

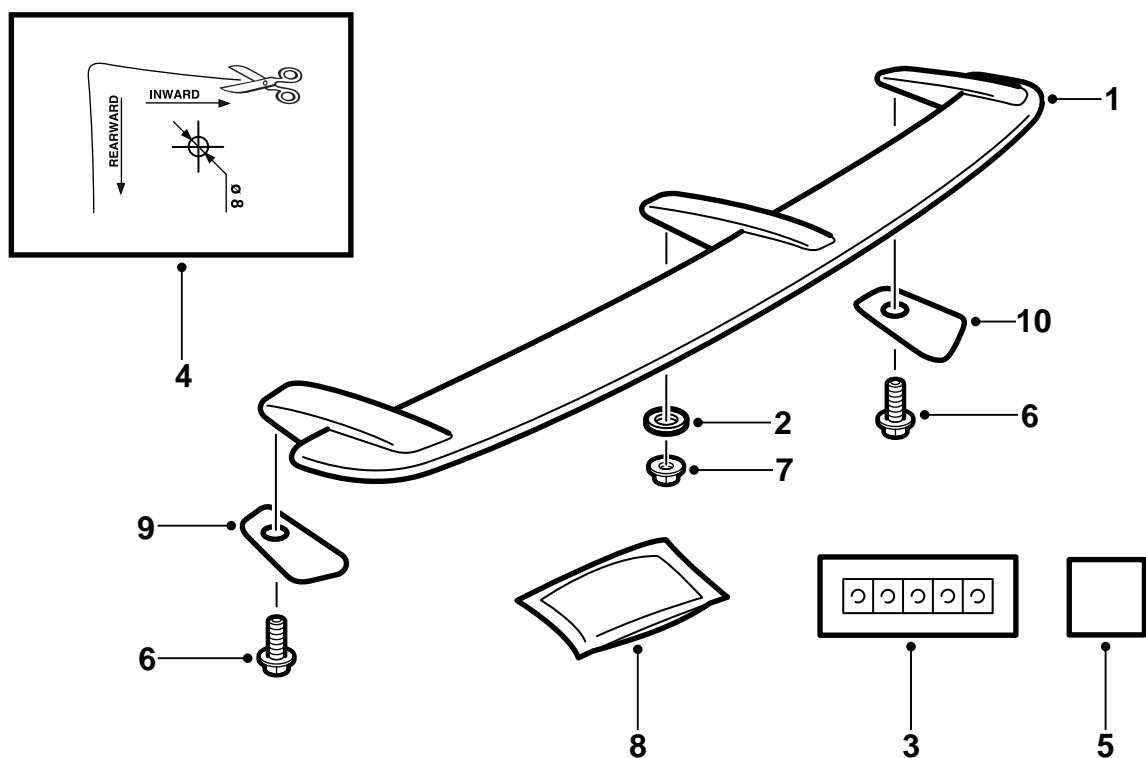


MONTERINGSANVISNING · INSTALLATION INSTRUCTIONS  
MONTAGEANLEITUNG · INSTRUCTIONS DE MONTAGE

## Saab 9-5 5D

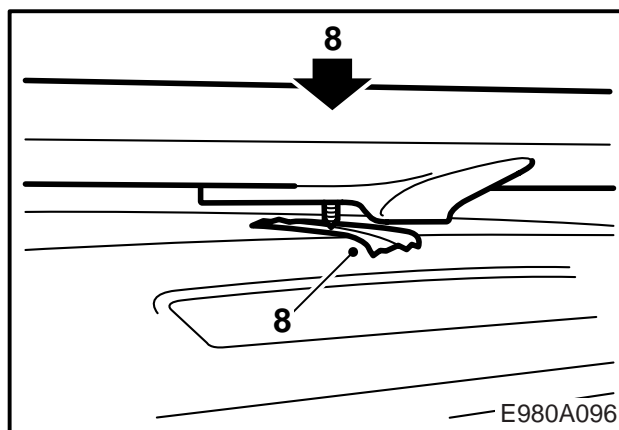
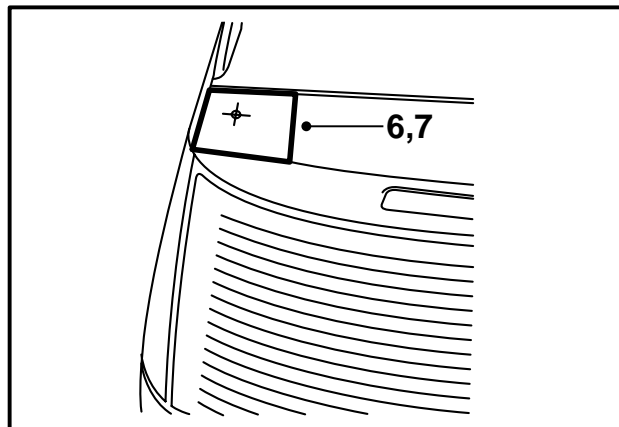
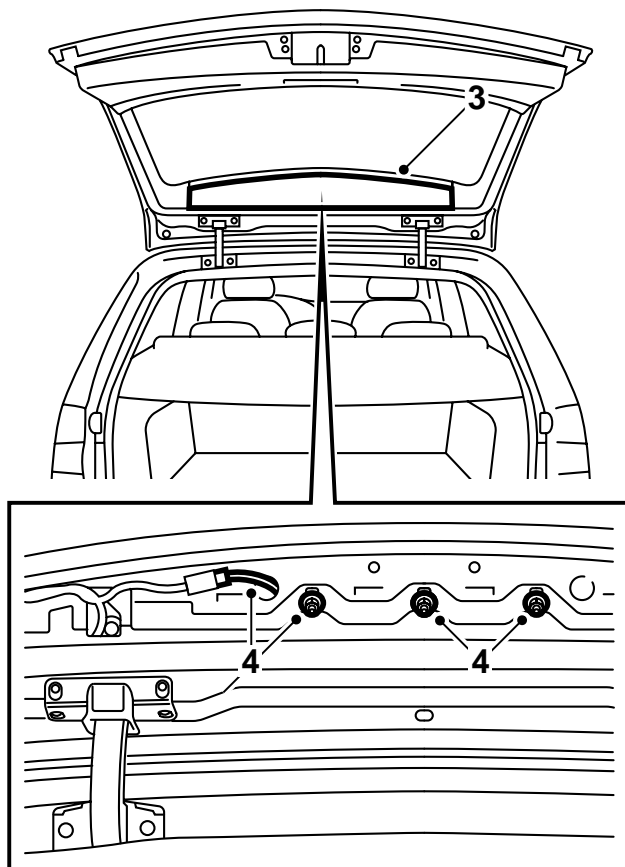
### Rear spoiler

Accessories Part No.	Group	Date	Instruction Part No.	Replaces
400 132 163	9:84-14	Dec 01	53 35 773	



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- 1 Spoiler
- 2 Seal
- 3 Zinc tape (x3)
- 4 Drilling template
- 5 Double-sided adhesive tape
- 6 Screw (x2)
- 7 Nut
- 8 Cleaning cloth
- 9 Seal L
- 10 Seal R



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 Open the hatch.
- 3 Remove the cover on the inside of the hatch at the top. Also remove the rubber plugs.
- 4 Remove the centre brake light.
- 5 Cut out the drilling template and position it as described in the instructions on it.
- 6 Mark the positions of the outer holes, using a centre punch.

