



PART # JT0018

JT GLADIATOR BANTAM COMP REAR BUMPER SYSTEM



ESTIMATED INSTALLATION TIME

3-5 hours

REQUIRED TOOLS & SUPPLIES

- 21mm socket
- 21mm wrench
- 17mm socket
- 16mm socket
- 15mm socket
- 8mm socket
- Masking tape
- Small phillips screw driver
- Small flathead screw driver
- Medium flathead screw driver
- 5/32" allen wrench
- 3/16" allen wrench
- Alignment bar (optional)
- Trim removal tool (not really optional)
- Gloves
- Safety glasses
- Jack/vehicle lift (optional)
- Grinder with cutting disc(s)
- Loctite (optional)
- Zipties

REQUIRED SKILLS

- General Mechanics Skills
- Drilling
- Cutting
- Measuring

NOTES:

- This product arrives in 3 separate boxes labeled JT0218, JT0217, JT0118, JT0117
- Component appearance in instructions may vary from those received
- Add-ons for this Kit include: Receiver JT0135, Rear inner fender kit JT0006, Fender chop kit JL2112, Stainless fender hardware upgrade HK2113

WARNING MESSAGES

This product demands a basic understanding of mechanical procedures and should only be installed by individuals proficient with mechanic's tools. Any tasks involving welding or cutting parts should be performed by trained professionals. Artec Industries disclaims responsibility for mishaps arising from improper installation, or any damage or accidents resulting from cutting or welding tasks. Exercise caution and seek professional help as required

SAFETY

1. We've furnished a written installation guide, along with relevant details, to aid you in making safety-conscious decisions.
2. While these guidelines will highlight potential risks, it's crucial to exercise your personal judgment when performing any required steps.
3. Before initiating any tasks, it's essential to conduct a job safety analysis to identify specific hazards in your situation and take measures to eliminate or protect against them.
4. Before commencing the installation of this product, make sure you familiarize yourself with and fully understand all safety warnings and guidelines.

DISCLAIMERS

All Artec Industries products should be installed by a competent, certified individual following the intended installation instructions for each product. Incorrect installations not only nullify any warranties but could also lead to product damage or even damage to the vehicle it's installed on. Prior to installation, carefully read all provided instructions or manuals, and watch any associated videos. For any doubts or queries, reach out to Artec Industries before beginning the installation process.

Many products necessitate lifting and supporting the vehicle off the ground. It is the installer's responsibility to ensure this can be done safely and that the right equipment is at hand to carry out the installation. Artec Industries installation instructions presume the installer is competent to lift the vehicle safely and correctly.

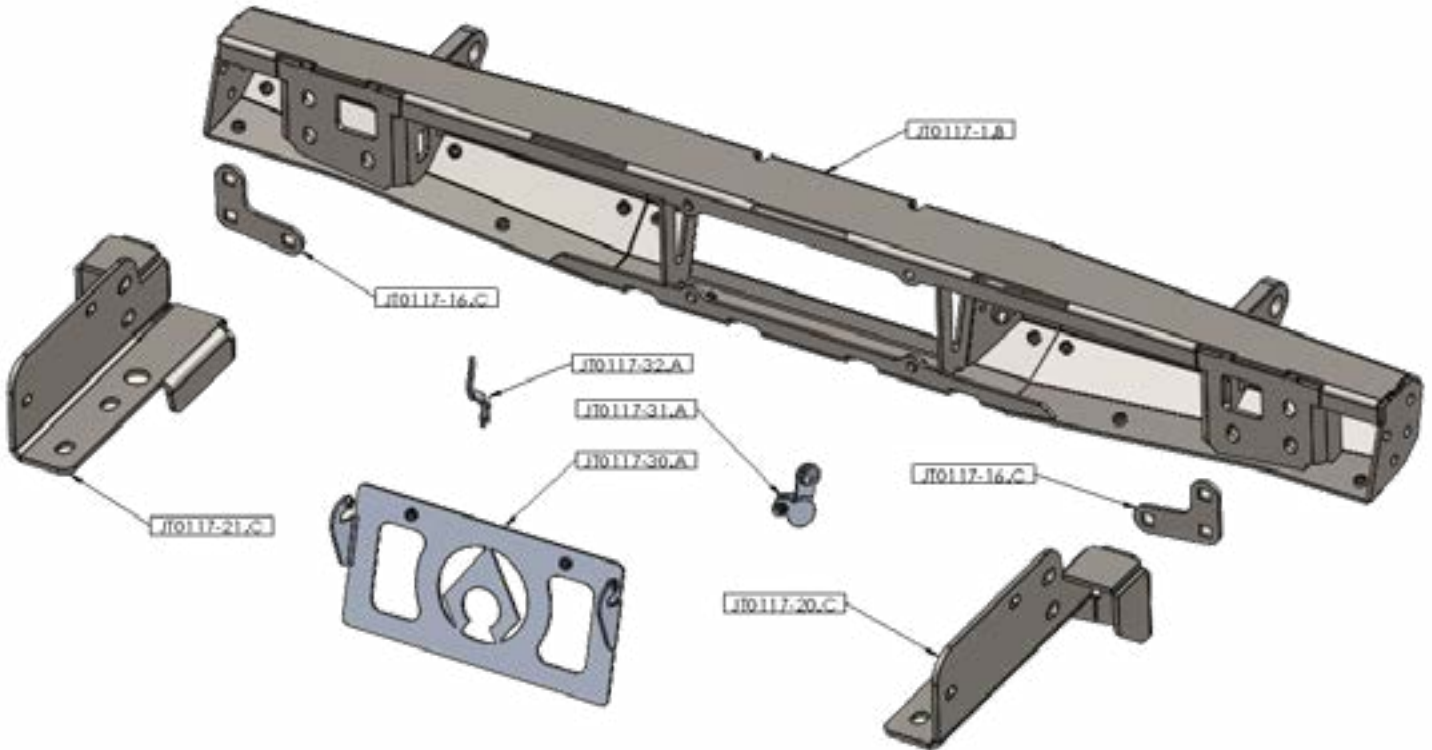
Modified vehicles won't perform identically to their stock counterparts. It's incumbent upon the vehicle owner to understand the alterations such modifications will bring to the vehicle's driving dynamics. These might encompass (but aren't limited to): changes in handling, braking, rollover angle, and potential incompatibilities with the factory-installed anti-lock braking systems, stability control systems, or traction control systems.

SPECIAL NOTES

- This product requires the body of the vehicle to be cut/modified.
- See the multiple optional steps are listed.
- Additional upgrades are called out.

JT0117 PARTS BILL OF MATERIALS

Please confirm you have all the listed parts below BEFORE beginning your installation. If any parts are damaged or missing, KEEP ALL ORIGINAL BOXES and PACKAGING and contact us.



NOTE: The part numbers indicated above end in a "." and "letter" which indicate the revision number for the part. The etched part number on your physical parts do not need to match the above drawing revision exactly.

