

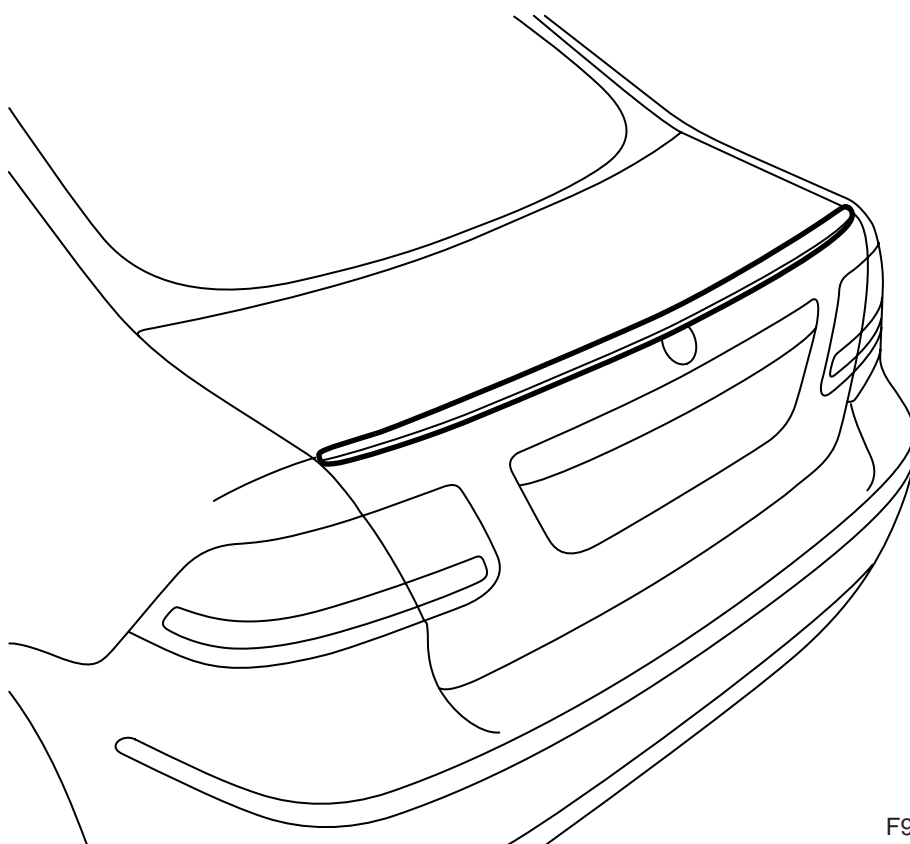


**MONTERINGSANVISNING · INSTALLATION INSTRUCTIONS  
MONTAGEANLEITUNG · INSTRUCTIONS DE MONTAGE**

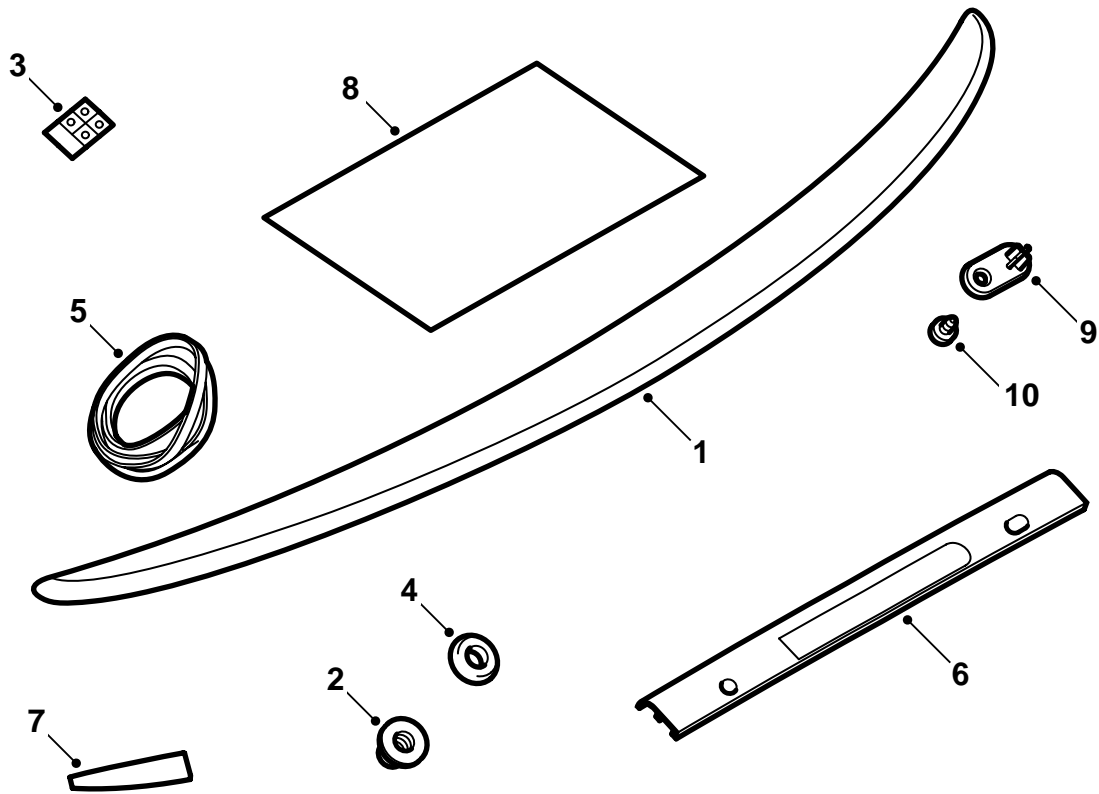
**Saab 9-3 4D M03-**

**Rear spoiler**

Accessories Part No.	Group	Date	Instruction Part No.	Replaces
<b>12 805 380</b>	<b>9:84-33</b>	<b>Oct 03</b>	<b>12 806 078</b>	

