

**Repair materials**

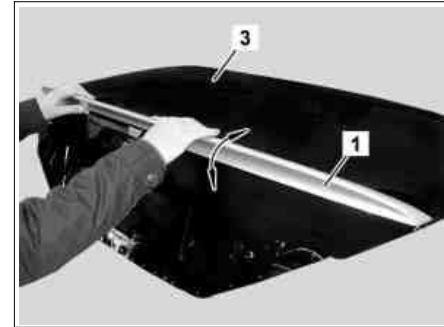
Number	Designation	Order number
BR00.45-Z-1025-04A	Cleaner	A 005 989 19 71

**i** The vehicle and the rear spoiler should have the same temperature (ambient temperature) when installing to prevent later distortion from various thermal expansion.

**i** The area on the trunk lid to be glued must be free of dust and grease. For cleaning, use mixture of IPA (Isopropanol alcohol) and water with a ratio of 50 : 50.

1 Install rear spoiler (1) on trunk lid (3), position correctly and align.

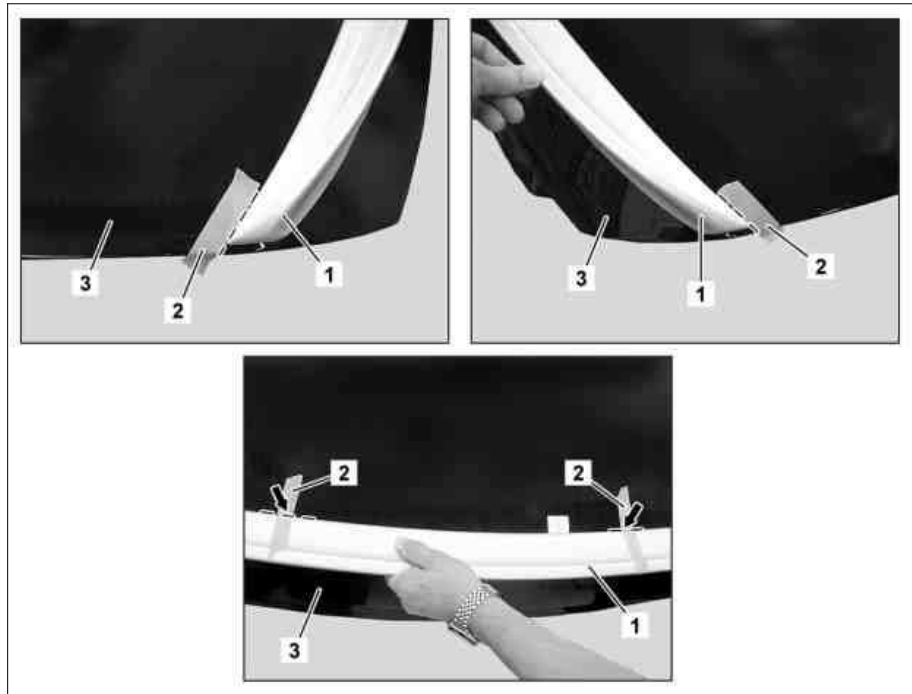
**i** Install rear spoiler (1) on edge of trunk lid (3) and then carefully move up and down with slight pressure until the correct position is reached. It should not be possible to move the rear spoiler (1) in this position and it should make uniform contact to the trunk lid (3) all the way around.



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2 Center rear spoiler (1) on trunk lid (3) and mark position with adhesive tape (TESA-KREPP) (2) on rear spoiler (1) and trunk lid (3).

