



Strong As An Ox™

## BX3323 Installation Instructions 2003-05 Saturn L Series

Serial No.

The front fascia, fascia brace and metal bumper are removed for baseplate installation. Drilling is required. Some vehicles fascia may require trimming. The BX8869 is available for this vehicle. Attachment Tabs are 24 inches center to center and a height of 14 inches.



1. Remove the three push pins from the top side of grill, set grill aside.



2. Just forward of front tires, in wheel well, are four push pins to remove, both sides.



3. Remove push pin from fascia support. Using the 10MM socket, remove metric bolt and set aside. Factory fascia support will not be reinstalled.



4. Just forward of wheel well, behind fascia's upper corner, push clip up to unlock fascia, both sides. Fascia will unlock properly when you hear a click, pull fascia forward and set aside. Remove three push pins from styrofoam insert, pull forward and set aside.



5. Using the 13MM socket, remove six metric bolts from metal bumper, pull forward and set aside. **NOTICE:** Pull air baffle tube straight down on passenger's side to release and expose inner frame area, set tube aside.



6. Bend upper fascia support bracket forward 90 degrees, both sides.



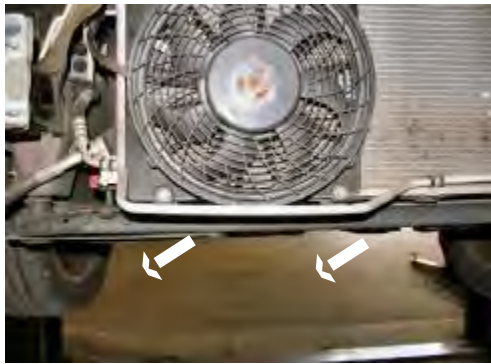
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7. Pull electrical coupler on top of radiator toward driver's side to release from bracket and unplug.



8. Remove the metric bolt from radiator bracket with the 10MM socket and set bracket aside.



9. Using the 10MM socket, remove the two metric bolts from the lower fan assembly, pull fan assembly down to remove from radiator and set aside.



10. Lift radiator assembly alignment pin up and out of rubber grommet and push assembly back toward the engine. This will open frame area to allow proper installation of baseplate.



11. Clamp baseplate to the bottom of frame with the vise grips (left photo). Top edge of baseplate will align top of the frame end and as far forward as possible while maintaining a level position with the vehicle. Set fascia in place on vehicle, slide receiver tubes through upper grill opening as shown in photo to the right. **Some vehicles may require trimming of area just above receiver tubes (see arrow in right photo) to prevent fascia from bending too much. Trimming should be done after baseplate is installed completely.**



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12. Using the baseplate as a template, drill all holes with the 13/32" drill bit (slide a piece of pipe or deep well socket over drill bit to prevent damage to radiator while drilling). Insert nut plate into hole on bottom side of frame to align with drilled holes, tighten the three 3/8-16 hex bolts and lock washers on both sides, according to drawing on last page. **Be sure and use loctite on all bolts before tightening. Tighten all bolts according to torque chart in the General Instruction sheet.**



13. Using the baseplate as a template, drill the lower hole into bottom of frame rail, both sides. When drilling holes into the bottom of frame, be aware of coolant line on passenger's side. Insert nut plate into hole on bottom side of frame to align with drilled holes tighten the 3/8-16 hex bolts and lock washers on both side according to drawing on last page. **Be sure and use loctite on all bolts before tightening. Torque all bolts according to torque chart in the General Instruction sheet.**



14. Reinstall air baffle tube on passenger's side, metal bumper, styrofoam and fascia. Replace fascia brace with support brace (item 2), 3/8-16 x 1" hex bolt, flat and lock washer, and attach to baseplate as shown on page three. Attach the other end to fascia mount with existing push pin, some trimming of fascia may be required as shown in step 11. **Do not cut horizontal rib of fascia.** Be sure all electrical components are plugged in properly.

15. The dimensional variations between otherwise identical cars can be considerable. While the location and size of the holes in the baseplate were designed to allow for easy installation, it may be necessary to file a hole slightly to allow a bolt to clear.

