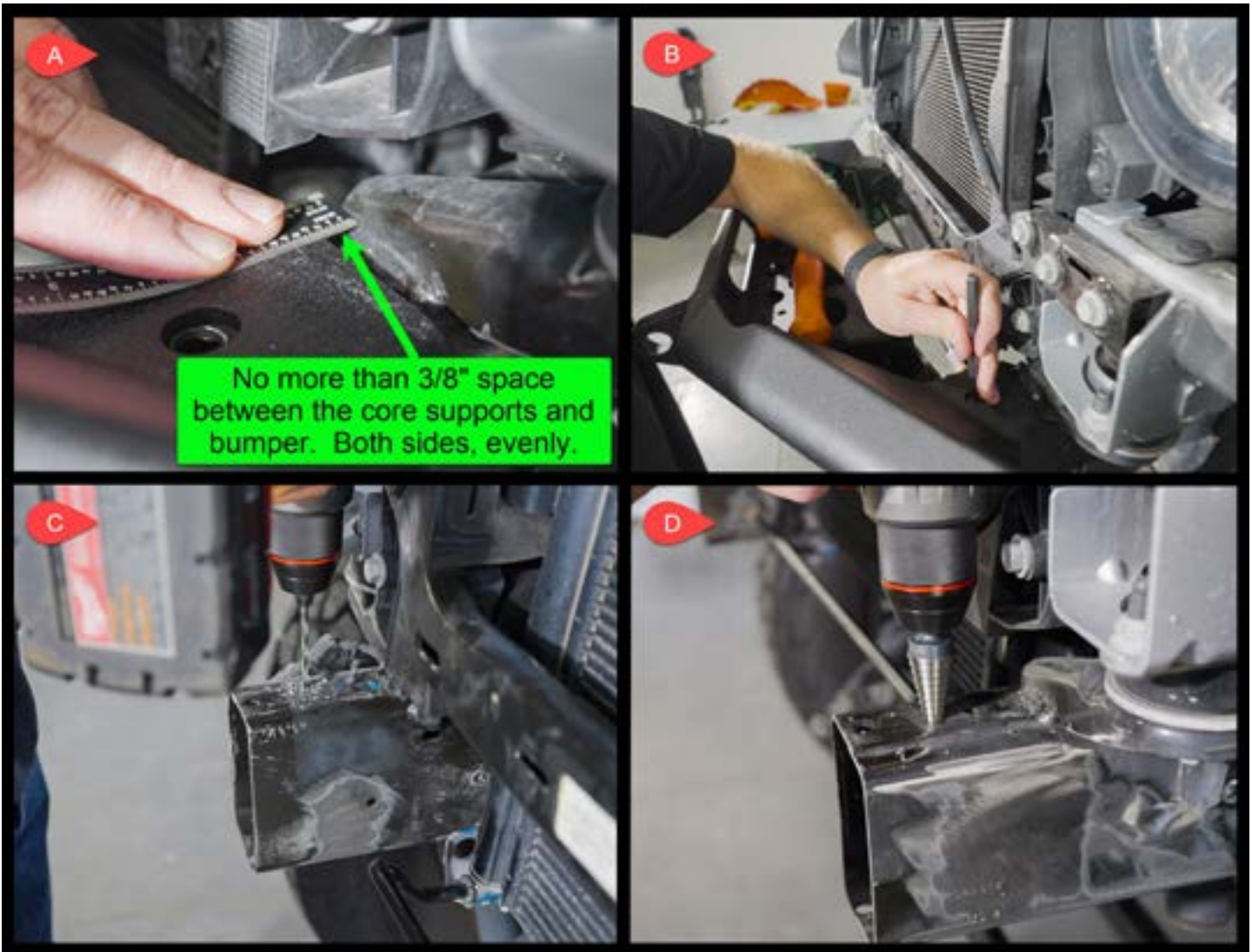




**Step 9:**

Once the power steering line is out of the way, and the frame surface has been finished and prepped you are ready to fit the BANTAM front bumper into place.

You should be able to fit the bumper nearly to the core support weld.

