



Jeep XJ Front Bumper Welders Kit

Fabrication Notes

Thank you for purchasing this product!

Installation Notes:

- This kit is designed to be compatible with 1984-2001 Jeep Cherokee XJ models.
- This kit is designed to be compatible with 1984-2001 Jeep Comanche MJ models.
- This kit requires welding, automotive mechanical knowledge, and general fabrication skills, it should only be done by qualified individuals.
- The components of this kit will need to be painted or powder coated during installation.
- Refer to your factory service manual to remove any factory components.
- We recommend tack welding the assembly and test fitting before fully welding the bumper.
- Works with Warn Zeon or Badlands Apex with the solenoid relocated.

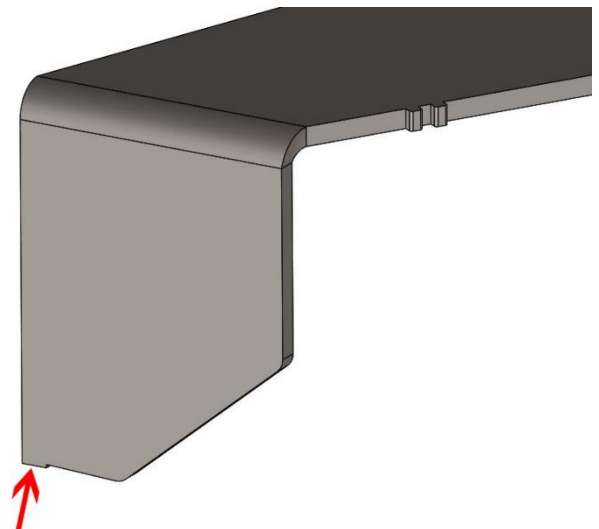
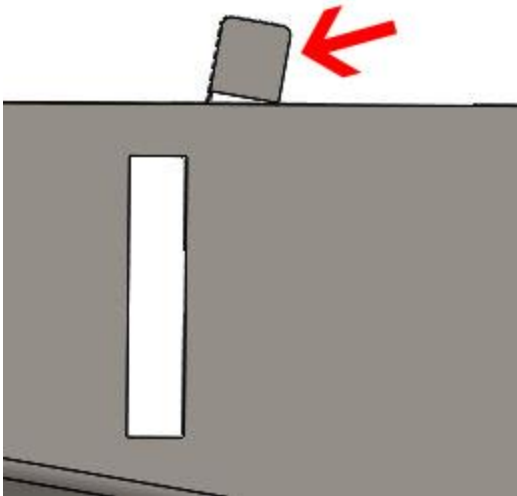
Tools required:

- Welding machine with the capability to weld at least ¼" thick steel.
- Various hand tools
- Grinder

