



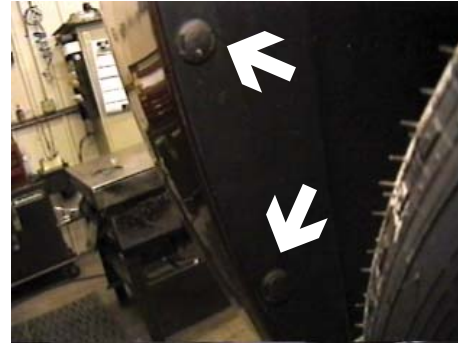
**BX3319 Installation Instructions**  
**2003-04 Saturn Ion (4 Cylinder Manual Only)**

Serial No.

**Strong As An Ox™** The front fascia and metal bumper are removed for baseplate installation. Minor trimming of fascia is required. Drilling is required. The BX8869 is available for the vehicle. Attachment Tabs are 24 inches center to center and a height of 13 1/2 inches.



1. Remove the four metric bolts from the top side of fascia using the 7MM socket. **Quad coupe model will not have black cover.**



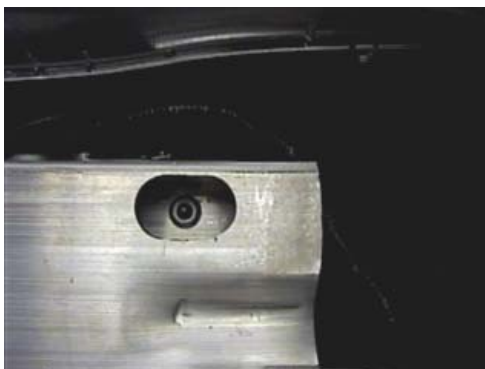
2. Just forward of front tire, inside wheel well, are two push pins to remove and one metric bolt to remove with the 7MM socket, both sides.



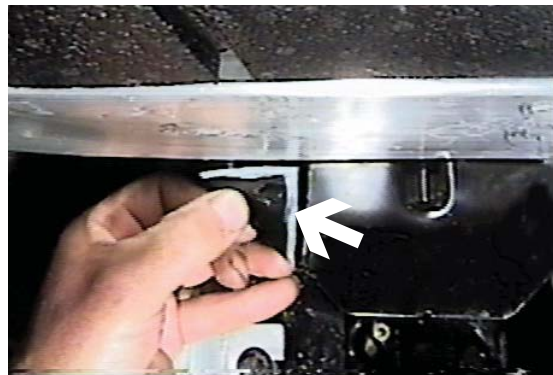
3. Just forward of front tire, on the bottom side of fascia, are four push pins to remove, both sides. Pull fascia ends to the side and forward, set aside.



4. Using the bottom edge of the metal bumper as a guide, mark the front of the bumper bracket with a scribe toward the inside of frame end, both sides.



5. Remove six metric bolts from metal bumper using the 13MM socket, set metal bumper aside.



6. Make horizontal cut to frame on bumper bracket's scribe mark and make a vertical cut on frame edge to open area for baseplate, both sides.



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7. Slide baseplate ends to the inside of frame rails. Slide up and forward as far as possible, clamp to frame. Using item 1 as a template, drill the three top holes with the 13/32" drill bit, both sides.
8. Insert item 2 into opening on bottom of frame to align with drilled holes and tighten items 3 and 4 according to drawing on last page. **Be sure and use loctite on all bolts before tightening. Torque all bolts according to Torque Chart in General Instructions sheet.**
9. Trim upper rib of fascia opening as needed. Reinstall metal bumper and fascia.
10. 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.
11. Install the tow bar and safety cables according to the instructions included in their packages.
12. Do **not** substitute other devices if the tow bar pin and clip are lost.
13. **DEALER OR INSTALLER: BE CERTAIN THE USER RECEIVES THE INSTRUCTION SHEET.**



Location of BX8869 bulb and socket installation on driver's side (right photo).