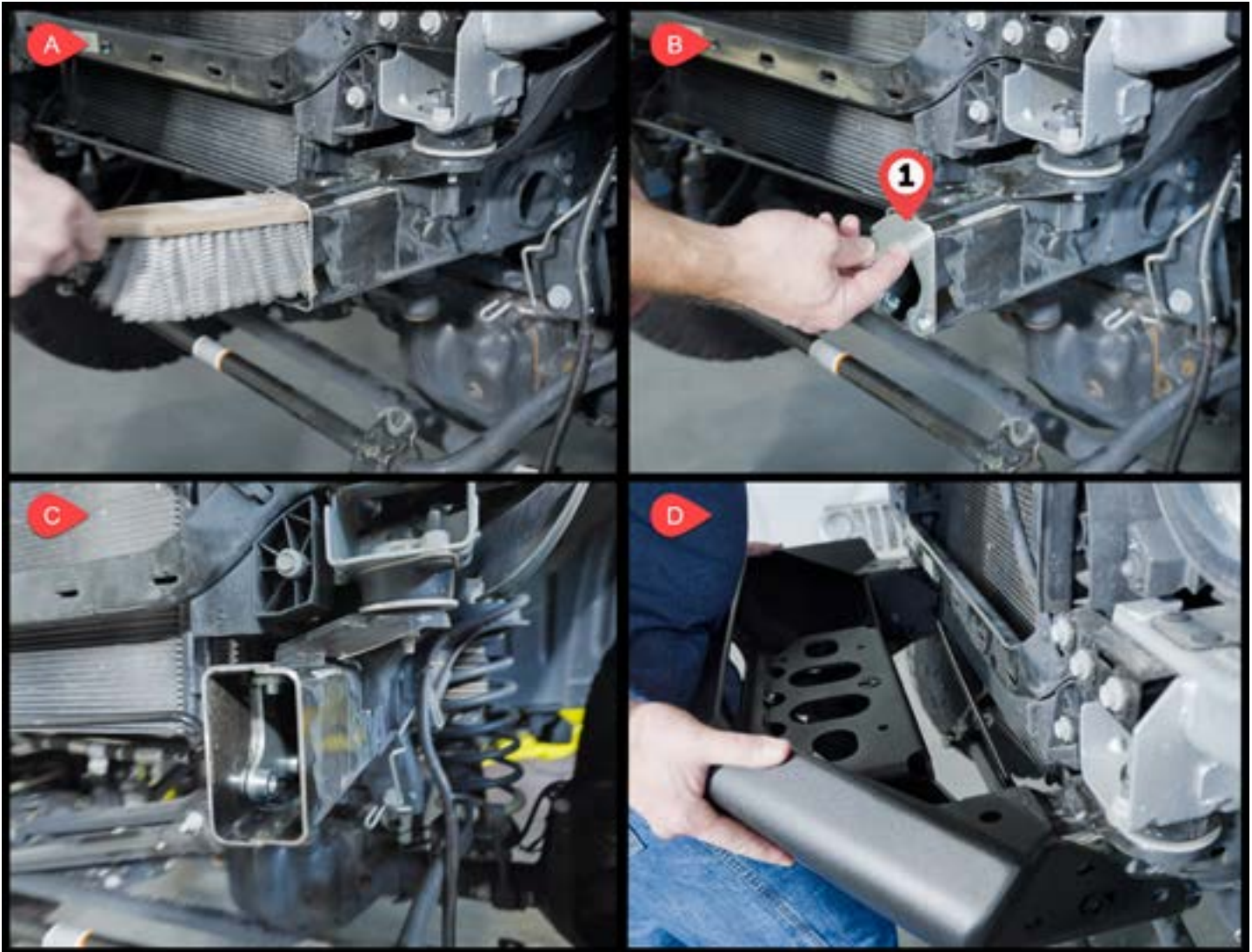


**Step 10:**

**A:** Fit the bumper squarely onto the frame with an even gap between both the driver and passenger core supports. This gap shouldn't be more than 3/8".

**B:** Mark/center punch the to TOP two bumper mounting holes. We suggest marking and drilling these two first, BEFORE drilling the balance of the holes.

**C & D:** Remove the bumper and drill the two 1/2" holes into the top of the frame. Suggest using a smaller bit as a pilot.



