

# Installation Instructions



**XRC Gen 1 Rear Bumper**  
**Part # S/B77855**  
**2018+ Jeep Wrangler JL®**



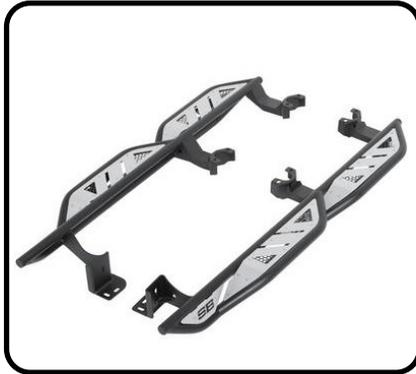
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Smittybilt, 1017 W 600 N, STE 4, Ogden, UT 84404

## Introduction

Thank you for choosing Smittybilt accessories for your Jeep Wrangler®. If you would like to view our full range of available accessories, please visit us at [www.smittybilt.com](http://www.smittybilt.com)



Aluminum Inner Fender Liners



Apollo Rock Sliders with Steps



XRC Gen 1 Front Bumper

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## Important Notes Before Starting

### ! IMPORTANT NOTE

Carefully read through this entire instruction manual thoroughly before attempting to install this part.

### ! IMPORTANT NOTE

These instructions were performed on a Rubicon model. Installation on Sport and Sahara models may differ slightly.

### ! IMPORTANT NOTE

Photos may vary from the actual product. Installation will remain the same.

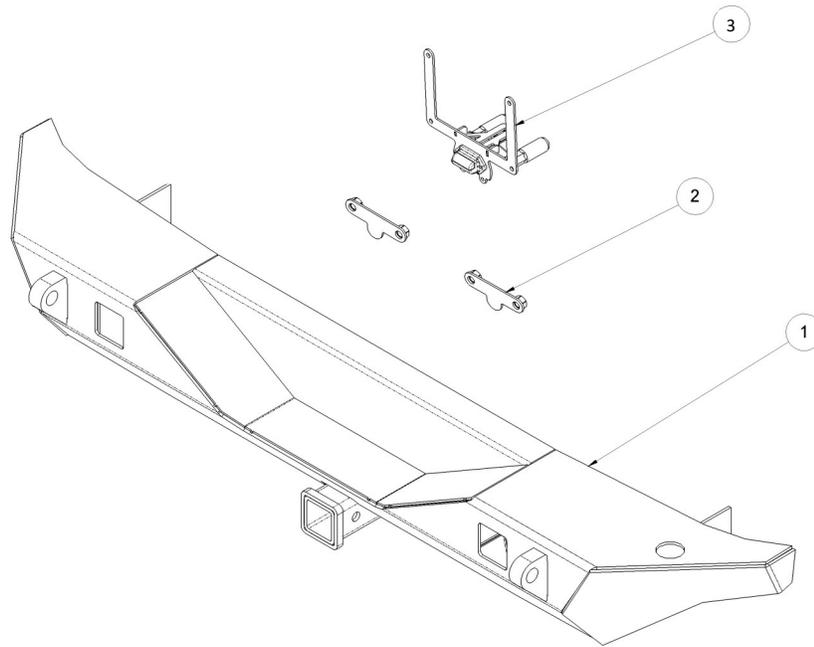
### ! WARNING

Park vehicle on flat surface, chock all four wheels and engage parking brake prior to installation. Serious injury can occur when working on vehicles alone. When possible, work with another person to reduce risk of injury from strain or other dangers that can occur when working alone.



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# Box Contents



ID	Part Description	QTY
1	XRC Gen 1 Rear Bumper	1
2	M12 Nut Plate	2
3	7734 - License Plate Relocation Kit	1
	Nut Plate	2
	M12 Split Lock Washer	4

ID	Part Description	QTY
	M12 Flat Washer	4
	M12-1.75x120mm Hex Head Bolt	4
	M6-1.0x20mm Button Head Bolt	8
	M6 Flat Washer	8
	M6 Split Lock Washer	8