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## Tools Required

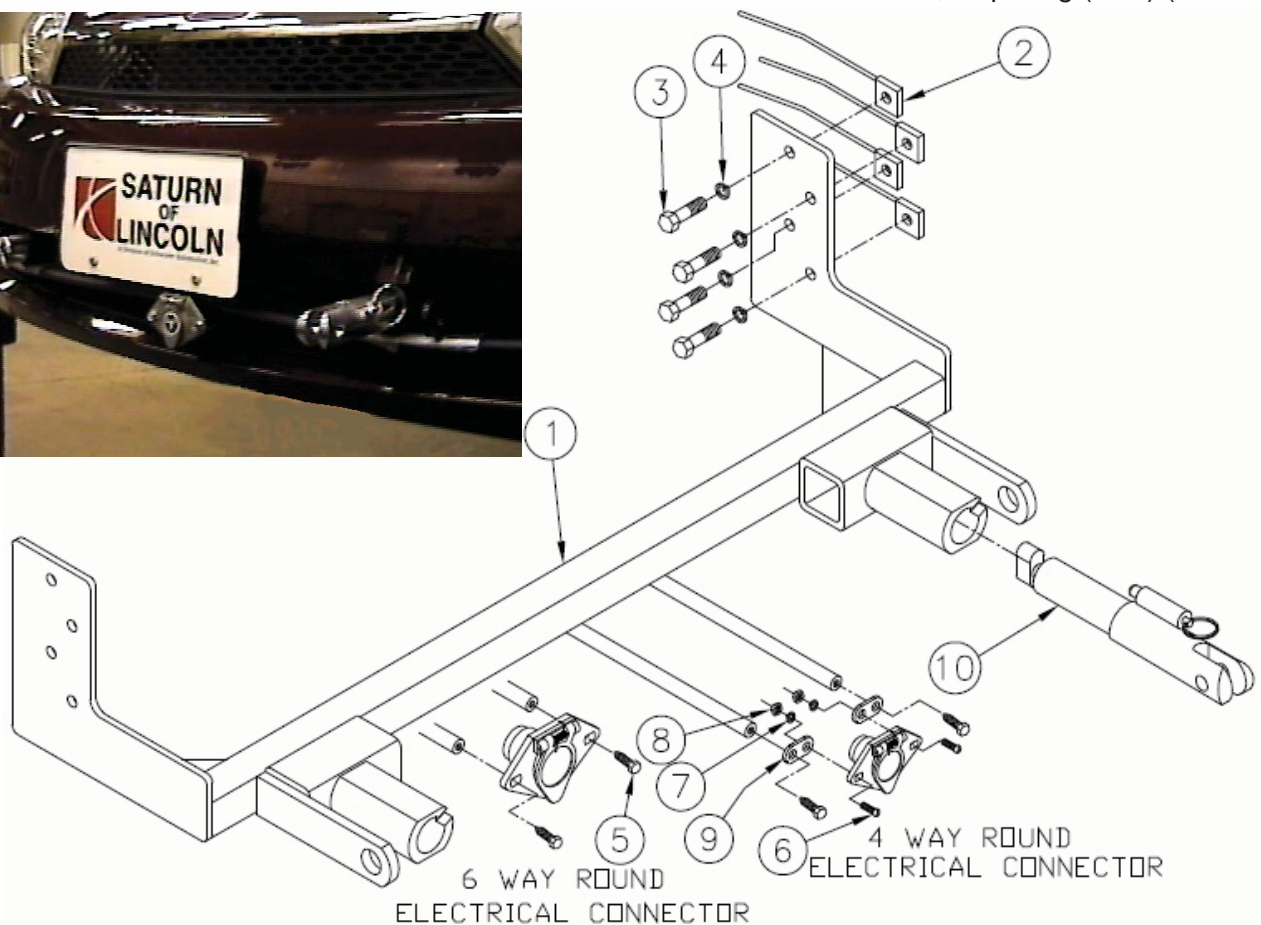
9/16" Socket  
13/32" Drill Bit  
Scribe

Loctite  
10MM Socket  
Hack Saw

7MM Socket  
13MM Socket  
Vise Grip

## Parts List

Ref. No.	Qty.	Part No.	Description
1	1	61-5873	Weldment, Base Plate, BX3319
2	8	61-5208	3/8-16 Nut Plate
3	8	201-0440	3/8-16 x 1 1/2 Bolt, Grd. 5, ZP
4	8	203-0010	3/8 Lock Washer, ZP
5	2	201-0553	1/4-20 x 1/2 Hx. Wshd, Type F Screw
6	2	201-0192	#10-32 x 1/2 Slot, Rd. Hd. Screw
7	2	203-0054	#10 Lock Washer
8	2	202-0047	#10-32 Hex Nut
9	2	101-5822	Adapter, 4 Way Connector
10	2	62-3469	Attachment, Assembly, SF/LB (R)
	2	201-0654	#10-16 X 1 Self Drilling Screw (Not Shown)
	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)



**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.

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