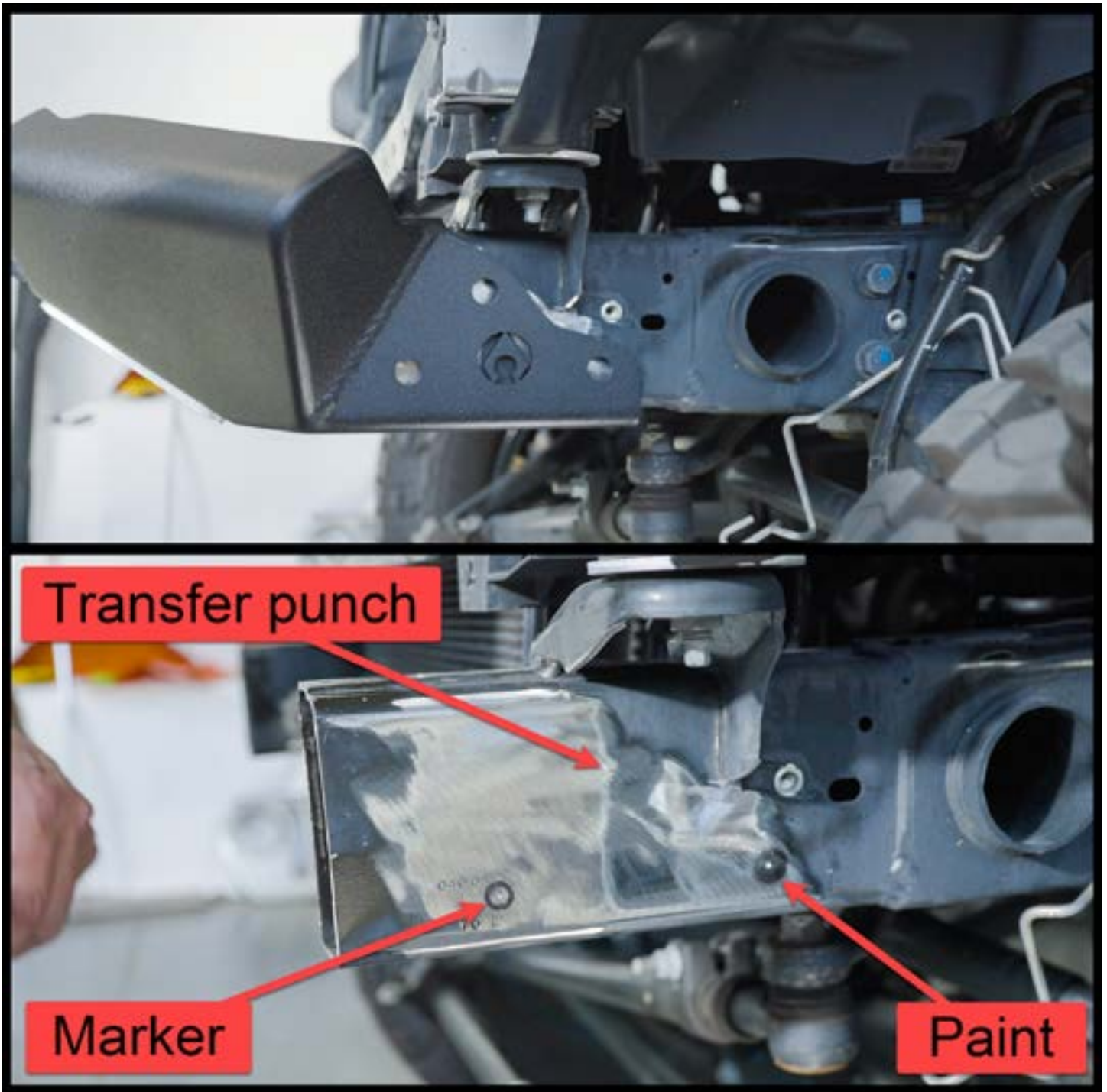
**Step 11:**

- A:** Remove the burrs left from drilling and then clean the frame out.
- B:** Insert the nut plates, JJ8021-5 PASSENGER and JJ8021-6 DRIVER as shown above.
- C:** Verify the nut plate is aligned with the hole.
- D:** Refit the bumper to the frame.