## Tools Required:

Socket Set

3/8" Ratchet Wrench

Torque Wrench

PPE



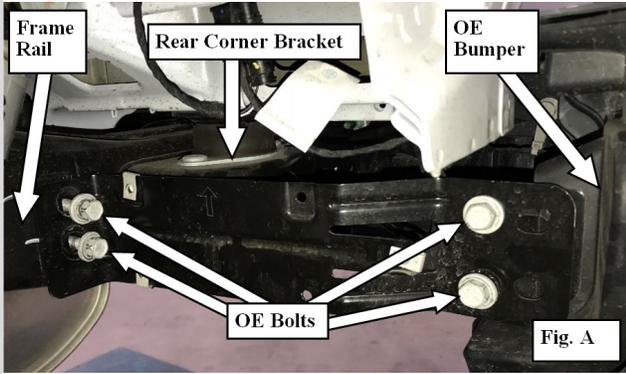
## IMPORTANT NOTE

Smittybilt is not responsible for any potential problems associated with installation of this kit in conjunction with other manufacturer's products.



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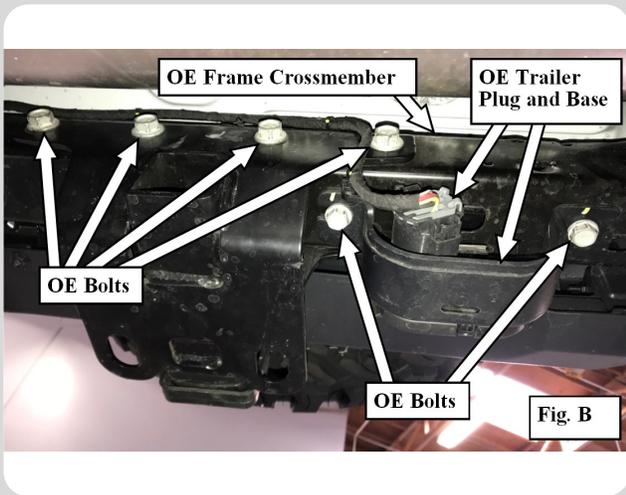
# Installation Instructions: XRC Gen 1 Bumper Install



## Step 1:

Park your **Jeep®** on a flat level surface. Apply the parking brake and chock all 4 wheels.

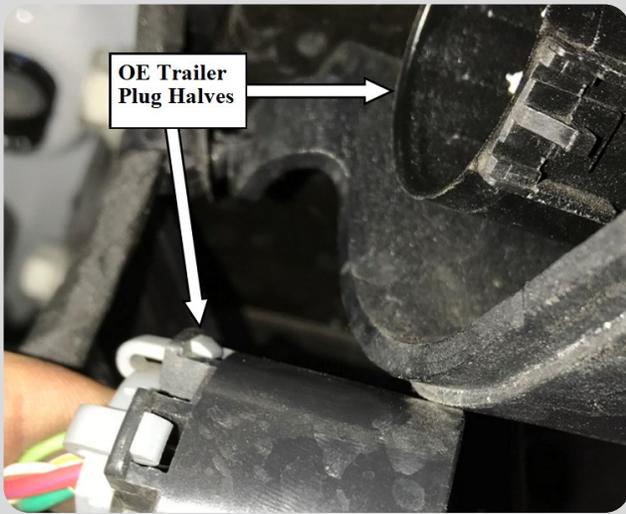
Remove the **(4 per side)** OE bolts securing the driver and passenger side rear corner brackets to the frame rails **(Fig. A)**



## Step 2:

**Note: Configuration will vary per model and options package.**

Using an **18mm Socket Wrench**, remove the **(4)** OE bolts securing the OE rear bumper to the OE frame crossmember. **(Fig. B)**



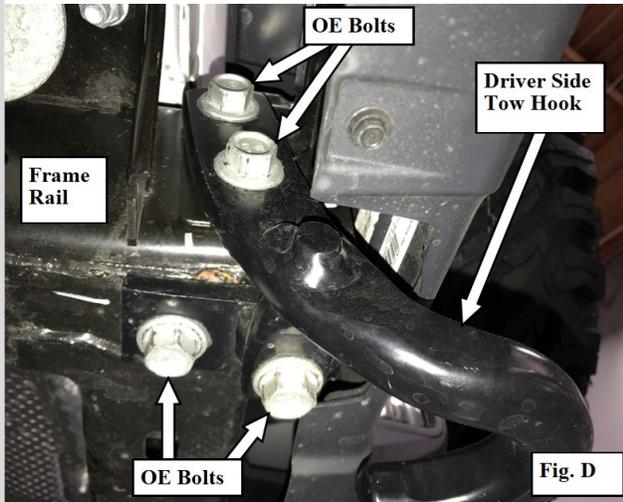
## Step 3:

If equipped, disconnect the trailer plug and unbolt the base from the frame.



