

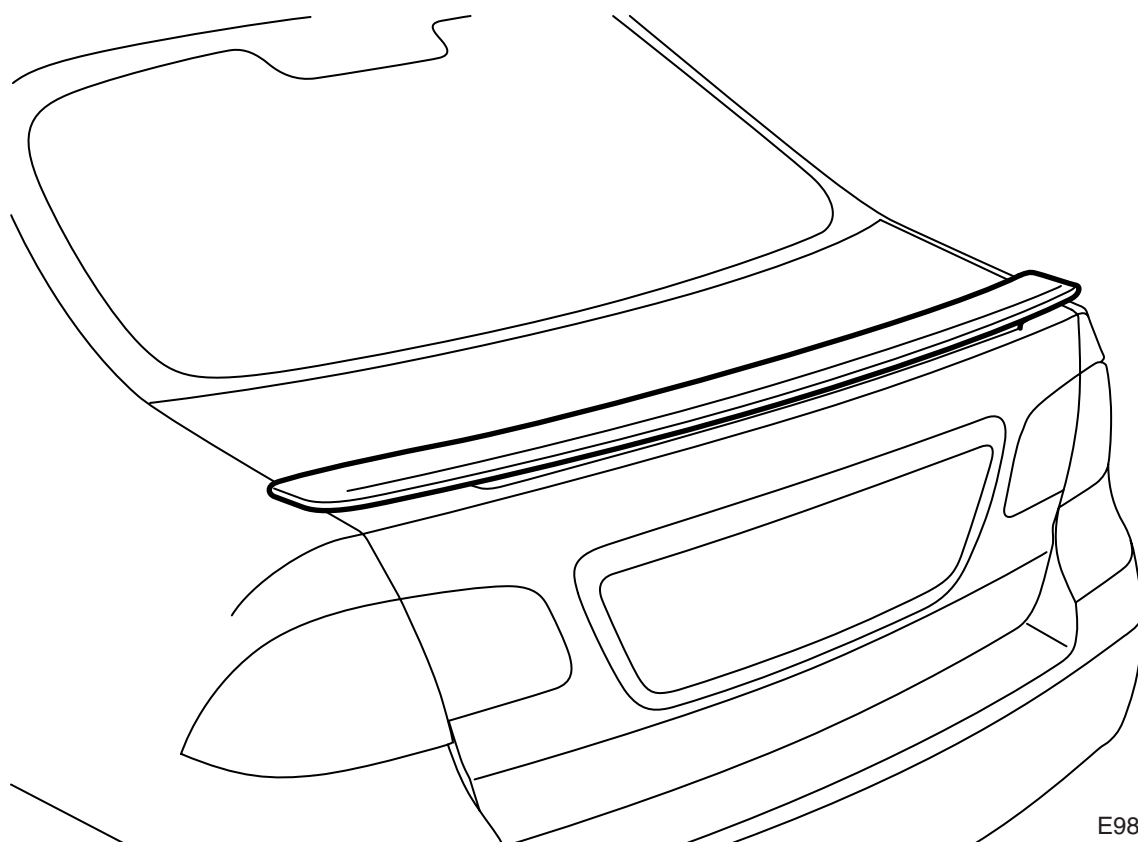


**MONTERINGSANVISNING · INSTALLATION INSTRUCTIONS
MONTAGEANLEITUNG · INSTRUCTIONS DE MONTAGE**

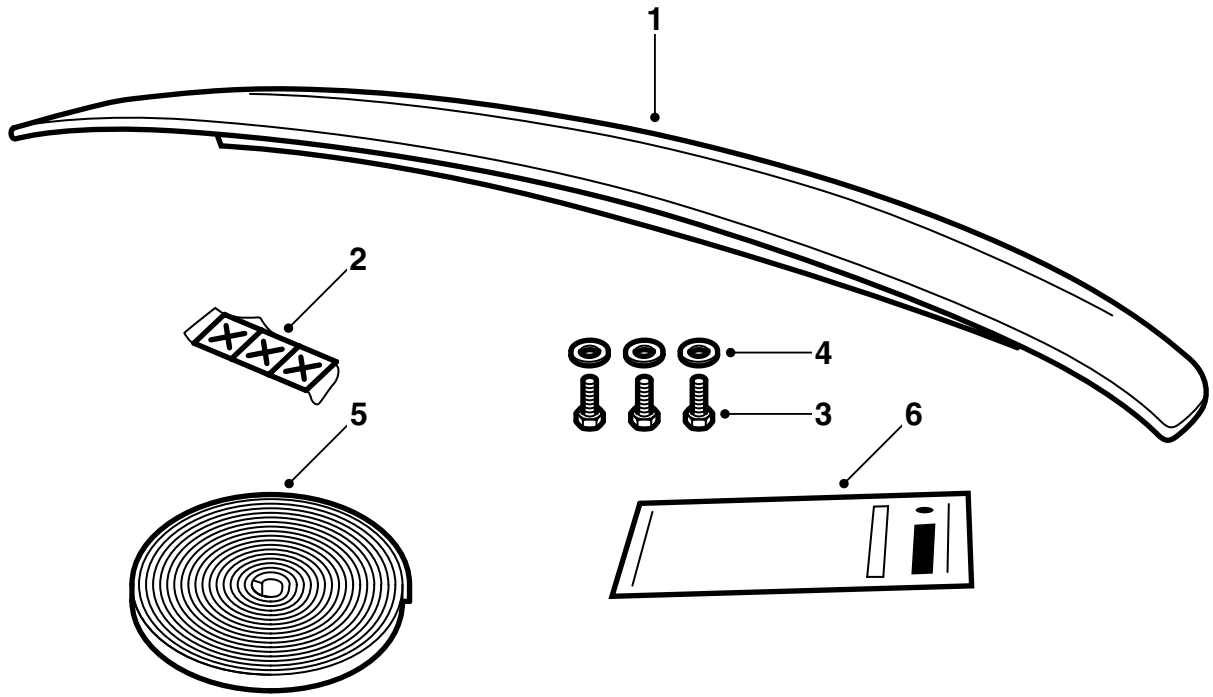
Saab 9-5 4D M06-

Rear spoiler

Accessories Part No.	Group	Date	Instruction Part No.	Replaces
93 185 386	9:84-35	Sep 05	32 025 689	

