

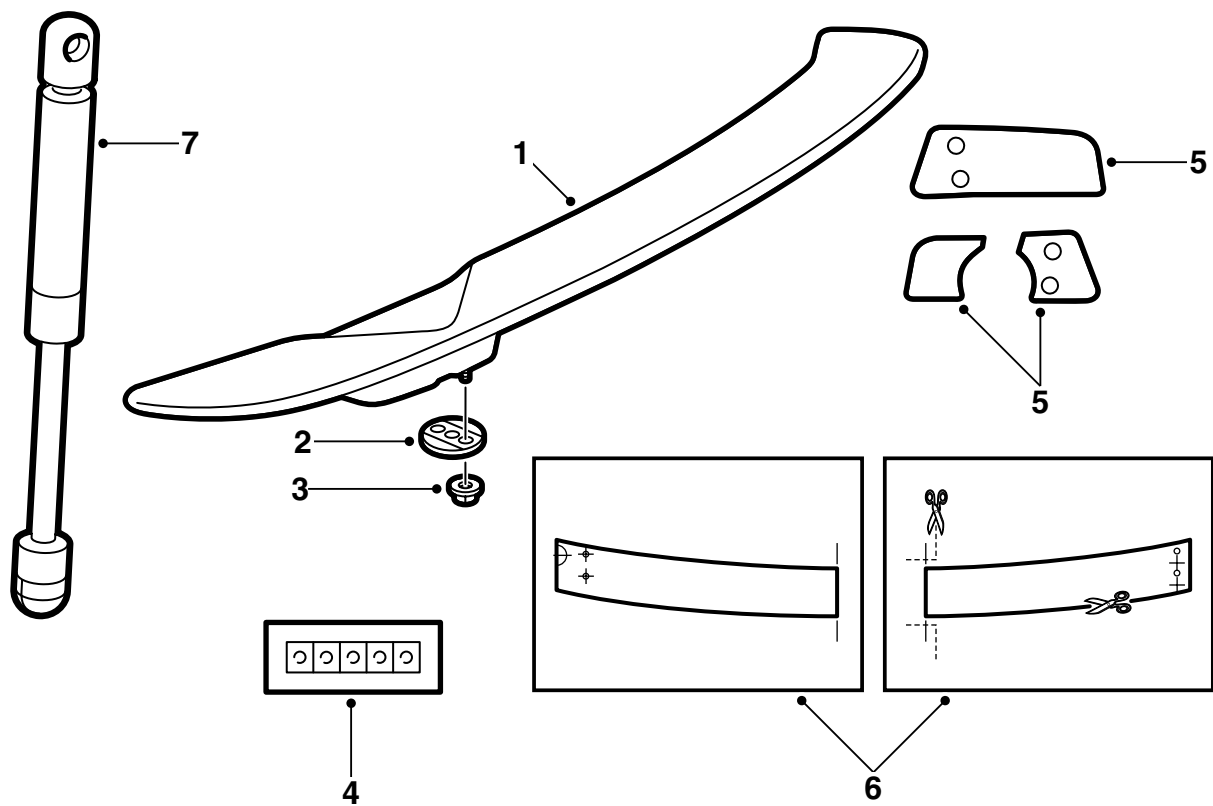


MONTERINGSANVISNING · INSTALLATION INSTRUCTIONS  
MONTAGEANLEITUNG · INSTRUCTIONS DE MONTAGE

## Saab 900 3D/5D M94-, Saab 9-3 3D/5D

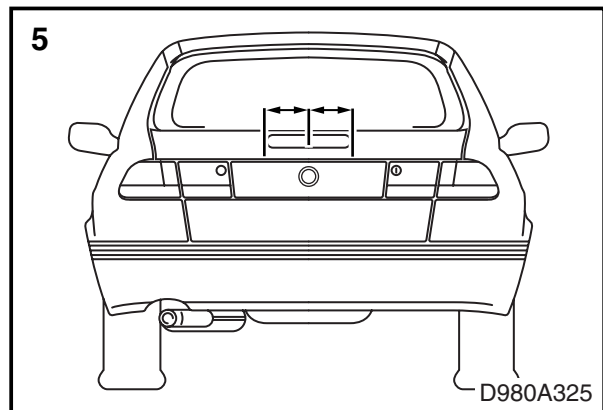
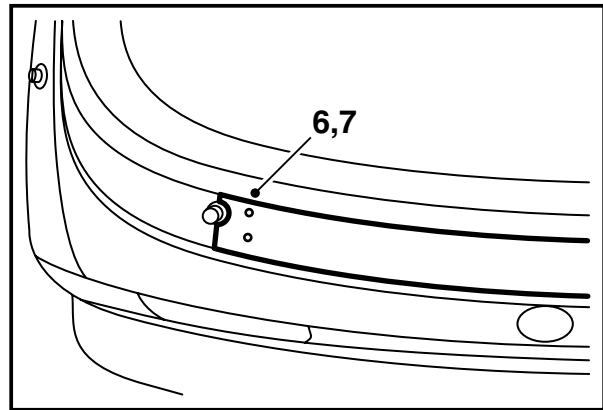
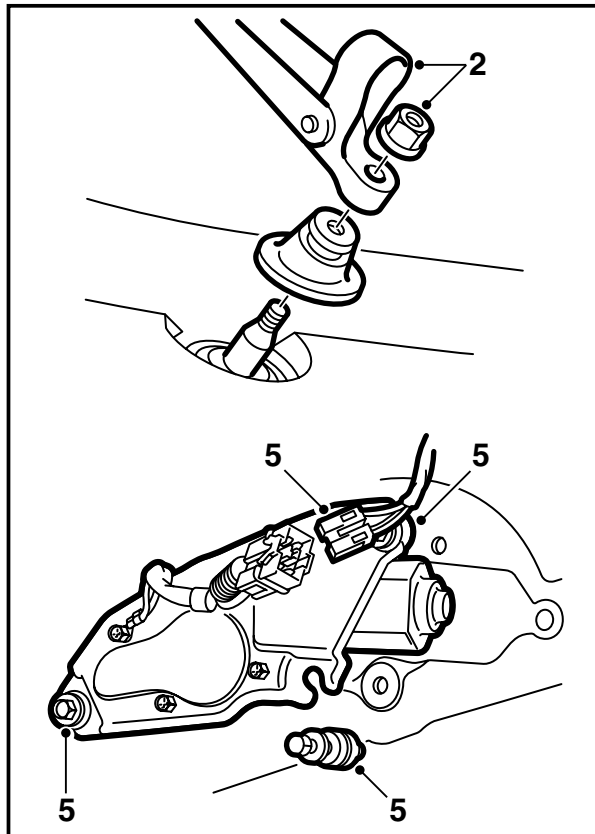
### Rear spoiler

Accessories Part No.	Group	Date	Instruction Part No.	Replaces
400 109 013	9:84-4	Oct 00	47 86 463	47 86 463 Aug 98



D980A324

- 1 Spoiler
- 2 Washer, round with tape (x2)
- 3 Six-sided nut with washer (x4)
- 4 Zinc washer (x4)
- 5 Sealing tape (3 parts)
- 6 Drill pattern (2 parts)
- 7 Gas strut (x2)



The spoiler is treated with black primer and consequently prepared for painting.

- 1 Paint the spoiler the same colour as the car. See "Painting instructions for pre-primed PUR-RIM plastic" in these mounting instructions.
- 2 **Cars with rear window wipers:** Remove wiper arm
- 3 Open the hatchback.
- 4 Remove the trim on the inside of the hatch.
- 5 **Cars without rear window wipers:** Place a piece of tape above the high level brake light, measure to determine the centre of the brake light and mark accordingly on the tape.

**Cars with rear window wipers:** Remove wiper motor in the following manner:

- Unplug the wiper connector.
  - Remove the screws that hold the wiper motor.
  - Lift away the wiper motor, retaining the rubber grommet with the motor.
- 6 Complete the pattern by:
    - Cut out the first part of the pattern as shown by scissors number 1.
    - Tape the two parts together. Use the lines to insure proper alignment.
    - Cut the pattern out as shown by scissors number 2.

- 7 **Cars without rear window wiper:** Place the pattern on the boot lid so that the bottom edge rests against the rear window rubber seal and the upper edge touches the high mounted stoplight. Make sure that the centre mark on the pattern matches the measured centre mark of the boot lid. Secure the pattern with tape.

