



Jeep TJ Frame Back Half Kit Installation Instructions

Thank you for purchasing our Jeep TJ Frame Back Half Kit!

Installation Notes:

- Installation of this kit requires an experienced fabricator with the ability to cut, weld, and fit various components.
- Installation of this kit will require custom frame rear suspension brackets.
- This kit is not compatible with the factory fuel tank.
- Fuel lines, brake lines, evap lines, and any other plumbing or wiring going to the rear of the jeep will need to be relocated.
- Sheet metal trimming at the rear of the Jeep under the tailgate is required.
- The two body mounts at the rear of the Jeep will no longer be used.

Tools required:

- Welding machine with the ability to weld at least 1/2" steel
- Grinder, plasma cutter, reciprocating saw, or other appropriate cutting tool
- Tape measure

Contents of each box

Bill Of Materials For B4WK12643			
QTY	Part Number	Etch Number	Description
4	B4W188799	799 B	TJ Backhalf Inner Frame Sleeve
1	B4W188800	800 B	TJ Backhalf R Top Plate
1	B4W188801	801 B	TJ Backhalf R Bottom Plate
1	B4W188803	803 B	TJ Backhalf R Inner Plate
1	B4W188802	802 B	TJ Backhalf R Outer Plate
1	B4W125023	023 B	TJ Backhalf Kit Crossmember
1	B4W125022	022 B	TJ Backhalf Bumper Inner Plate
1	B4W188806	806 B	TJ Backhalf Bumper Shell
2	B4W500032	032	TJ Backhalf Recovery Point
1	B4W188809	809 B	TJ Backhalf L Outer Plate
1	B4W188810	810 B	TJ Backhalf L Inner Plate
1	B4W188807	807 B	TJ Backhalf L Top Plate
1	B4W188808	808 B	TJ Backhalf L Bottom Plate

Step 1:

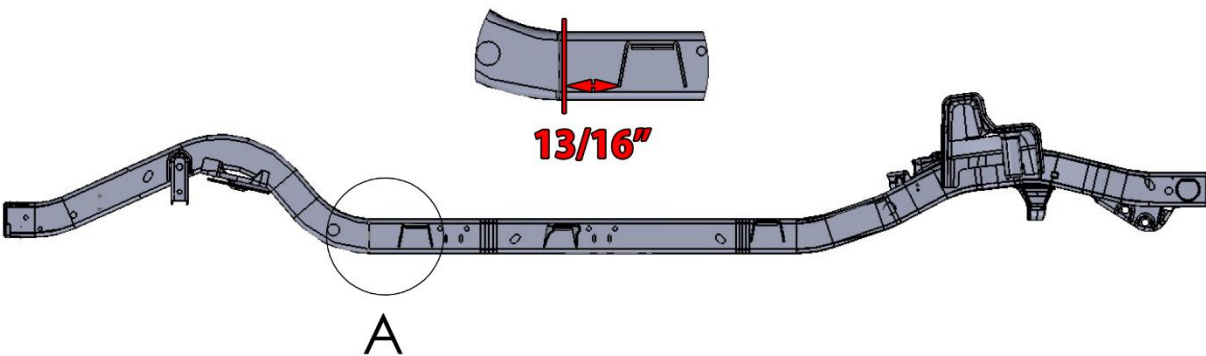
Remove the fuel tank, rear axle, the entire rear suspension, and any other components that are attached to the rear section of the frame.

Step 2:

Measure back 13/16" from the lower corner of the 3rd body mount back from the front of the Jeep and mark the frame all the way around on both sides. Use this mark to cut and remove the rear section of the frame.

