

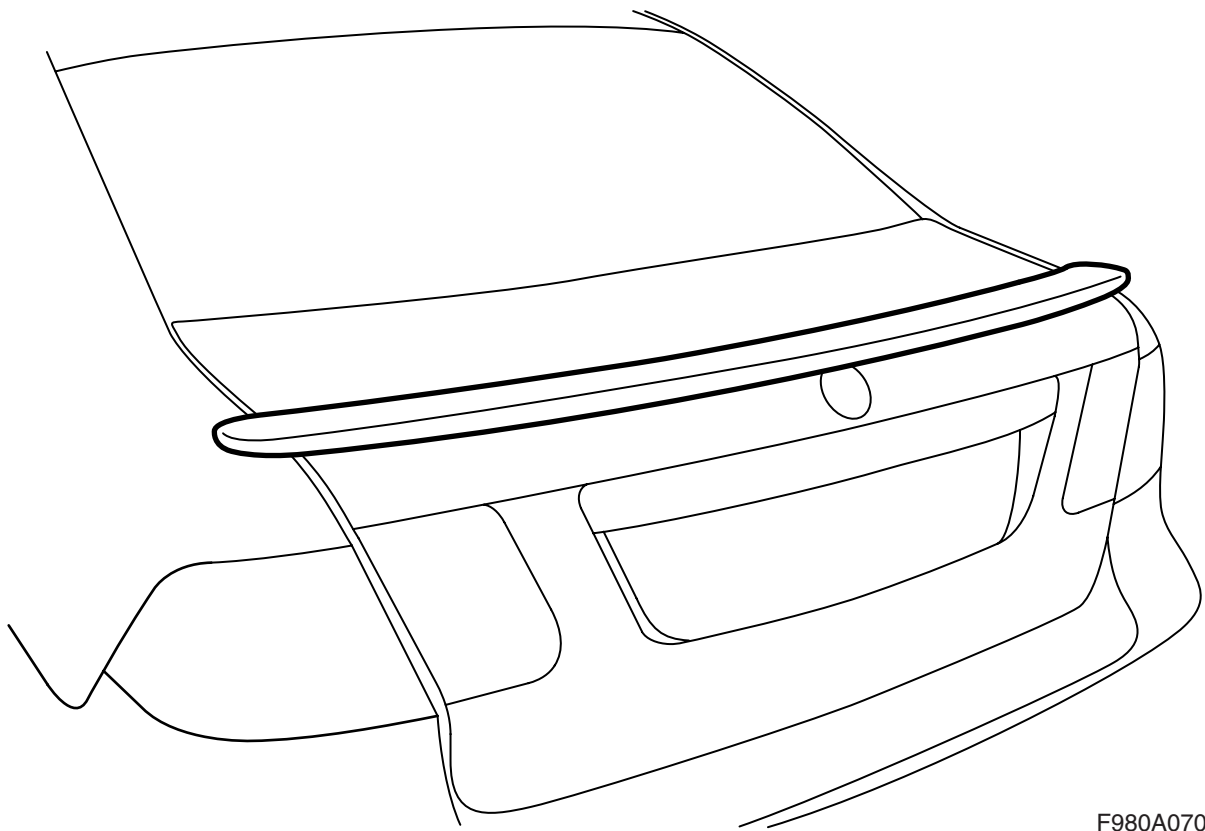


**MONTERINGSANVISNING · INSTALLATION INSTRUCTIONS
MONTAGEANLEITUNG · INSTRUCTIONS DE MONTAGE**

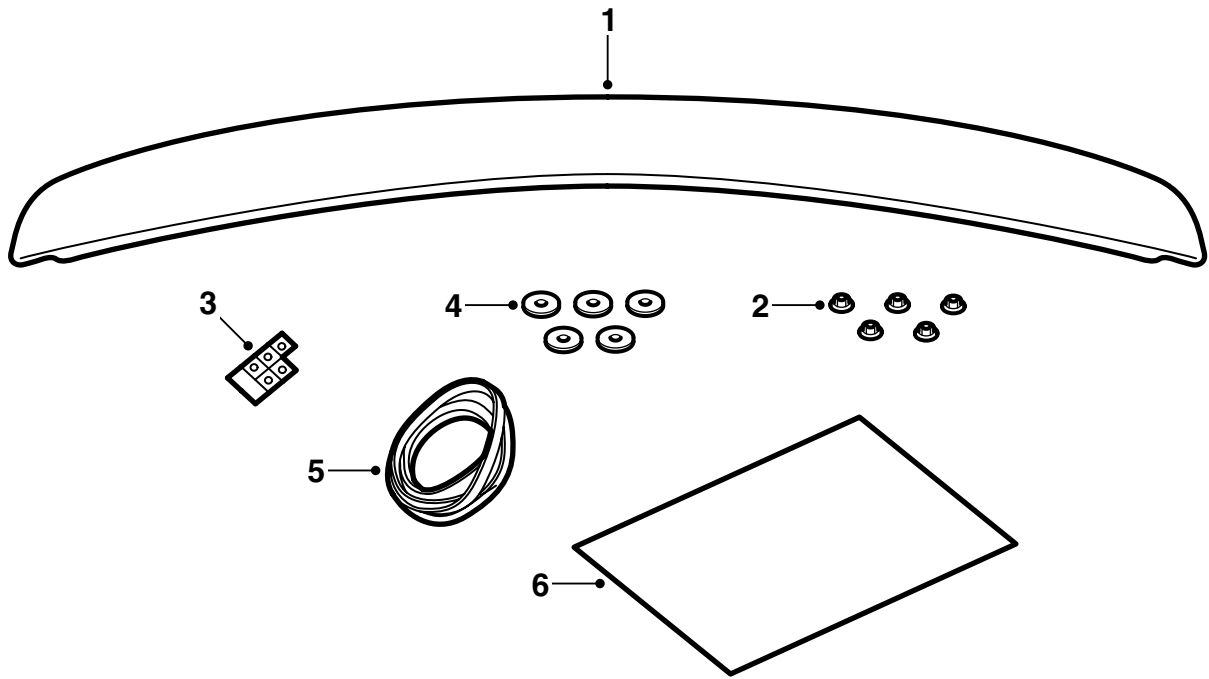
Saab 9-3 M03-

Rear spoiler

| Accessories Part No. | Group | Date | Instruction Part No. | Replaces |
|----------------------|---------|--------|----------------------|-------------------|
| 12 786 790 | 9:84-15 | Oct 02 | 12 789 096 | 12 789 096 Mar 02 |