HK0117 HARDWARE BILL OF MATERIALS

HK5117

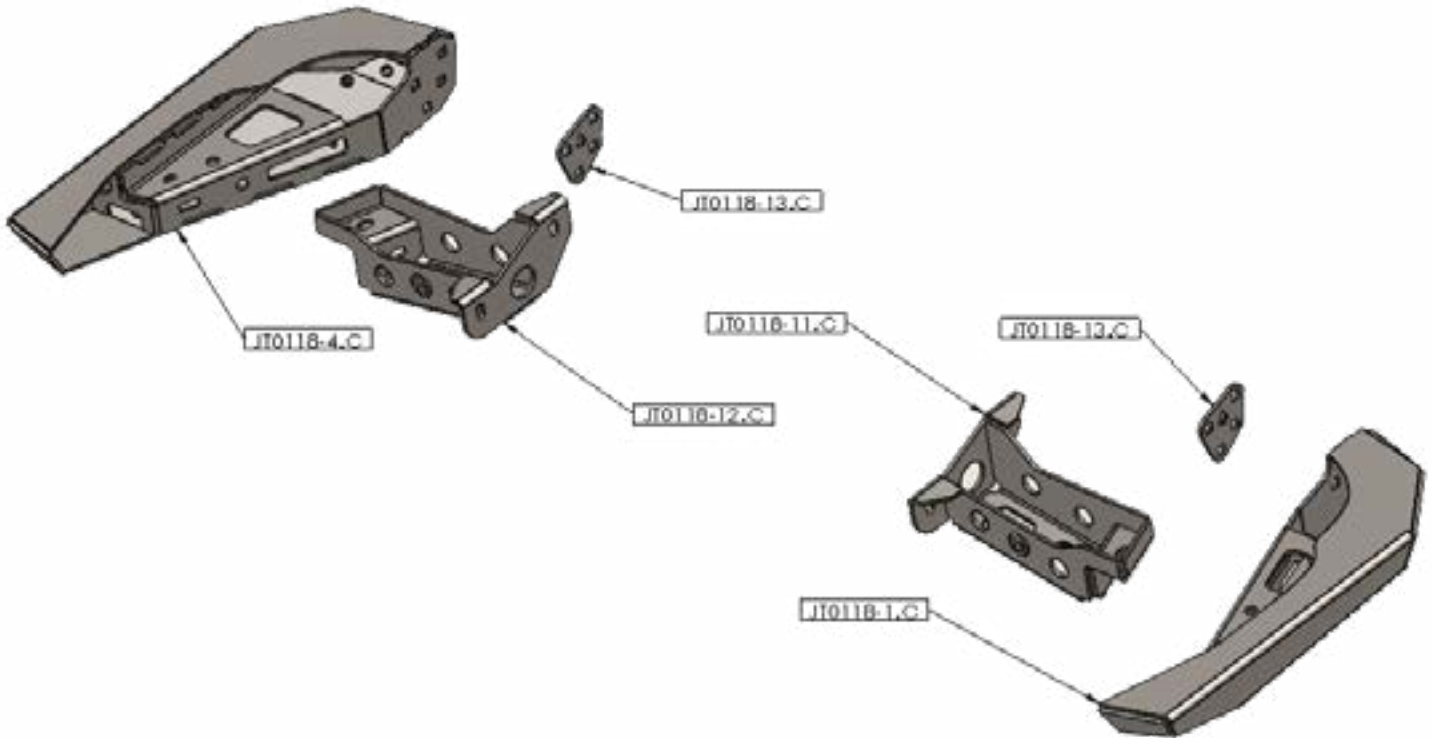
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	HW0234	M12-1.75mm Steel Flange Nut - MAGNI 565 COATING	6
2	HW0244	M12-1.75x35mm Steel Carriage Bolt - MAGNI 565 COATING	6
3	HW0245	M12 Steel Push Nut/Washer - MAGNI 565 COATING	6
4	HW0251	M14-2.0mm Steel Flange Nut - MAGNI 565 COATING	4

HK0117

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	HK5117_A	MS HARDWARE KIT, HIGH CLEARANCE REAR BUMPER CENTER SECTION, JEEP JT GLADIATOR	1
2	JL5501-6	Sensor Spacer for JL Nighthawk Rear Bumper	4
3	HW0102	O-Ring 1.0625" ID 0.0625" Width	4
4	HW0103	Plastic Plugs for Panels with Snap-in Ring 3/4" ID	4
5	HW0062	1/4"-20 x 3/4" Button Head Socket Cap Screw Zinc Plated	4
6	HW0217	1/4" UHMW Plastic Washer, WHITE	2
7	HW0092	1/4"-20 x 1/2" Button Head Socket Cap Screw Zinc Plated	2
8	HW0067	1/4" Standard Flat Washer Clear Zinc	2
9	HW0252	1/4"-20 RH THIN JAM NUT - CLEAR ZINC COATING	2

JT0118 PARTS BILL OF MATERIALS

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NOTE: The part numbers indicated above end in a "." and "letter" which indicate the revision number for the part. The etched part number on your physical parts do not need to match the above drawing revision exactly.

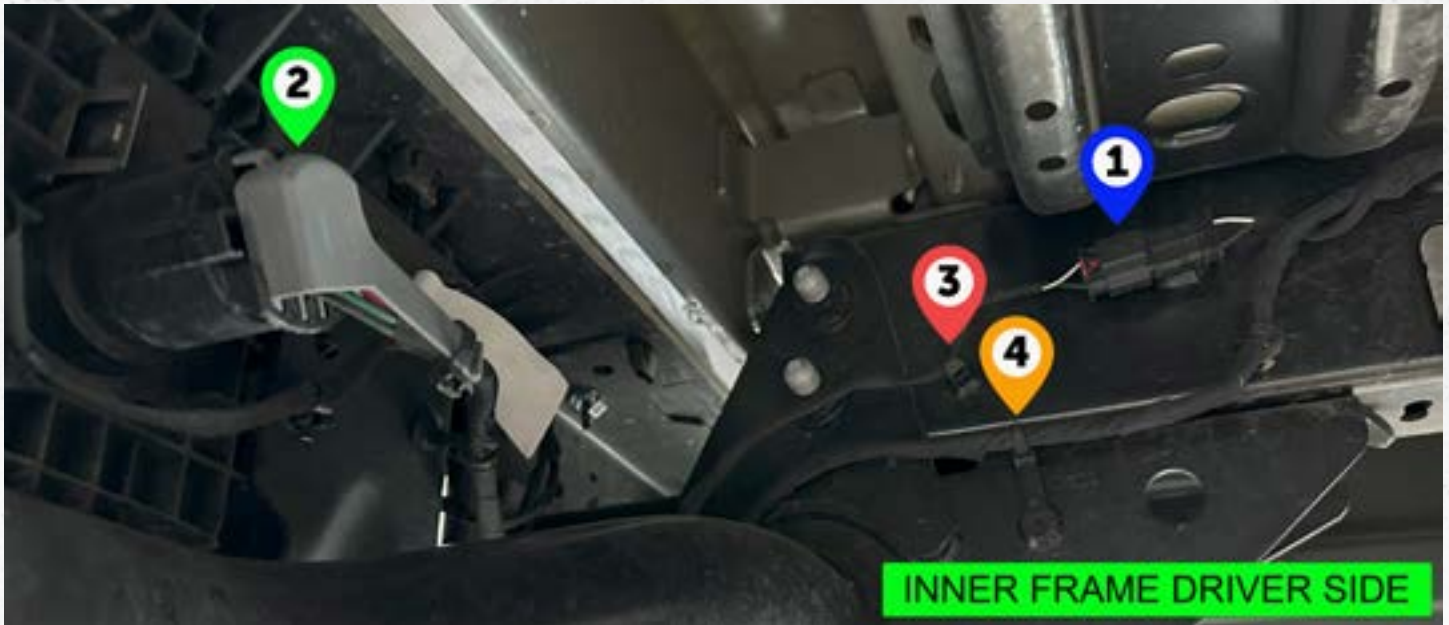
HK0118 HARDWARE BILL OF MATERIALS

HK0118				
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.	
1	HW0243	M10-1.5x25mm MAGNI 565 Carriage Bolts	8	
2	HW0233	M10 x 1.5mm Steel Flange Nut - MAGNI 565 COATING	12	
3	HW0229	3/8" Flat USS Washer Zinc	4	
4	HW0238	M10-1.25x30mm MAGNI 565 Flanged Hex Head Screw	4	
5	HW0237	M10-1.25x25mm MAGNI 565 Flanged Hex Head Screw	4	