16. Install the tow bar and safety cables according to the instructions included in their packages.

17. Do **not** substitute other devices if the tow bar pin and clip are lost.

18. **DEALER OR INSTALLER: BE CERTAIN THE USER RECEIVES THE INSTRUCTION SHEET.**



## Tools Required

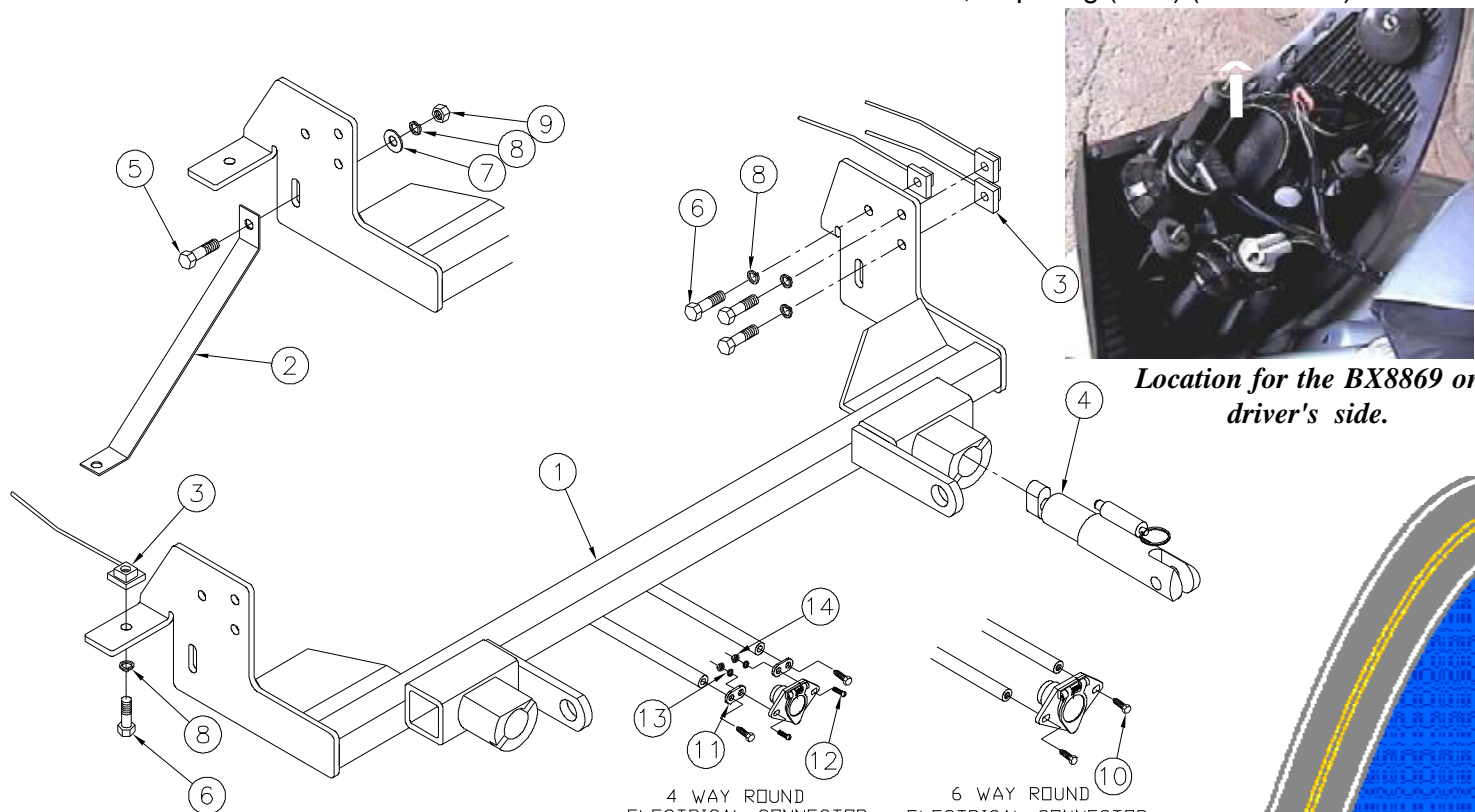
9/16" Socket  
3/4" Socket  
13/32" Drill Bit

Loctite Red  
13MM Socket  
Large Vise Grip

7MM Wrench  
9/32" Socket

## Parts List

Ref. No.	Qty.	Part No.	Description
1	1	61-6059	Weldment, Base Plate, BX3323
2	2	102-6314	Support Brace
3	8	61-5208	3/8-16 Nut Plate
4	2	62-3468	Attachment, Assembly, SF/ SB (R)
5	2	201-0443	3/8-16 x 1 Bolt, Grd. 5, ZP
6	8	201-0440	3/8-16 x 1 1/2 Bolt, Grd, 5, ZP
7	2	203-0003	3/8 Flat Washer, ZP
8	10	203-0010	3/8 Lock Washer, ZP
9	2	202-0003	3/8-16 Hex Nut, ZP
10	2	201-0553	1/4-20 x 1/2 Hx. Wshd, Type F Screw
11	2	101-5822	Adapter, 4 Way Connector
12	2	201-0192	#10-32 x 1/2 Slot, Rd. Hd. Screw
13	2	203-0054	#10 Lock Washer
14	2	202-0047	#10-32 Hex Nut
	2	226-0046	Baseplate Safety Cable, 36" CL III (Not Shown)
	2	229-0359	Quicklink, 3/8, ZP (Not Shown)
	2	290-0437	Receiver, Cap Plug (BLK) (Not Shown)



*Location for the BX8869 on driver's side.*

**IMPORTANT:** Use only genuine factory replacement parts on your Base Plate. Do not substitute homemade or nontypical parts. If a bolt is lost or in need of replacement, for your safety and the preservation of your Base Plate, be sure to use a replacement bolt of the same grade (Usually Grade 5, refer to parts list). Repair parts may be ordered through your nearest **Blue Ox** dealer or distributor.