



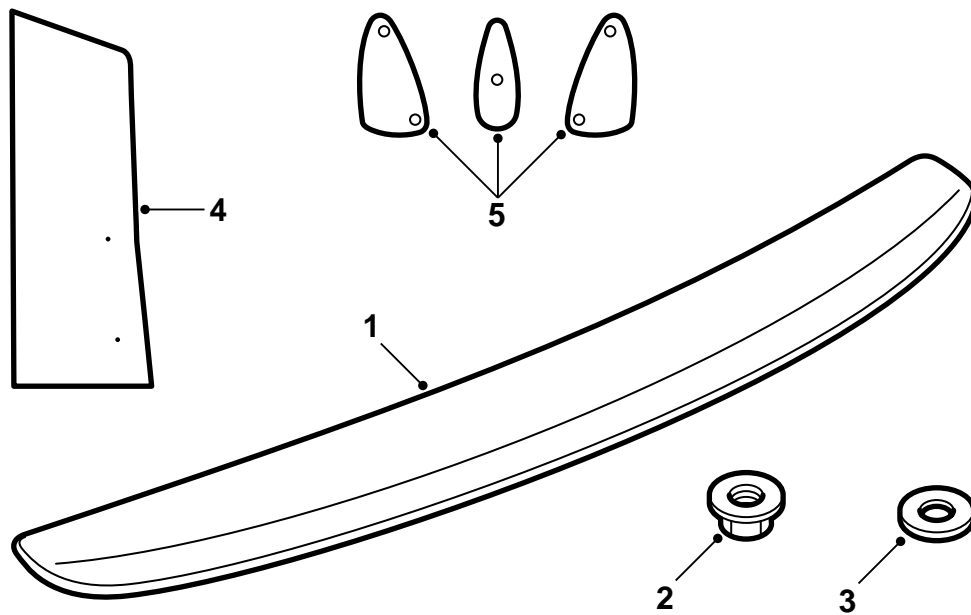
SAAB

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

Saab 9-5 4D

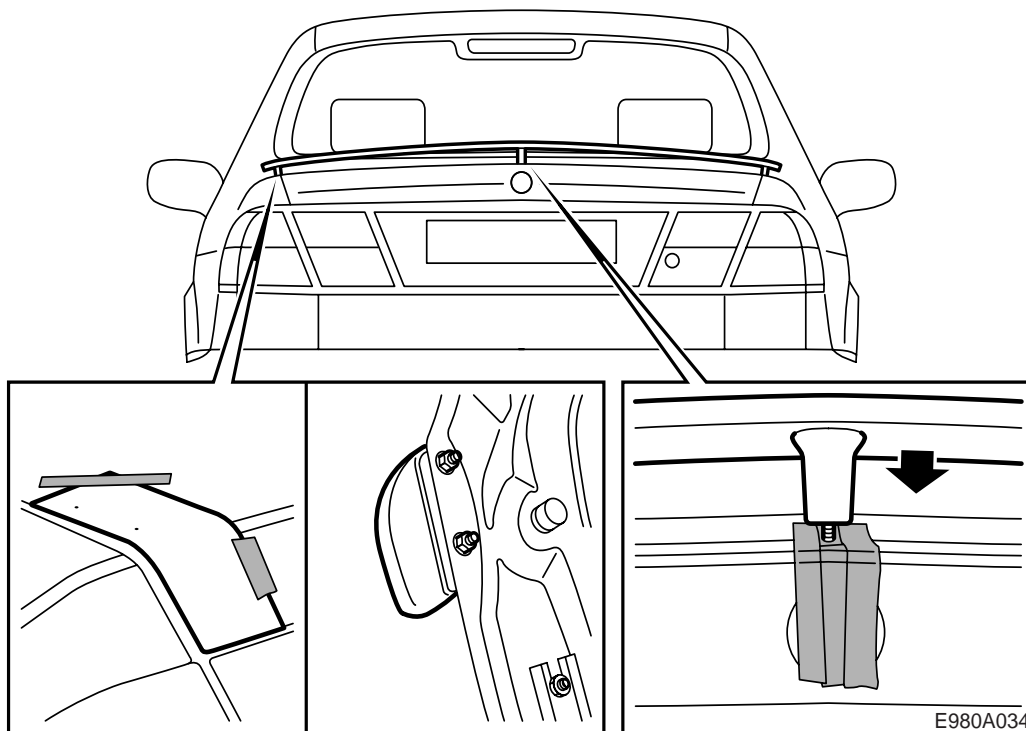
Rear spoiler

Accessories Part No.	Group	Date	Instruction Part No.	Replaces
400 106 217	8:46-26	Nov 98	46 77 233	46 77 233 Jul 97



E980A033

- 1 Spoiler
- 2 Nut (5)
- 3 Zinc washer (5)
- 4 Template
- 5 Seals



- 1 Open the boot lid and remove the boot lid trim.

Important

The boot lid trim is fitted by means of 3-stage rivets. Carefully press in the centre of the rivet slightly and then withdraw the entire rivet.

- 2 **Left:** Cut out the template. Line it up on the left-hand side of the boot lid and tape it in place.
- 3 Mark the hole positions with a centre punch and drill the holes using a 9 mm bit.

Note

Catch drillings and swarf on the underside with a magnet

- 4 **Right:** Line up the template on the right-hand side of the boot lid and tape it in place.
- 5 Mark the hole positions with a centre punch and drill the holes using a 9 mm bit.

Note

Catch drillings and swarf on the underside with a magnet.

- 6 Fasten tape to the middle of the boot lid, over the badge and up onto the lid.
- 7 Fit the double-sided adhesive seals on the spoiler brackets.
- 8 Position the spoiler so that it fits in the outer holes. Press lightly on the the centre of the spoiler to locate and mark the position of the centre hole.
- 9 Remove the spoiler and drill the hole with a 7

mm bit.

- 10 Remove the tape from the boot lid.
- 11 Deburr the holes and remove loose drillings, swarf and flakes of paint. Clean with Teroson FL Cleaner. Apply Standox 1K Primer Filler. Apply finishing paint. Apply Terotex HV 400 or Mercasol 1 cavity sealant on internal surfaces.
- 12 Place the washers over the holes.
- 13 Remove the protective backing paper on the tape under each bracket on the spoiler.
- 14 Position the spoiler so that it fits in the holes.
- 15 Leave the spoiler in place and carefully open the boot lid.
- 16 Tighten the spoiler by means of the five nuts.
Tightening torque 6 Nm (4.5 lbf ft)
- 17 Remove any drillings using a vacuum cleaner.
- 18 Refit the boot lid trim.

Painting directions**Painting directions for pre-primed PUR-RIM plastic**

- During the painting process, the spoiler must be positioned to avoid deformation.
- The temperature must not exceed +40°C (104°F).
- The spoiler is primed on delivery.
- Use clean gloves when handling the spoiler.

Drying time

70 minutes at 40°C (104°F).

Preparations

- For best results, a pore-filling primer should be applied.
- Grind primed surfaces thoroughly. Use 3M 1200 or 800 abrasive paper.