



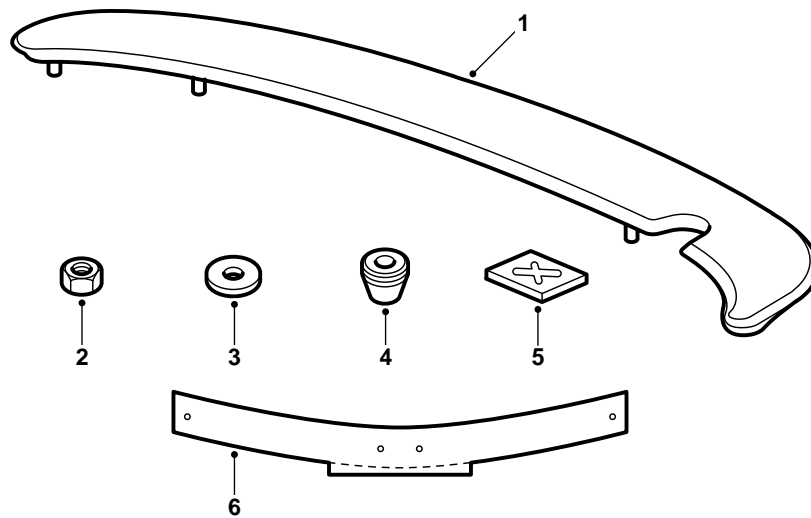
SAAB

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

Saab 900 M94-, Saab 9-3

Rear spoiler

Accessories Part No.	Group	Date	Instruction Part No.	Replaces
400 102 174	8:46-22	Jan 99	86 79 060	75 03 31 Aug 94



D980A145

- 1 Spoiler
- 2 Nuts (3x)
- 3 Washer, 50 mm (3x)
- 4 Bush with seal (2x)
- 5 Zinc washer (5x)
- 6 Drilling template

Preparations

Paint the spoiler unless it is to remain black. If the spoiler is to be fitted to a car without rear window wiper, the cover must also be painted. See "Directions for painting" below.

Important

The spoiler has been surface treated with black primer and is therefore ready for painting. The primer is also approved as a surface finish. If the spoiler is to remain black in colour, then no other painting is required.

Directions for painting

Directions for painting pre-primed PUR-RIM plastic

- The spoiler must be placed where it will not be deformed while painting.
- The temperature must not exceed +45°C.
- The spoiler is pre-primed on delivery.
- Use clean gloves when handling the spoiler.

Drying times

70 minutes at +40°C.

Preparations

- For best results, apply pore-filling primer. Use Glassurit Por Rapid Filler 285-100.
- Smooth off the primed surface thoroughly. Use abrasive paper 3M 1200 or 800.

Composition of painting system

Solid finishing paint

- Series 21 (uni) +20% Glassodur softener 521-111.
- Mix 2:1 with Glassodur hardener 929-73.
- 10% Glassodur thinner 352-50.

Apply by spraying two thin coats.