**Step 12:**

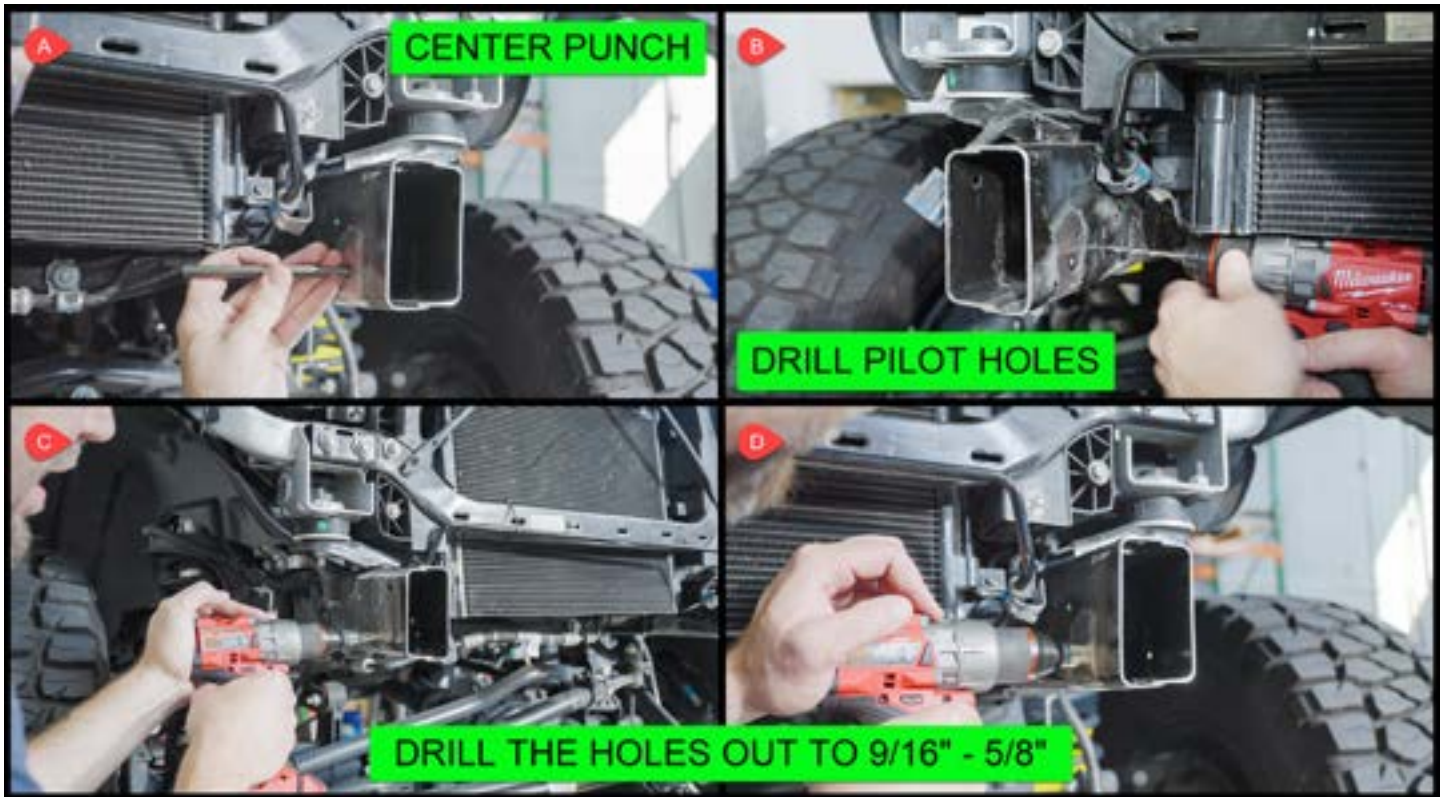
Using the 7/32 allen wrench, assemble the bumper **SQUARELY** to the frame with 2 - **1** 3/8 x 1.5" flathead bolts and custom tapered aluminum washers. **TIGHTEN** this hardware to hold the bumper in place while you mark the remaining holes.