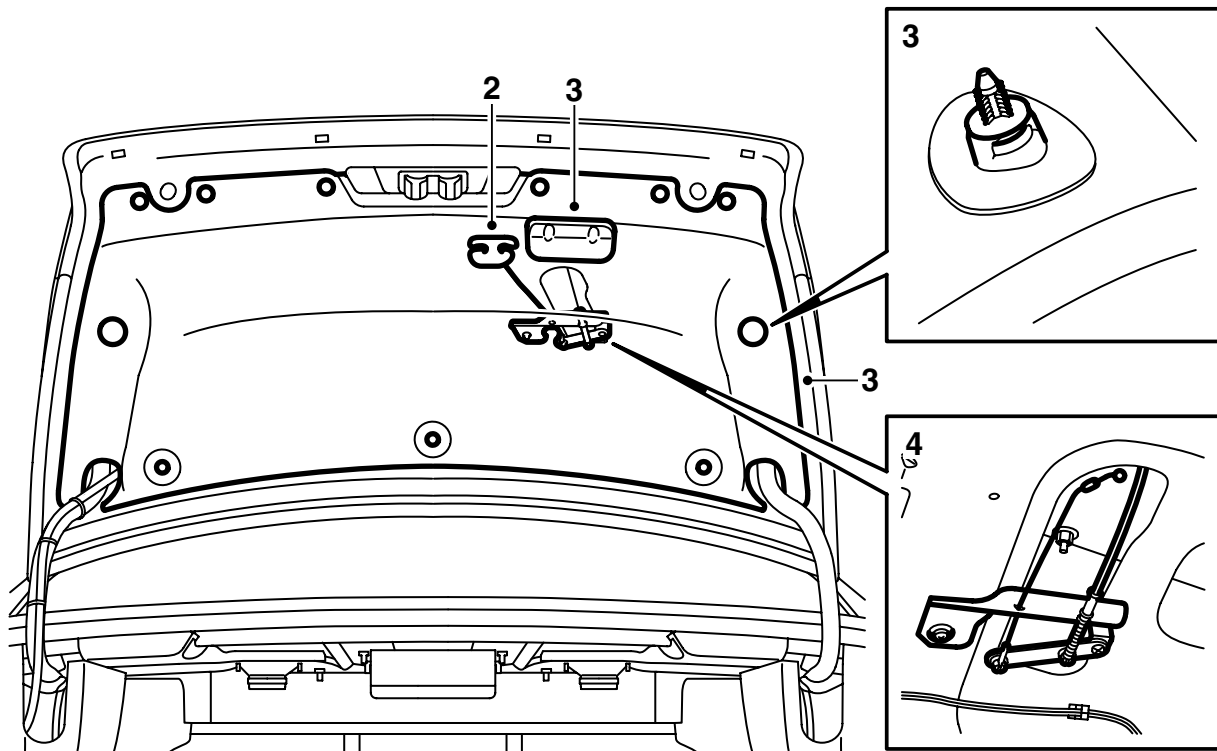


F980A070



F980A009

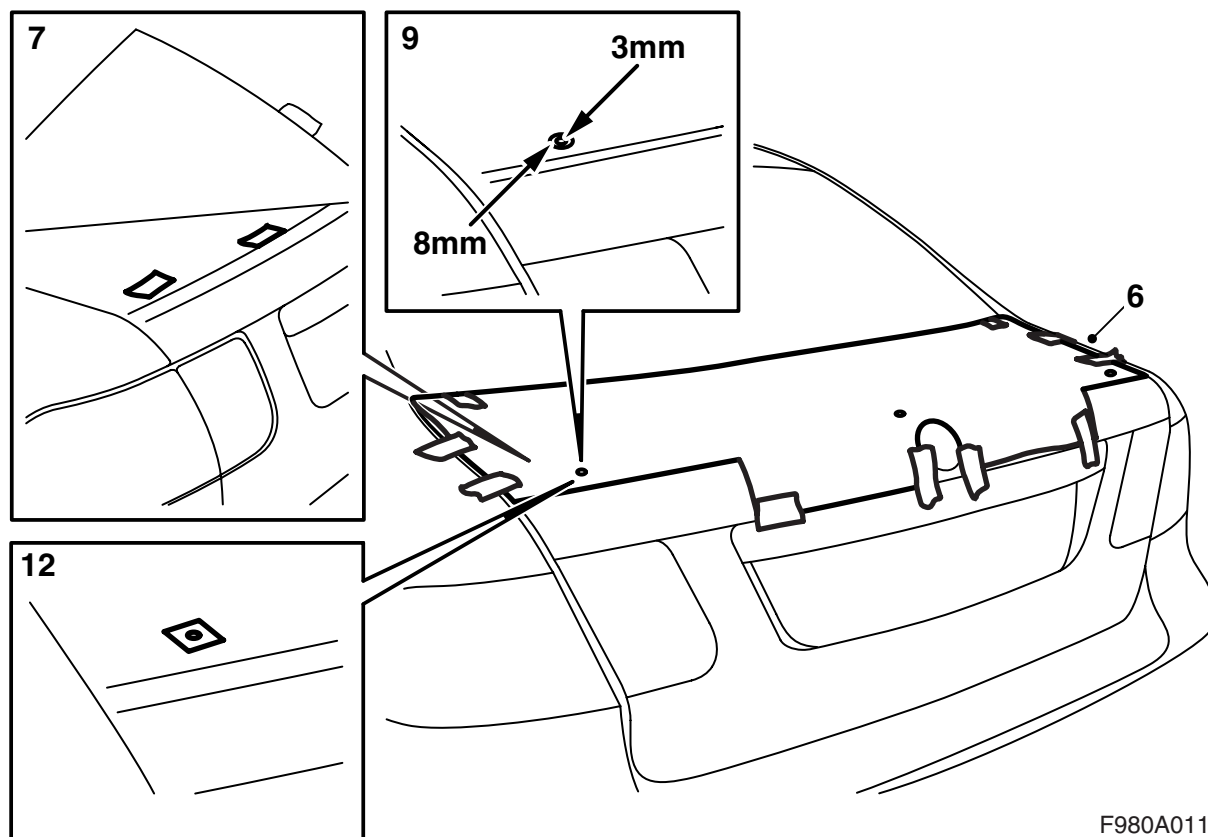
- 1 Spoiler
- 2 Nuts (x5)
- 3 Zinc tape (x5)
- 4 Seal (x5)
- 5 Sealing strip
- 6 Template (2 parts)



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 hatchback.
US: Remove the emergency handle.
- 3 Remove the closing handle on the inside of the boot lid, the two-stage rivets and the boot lid trim.
- 4 **US:** Remove the screws of the emergency opening mechanism and move the mechanism aside.