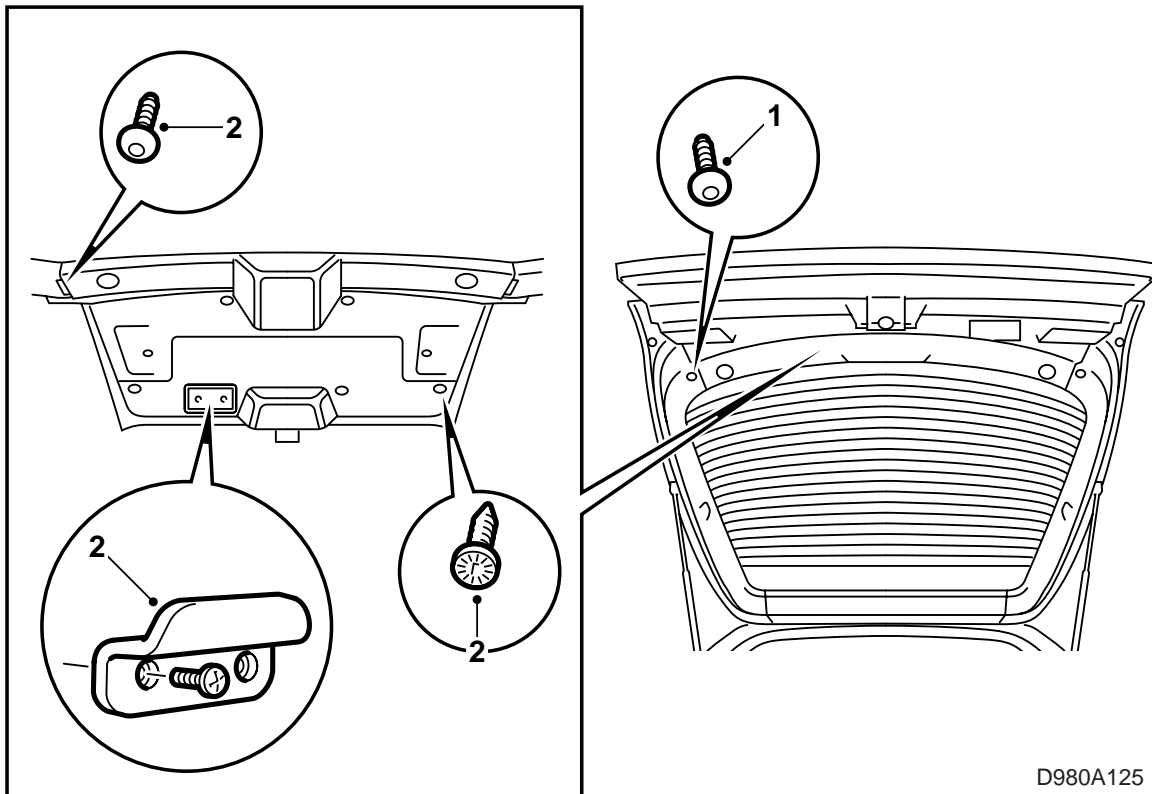
Metallic finishing paint

- Series 54 (base metallic) +25% Glassodur thinner 352-50.

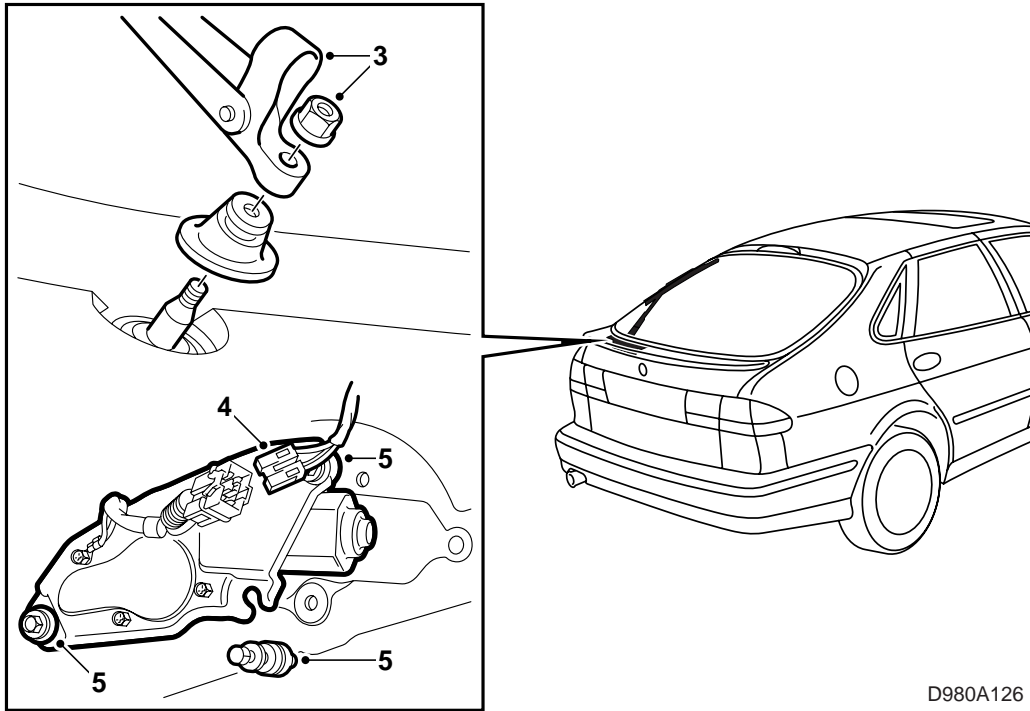
Apply by spraying two thin coats.