**Step 13:**

You can mark the holes using multiple different ways once you have mounted the bumper with the 3/8" flathead bolts.

- 1.** Mark the remaining 10 holes.
- 2.** Remove the bumper.
- 3.** Pull the nut plate inserts JJ8021-5 and JJ8021-6 from the frame.



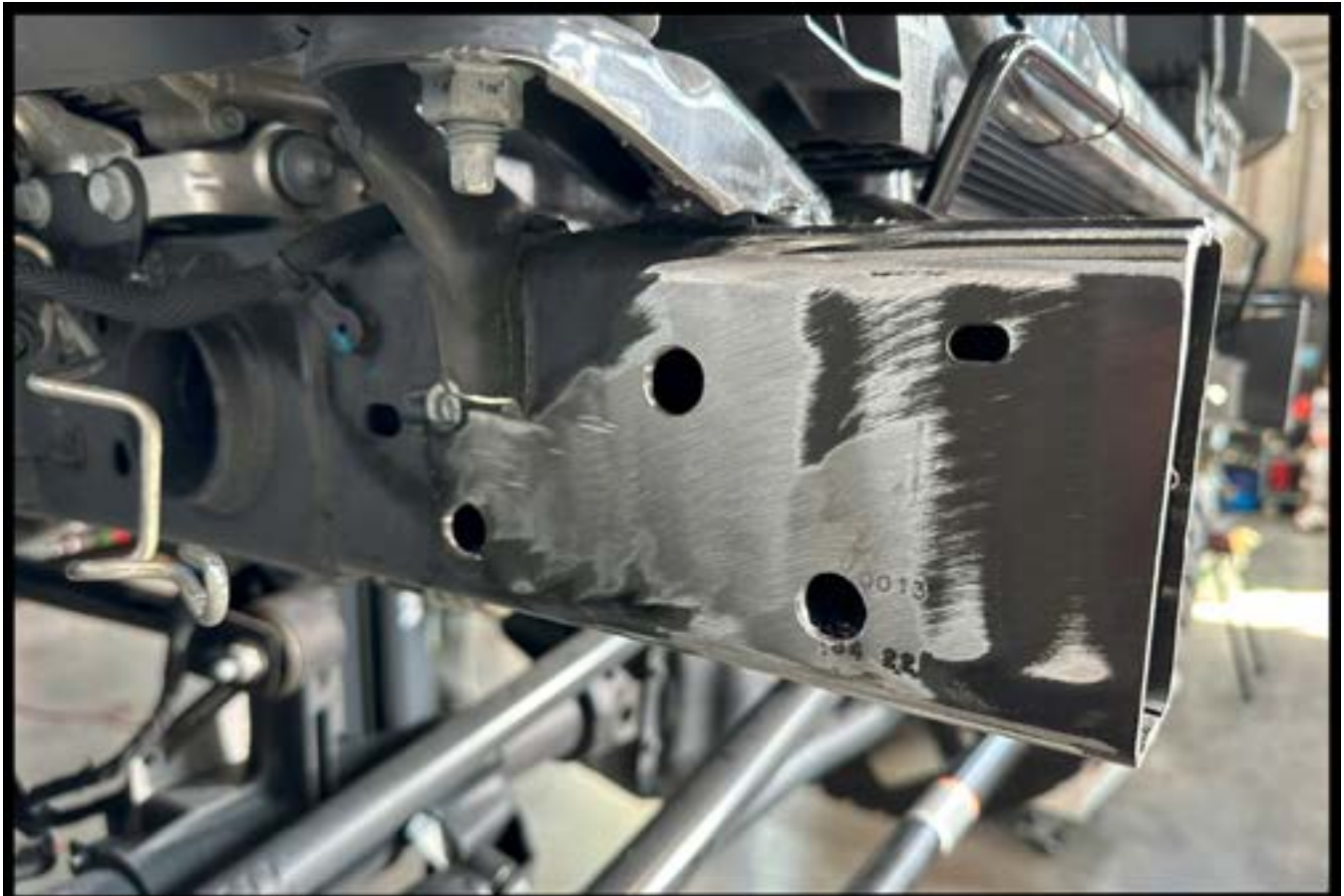
**Step 14:**

*Make sure you have pulled the nut plate inserts.*

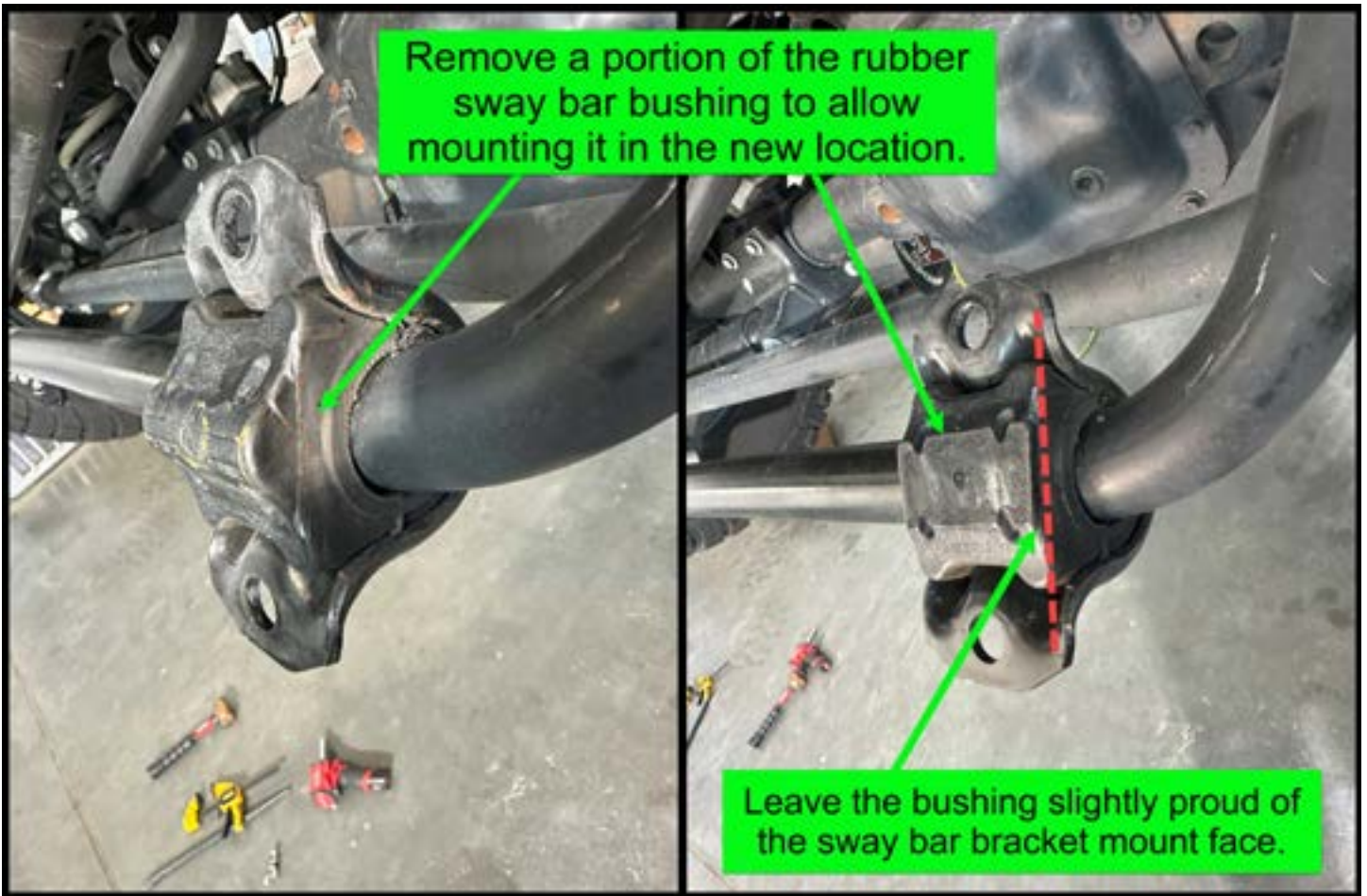
**A:** Center punch the marked holes.