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# Installation Instructions: XRC Gen 1 Bumper Install

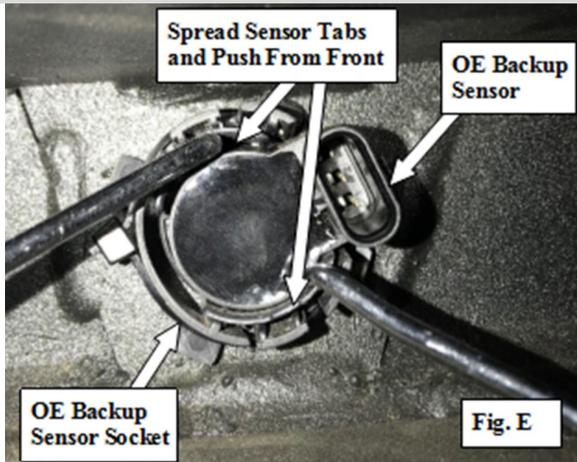


## Step 4:

On the driver side, remove the **(4)** OE bolts and remove the tow hook from the frame. On the passenger side, remove the **(2)** OE bolts securing the OE rear bumper to the side of the frame rail. **(Fig. D)**

Under the driver side rear quarter panel, disconnect the backup sensor harness connector.

With assistance, carefully remove the OE bumper from the vehicle. Save the OE hardware for reinstallation.



## Step 5:

For vehicles without sensors, skip to **Step 8**.

Unplug the OE wiring harness from the OE backup sensors and remove the OE backup sensors by spreading the back of the sockets, where clipped over the sensor tabs, while pushing the sensors out from the front. **(Fig. E)**

Be sure to note the orientation and position of each sensor and retain all the OE sensor O-rings.



## Step 6:

Install **(1)** of the included circular foam pads on the back of the sensor as shown.



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## Installation Instructions: XRC Gen 1 Bumper Install



### Step 7:

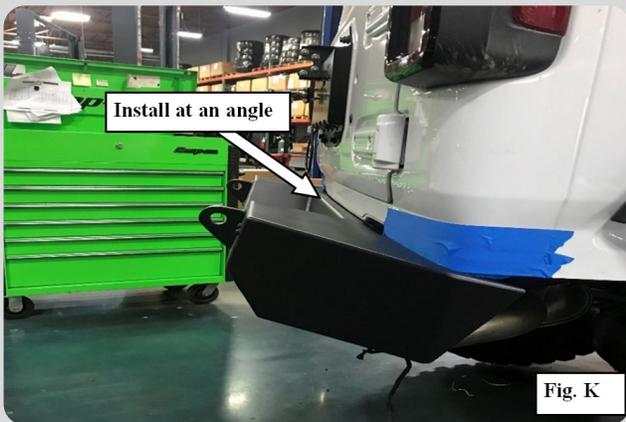
Matching the positioning from the **OE** bumper. Install the sensor into the welded sockets on the **XRC Gen 1 Rear Bumper**. Then, install the plastic half circle retaining clip into the welded socket as shown. The sensor should be secure in place. If there is some movement in the sensor, remove the retaining clip and add an additional foam pad on top of the existing one. Repeat this step for the remaining sensors.



### Step 8:

#### Vehicles without sensors only:

Insert the included rubber plug into the welded sensor sockets from the back side of the bumper. Make sure the ears on the plug are aligned with the sensor hole slots. Then, from the outside of the bumper, install one of the included rubber discs to fill the gap between the sensor plug and the face of the bumper as shown.



### Step 9:

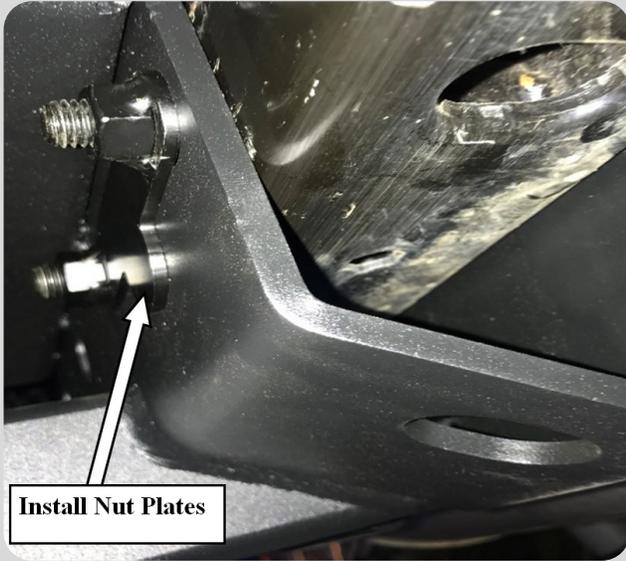
#### Note: This step will require 2 people.