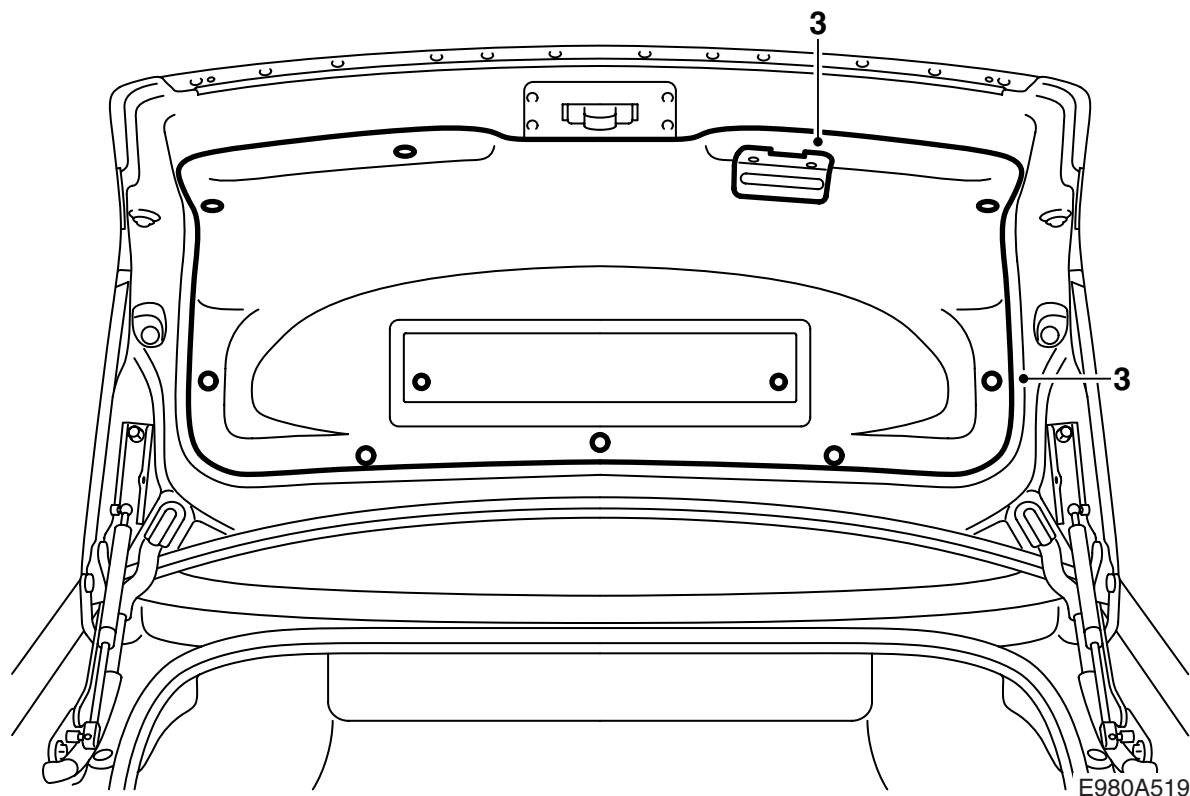


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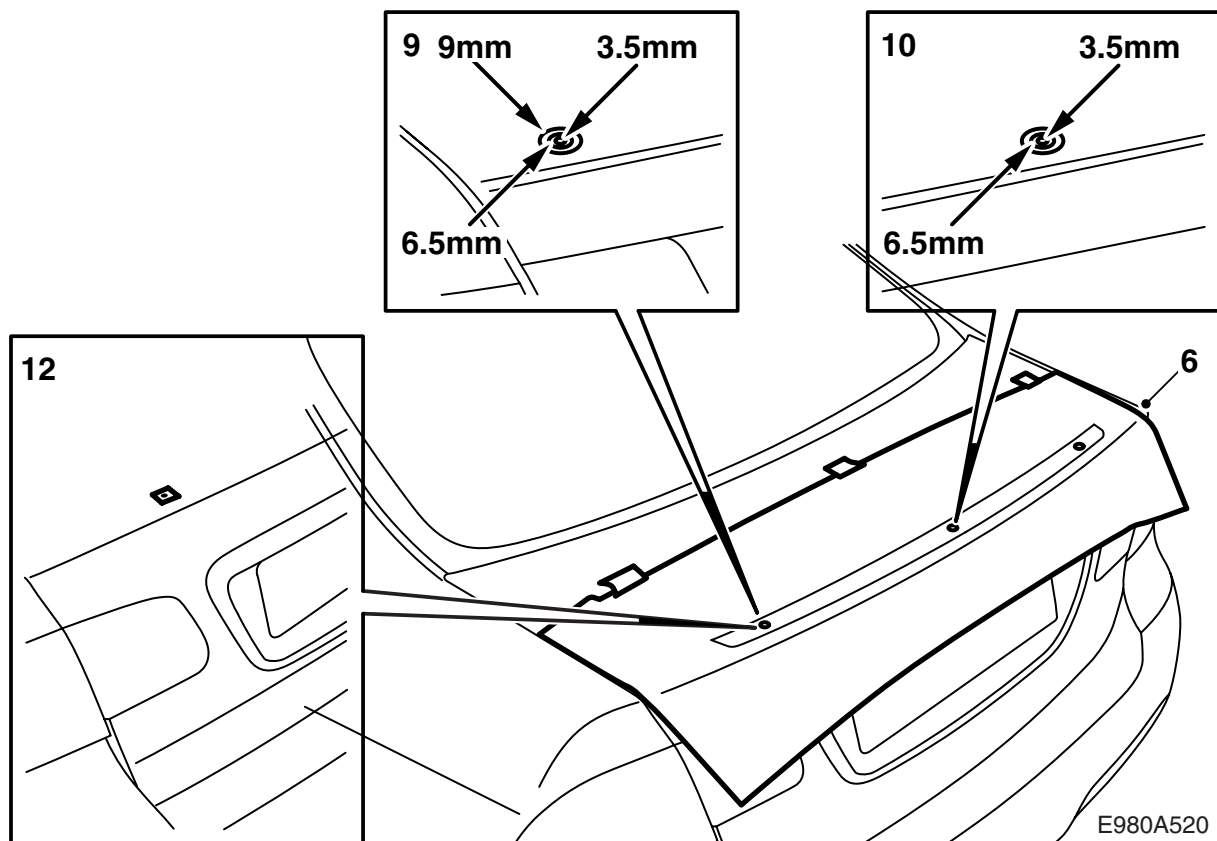
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- 1 Spoiler
- 2 Zinc washer (x3)
- 3 Screw (x3)
- 4 Washer (x3)
- 5 Sealing strip
- 6 Template



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

- 1 Paint the spoiler the same colour as the body, see "Instructions for painting preprimed PUR plastic" in these installation instructions.
- 2 Open the boot lid.
US/CA: Detach the emergency opening handle from the trim.
- 3 Remove the closing handle on the inside of the boot lid, the two-stage rivets and the boot lid trim.
- 4 **US/CA:** Pass the emergency opening handle through the opening in the trim.
- 5 Close the boot lid.