- MS-Top clear enamel 923-85.
- Mix 2:1 with Glassodur hardener 929-73.
- 10% Glassodur thinner 352-91.

Apply by spraying two thin coats.



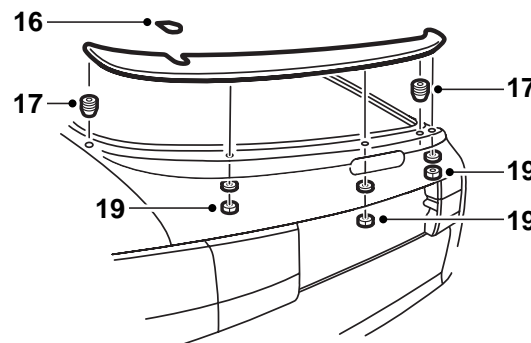
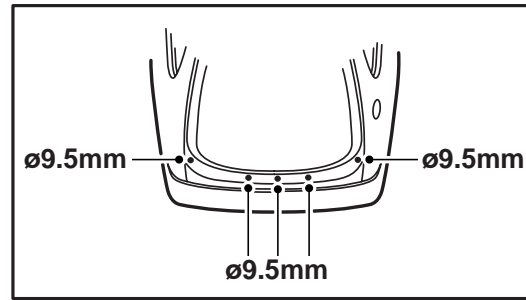
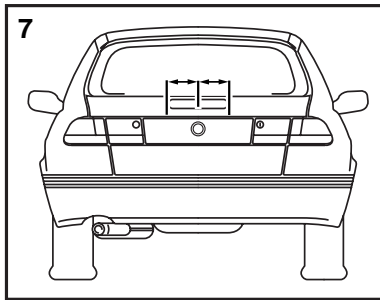
- 1 Remove the screws securing the bottom of the side cover plates inside the tailgate. Bend out the cover plates to access the screws securing the trim on the inside of the tailgate.
- 2 Unscrew the door pull and remove the trim on the inside of the tailgate.



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Cars with rear wiper

- 3 Remove the wiper arm.
- 4 Unplug the wiper motor connector.
- 5 Remove the bolts securing the wiper motor.
- 6 Lift away the motor and retain the rubber grommet.



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7 **Saab 900:** Measure out the centre of the high-level brake light and make mark at the top.

Saab 9-3: Measure out the centre of the emblem and make a mark at the top.

8 Position the template (44 84 218) on the tailgate so that it is edge-to-edge with the rear window housing and the top of the high-level brake light or emblem. Position the centre mark of the template against the centre mark on the tailgate. Affix the template with adhesive tape.

9 Make sure the distance between the hole markings corresponds with the position of the studs on the spoiler.

10 Mark the position of the three middle holes with a centre punch.

11 Remove the template and drill holes according to the markings. Use a $\varnothing 9.5$ mm drill.

12 Mark the position of both outer holes as follows:

- Affix pieces of adhesive tape to the tailgate where the outer holes are to be drilled.
- Position the spoiler in the three centre holes and press down the outer ends to mark the position of the holes on the pieces of tape.
- Make sure the pieces of adhesive tape have been marked.
- Remove the spoiler and mark the position of the holes with a centre punch.

13 Remove the pieces of tape and drill holes according to the marks. Use a $\varnothing 9.5$ mm drill.

14 Rustproof the drill holes as follows:

- Remove burrs in the holes and any loose cuttings or paint flakes with compressed air.

- Apply primer. Use Standox 1K Fullprimer or equivalent.

- Apply finishing paint.

- Place the zinc washers over the holes on the outside of the tailgate. Enlarge the holes in the washers.

15 Clean the mounting surfaces of the spoiler and tailgate with Teroson cleaner FL.

16 **Cars without rear wiper: Press on the cover in the spoiler (found in the accessory kit).**

17 Press the bushes into the two outer holes.

18 Put the spoiler in place and press down the ends.

19 Fit the washers and screw on the spoiler.

20 **Cars with rear wiper:** Refit the rubber grommet, wiper motor and wiper arm.

21 Refit the trim, door pull and side cover plates on the inside of the tailgate.