Carefully raise the rear bumper at an angle and insert it against the outer frame rails and align the mounting holes. Loosely install the **OE** bolts on the outside of the frame rails, do not tighten the hardware yet.



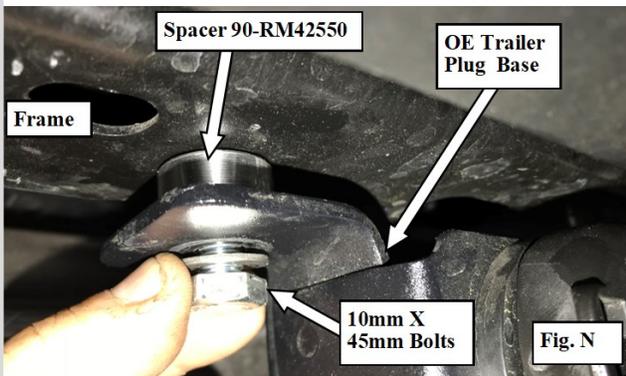
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## Installation Instructions: XRC Gen 1 Bumper Install



### Step 10:

Secure the **XRC Gen 1 Rear Bumper** to the rear frame crossmember using the (4) supplied **M12-1.75x120mm Bolts**, (2) **M12 Flat Washers**, and (2) **M12 Nut Plates**. Adjust and level the rear bumper. Then, torque all the hardware using the specifications on **Page 8** of this guide.



### Step 11:

If applicable, reinstall the trailer plug base to the frame using the (2) provided **M10-1.5x45mm Bolts** and spacers (**90-RM42550**) and reconnect the trailer plug. Torque the **M10 Hardware** using the specifications on **Page 8** of this guide. (**Fig. N**)



### Step 12:

Install the license plate bracket (**S/B7734**) according to the instructions included with the kit.

Recheck all hardware proper torque before driving after install, 500 miles or 1 month after install, and every 4-6 months thereafter.

**Installation is now complete.**

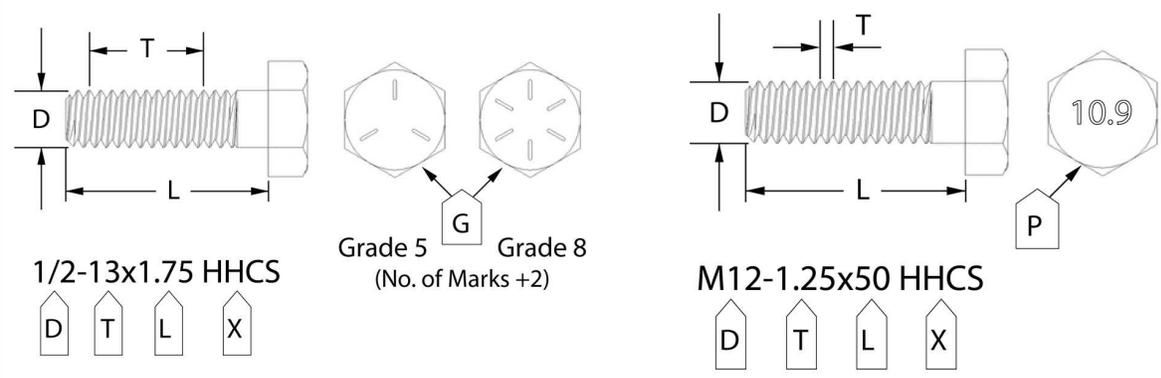


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# Bolt Torque Specifications

Use this only as a guide for hardware without a called out torque specification in the instruction manual.