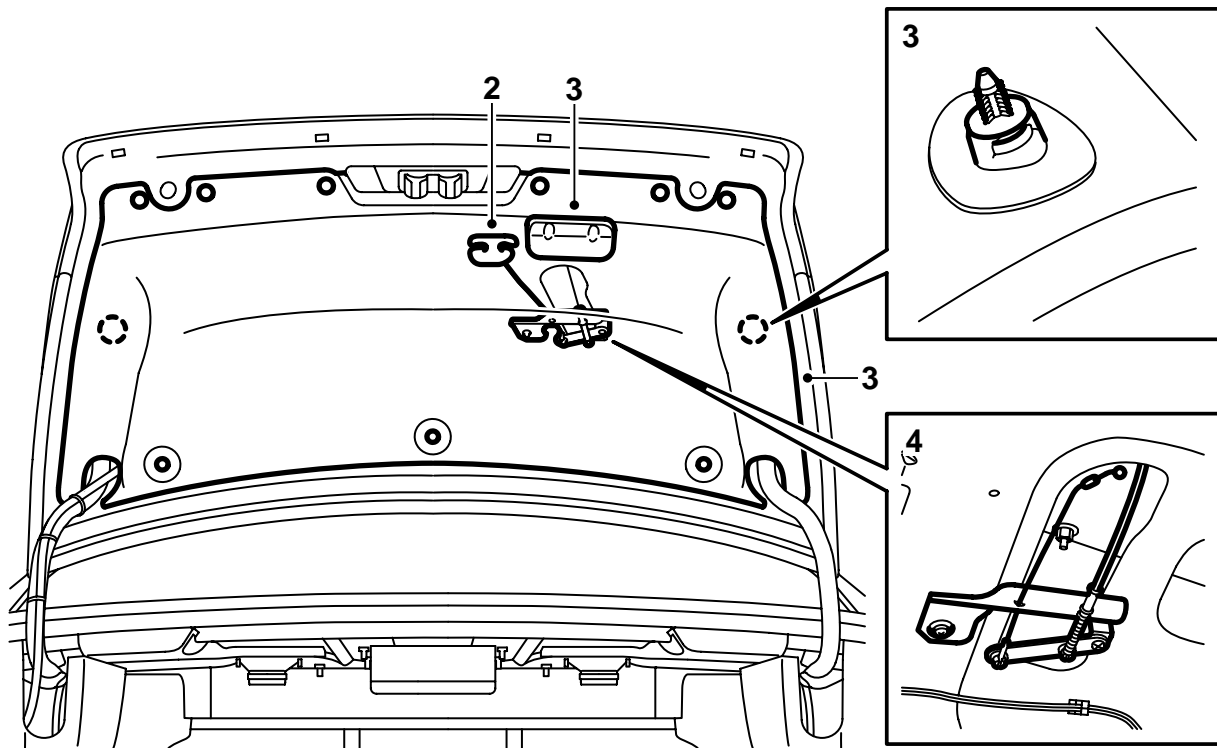


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F980A319

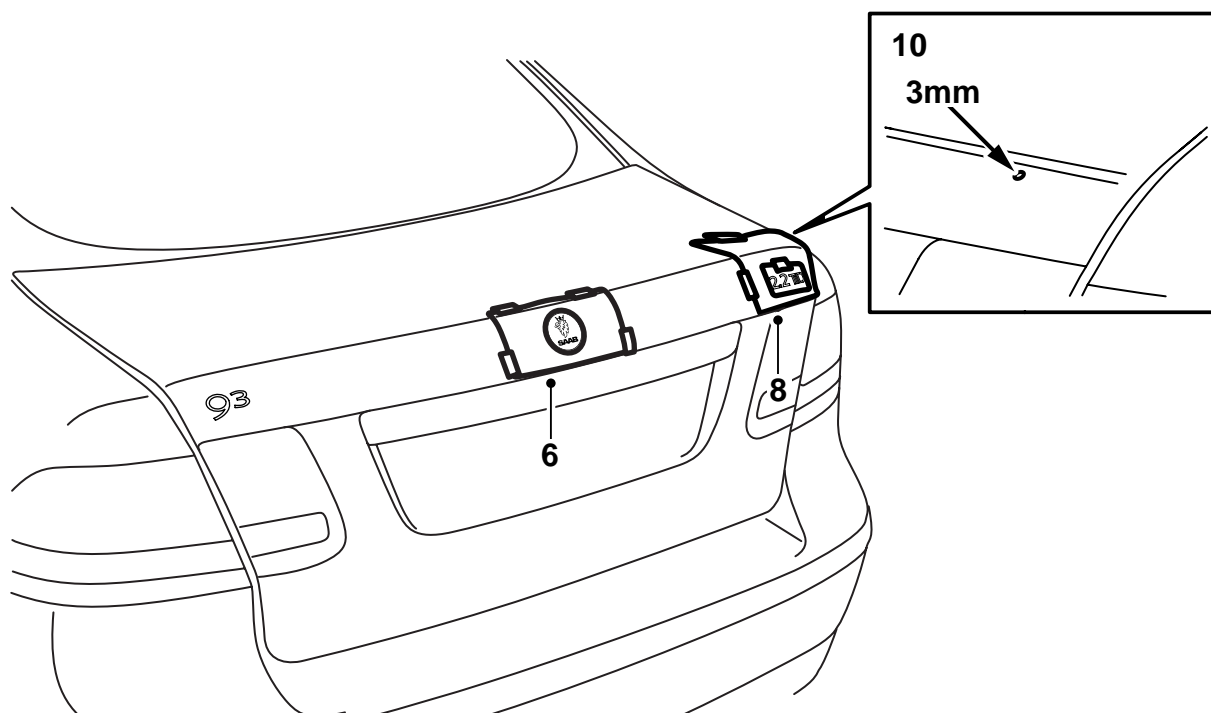
- 1 Spoiler
- 2 Nut (x4)
- 3 Zinc tape (x4)
- 4 Seals (x6) (2 are not used in fitting accessories)
- 5 Chafe protection tape (x2)
- 6 Reinforcement
- 7 Double-sided adhesive tape (x2)
- 8 Template
- 9 Plastic guide (x2) (not used in fitting accessories)
- 10 Screw (x2) (not used in fitting accessories)



F980A010

The spoiler has been treated with grey primer and is ready for painting.

- 1 Paint the spoiler the same colour as the body; see "Directions for painting preprimed ABS plastic" in these installation instructions.
- 2 Open the boot lid.  
**US:** Remove the emergency handle.
- 3 Remove the closing handle on the inside of the boot lid, remove the clips and remove the boot lid trim.
- 4 **US:** Remove the screws of the emergency opening mechanism and move the mechanism aside.



F980A323

- 5 Take the template and cut out the template parts in accordance with the instructions.
- 6 Fit one part of the template at the round emblem on the boot lid
- 7 Fit the pieces of tape where holes are to be drilled (x2) and secure the template using tape.
- 8 Fit the other part, with the text "RH" visible, at the rear right-hand corner of the boot lid.
- 9 Fit a piece of tape where the hole is to be drilled and secure the template with tape.
- 10 Using a 3 mm bit, drill in accordance with the markings on the template parts.