F980A011

- 5 Cut out the template's parts, join them and fit them together using pieces of tape.
- 6 Line up the template with the round emblem on the boot lid and the front corners of the boot lid. Secure the template with tape at the emblem and the front corners.
- 7 Lift up the template at the emblem and affix tape where the holes are to be drilled (5).
- 8 Refit the template and secure with tape.
- 12 Fit the pieces of zinc tape to the boot lid.

Important

Check the position of the template and adjust as necessary.

- 9 Drill holes as marked.
-

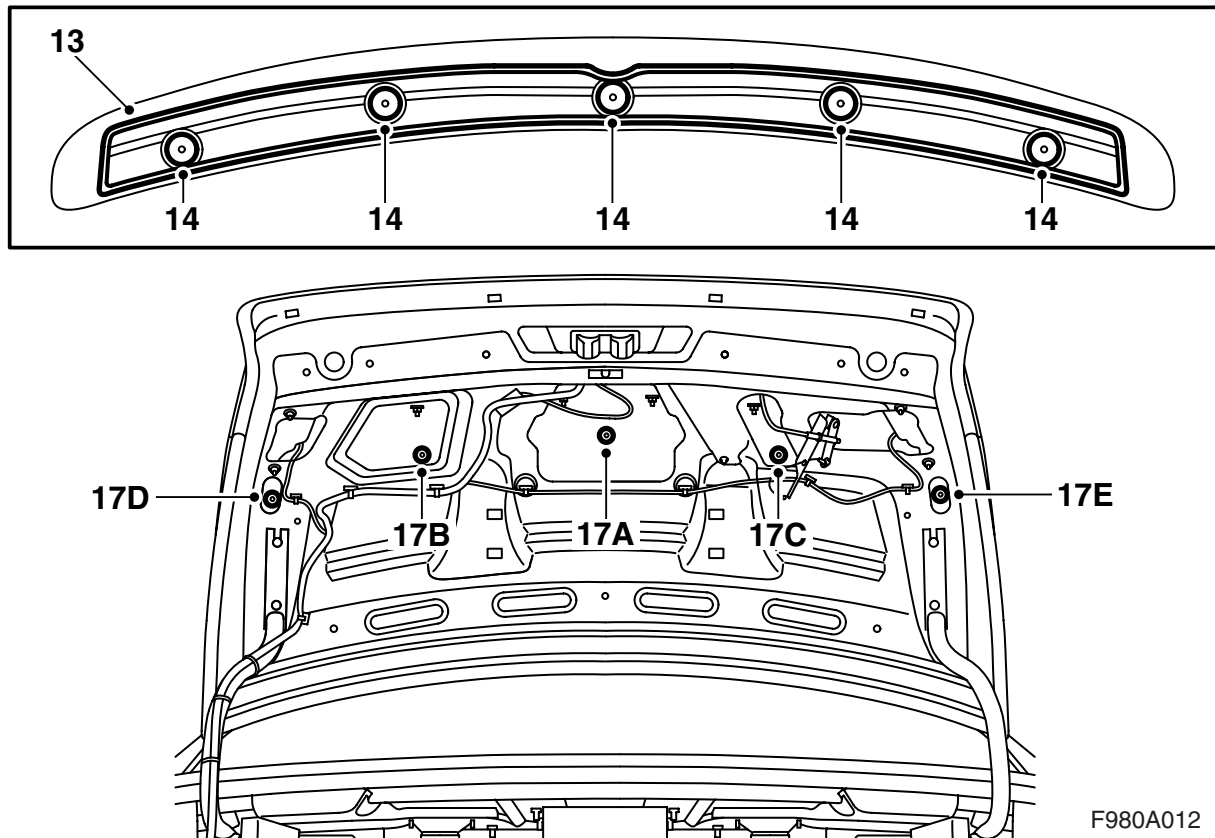
Important

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

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

First drill with a 2 mm bit, then with a 5 mm bit and end with an 8 mm bit.