<b>Bolt Torque and ID</b>						
Decimal System			Metric System			
<i>All Torques in Ft. Lbs. Maximums</i>						
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>G= Grade (Bolt Strength)</p> <p>D= Nominal Diameter (Inches)</p> <p>T= Thread Count (Threads per Inch)</p> <p>L= Length (Inches)</p> <p>X= Description (Hex Head Cap Screw)</p>	<p>P= Property Class (Bolt Strength)</p> <p>D= Nominal Diameter (Millimeters)</p> <p>T= Thread Pitch (Thread Width, mm)</p> <p>L= Length (Millimeters)</p> <p>X= Description (Hex Head Cap Screw)</p>
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# Notes and Disclaimers

## Product cleaning and maintenance instructions

Stainless Steel Finish – Aluminum polish may be used to polish small scratches and scuffs on the finish. Mild soap, window or glass cleaner may be used to clean the finish. Dual state powder coat finish – Mild soap, window or glass cleaner may be used to clean the finish. In order to protect the finish, you may wax your product on a regular basis with pure carnauba automotive wax. Do not use any types of soap, polish or was that contains abrasive that could damage the finish. Textured coated finishes should be cleaned with a mild soap on a damp sponge. Do not apply polish or was that requires to be removed by means of buffing. This type of wax is commonly used at car wash facilities. Chrome Finish – Mild soap, window or glass cleaner may be used to clean the finish. In order to protect the finish, you should wax your product on a regular basis with pure carnauba automotive wax. Do not use any types of soap, polish or was that contains abrasive that could damage the finish.

## SMITTYBILT ADVANTAGE WARRANTY

### LIMITED-LIFETIME WARRANTY FOR STRUCTURAL COMPONENTS

#### 5-YEAR FINISH WARRANTY

Smittybilt Automotive Products, LLC (SAP) warrants to the original purchaser that (a) the physical components (e.g., metal components, welds, etc.) of any SAP **JL XRC Gen 1 Rear Bumper** will be free of defects in material and workmanship for the lifetime of the product from the date of purchase of the bumper, and (b) the finish will be free of defects in material and workmanship for a period of 5-years from the original date of purchase. This warranty applies only to the original purchaser of the bumper and is non-transferable. To obtain any warranty service, you must provide SAP with a proof of purchase and date of purchase that is acceptable to SAP, such as a copy of your purchase receipt.

This warranty does not cover labor of part replacement of the bumper. SAP will, at its sole discretion, provide replacement part (s) for a defective bumper or component, provided this is done within the warranty period. To request assistance under warranty, one must call or email using the phone number or email at the bottom of this page. This warranty does not apply (1) wearable components; or (2) if the bumper has been damaged, including, but not limited to: abuse, misuse, collision, modification, misapplication, improper installation, or improper service. This warranty is void if any SAP serial number has been removed or defaced; or if bumpers are used for any commercial, industrial, or rental applications. This warranty only applies to XRC Gen 1 Rear Bumpers bought, sold, and used within the Untied States or Canada unless otherwise specifically agreed in writing by SAP.

THE WARRANTY SET FOURTH ABOVE IS THE ONLY WARRANTY. THERE ARE NO OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANT ABILITY OR FITNESS FOR A PARTICULAR PURPOSE. ANY IMPLIED WARRANTY WHICH BY LAW MAY NOT BE EXCLUDED IS LIMITED TO A DURATION OF ONE (1) YEAR FROM THE DATE OF ORIGINAL RETAIL PURCHASE OF THE PRODUCT. No SAP dealer, agent, or employee is authorized to make any modification, extension or addition to this warranty. SAP SHALL NOT BE LIABLE FOR SPECIAL, INDIRECT, INCIDENTAL OR CONSEQUENTIAL DAMAGES (INCLUDING, BUT NOT LIMITED TO, LOST PROFITS, DOWN TIME OR LOSS OF USE) UNDER ANY LEGAL THEORY, EVEN IF SAP WAS ADVISED OF THE POSSIBILITY OF SUCH DAMAGES. Some states do not allow the exclusion of implied warranties or the exclusion or limitation of liability for incidental or consequential damages, or limitations on how long an implied warranty lasts, so the above limitation or exclusion may not apply to you. This Warranty gives you specific legal rights. You may also have other rights that vary from state to state. SAP reserves the right to change product design without notice. In situations in which SAP has changed a product design, SAP shall have no obligation to upgrade or otherwise modify previously manufactured products. For warranty inquires contact SAP at:

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Customer Service Department

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