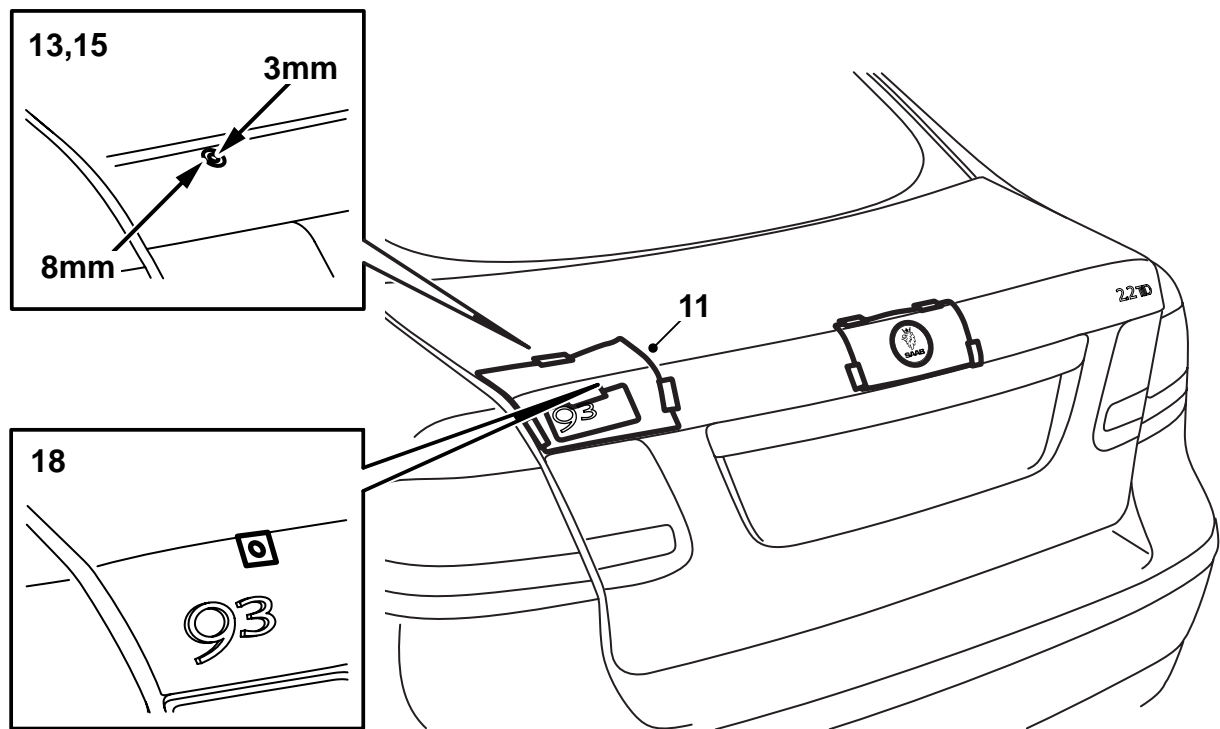
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**Important**

Do not use a centre punch to mark the hole positions.

Do not press the drill against the boot lid when drilling.

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F980A320

- 11 Remove the template at the rear right-hand corner of the boot lid, turn the template and fit it, with the text turned to face the boot lid, at the rear left-hand corner of the boot lid.
- 12 Fit a piece of tape where the hole is to be drilled and secure the template with tape.
- 13 Using a 3 mm bit, drill in accordance with the marking on the template part.
- 14 Remove the template parts and the pieces of tape.
- 15 Bore out the holes with an 8 mm bit.
- 16 Fit the spoiler with the studs in the bored holes and check that the spoiler fits.
- 17 Deburr the holes and remove loose drillings and flakes of paint. Clean with Teroson FL Cleaner. Apply Standox 1K Primer Filler. Apply finish paint. Apply Terotex HV 400 or Mercasol 1 cavity sealer to internal surfaces.
- 18 Fit the enclosed pieces of zinc tape to the boot lid with the crosses directly above the centre of the holes.

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### Important

Do not use a centre punch to mark the position of the hole.

Do not press the drill against the boot lid when drilling.