STEP LOCATION GUIDE



DISASSEMBLY INSTRUCTIONAL GUIDE



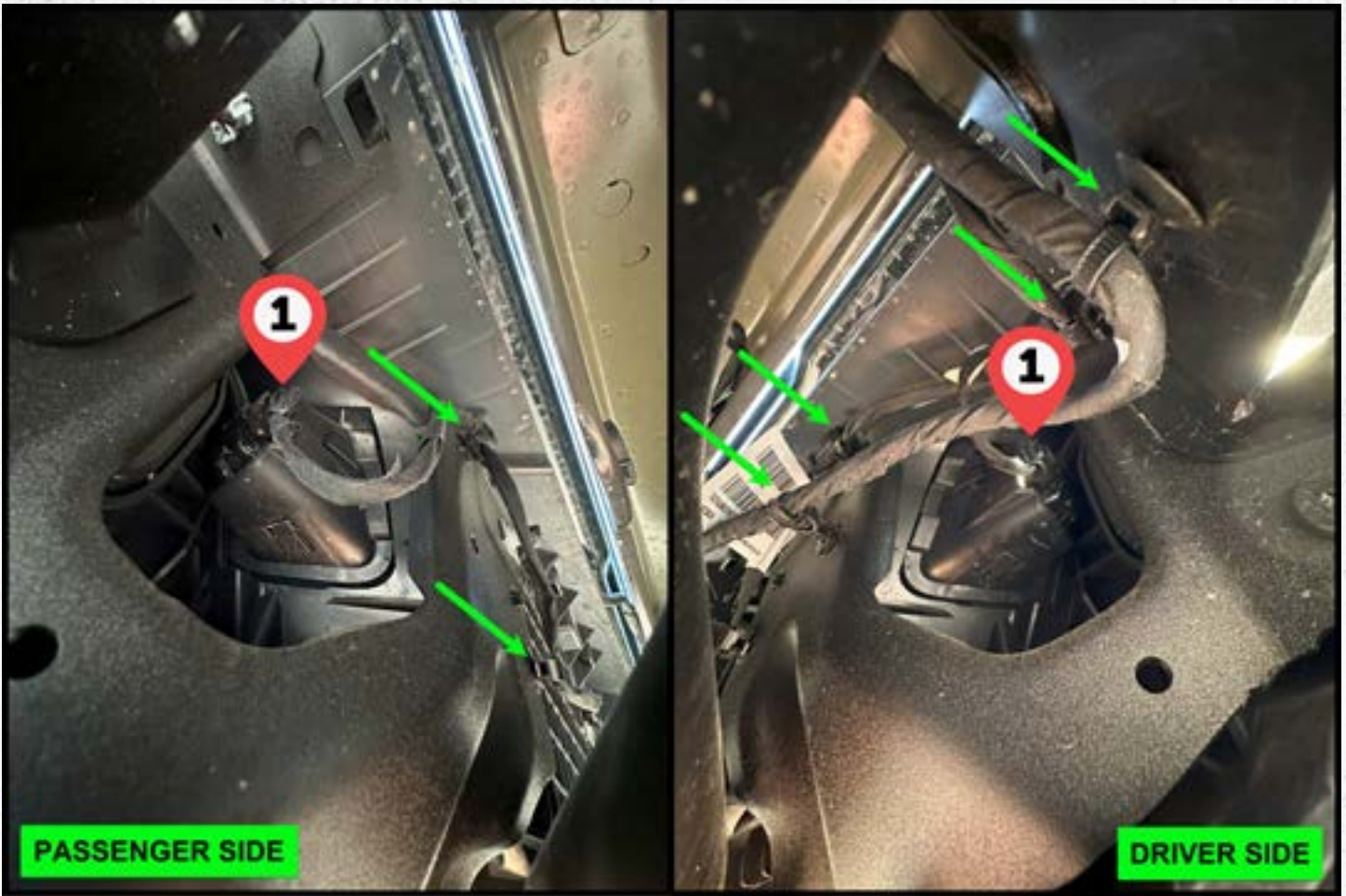
Step 1:

Before any mechanical disassembly, you will need to disconnect the wiring from the bumper. This will include the trailer plug assembly, license plate lights (x2) and reverse sensor lights IF you have them. In this guide we cover the license plate lights and trailer plug assemblies.

A. Disconnect the ① license plate light plug and then cut the ziptie clips ③ and any ties from there to the bumper.

B. Disconnect the ② trailer tow connector from the bumper and cut the ziptie clips ④ and any ties from there to the bumper. Do not remove this connector but coil and zip tie it up and out of way.

NOTE: Be carefull not to damage any of the wiring during disassembly as you will be reusing it during reassembly.



Step 2A:

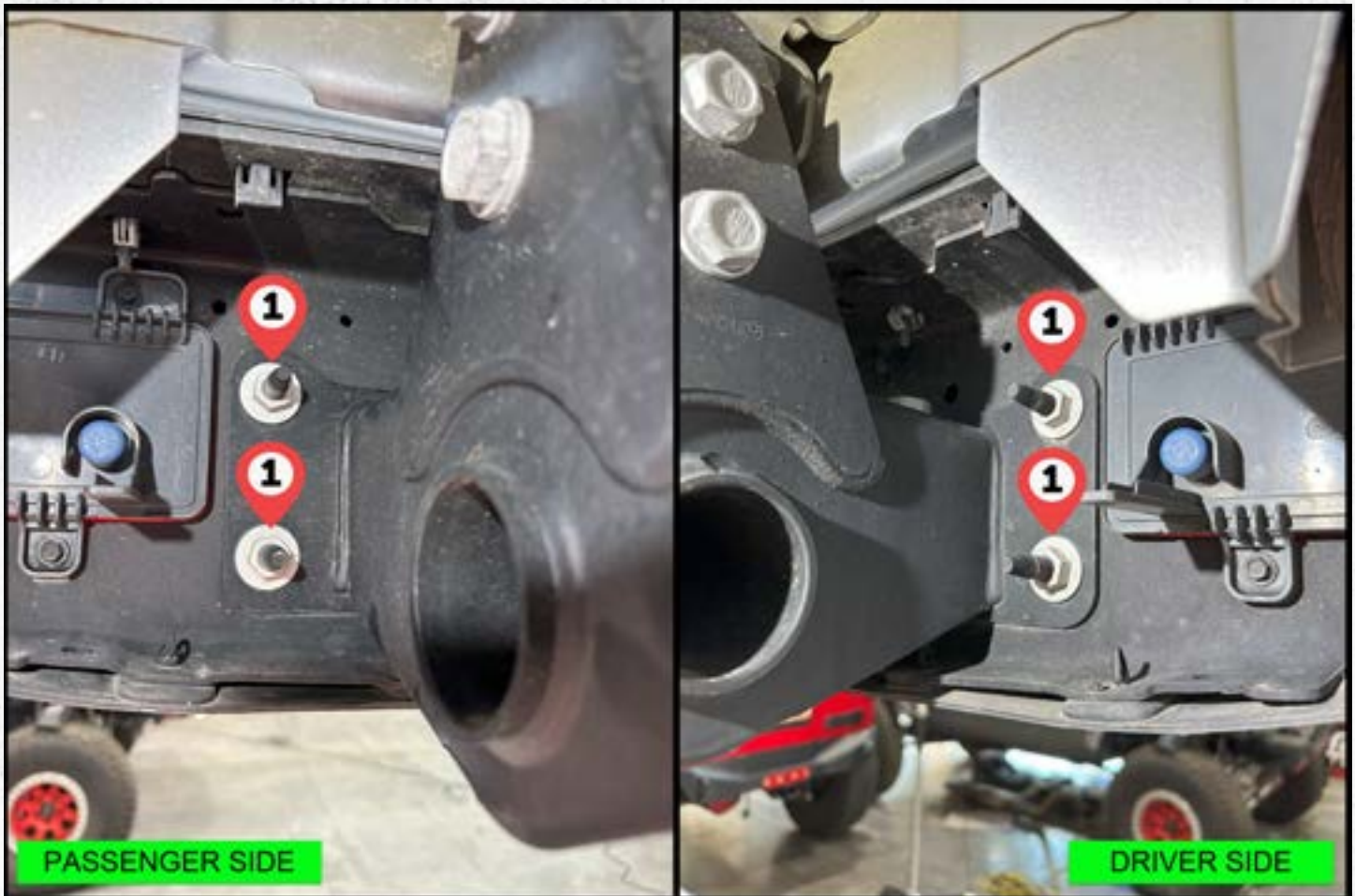
Disconnect the wiring from the ❶ 2 - license plate lights and clip ALL the zipties holding the wiring to the bumper **GREEN ARROWS**.

NOTE: Keep this harness. It will be used on the new bumper with different routing.



Step 2B:

Once you have removed the wiring you are now ready to move onto the mechanical disassembly.