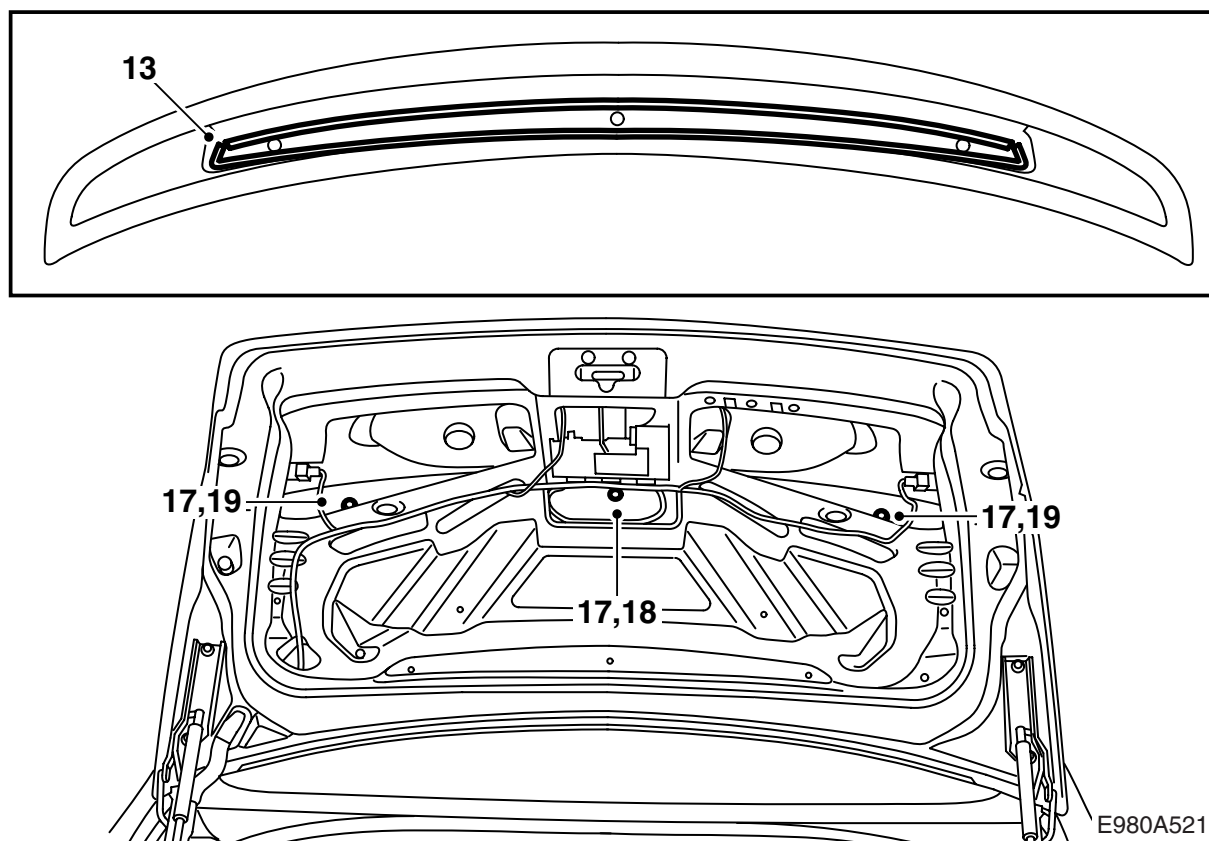


- 6 Cut out the template in accordance with the markings. Position the template on the boot lid and secure it with several pieces of tape.