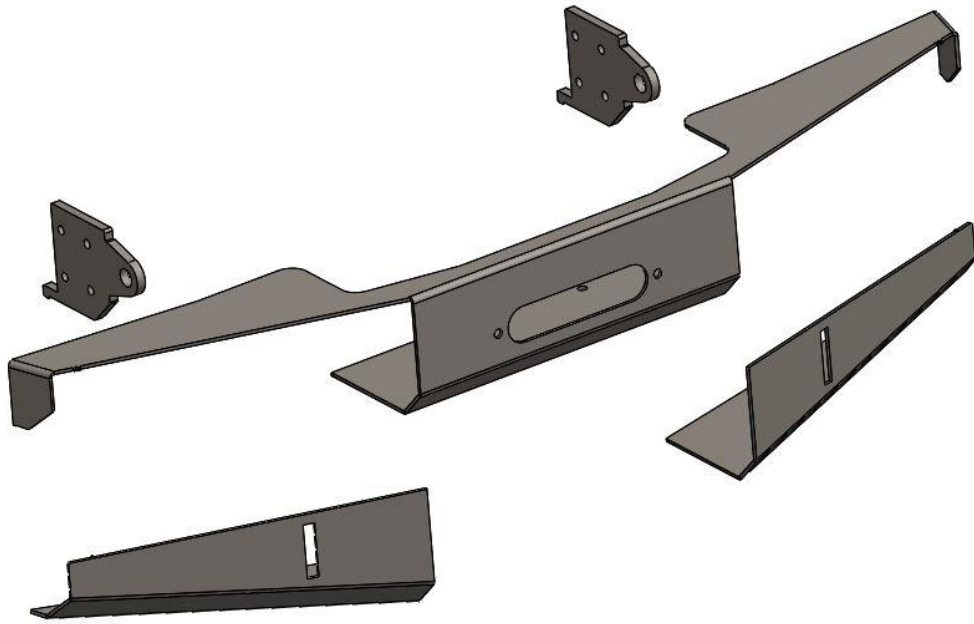
Contents of box

Bill Of Materials for B4WK12873			
QTY	Part Number	Etch Number	Description
2	B4W250450	450	XJ Front Bumper Brackets
1	B4W188C30	C30 B	XJ Front Sheetmetal Bumper Passenger Wing
1	B4W188C29	C29 B	XJ Front Sheetmetal Bumper Main
1	B4W188C31	C31 B	XJ Front Sheetmetal Bumper Driver Wing
2	B4W188443	443	XJ Front Bumper Frame Spacer
2	B4W500110	110	XJ Front Winch Bumper Recovery Points
2	50C350HCS8Y	NA	1/2 -13 x 3.5
20	50NWSAFY	NA	1/2" SAE Flat Washer Yellow Zinc
10	50CNNE0Y/GC	NA	1/2"-13 Nylon Lock Nut
6	.100C350BHFOY/6921	NA	M10-1.5 x 35mm Hex Flange Bolt Yellow Zinc
8	50C200HCS8Y	NA	1/2-13 X 2 Hex Cap Screw Gr 8 Zinc/Yellow
B4WK12874 addons			
2	B4W188582	NA	TJ Front Bumper Bull Bar Gusset
1	DOM0054	NA	Updated TJ Bull Bar

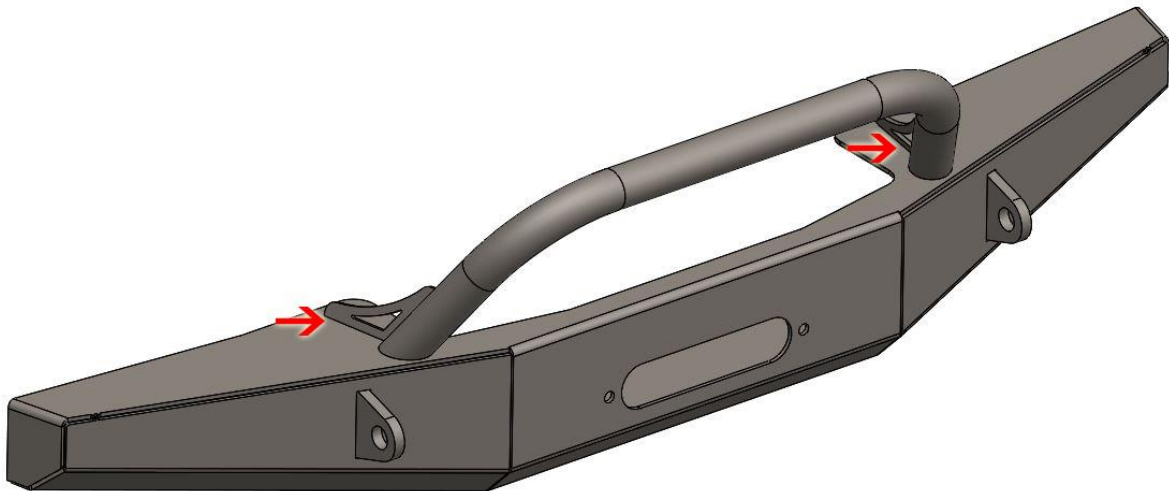
Grind these tabs off each side of the bumper.



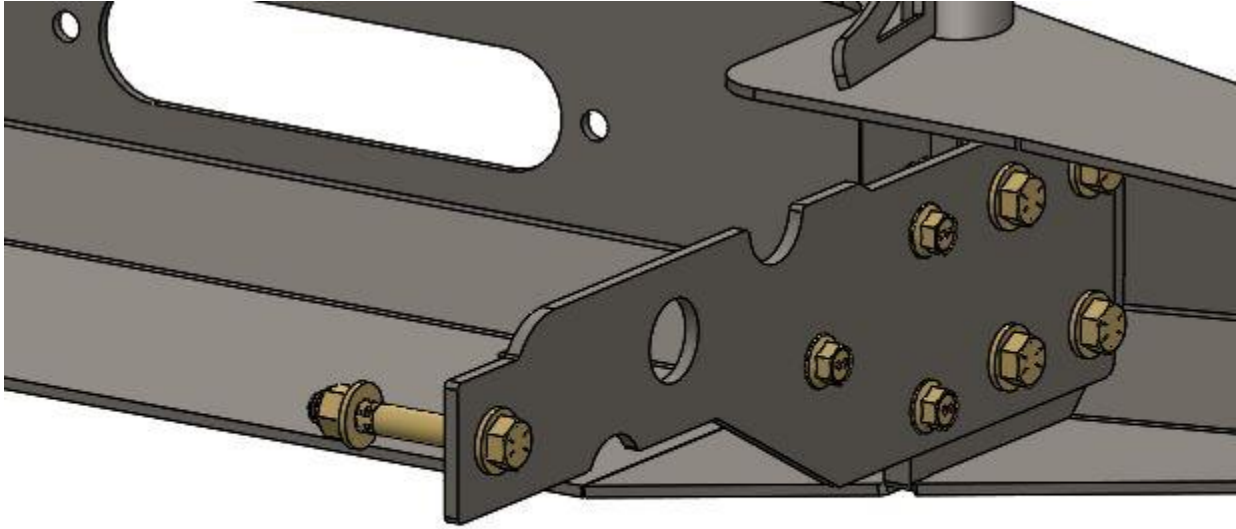
All parts will tab into the main shell. Align edges and tack in place.



Align the bull bar and gussets with etch as shown below, tack weld in place.



Assemble the bumper bracket as shown below if you have frame stiffeners install B4W188443 between the bracket and the bumper.



Test fit the bumper and finish weld all seams.

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