**i** Carefully cut adhesive tape (TESA-KREPP) (2) at spoiler edge with suitable tool (see arrows).



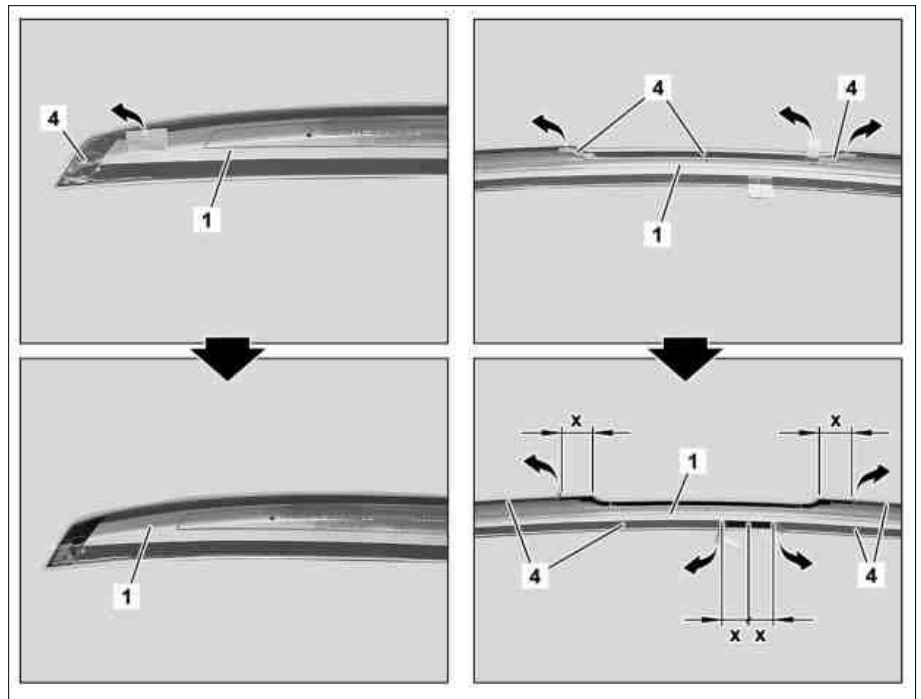
P88.50-2872-06

- 3 Detach protective foils (4) on right, left and in center from adhesive tape.

**i** Remove protective foils (4) from adhesive tape only in areas described. Never remove protective foils (4) completely.

**i** The area on the trunk lid to be glued must be free of dust and grease. For cleaning, use mixture of IPA (Isopropanol alcohol) and water with a ratio of 50 : 50.

X = 50 mm



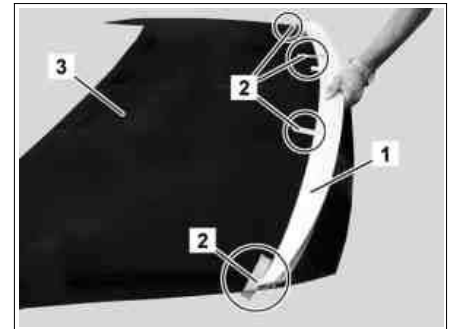
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- 4 Align rear spoiler (1) with adhesive tape (TESA-KREPP) (2) and outer edge of trunk lid (3) (see circles).

**i** When aligning rear spoiler (1), keep removed foil area away from trunk lid (3), because the adhesive tape can be damaged when detaching the rear spoiler (1) again.

- 5 Position rear spoiler (1) on removed foil area and press on firmly.

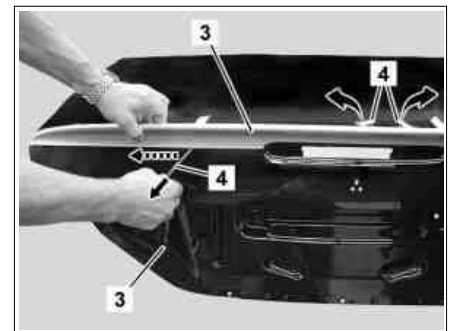
**i** Check position of rear spoiler (1)!



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- 6 Pull out protective foil (4) in increments of 15 - 20 cm, first at bottom and at top, starting at center and press on rear spoiler (1).

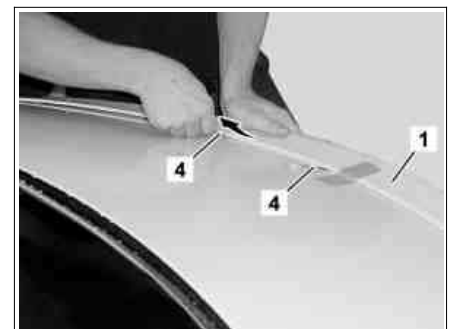
**i** Check position of rear spoiler (1)!



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**i** Do not pull out protective foil (4) all at once.

**i** Slightly lift rear spoiler (1) in area to be removed to facilitate removal of the protective foil and to prevent it from tearing off.



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7 Firmly press rear spoiler (1) to trunk lid (3) from inside toward outside with clean cotton rag.

**i** Remove air bubbles from adhesive tape.

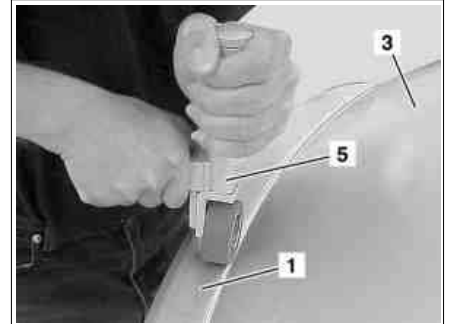


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8 To increase the processing reliability when installing rear spoiler (1), press finally rear spoiler (1) down on trunk lid (3) using a 3M load roller (5) starting at one side.

**i** When pressing on, ensure that the pressure is applied directly on the adhesive tape.

**i** The maximum adhesive force is reached after approx. 72 hours at 20 °C!  
Avoid any contact with moisture (e.g. rain, fog, carwash) within the first 24 hours.  
Prevent any mechanical stress.



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