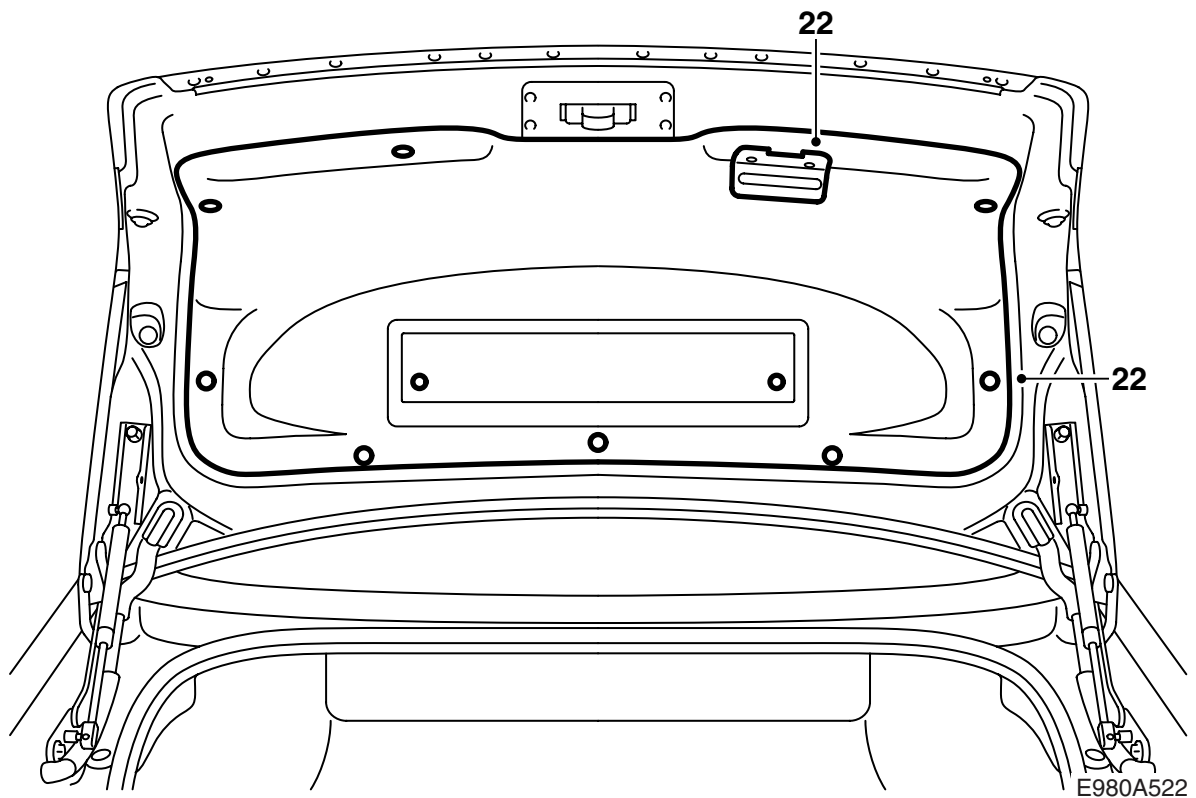
Important

Check the position of the template and adjust as necessary. The measurements to the front edge of the boot lid must be equal on the right and left-hand sides.

- 7 Mark out the holes using a centre punch.
- 8 Remove the template and tape.
- 9 Drill the outer holes in 3 stages. Drill in accordance with the following:
- Stage 1: 3.5 mm drill bit
 - Stage 2: 6.5 mm drill bit
 - Stage 3: 9 mm drill bit
- 10 Drill the centre hole in 2 stages. Drill in accordance with the following:
- Stage 1: 3.5 mm drill bit
 - Stage 2: 6.5 mm drill bit
- 11 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.
- 12 Fit the zinc washers on the new drilled holes. The zinc washers must be fitted on the outside of the boot lid.



- 13 Fit the sealing strip on the underside of the spoiler.
- 14 Open the boot lid.
- 15 Apply Loctite 242 Thread locking adhesive, to the screws.
- 16 Position the spoiler on the boot lid.
- 17 Insert the screws with washers. Check the fit of the spoiler
- 18 Tighten the centre screw.
**Tightening torque, centre screw, 7 Nm
(5 lbf ft)**
- 19 Tighten the outer screws.
**Tightening torque, outer screws, 2 Nm
(1.5 lbf ft)**
Check the fit of the spoiler.
- 20 Clean off and vacuum all swarf.



- 21 **US/CA:** Fit the emergency opening mechanism.
- 22 Fit the boot lid trim, the two-stage rivets and the closing handle.
- 23 **US/CA:** Fit the emergency opening handle.
- 24 Close the boot lid.

 **WARNING**

As the spoiler protrudes over the sides of the boot lid, there is a risk of crushing between the spoiler and the rear wings.

Advise the customer that there is a risk of crushing.

Instructions for painting preprimed PUR-RIM plastic.

- Clean the surfaces thoroughly.
- 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

- For best results, pore-filling paint should be applied.
- Rub down the primed surfaces thoroughly. Use 3M 1200 or 800 abrasive paper.