



## **BX1612 Installation Instructions 1991-94 Chevrolet Cavalier**

Installation of this baseplate requires removing the plastic air dam and the center section of the grill. Holes will need to be drilled through the top of the bumper channel and the air dam will be notched.

1. Read the General Instruction Sheet included with this baseplate.
2. The baseplate attaches to the engine mount braces under the car and to the bumper using eight total bolts, all of which are supplied with the baseplate.
3. Remove the plastic air dam which hangs below the engine support beams.
4. Remove the center grill section between the headlights. It is attached with four screws. A long extension for the socket is needed for the bottom two screws.
5. Two beams support the engine and transaxle. Place a jack under each beam and apply enough pressure to hold the braces in place when the two front bolts on each beam are removed.
6. Remove the two front bolts from each support beam. They will not be used for the baseplate installation.
7. Using the four 12mm x 50mm bolts, flat and lock washers supplied, loosely bolt the two lower mounts to the car. Put the 7/8" thick round spacers between the mount plates and the engine support beam.
8. Position the base angle in the opening in the lower bumper. The legs of the angle should extend up and forward. Slide the base angle back to meet the lower mounts.
9. Loosely start a 1/2 x 1 3/4 bolt in the outside holes of the base angle and lower mounts.
10. Insert an upper base angle support through the opening between the headlights. The 1/2" hole should align with the inside hole on the base angle and lower mount and the end with the two 5/16" holes should lay flat on the top of the bumper. When the support is in position start a 1/2 x 1 3/4 bolt through the lower mount, base angle, and upper support.
11. Using the upper support as a guide, drill 5/16" holes through the top of the bumper channel. When the holes are drilled, start the 5/16 x 1 bolts through the bumper and support.
12. The dimensional variations between otherwise identical vehicles 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.
13. When all bolts are started apply Loctite and fully tighten.
14. Replace the air dam removed in Step 3. Notches will need to be cut to allow the lower mounts to clear.
15. Replace the grill removed in Step 4. Start the lower two screws first.

# **Automatic**

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**

- |               |                     |   |
|---------------|---------------------|---|
| 7mm socket    | 10mm socket         | 1/2 socket and combination wrench       |
| 13mm socket   | 15mm socket         | 3/4 socket and combination wrench       |
| 19mm socket   | Jack                | Long extension for 7mm and 3/4" sockets |
| Locktite Blue | Drill and 5/16" bit |   |

**Parts list**

Ref. No.	Qty.	Part No.	Description
1	1	61-3689	Weldment, Base Angle, BX1612
2	2	61-3690	Weldment, Lower Mount, BX1612
3	2	102-3207	Flat, Upper Base Angle Support
4	4	104-0372	Spacer, 1 1/4 OD x 0.531 ID x 3/4
5	4	201-0068	1/2-13 x 1 3/4 Hex Bolt, Grade 5
6	4	201-0467	12mm-1.75 x 50mm Hex Bolt, Grade 10.9
7	4	201-0469	5/16-18 x 1 Hex Bolt, Grade 5
8	4	202-0002	5/16-18 Hex Nut
9	4	202-0005	1/2-13 Hex Nut
10	4	203-0002	5/16 Flat Washer
11	4	203-0009	5/16 Lock Washer
12	4	203-0012	1/2 Lock Washer
13	4	203-0105	12mm Lock Washer
14	4	203-0112	12mm Flat Washer

