



WJ Modular Front Bumper Stubby Center Section DIY Assembly

1999-2004 Jeep Grand Cherokee WJ
Part number: DPL-WJ-FBS, Revision 4/18/18

This is the DIY Stubby Bumper assembly instructions. After assembly, see Stubby Bumper installation instructions.

Step 1: Once unboxed, the bumper is ready for building. The stubby bumper itself is symmetrical, (so there is no specific inside or outside), so decide which side will be facing outward and place the bumper on a table with that side facing up.

Step 2: On the face that will be visible, we recommend scoring the outside of each bend tab about halfway through to ease the hand bending process and keep the weld gaps smaller.



Step 3: Bend all sections of the bumper to the final shape (Note: If a piece cracks off don't worry, just realign and tack weld in place), As you are bending the bumper, pay special attention to the outermost vertical flange with 3 bolt holes. You want this to be as close to parallel with the matching cut on the bottom plate, as this is the face your frame mounts, D ring (and bumper wings) bolt to, so it being square is important.

Step 4: Tack weld the body at evenly spaced intervals to set every bent flange in their final position, and start preparing for finish welding. When approaching the finish weld process, you do not want to concentrate too much heat in any specific area, so it is highly advisable to shift around and evenly distribute the heat along with letting things cool after longer welds.



Step 5: Weld all seams, bouncing around to balance heat input as described. Once welded, you can choose to leave the welds exposed or grind them back to a nice bevel for a smooth appearance depending on your desired outcome.

Step 6: Enjoy your handiwork, the stubby bumper shell itself is complete. Once the bumper build is complete, you can move on to the installation (See: WJ Stubby Bumper Installation Instructions)



If you also purchased D-Ring tabs at this time, you can bolt them up to your welded bumper, and weld the 2 pieces per side together now. See photo for orientation. Slide the 3/4" tab and bottom plate together so the edges just touch, and weld together (be sure not to weld through to the bumper itself, unless you are permanently adding them on).