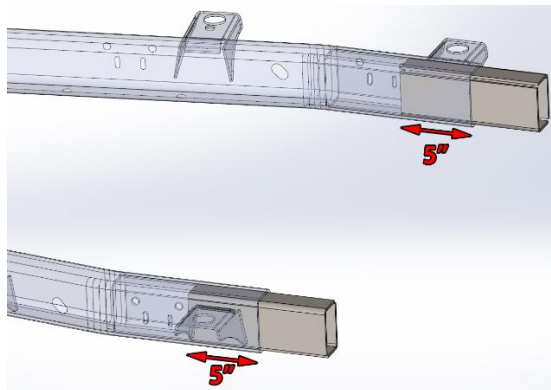
DETAIL A

SCALE 1 : 10



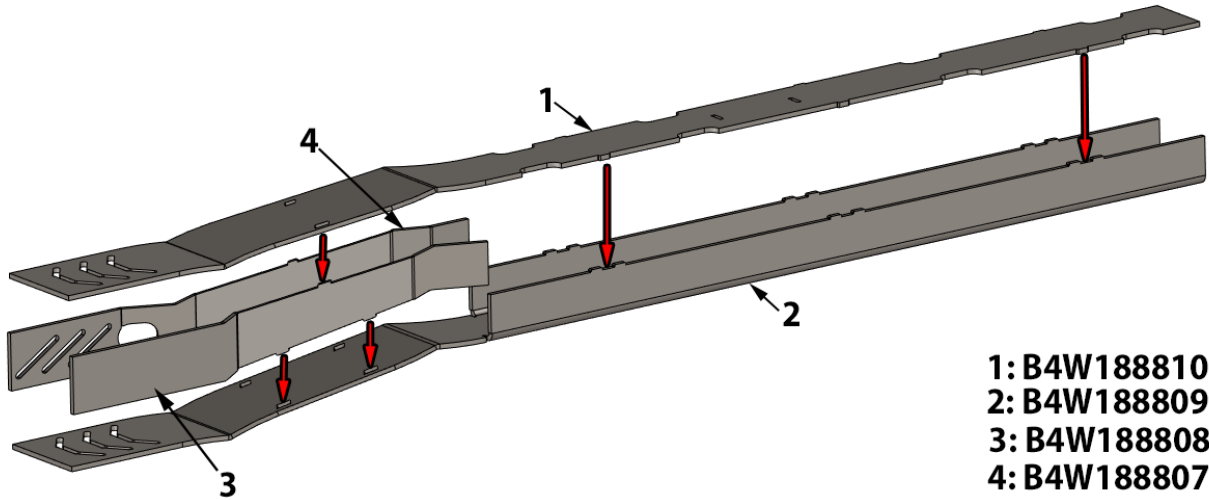
Step 3:

Insert the provided frame sleeves inside the frame 5" and weld in place. If desired, holes can be drilled in the frame to provide locations for plug welds for extra strength. The welds on the ends of the frame rail should not be wider than 3/16" to provide space for the new frame rails to be installed.



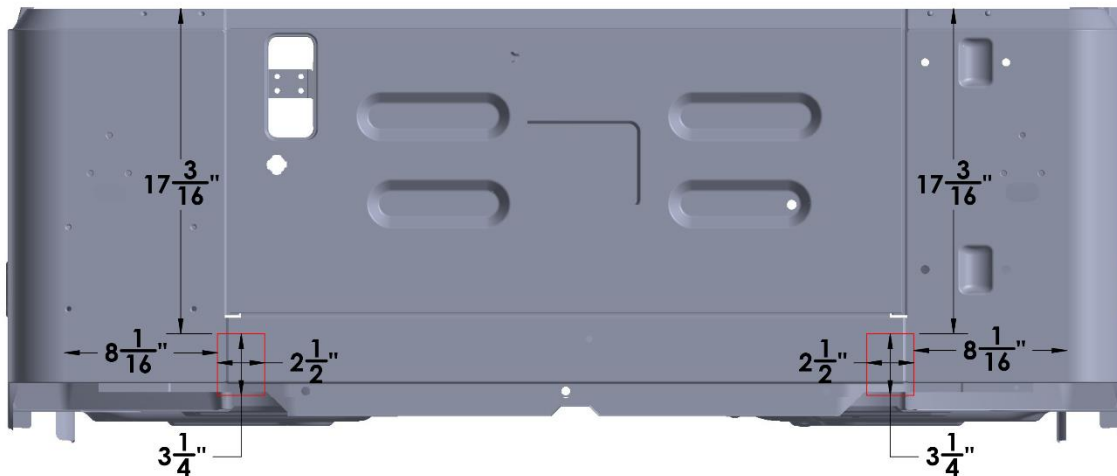
Step 4:

Assemble the components that will make up the left side frame rail as shown in the image below. Repeat this process with part numbers B4W188800, B4W188801, B4W188802, and B4W188803 for the opposite side of the vehicle. It is recommended to only tack weld the components together at this time.