Step 3 OPTIONAL

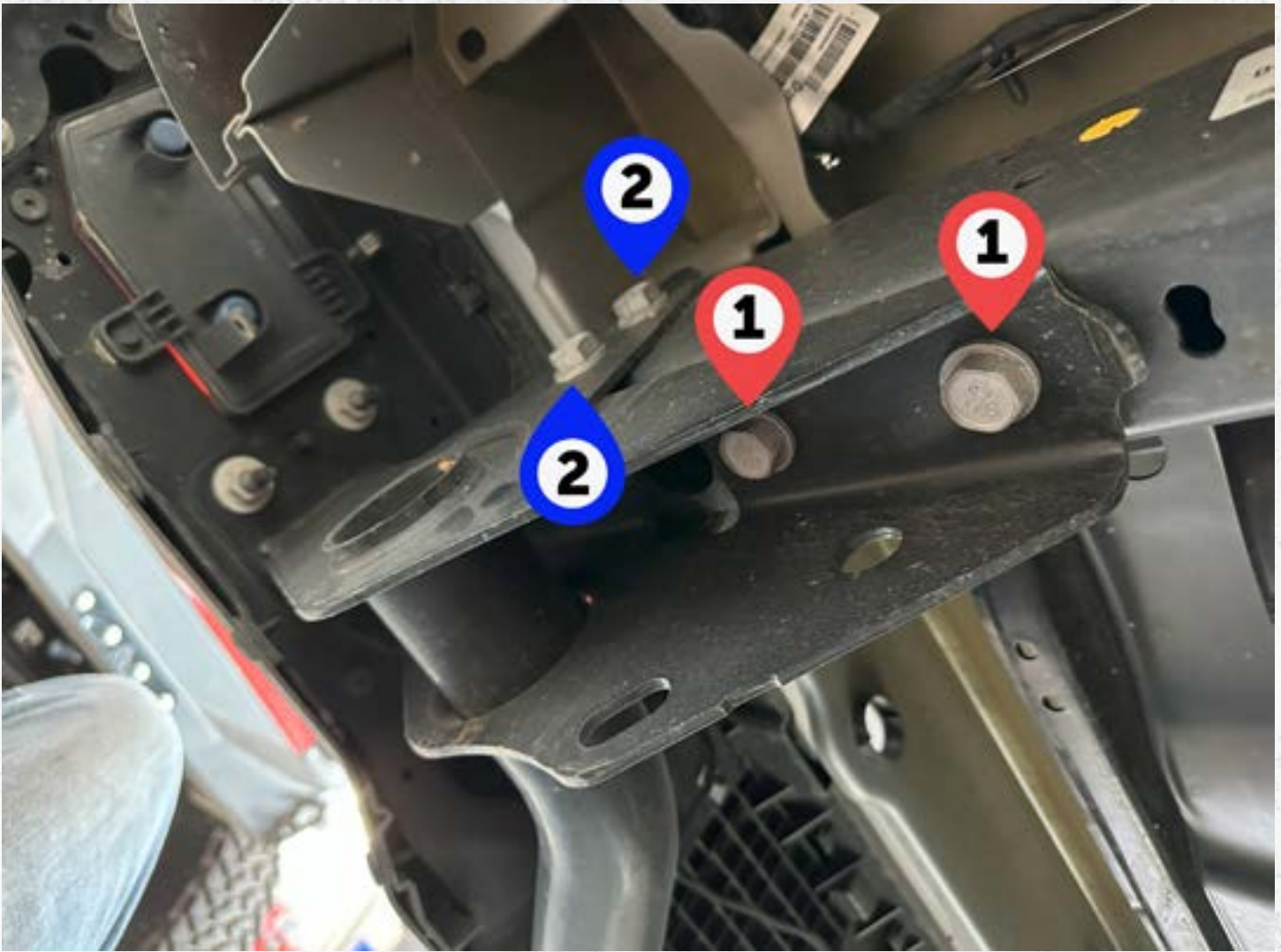
A. Remove 4 - M10 nuts ❶ using a 16mm socket. Do this BEFORE removing the license plate, and the bolts behind the license plate.

B. While holding the bumper in place, pushing the bumper into the vehicle, remove 2 - M10 bolts ❷ using a 16mm socket. Once they are removed you can now take the bumper off.

NOTE: This step is optional. You can remove the receiver and bumper at the same time on the following step.



Once you have removed the bumper you can easily remove the trailer plug by relieving the retaining clips on the back.



Step 4:

A. To disassemble the receiver hitch from the frame begin by removing 4 - M14 bolts ❶ using a 21mm socket from both frame locations.

B. After removing the bolts from location ❶, UNTHREAD but do not remove the 4 - M14 bolts ❷ using a 21mm socket. Support the hitch and then remove the bolts from location ❷. This will free the hitch completely.

NOTE: unlike the factory bumper, the receiver hitch has some weight to it. You may want a second set of hands supporting the hitch when disassembling it.

ASSEMBLY INSTRUCTIONAL GUIDE



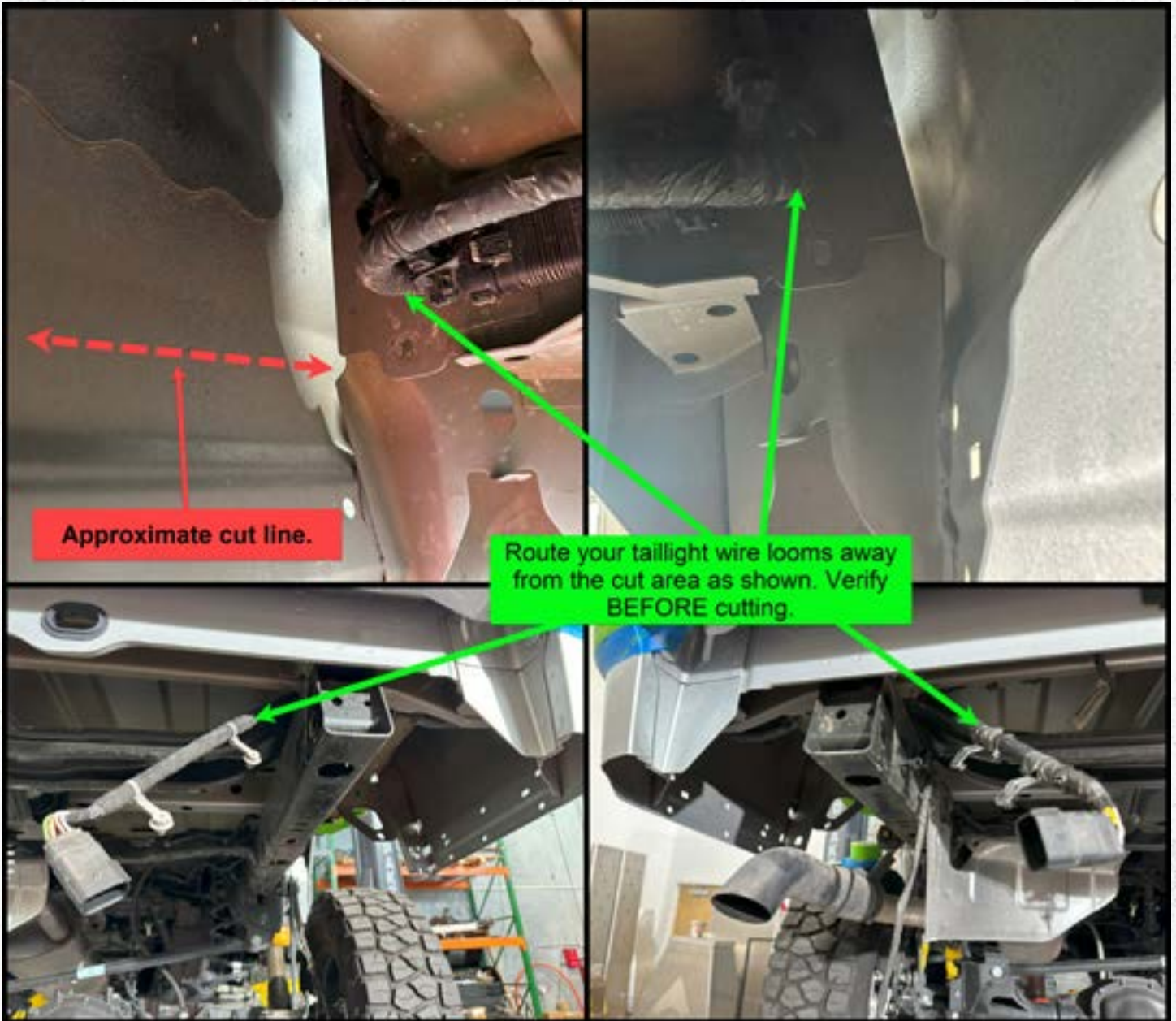
Step 5:

- A. Using an 8mm socket remove 2 - screws ❶.
- B. Carefully move the taillight away from the tailgate about a 1/4" or until you hear a click.
- C. Once the screws have been removed and the internal clip is disengaged you can pull the light.



Step 6:

- A. Disconnect the tail light plug by first, pulling/sliding the red tab down RED arrow and then depressing the latch GREEN arrow.
- B. Using a screwdriver or trim tool disassemble the wiring from the bed ❶.



Step 7. You **NEED** to pull the taillight wire loom out of its original location and locate it **AWAY** from the cut area. This is very **IMPORTANT**, take the time to properly keep this wiring from the cut area.



Step 8. Remove the the plastic bed bumper using a pair of plyers to pinch the tabs on the inside of the bed. You will not reuse these parts.

NOTE: In the following steps you will remove the inner fender liner and the outer fender flair in preparation for the bed cut. We suggest replacing the plastic inner fender liner with JT0006 (JT rear inner fender kit) and JL4112/HK4112 (fender chop kit and stainless hardware upgrade) upgrading from the plastic clip anchors that will inevitably break during disassembly.