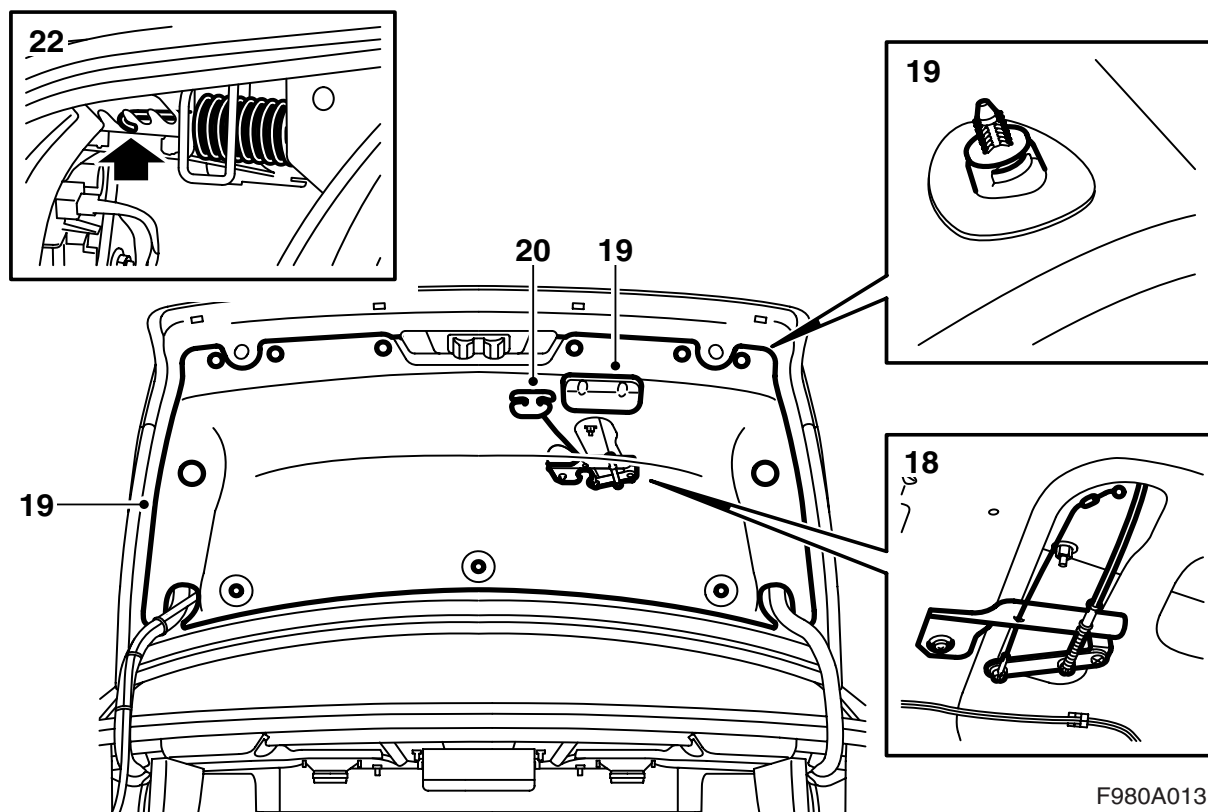
- 10 Remove the template and tape.
- 11 Deburr the holes and remove loose drillings, swarf and flakes of paint. Clean with Teroson FL Cleaner. Apply Standox 1K Primer Filler. Apply finishing paint. Apply Terotex HV 400 or Mercasol 1 cavity sealant on internal surfaces.



F980A012

- 13 Fit the sealing strip inside the bottom edge of the spoiler starting at the recess for the emblem.
- 14 Fit the seals on the bolts.
- 15 Place the spoiler on the boot lid.
- 16 Hold the spoiler in place and carefully open the boot lid.
- 17 First secure the spoiler with the five nuts. Then carefully tighten the nuts a few turns at a time in the order specified in the illustration (A, B, C, D, E) until the correct tightening torque has been reached.

Tightening torque 6 Nm (4.5 lbf ft)



- 18 **US:** Fit the emergency opening mechanism.
- 19 Fit the boot lid trim, the two-stage rivets and the closing handle.
- 20 **US:** Fit the emergency handle.
- 21 Lower the cover in the luggage compartment trim on both the right and the left-hand sides.
- 22 Tighten both right and left springs one notch.
- 23 Put up both covers.
- 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.

Directions for painting preprimed ABS plastic

- The spoiler must be placed where it will not be deformed while painting.
- The temperature must not exceed +40°C (104°F).
- The spoiler is pre-primed on delivery
- Use clean gloves when handling the spoiler

Drying times

70 minutes at 40°C (104°F).

Preparations

- Smooth off the primed surface thoroughly. Use abrasive paper 3M 1200 or 800.