**B:** Using a smaller bit, 3/16" works well, drill pilot holes.

**C & D:** Using a 9/16" or 5/8" bit, or as shown above a Unibit, drill out the 10 holes.



**Step 15:**  
Clean out the frame, deburr the holes and paint the frame in preparation for the final assembly.



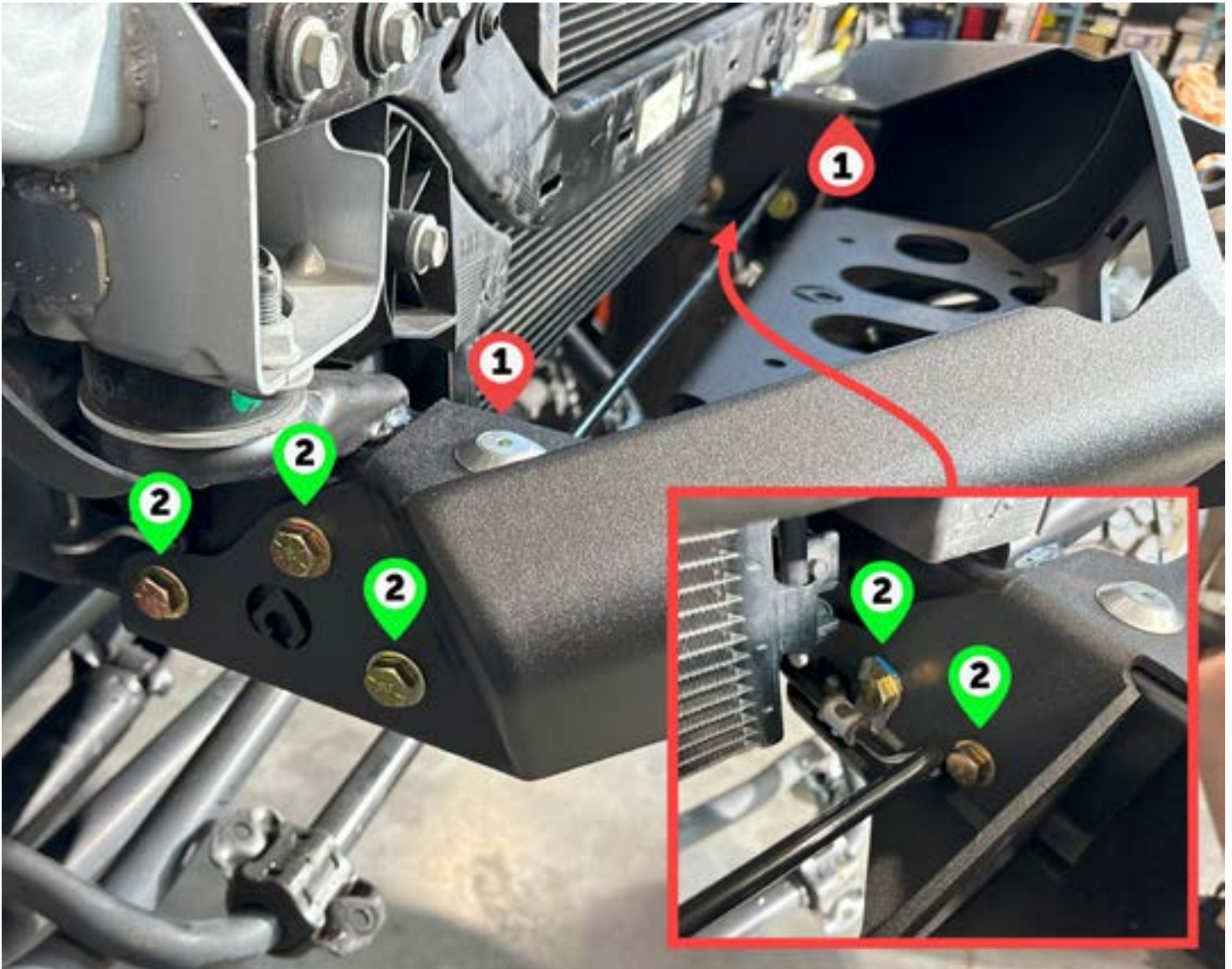
**Step 16:**

If you are using the stock sway bar, you will need to shave the hump off the rubber bushing before reassembly. A sanding flapdisk works well.

If you are using the Anti-Rock front sway bar no modification is necessary.