Step 9:

A: Using a 8mm socket remove 3 - screws **2**

B: Using a screwdriver or trim tool remove the 4 - plug fasteners **3**

C: To remove fender assembly; First, push the fender into the body and then immediately pull the fender away from the bed. Some of the plastic clips may/will break. Mopar PN# 68526185AA

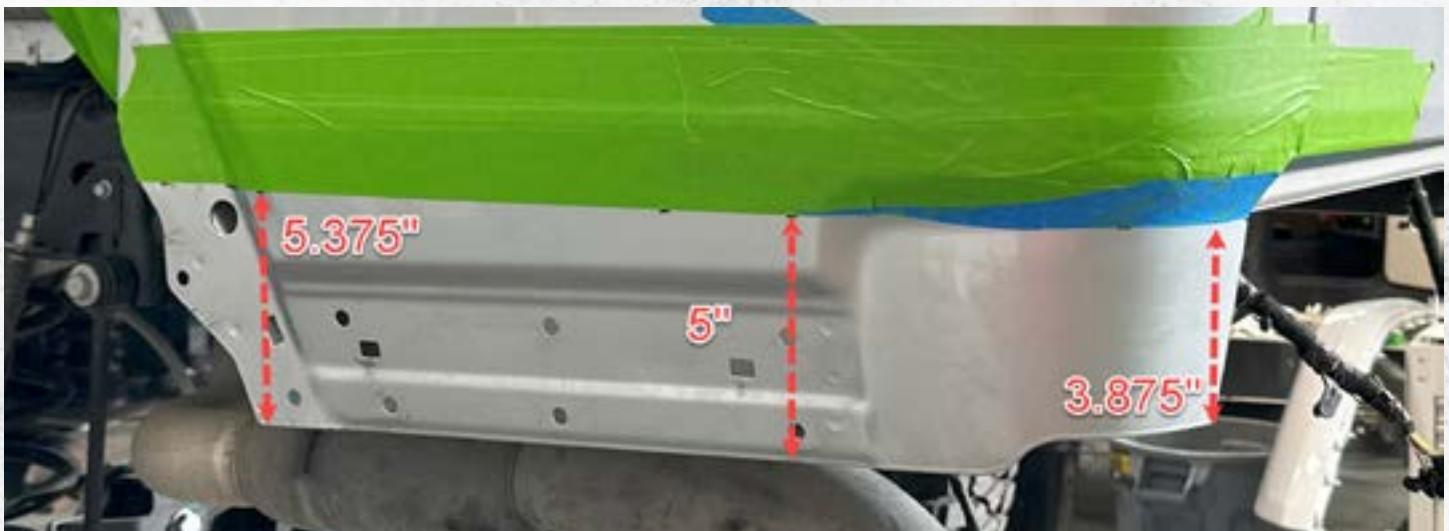
OPTIONAL: If you choose to utilize the fender chop kit (JL4112) Using a small screwdriver remove the 9 - plastic rivet style fasteners **1** by pushing the rivet center out.



Step 11:

A: First you will need a piece of material, tubing, 2x4 or level (probably the best option) that is 6 feet long. You will place it across your bed rails as seen above. This will give you the best reference point for measuring your bed cut. The bed rails are parallel with your frame. Measure from the bedrails 22.25" and mark the bed. This is your cut line. Transcribe this measurement from the fender to the bed corner.

B: We suggest using marking tape to protect your bed. Place the tape on/above your cut line. This will take you time because the bed has multiple contours.



Step 11B.

This are approximate measurments from the bottom edge of the bed. We suggest taking your measurement from the top, but if that is not an option you can use these measurements as a reference.



Step 12:

For the driver side you will want also tape off/protect the fuel inlet area at the front of the fender and the wiring/evap lines the rear of the fender as shown above.

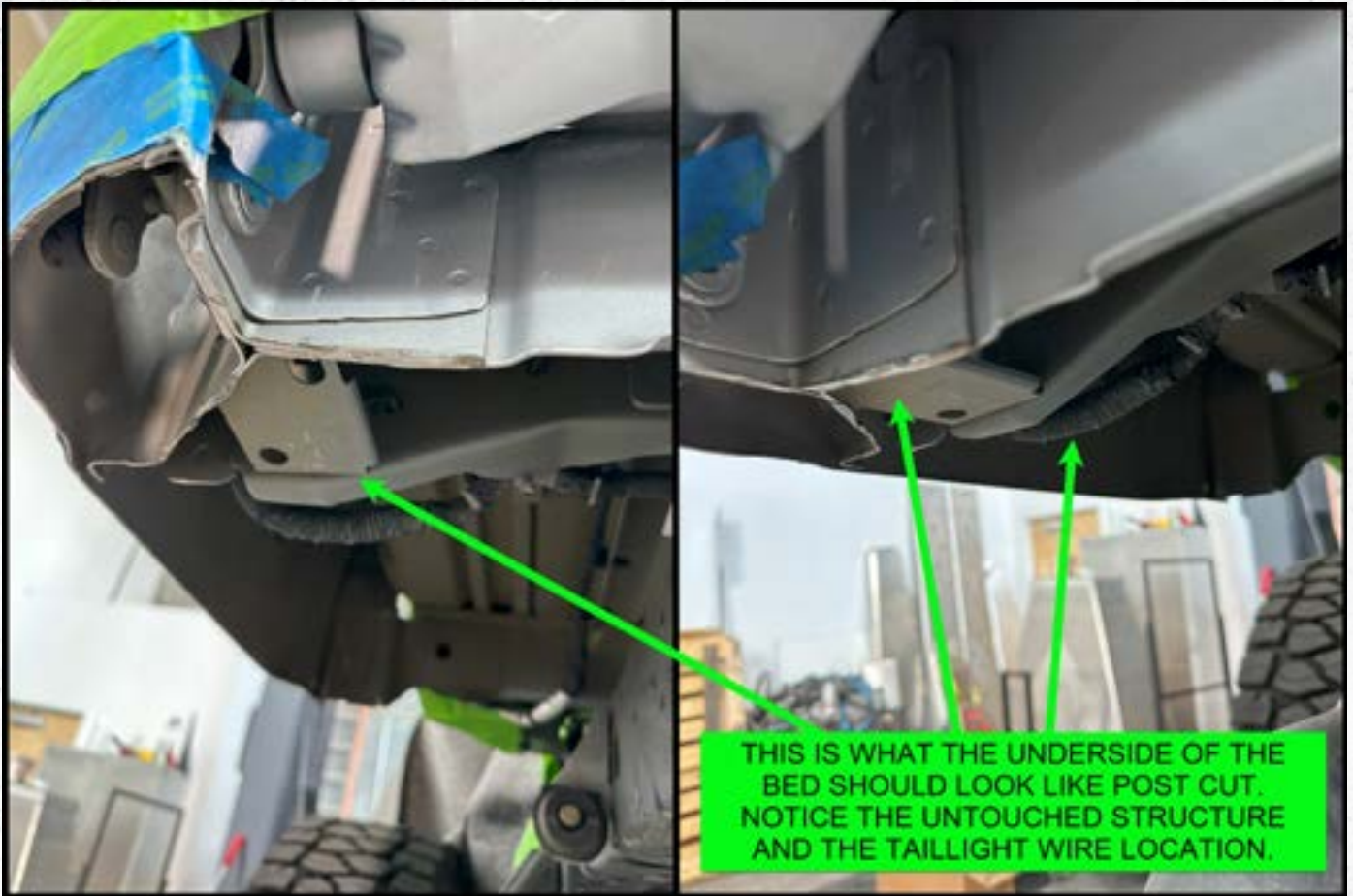


Step 13:

BEFORE cutting verify all wiring is out of the cut area.