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- 14 Remove the template parts and the pieces of tape.
  - 15 Bore out the holes with an 8 mm bit.

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### Important

Do not press the drill against the boot lid when drilling.

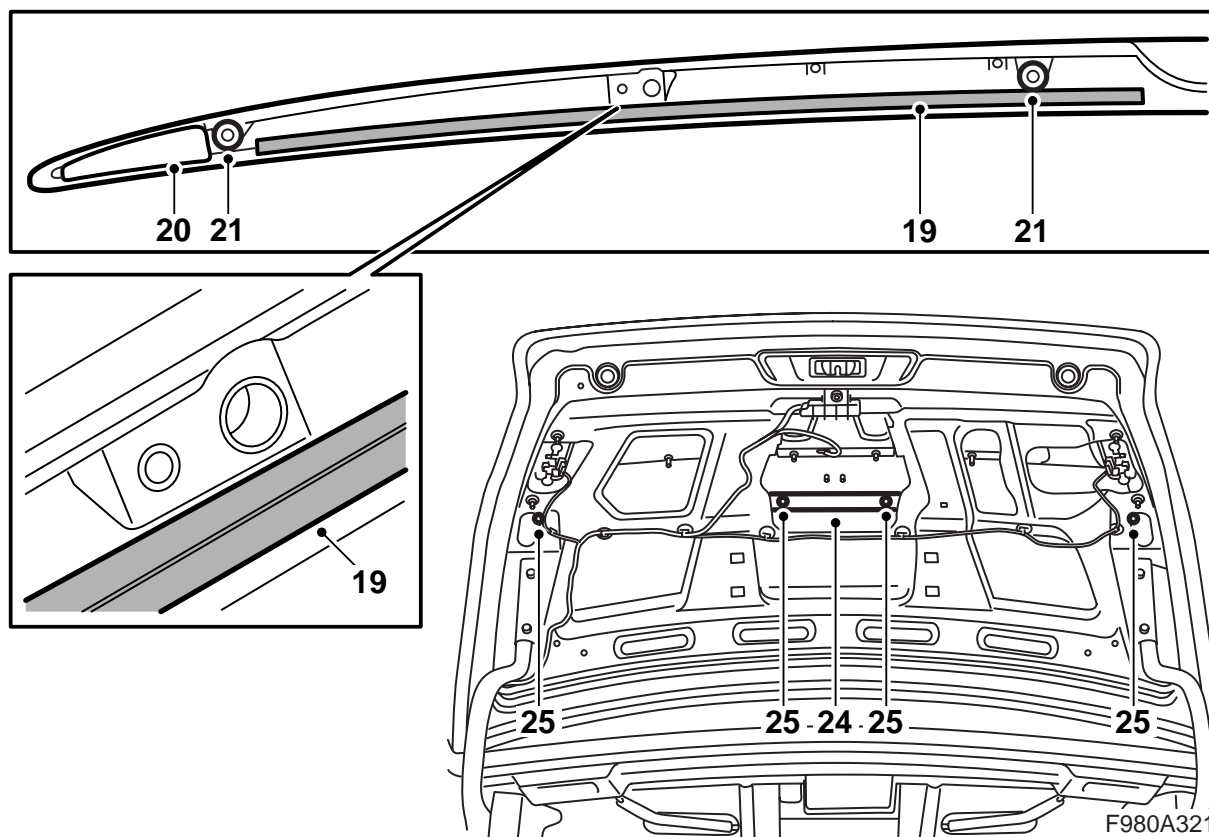
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- 16 Fit the spoiler with the studs in the bored holes and check that the spoiler fits.

### Note

If necessary the bit can be used laterally so that the holes are oval.

### Note

Be careful that the pieces of tape are not visible outside of the spoiler.