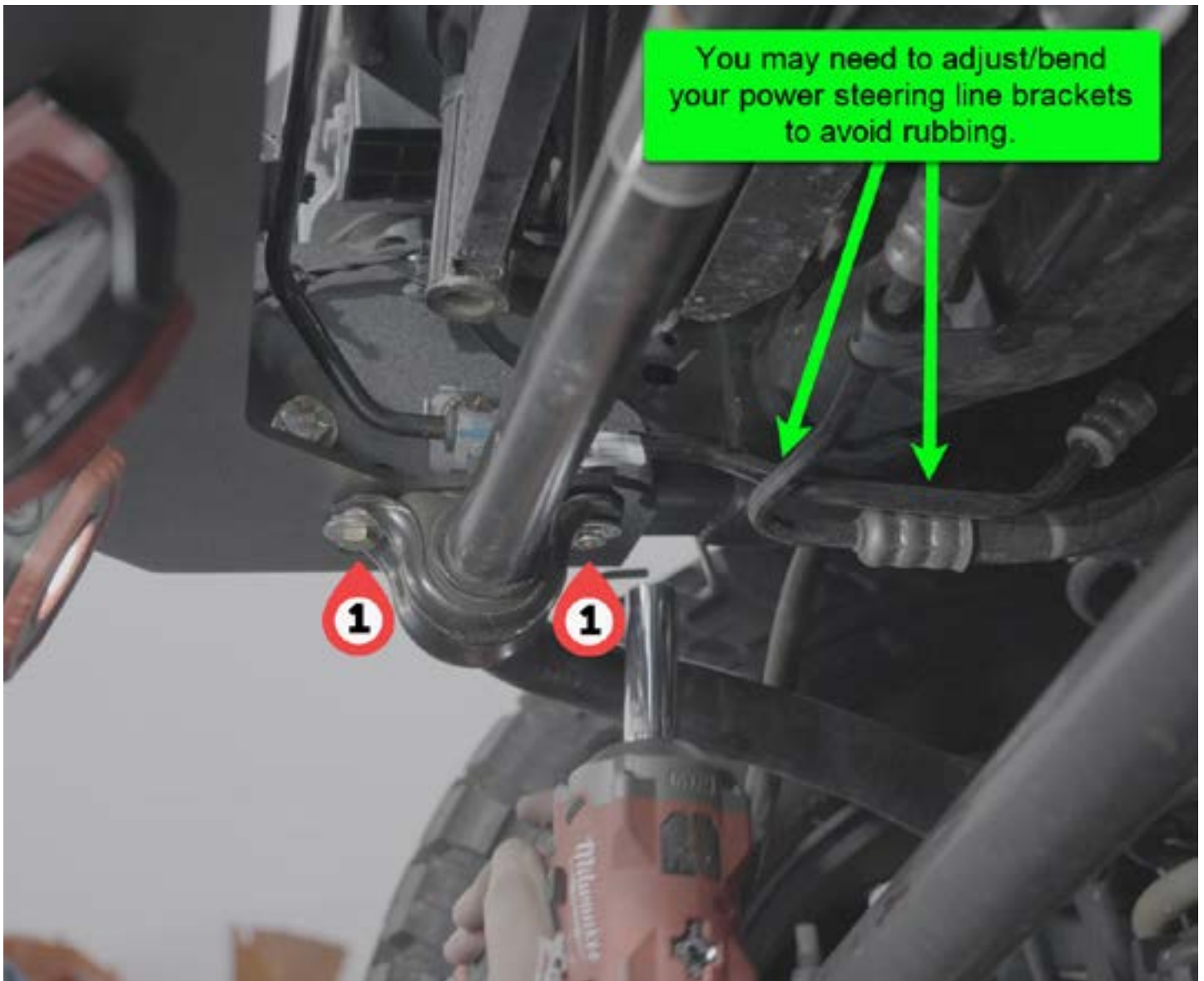


## ASSEMBLY INSTRUCTIONAL GUIDE



### Step 17:

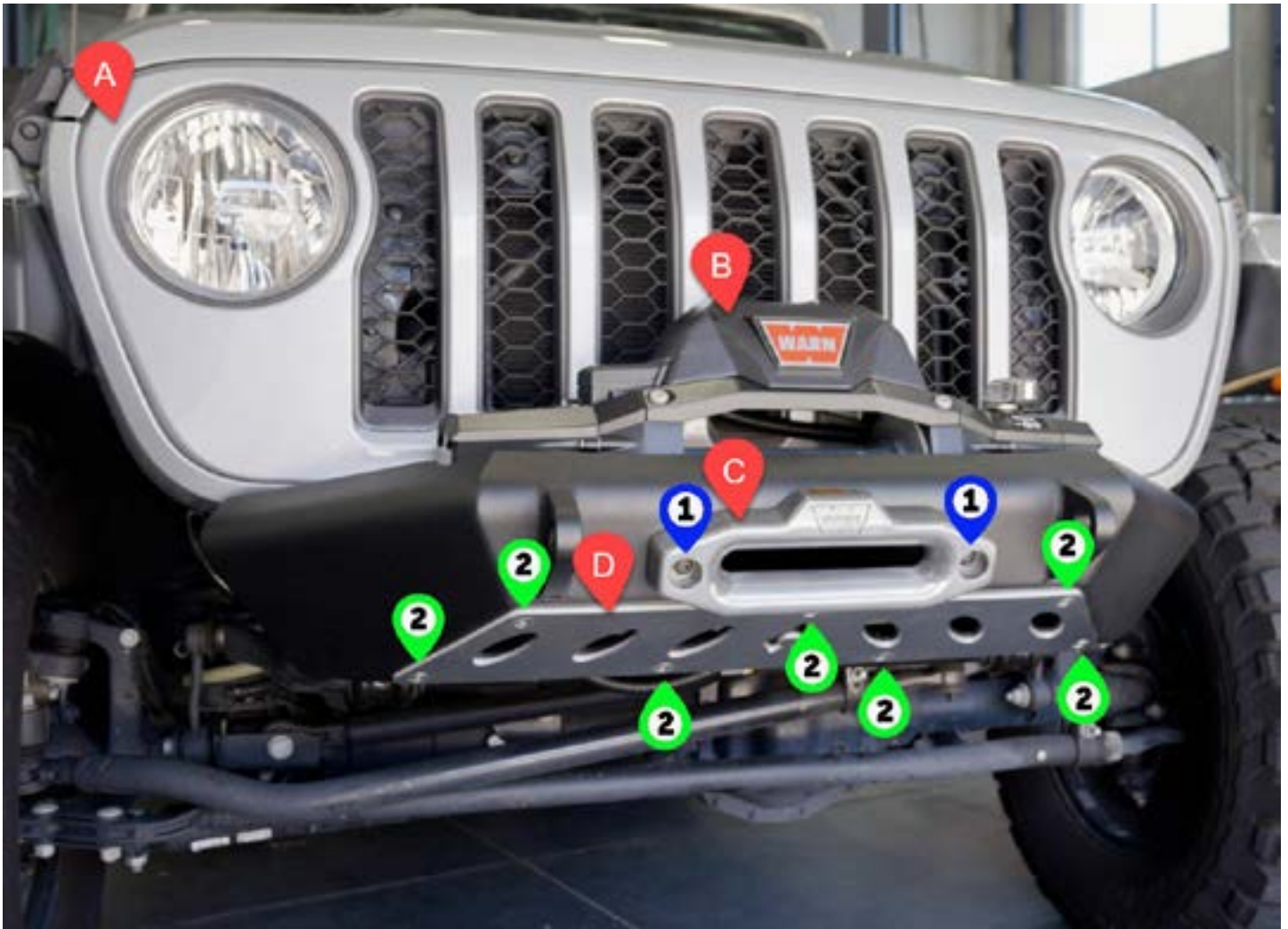
1. After the paint is dry, reinsert the nut plates. JJ8021-5 PASSENGER and JJ8021-6 DRIVER.
2. Line up the nut plates with the holes as best you can.
3. Reassemble the bumper to the frame. *Loosely* install all hardware as shown above.
4. Starting with the 2 - 1 3/8 x 1.5" flathead bolts and custom tapered aluminum washers, tighten using 7/32 allen wrench.
5. Then tighten the 10 - 3/2 x 1.25" grade 8 zinc plated bolts and washers using 3/4" socket.



**Step 18:**

Using a 9/16" socket, reassemble the sway bar to the bumper with 4 - ❶ 3/8 x 1" grade 8 zinc plated bolts and washers. **TIGHTEN** this hardware.

**NOTE:** check and adjust any power steering lines to avoid rubbing.



**Step 19:**

**A:** Reinstall the grill using the 6 - push pin retainer clip retainers.

**B:** Install your winch. **TIGHTEN** hardware.

**NOTE: DO NOT INSTALL THE ALUMINUM SKID UNTIL AFTER YOU HAVE MOUNTED YOUR WINCH.**

**C:** Install your fairlead using 2 - ① 3/8 x 1" button head bolts.

**D:** Install the aluminum skid using the 7 - ② 5/16 x 3/4" flat head bolts.

**VERIFY ALL HARDWARE IS TIGHT**

## CONCLUSION AND MAINTENANCE GUIDE



### CONCLUSION

Congratulations on finishing the installation for your Artec Industries BANTAM FRONT BUMPER. Before driving your vehicle, inspect all bolts again to ensure proper tightness. Now take your vehicle out and enjoy the outdoors in confidence.

### MAINTENANCE / CARE

- After 500 miles, inspect all components and hardware to ensure they are properly fastened.
- Use standard powder coating care and maintenance procedures