



Installation Instructions

XRC Rear Bumper

(Part # 76855)

2007-2012 Jeep Wrangler (JK)

For Technical Support/Warranty Information please call 310-762-9944

Smittybilt, 400 West Artesia Blvd, Compton, CA 90220

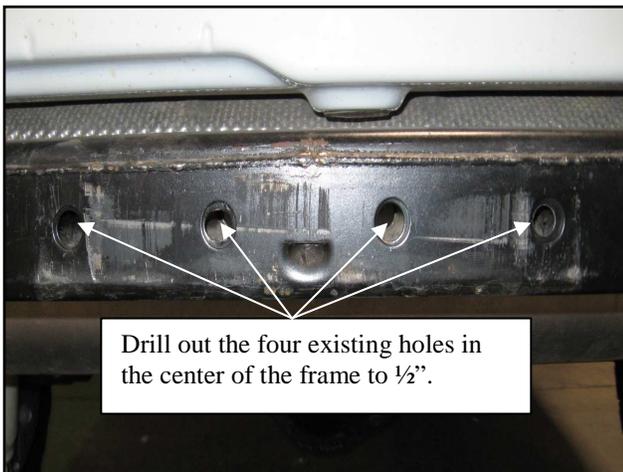
NOTE: Carefully read entire instructions before installing this product. It is recommend having assistance for ease of installation. If using OEM wheels a wheel spacer will be required for the spare tire carrier due to the backspacing. (Smittybilt Part# 3721)



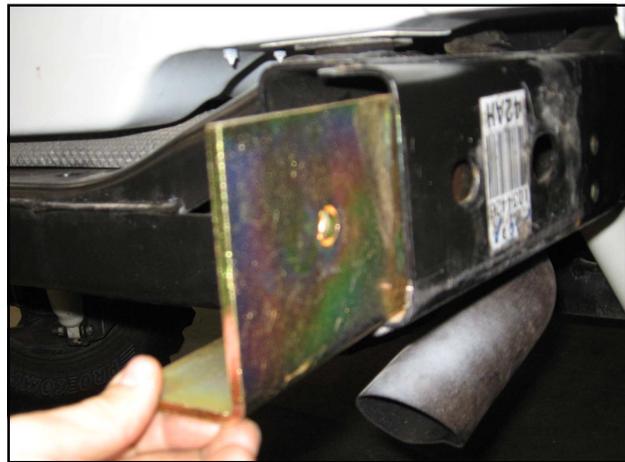
Parts Included	Qty	Parts Included	Qty
XRC Rear Bumper	1	1/2" Flat Washer (USS)	8
Nut Plate	2	1/2" Flat Washer (SAE)	4
1/2"-13 x 4 1/2" Hex Bolt	4	1/2" Lock Nut	4
1/2"-13 x 1 1/4" Hex Bolt	4		

Step 1: Remove the factory rear bumper and support brackets from the vehicle.

Step 2: Drill out the four holes in the center of the frame to 1/2". (Fig A)



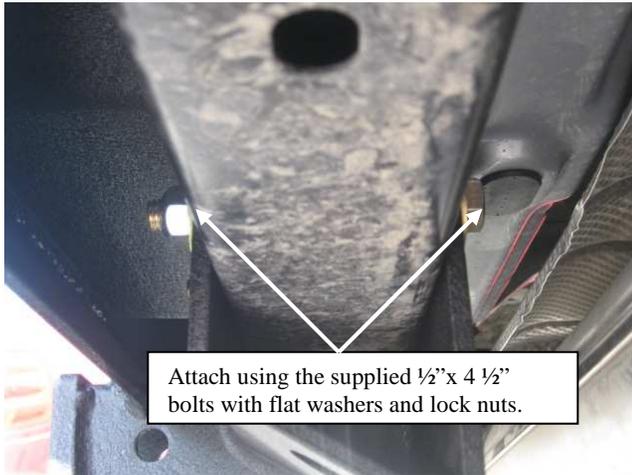
(Fig A)



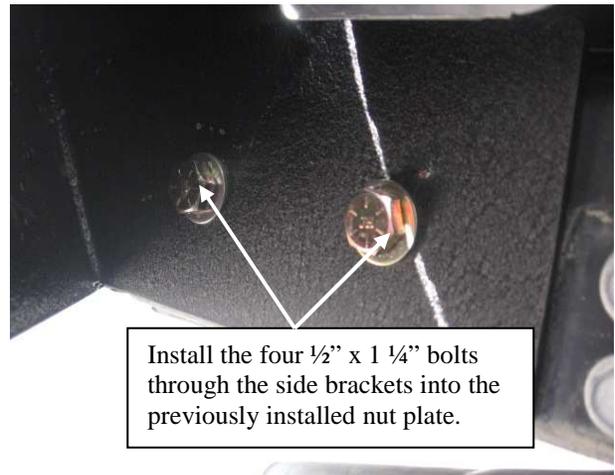
(Fig B)

Step 3: Insert nut plate into the inside of the rear frame rails lining up the nuts in the plate with the holes in the frame rail. (Fig B)

Step 4: Position the rear bumper up into place, aligning the four holes in the center of the frame with the holes on the hitch plate portion of the bumper. (Fig D) (This step may require assistance) Attach using the supplied 1/2"x 4 1/2" bolts with flat washers and lock nuts. Do not completely tighten at this time.



(Fig C)



(Fig D)

Step 5: Install the four 1/2" x 1 1/4" bolts through the side brackets into the previously installed nut plate.

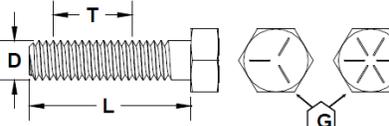
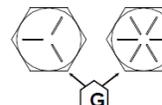
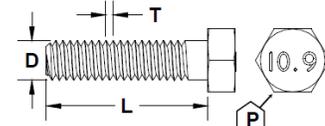
Step 6: Make sure bumper is level and the completely tighten all hardware. Torque bolts to 90 ft-lb.

Step 7: Installation is now complete. (Fig E)



(Fig E)

Bolt Torque and ID						
Decimal System			Metric System			
All Torques in Ft. Lbs.						
Bolt Size	Grade 5	Grade 8	Bolt Size	Class 9.8	Class 10.9	Class 12.9
5/16	15	20	M6	5	9	12
3/8	30	45	M8	18	23	27
7/16	45	60	M10	32	45	50
1/2	65	90	M12	55	75	90
9/16	95	130	M14	85	120	145
5/8	135	175	M16	130	165	210
3/4	185	280	M18	170	240	290

 <p>1/2-13x1.75 HHCS D T L X</p>	 <p>Grade 5 Grade 8 (No. of Marks + 2)</p>	 <p>M12-1.25x50 HHCS D T L X</p>
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<p>G = Grade (Bolt Strength) D = Nominal Diameter (Inches) T = Thread Count (Threads per Inch) L = Length (Inches) X = Description (Hex Head Cap Screw)</p>	<p>P = Property Class (Bolt Strength) D = Nominal Diameter (Millimeters) T = Thread Pitch (Thread Width, mm) L = Length (Millimeters) X = Description (Hex Head Cap Screw)</p>
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