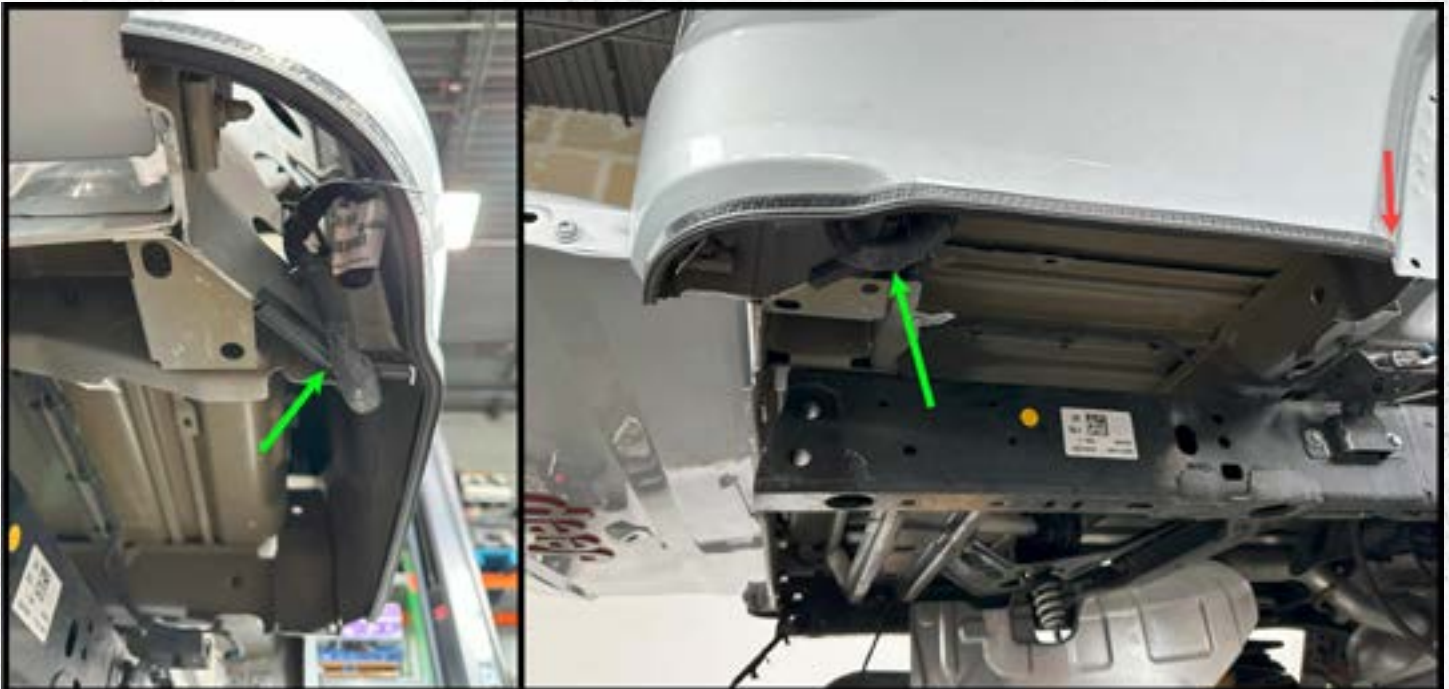
Once that has been confirmed, using one or more of the following: sawzall, jigsaw or right angle grinder, remove the bed as shown above. SEE the next step for a view of the underside. Be carefull not to cut upward after you have cut the out shell. Keep the cut as level as possible.

Note: You can always remove more but you cannot add it back. Take your time.

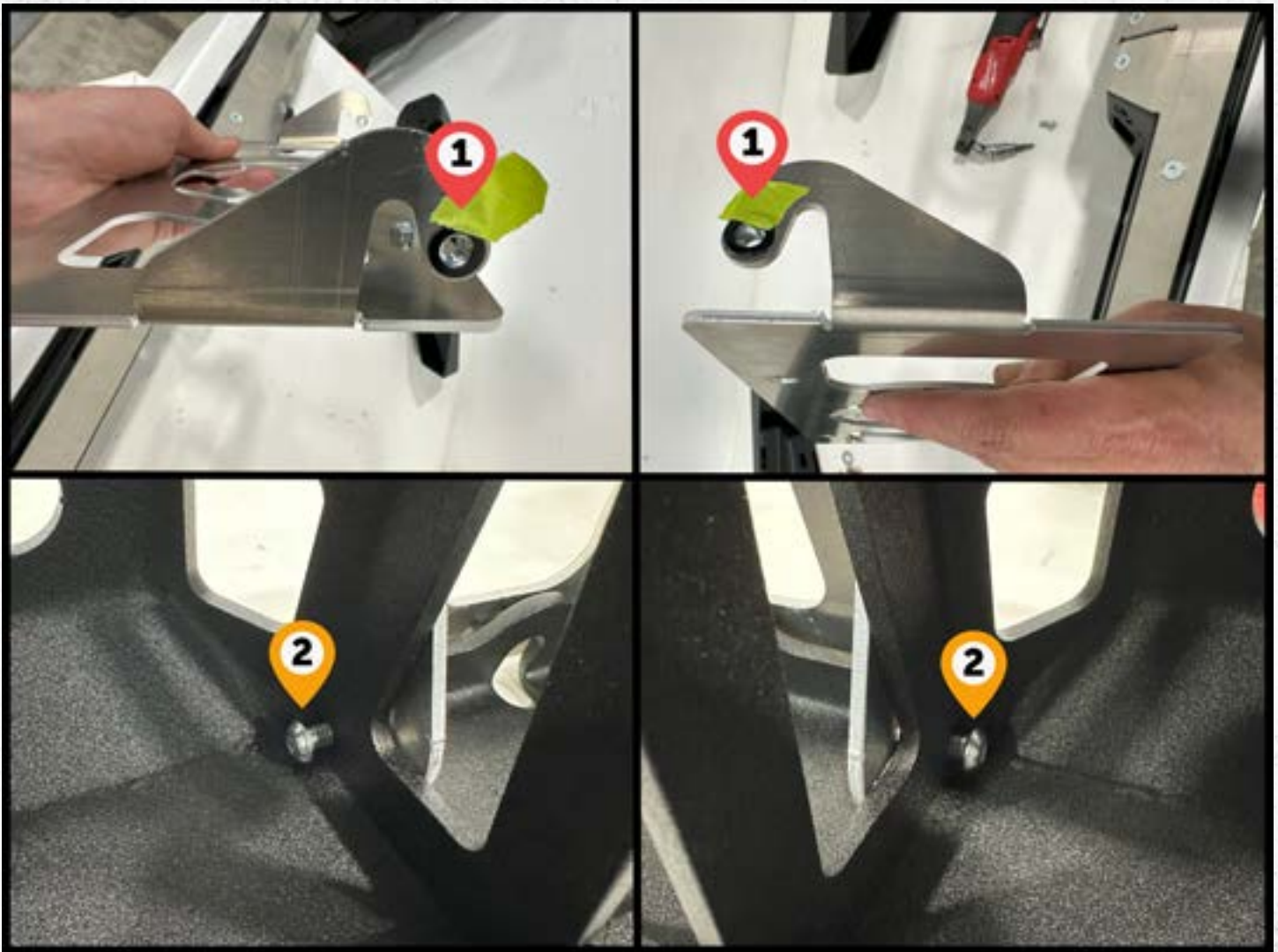


Step 14A:

Using a grinder, deburring tool or file remove any burr that resulted from the cutting process. Once the edge has been finished, you can now coat/paint the raw steel.



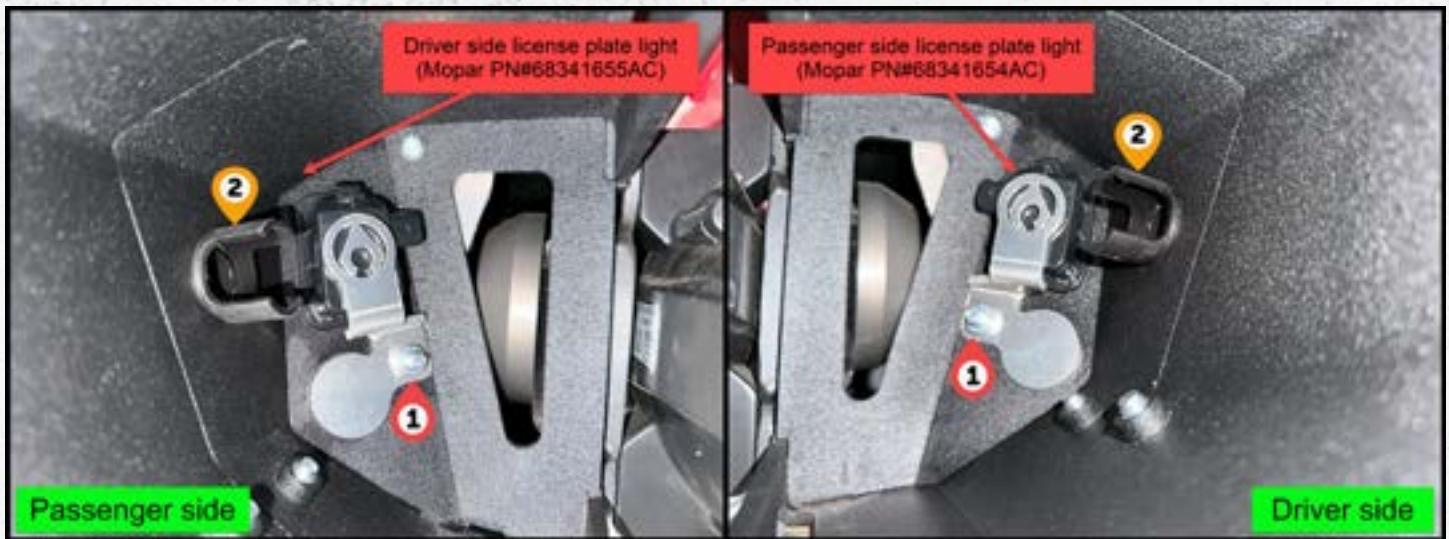
Step 14B: OPTIONAL. But we suggest applying a rubber trim to the cut edge as seen above. The **GREEN** arrows are where the taillight wiring will run. The **RED** arrow shows where the trim can end at the fender.



