



**DAK SPOILER – ROOF SPOILER**  
**SUBARU IMPREZA 2004**



**LAK- EN MONTAGE-INSTRUCTIES**  
**PAINTING AND FITTING INSTRUCTIONS**

**TS SB11**



## **DAK SPOILERS – ROOF SPOILERS** (PUR-IHS)

### **LAK-EN MONTAGE-INSTRUCTIES** **PAINTING AND FITTING INSTRUCTIONS**

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### **LAK INSTRUCTIES – PAINTING INSTRUCTIONS**

#### **MATERIAAL SPECIFICATIES - MATERIAL SPECIFICATION**

|                                                                            |                 |         |             |
|----------------------------------------------------------------------------|-----------------|---------|-------------|
| RECOMMENDED FORMULATION                                                    | parts by weight |         |             |
| VORACOR CS 649 Polyol                                                      | 100             |         |             |
| VORACOR CS 679 Isocyanate                                                  | 110             |         |             |
| REACTION CHARACTERISTICS (at 20° C components temperature)                 |                 |         |             |
| <b>Actual values vary depending on processing conditions.</b>              |                 |         |             |
| Cream time                                                                 | sec             | 28-32   |             |
| Gel time                                                                   | sec             | 73-80   |             |
| Rise time                                                                  | sec             | 105-115 |             |
| Free rise density                                                          | kg/m³           | 123-136 |             |
| <b>Processing conditions</b>                                               |                 |         |             |
| Components temperature                                                     | C               | 20-30   |             |
| Molds temperature                                                          | C               | 35-45   |             |
| Obtainable thickness                                                       | mm              | 10-60   |             |
| Demolding time                                                             | min             | 8-15    |             |
| <b>Typical Foam Properties Related to molded polymer, thickness 10 mm.</b> |                 |         |             |
| Overall density                                                            | kg/m³           | 450     | ISO R 845   |
| Skin hardness                                                              | Shore D         | 55      | ASTM D 2240 |
| Tensile strength                                                           | kg/cm²          | 100     | UNI 8071    |
| Elongation at break                                                        | %               | 8       | UNI 8071    |
| Flexural strength                                                          | kg/cm²          | 190     | UNI 7219    |
| Flexural modulus                                                           | kg/cm²          | 5000    | UNI 7219    |
| Dimensional stability (linear variation 48 hours at 70° C)                 | %               | 0,2     | UNI 8069    |
| Flame behaviour                                                            |                 | B2      | DIN 4102    |
| Testing methods are available on request                                   |                 |         |             |

### **VOORBEREIDING VOOR HET LAKKEN - PREPARATION BEFORE FINAL PAINTING**

Volg de onderstaande procedure voordat u de spoiler monteert. Before installation of spoilers, follow the procedure below.

#### **STAGE 1: SCHUREN – SANDING**

Schuur het gehele product met 240 korrel schuurpapier. Laat alle oppervlakken aan de lucht drogen of reinig ze met nitroverdunner..

*Sand the entire product with 240 dry sandpapers. Air dry or clean all surfaces with nitro thinner.*

#### **STAGE 2: PRIMER VOORBEREIDING - PRIMER PREPARATION**

Lak het gehele product met 3+1 primer bij kamertemperatuur (20°-25°C) \*\* **DROOGTIJD (3 uur) A**

*Paint the entire product with 3+1 primer at room temperature (20°-25°C) \*\* DRYING TIME (3 hours) A*

#### **STAGE 3: EGALISEREN – FILLING- ATTENTION: LEAVE VENTILATION HOLES OPEN !**

Breng een zachte plamuur aan op eventuele krassen of beschadigingen. Breng een 2e laag primer aan \*\*\*  
**DROOGTIJD (3 uur) B**

*Apply a soft putty to any scratches or marks. Apply 2<sup>nd</sup> coat of primer \*\*\* DRYING TIME (3 hours) B*

### **BEHANDELING VOOR EINDLAKWERK - PROCESS FOR FINAL PAINTING**

De spoilers zijn nu voorzien van 2 lagen primer (polyurethaan & acryl basis). Ze zijn klaar voor de definitieve lak.  
**OPGELET: VENTILATIEGATEN OPEN LATEN !!**

*The spoilers are now primed with 2 layers (polyurethane & acrylic base ). They are ready for final painting.  
**ATTENTION: LEAVE VENTILATION HOLES OPEN !!***

|                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <br><br> | <p><b>STAGE 4: SCHUREN - FINAL SANDING</b><br/>Schuur het hele product met schuurpapier korrel 800.<br/><i>Sand the whole product with 800 grit sandpaper.</i></p> <p><b>STAGE 5: LAKKEN - FINAL PAINTING</b><br/>Reinig het geheel nog eens goed** en lak het met acrylverf.<br/><b><i>Give a final good clean** and paint with the final acrylic paint</i></b></p> <p><b><u>ATTENTIE – ATTENTION</u></b><br/><b>(VERFTEMPERATUUR MAG NIET HOGER ZIJN DAN 40° C)</b><br/><b>(PAINTING TEMPERATURE SHOULD NOT EXCEED 40° C)</b></p> |
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### Tools Needed - Benodigdheden

|                                                                                   |                                                                                                                                                                                            |
|-----------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|  | <ul style="list-style-type: none"> <li>Pencil - Potlood</li> <li>Tape Measure - Meetlint</li> <li>Tape - Tape</li> <li>Gloves - Handschoenen</li> <li>Cloth - (Microvezel) doek</li> </ul> |
|-----------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

### Placement instructions (This job requires 2 people) Installation time: 10 min.

|                                                                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                       |
|-------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|    | <p>Put the spoiler on the car to check the correct fitment position. The line we must use as guide is the upper windshield rubber. Put paper tape around the base of the spoiler in order to mark the place that the spoiler fits. After that rub with sandpaper the inside of the spoiler base and with sandpaper 1000-2000 the area over the car. We want just to rough a little the varnish, so we have a better gluing result</p> |
|  | <p>Clean very well with alcohol or nitro solvent all the contact surfaces. Put silicone on the spoiler base. Be careful not to overflow any silicone out of the spoiler after the fitment. Put a lot of paper tape to hold it on to its place until silicone strengthens and pay attention at the drape in the middle of the spoiler</p>                                                                                              |
|  | <p>A block of hard foam is included in order to act as a positioning guide and help you place the spoiler on the roof. You should place the block in the center of the spoiler as shown in the picture.</p>                                                                                                                                                                                                                           |

### ATTENTION: On car use after the installation