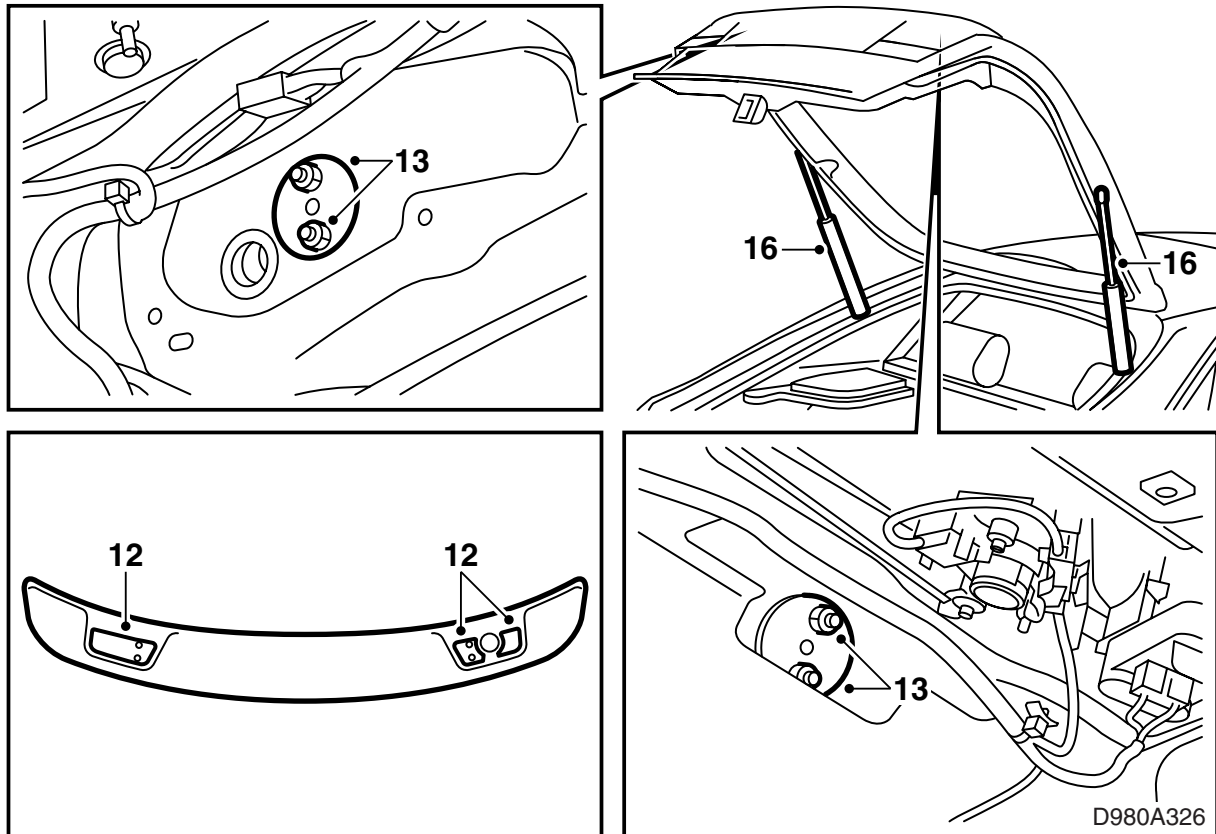
**Cars with rear window wipers:** Place the pattern against the edge of the rear window wiper motor hole and against the rear window's rubber seal. Secure the pattern with tape.

- 8 Check that the distance between the hole markings matches the spoiler stud placement.
- 9 Mark the position of the holes, using a centre punch.

### Note

Exercise care.

- 10 Drill an 8 mm hole according to the markings. Start with a smaller bit.
- 11 Protect the holes from corrosion as follows:
  - Deburr the holes and remove loose drillings and flakes of paint with compressed air.
  - Apply Standox 1K Primer Filler or other equivalent product.
  - Apply finish paint.
  - Affix zinc tape over the holes and press down with a screwdriver so that the tape folds down over the edges.



12 Mount the sealing tape on the spoiler and fit the spoiler on the boot lid.

13 Attach the washers with the tape side against the boot lid and the nuts that hold the spoiler.

**Tightening torque 6 Nm (4.5 lbf ft)**

14 **Cars with rear window wipers:** Attach the wiper motor as follows:

- Refit the wiper motor along with the rubber grommet.
- Attach the screws that hold the wiper motor.
- Reconnect the wiper motor wiring.

15 Reattach the upholstery on the inside of the boot lid.

16 Replace the gas struts as follows:

**⚠ WARNING**

The boot lid must be supported while the gas struts are removed.

- Remove the locking clips at both ends of the gas struts. Use a standard screwdriver.
- Pull the gas struts loose from their attachment points on the boot lid and chassis.
- Attach the gas struts from the kit.

17 Close the boot lid.

18 **Cars with rear window wipers:** Attach the wiper arm.

**Painting directions for primed PUR-RIM 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)

**Preparation**

- For best results, apply pore filler first.
- Sand the primed surfaces thoroughly. Use 3M 1200 or 800 abrasive paper.