Step 15:

A: Using a piece of tap, attach the 2 - nylon washers **1** as seen above. Paying attention not lose the washers, insert the license plate holder into the bumper.

B: With a 3/16" allen wrench, assemble the license plate holder to the bumper with 2 - 1/4 x 1/2" button head screw **2** and 1/4" zinc plated washers. Adjust the screw to your desired tension. Then attach and tighten the 1/4" nut, post pem nut. (Washers not shown above)



Step 16.

A: THIS BUMPER UTILIZES THE STOCK LICENSE PLATE LIGHTS.

Plugging the cable in beforehand (not shown above) insert the license plate lights into the correct locations; Passenger side light 68341654AC into the driver side bumper location, (Driver side light 68341655AC into the passenger side bumper location). Once placed retain the light with JT0117-31 (JT0117-32 for driver side location) and 1- 1/4 x 3/4" button-head screw ❶ using a 3/16" Allen wrench. Verify fit and then tighten them.

B: If you have the reverse sensors, install them into the appropriate bumper locations using JL5501-6 plastic inserts ❷ to seat them. If you do not have the reverse sensors use HW0103 to cap the sensor inserts.

NOTE: temporarily zip-tie the license plate wire harness to the bumper. It will keep this from interfering with the install later.



Step 17.

A: Lay the bumper center section and corner pods **UPSIDEDOWN** on a flat surface as shown above with the 8 - M10 carriage bolts and 8 - M10 flange nuts ❶ (different hardware is shown above).

B: Place the JT0118-13 plates, with the corner pods in prep for assembly. Arrows will point up, but in this orientation they are pointing down (Same plate as shown above **WITHOUT** the pem nuts inserted)



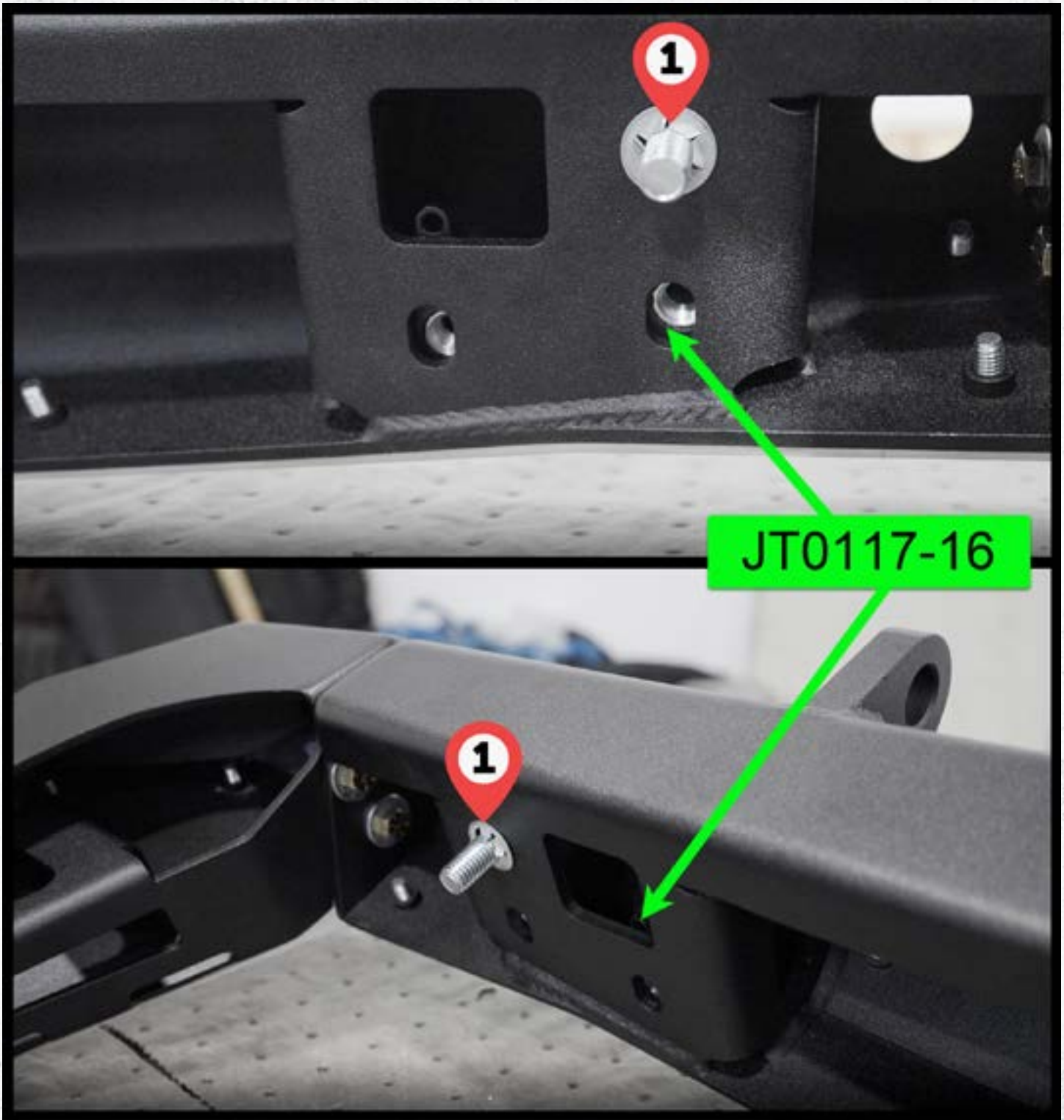
Step 18.

A: Place the corner pods into the orientation above.

B: Align the corner pod up with the center bumper section.

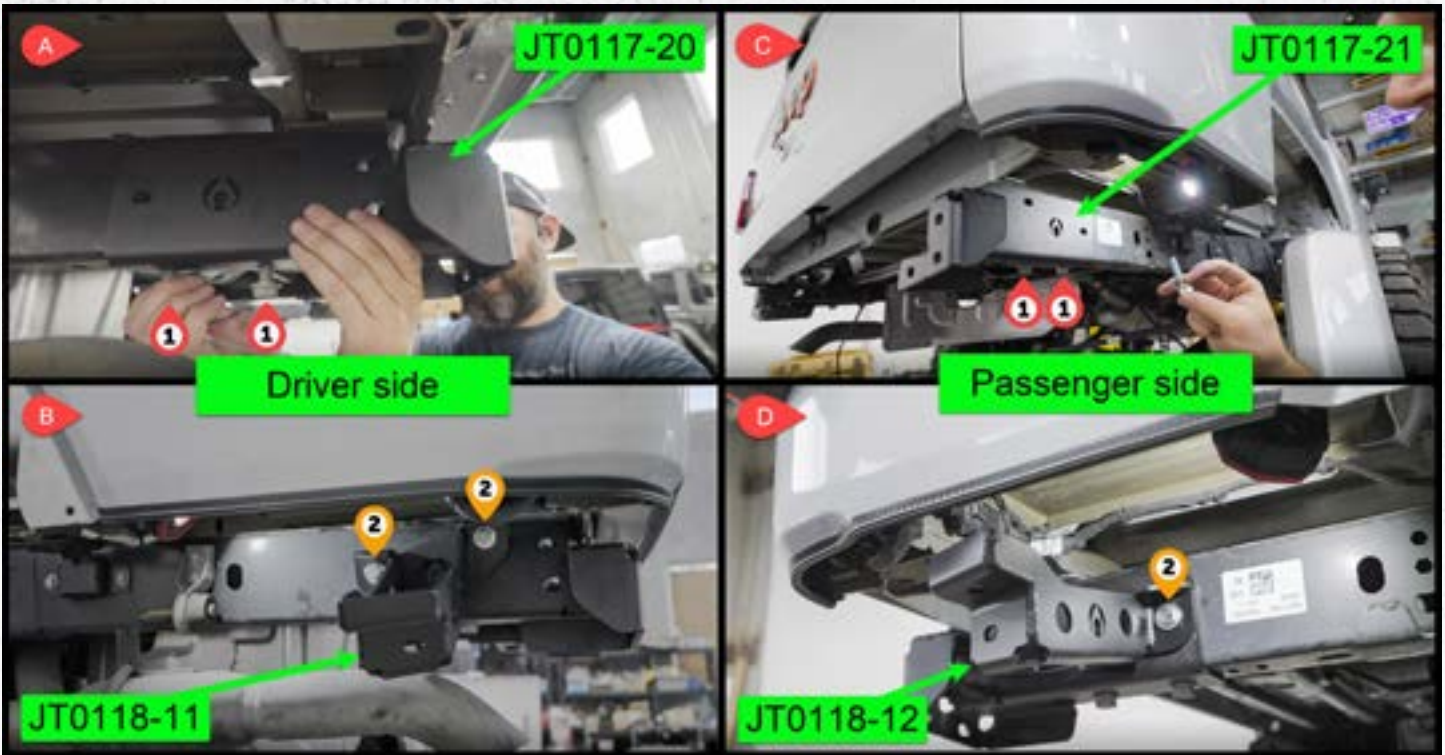
C: Insert the carriage bolts into the JT0118-13 plate, then assemble them **ARROW DOWN**, in this orientation. Hand tighten the flange nuts.