### Note

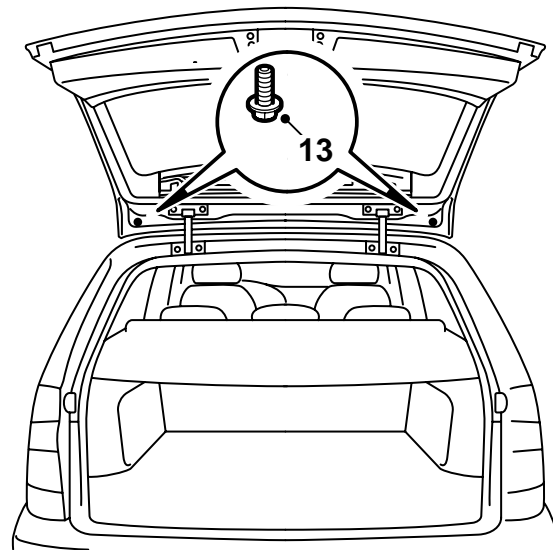
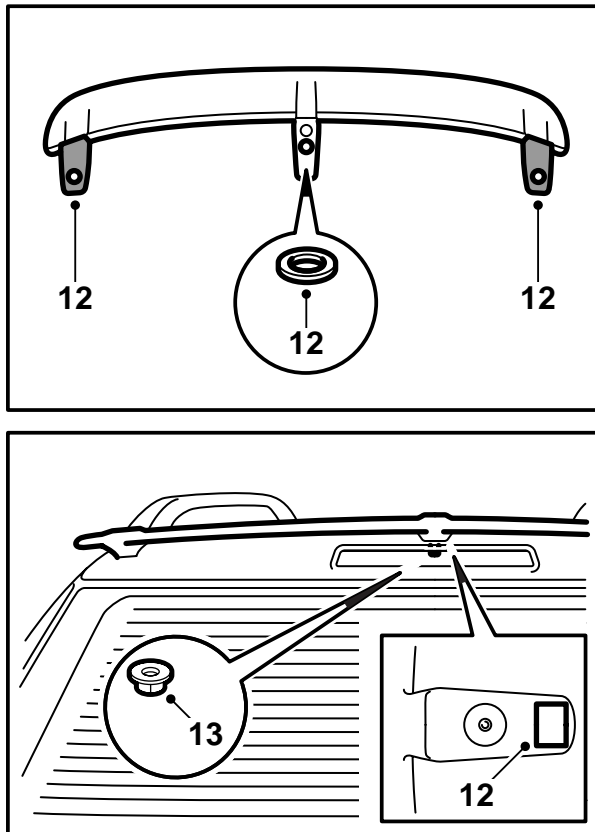
Exercise care.

- 7 Drill holes as marked.  
Use an 8 mm drill bit.
- 8 Use masking tape to mark the approximate position of the centre hole. Fit the spoiler in place, inserting the outer screws to hold it in position. Press it down in the middle. Lift the spoiler away. The screw in the centre of the spoiler should have left a mark in the masking tape.

- 9 Drill an 8 mm hole at the centre mark.

Lay the spoiler in position and make sure the holes in the tailgate correspond with the fastening points in the spoiler. If they do not, the holes must be elongated with a file.

- 10 Protect the drilled 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.



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- 11 Wipe clean with the cleaning cloth under the spoiler fastening points and on the tailgate where the spoiler is to be fitted.
- 12 Fit the seals and affix the double-sided adhesive tape under the centre fastening point on the spoiler, see illustration.
- 13 Remove the backing paper from the adhesive tape and position the spoiler correctly starting with the rear edge.

### Important

It is very important that rear edge of the spoiler is positioned correctly before the tape adheres to the tailgate.

Press down the front of the spoiler and hold the front edge of the centre fastening point for at least 1 minute to allow the tape to adhere properly. Fit the spoiler retaining screws and nut but do not tighten them yet. The centre nut can be fitted through the space left where the brake light has been removed. Tighten the nut on the centre fastening point first and then the screws on the outer edges of the spoiler.

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

Check that the play between the tailgate and the spoiler's fastening points is satisfactory.

- 14 Fit the centre brake light and the rubber plugs.  
**Tightening torque 3.9 Nm (2.9 lbf ft)**
- 15 Fit the cover plate on the inside of the tailgate. Close the tailgate.

### **Painting instructions for preprimed 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).

### **Preparations**

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