



**DAK SPOILER – ROOF SPOILER**  
**AUDI A3 8P 3D GT (2003 – 2012)**



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

**TS AU66**



## **DAK SPOILERS – ROOF SPOILERS**

**(PUR-IHS)**

### **LAK-EN MONTAGE-INSTRUCTIES**

### **PAINTING AND FITTING INSTRUCTIONS**

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### **LAKINSTRUCTIES – PAINTING INSTRUCTIONS**

### **MATERIAALSPECIFICATIES - 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><u>Actual values vary depending on processing conditions.</u></b>              |                    |         |             |
| <i>Cream time</i>                                                                 | sec                | 28-32   |             |
| <i>Gel time</i>                                                                   | sec                | 73-80   |             |
| <i>Rise time</i>                                                                  | sec                | 105-115 |             |
| <i>Free rise density</i>                                                          | kg/m <sup>3</sup>  | 123-136 |             |
| <b><u>Processing conditions</u></b>                                               |                    |         |             |
| <i>Components temperature</i>                                                     | C                  | 20-30   |             |
| <i>Molds temperature</i>                                                          | C                  | 35-45   |             |
| <i>Obtainable thickness</i>                                                       | mm                 | 10-60   |             |
| <i>Demolding time</i>                                                             | min                | 8-15    |             |
| <b><u>Typical Foam Properties Related to molded polymer, thickness 10 mm.</u></b> |                    |         |             |
| <i>Overall density</i>                                                            | kg/m <sup>3</sup>  | 450     | ISO R 845   |
| <i>Skin hardness</i>                                                              | Shore D            | 55      | ASTM D 2240 |
| <i>Tensile strength</i>                                                           | kg/cm <sup>2</sup> | 100     | UNI 8071    |
| <i>Elongation at break</i>                                                        | %                  | 8       | UNI 8071    |
| <i>Flexural strength</i>                                                          | kg/cm <sup>2</sup> | 190     | UNI 7219    |
| <i>Flexural modulus</i>                                                           | kg/cm <sup>2</sup> | 5000    | UNI 7219    |
| <i>Dimensional stability (linear variation 48 hours at 70° C)</i>                 | %                  | 0,2     | UNI 8069    |
| <i>Flame behaviour</i>                                                            |                    | 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 !!**

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| <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***

|                                                                                   |                                                                                                                                                                                                                    |
|-----------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|  | <div>Pencil</div> <div>- Potlood</div> <div>Tape Measure</div> <div>- Meetlint</div> <div>Tape</div> <div>- Tape</div> <div>Gloves</div> <div>- Handschoenen</div> <div>Cloth</div> <div>- (Microvezel) doek</div> |
|-----------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

**Placement instructions (This job requires 2 people)**  
**Montage instructies (Voor deze taak zijn 2 personen nodig)**

|                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                        |
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|                                                                                                                                                                                                                                                                                                                                        | <p>Center the spoiler and measure so that it is exactly in position. Draw a pencil outline around its base or contact surface.</p> <p>Centreer de spoiler en bepaal de exacte positie. Teken met potlood een omtrek rond de basis of het contactvlak.</p>                                                                                                              |
|                                                                                                                                                                                                                                                                                                                                       | <p><b>Clean the car surface &amp; spoiler with cleaner.</b> Apply silicone over entire surface- touching points to be glued. Then, center the spoiler on the car.</p> <p><b>Reinig het auto-oppervlak en de spoiler met een geschikt reinigingsmiddel.</b> Breng de lijm aan over het gehele oppervlak - contactpunten. Centreer vervolgens de spoiler op de auto.</p> |
|                                                                                                                                                                                                                                                                                                                                      | <p>Additionally press down and secure the roof spoiler with suitable adhesive tape. The application is complete, and the car is now ready to move.</p> <p>Druk vervolgens de dakspoiler aan en fixeer deze met geschikte tape tot de lijm droog is. Het aanbrengen is voltooid, en de auto is nu klaar voor gebruik.</p>                                               |
| <p align="center"><b>ATTENTIE: Over het gebruik van de auto na de installatie</b><br/> <b>ATTENTION: On car use after the installation</b></p> <div>  <div>12h</div> <div>max. 100 km/h</div> <div>24h</div> <div>  <div>48h</div> </div> </div> |                                                                                                                                                                                                                                                                                                                                                                        |