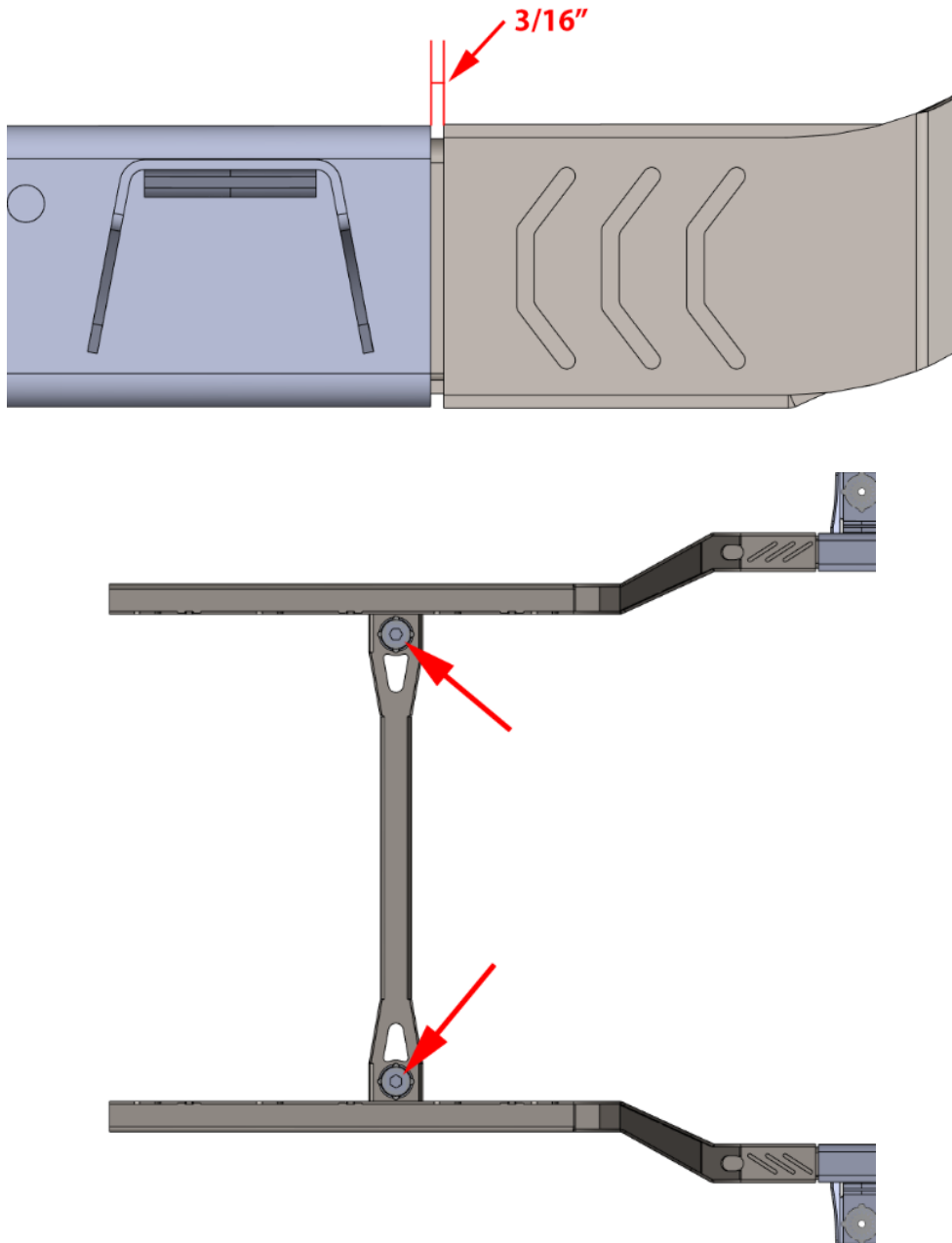
Step 7:

The sheet metal on the rear of the vehicle under the tailgate now needs to be trimmed to provide room for the new frame rails. Refer to the image below for the locations to trim, the locations will need to be modified if a body lift is installed. The 8-1/16" measurement is pulled from the factory seam where the corners of the tub are welded together.



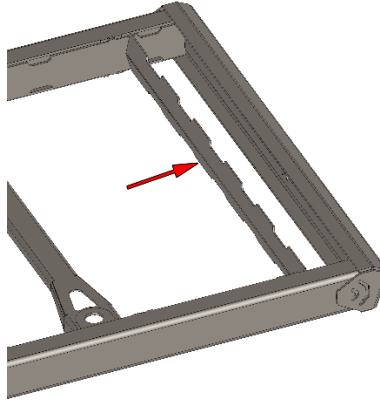
Step 6:

Slide each assembled frame rail over the frame sleeves installed in step 3 and leave a 3/16" gap between the ends of the frame rails. Bolt the crossmember to the body mounts under the tub and insert the crossmember tabs into each frame rail. After the crossmember is in place tack weld it to each frame rail. Place the rear bumper shell over the end of the frame rails and tack weld in place.



Step 8:

Un-bolt the body mounts and remove the entire assembly from the vehicle. Insert the bumper inner support inside the rear bumper and weld in place. Place the recovery points in the desired location on the rear of the bumper and weld in place. The assembly can now be finish welded in all areas except the sections that slip over the frame sleeves.



Step 9:

Place the assembly back in the vehicle and finish weld all joints. Slots have been provided in various locations for plug welds to add additional strength.

Congratulations you have completed the installation of your frame back half kit!

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