D: Holding the center bumper and the corner pods down tight to the flat surface, tighten the flange nuts.



Step 19.

A: Insert 3 - M12 x 35mm carriage bolts **1** into each JT0117-16 bracket. Place the bracket inside the bumper as shown above. Once inserted with the carriage bolts through the bumper, attach the M12 push nut washers. (The above picture does not show the latest revision)



Step 20.

AC: Loosely install brackets JT0117-20 (Driver) and -21 (Passenger) using the ❶ 4 - OEM M14 bolts.
 BD: Loosely install brackets JT0117-11 (Driver) and -12 (Passenger) using ❷ 4 - M10 x 30mm flange bolts and 3/8" washers.



Step 21.

Loosely install the 4 - OEM M14 bolts ❷ and 4 - M14 flange nuts ❶ through the frame bracket and frame.



Step 22.

A: With the help of another person, attach the bumper assembly loosely to the frame brackets using **1** 6 - M12 flange nuts. (Not shown above)

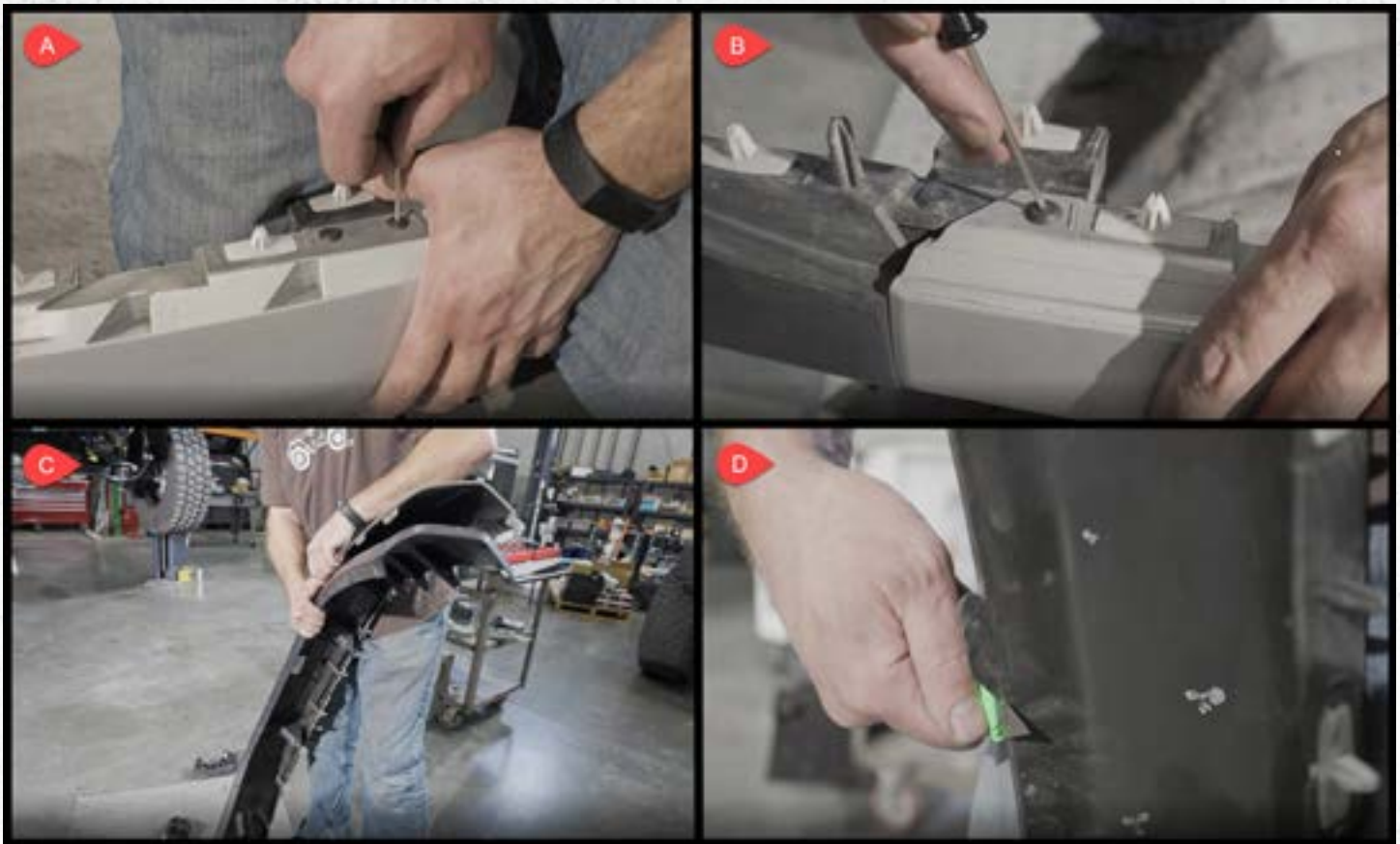
B: Once loosely attached to the main frame brackets you can now assemble the corner pods to the support brackets using **2** 4 - M10 x 25mm flange bolts.

NOTE: Leave loosely assembled at this stage.



Step 23.

Plug in, route and ziptie your license plate light wiring and if applicable you reverse sensor wiring. Take care to keep the wiring from hanging down or in areas where it can be pinched.



Step 24 OPTIONAL

Before reinstalling the fender flair, finish removing the inner liner:

A and B: Using small screwdriver remove the plastic rivet style fasteners by pushing the rivet center out.

C: Peel the inner liner out. This can be somewhat difficult.

D: Using a NEW razor blade, clip the tabs off. Take you time here to avoid cutting yourself or cutting more off than you want to. Be carefull and use the proper safety equipment when using a box cutter.

Once the tabs are removed go ahead and reattach the fender flare to the bed.

NOTE: This step is not required but suggested. For best results, remove the fender liner and install the following: JT0006 (JT rear inner fender kit) replacing the plastic inner fender liner and JL4112/ HK4112 (fender chop kit and stainless hardware upgrade) upgrading from the plastic clip anchors.

JT0018 INSTALLATION INSTRUCTIONS



Step 25. For best fit results, first push the bumper into the frame as you tighten your frame brackets. Next, lift the bumper assembly and tighten it paying close attention the spacing and reveal between the bumper and the bed. You can also adjust the angle of the corner pod at this stage.

Once everything looks good, tighten ALL hardware.
Verify all hardware is tight and wiring is connected and routed properly.

CONCLUSION AND MAINTENANCE GUIDE



CONCLUSION

Congratulations on finishing the installation for your Artec Industries Bantam Rear Comp Bumper.

Before driving your vehicle, inspect all bolts again to ensure proper tightness.

If you used a vehicle lift, take proper care to ensure you lower your vehicle safely.

Now take your vehicle out and enjoy the outdoors in confidence.

MAINTENANCE / CARE

- After 500 miles, inspect all components and hardware to ensure they are properly fastened.
- If driving during the winter where salt is used on the roads, thoroughly and frequently wash under-side of vehicle to prevent salt based corrosion.
- If removal of skid panels is required for vehicle maintenance, and bolts will not loosen, tap the bolt heads with a small sledge hammer using moderate force. This will allow the threads to loosen.
- Spray wax or similar products can be used to create a protective barrier on raw metals to protect against long term corrosion.