19 Fit the chafe protection tape to the spoiler.

### Important

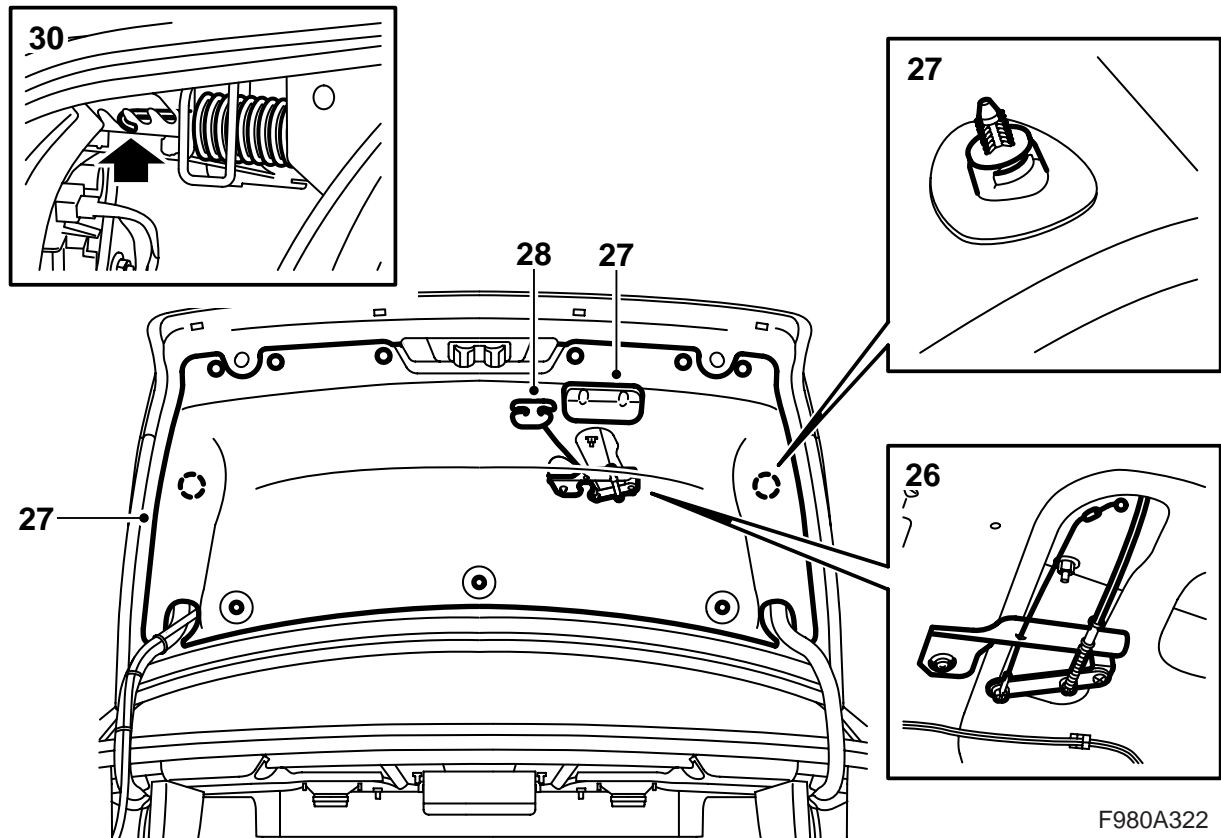
The tape must be fitted to the inner edge of the spoiler.

- 20 Fit the double-sided adhesive tape to the outer ends of the spoiler.
- 21 Fit the seals onto the studs.
- 22 Pull away the protective film from the pieces of double-sided tape, position the spoiler on the boot lid, centre it and press it into place.
- 23 Carefully open the boot lid and check that the spoiler has been secured.
- 24 Pull away the protective film from the reinforcement, fit the reinforcement to the spoiler's centre studs and fit the nuts.
- 25 Carefully tighten the nuts several turns at a time until the correct tightening torque has been reached.

**Tightening torque 4 Nm (3 lbf ft)**

### Important

Check the position of the spoiler and adjust if necessary.



F980A322

- 26 **US:** Fit the emergency opening mechanism.
- 27 Fit the trim on the inside of the boot lid, fit the clips and fit the closing handle.
- 28 **US:** Fit the emergency handle.
- 29 Lower the cover in the luggage compartment trim on both the right and the left-hand sides.
- 30 Tighten both right and left springs one notch.
- 31 Put up both covers.
- 32 Close the boot lid.

### **Directions for painting preprimed ABS plastic**

- During the painting process the spoiler should be placed in such a way that it will not be deformed.
- The temperature must not exceed +40 °C (104 °F).
- The spoiler is preprimed as delivered from the supplier.
- Clean gloves should be worn when handling the spoiler.

### **Drying time**

70 minutes at 40 °C (104 °F).

### **Preparations**

- Rub down the primed surfaces thoroughly. Use 3M 1200 or 800 abrasive paper.