



## M-16601-R00 2000 Ford Racing Mustang Cobra R Air Dam INSTALLATION INSTRUCTIONS

NO PART OF THIS DOCUMENT MAY BE REPRODUCED WITHOUT PRIOR AGREEMENT AND WRITTEN PERMISSION OF  
FORD RACING PERFORMANCE PARTS

Please contact the Tech "Hot Line" for the most current instruction information (586) 468-1356

**!!! PLEASE READ THE FOLLOWING INSTRUCTIONS CAREFULLY PRIOR TO INSTALLATION !!!**

### INTRODUCTION:

Ford Racing has developed this air dam kit to provide owners with an opportunity to upgrade their vehicle with a more sporty appearance. The air dam is molded from thick, durable urethane and should be painted to match the vehicle color.

### OVERVIEW:

The air dam is original equipment on the 2000 Mustang Cobra "R". It can be installed on 1999 and 2001 Cobra models, and the 1999 and later model Mustang GT's with the Cobra bumper cover kit M-17957-A50 installed. Nine holes need to be drilled in the bumper cover to mount the air dam. Note that ground clearance will be reduced with the air dam installed. Automatic car wash machines may damage Cobra R Air Dam and Rear Wings. Hand washing is recommended.

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**Note:** If used for speeds above 90 mph, additional air dam/bumper cover support is recommended. This is necessary because the air dam creates a lot of down force and pulls down on all of the air dam/bumper cover fasteners.

### PARTS IN KIT:

- |                       |                           |
|-----------------------|---------------------------|
| (1) Air Dam           | (36) Pop rivets           |
| (1) Metal "C" bracket | (2) Metal saddle brackets |
| (9) Panel fasteners   | (2) Rubber mounts         |

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### TOOLS REQUIRED:

Scribe tool – short body or 90° tip  
Vise Grip® clamps (4SP) model or equivalent  
Carbide burr 3/8" round head or flame tip  
Grinding disc for use in die grinder  
90° small body air drill  
Short 1/8" and 11/32" drill bits  
Pop rivet gun



### OPTIONAL TOOLS:

Short body air hammer-style rivet gun  
Semi-hollow tubular rivet set tool  
Rivet backer tool



### **SAFETY:**

**WEAR PROTECTIVE CLOTHING, GLOVES AND EYEWEAR WHILE WORKING.**

**WORK ONLY IN PROPERLY VENTILATED AREA.**

**READ THE PAINT MANUFACTURER'S DIRECTIONS CAREFULLY PRIOR TO BEGINNING.**

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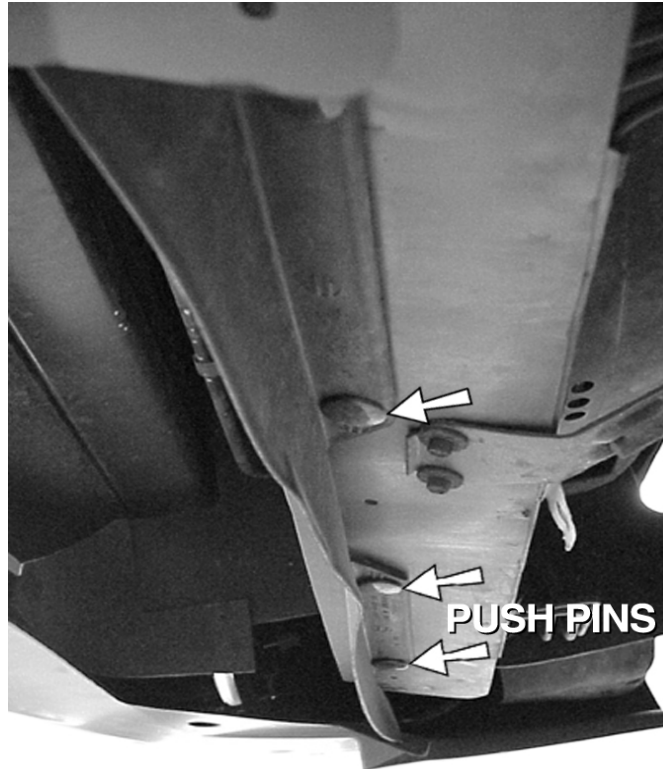


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**INSTALLATION INSTRUCTIONS:**

- STEP 1:** Raise front of vehicle and support properly to provide access to underside of the front end.
- STEP 2:** Remove original equipment air dam by removing push pins used for installation.

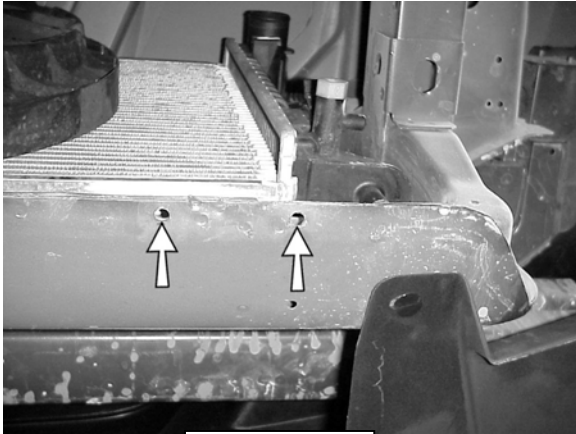


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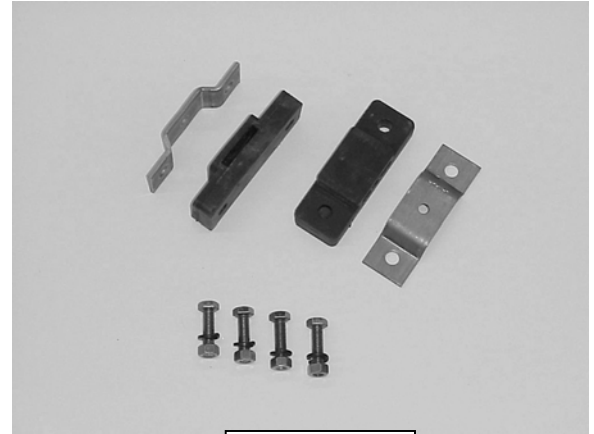
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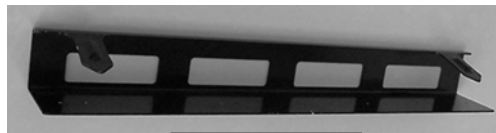
**STEP 3:** Drill the mounting holes for the "C" bracket's rubber mounts (see picture 3-1). Slide the rubber mounts (see picture 3-2) onto the "C" bracket (see picture 3-3) and center under the radiator support as shown (see picture 3-4). Mark the holes on the radiator support using the rubber mounts as a template and drill (4) 11/32" holes. Loosely mount the steel saddle bracket and rubber mount to the radiator support. Install the "C" bracket as shown.



Picture 3-1



Picture 3-2



Picture 3-3



Picture 3-4

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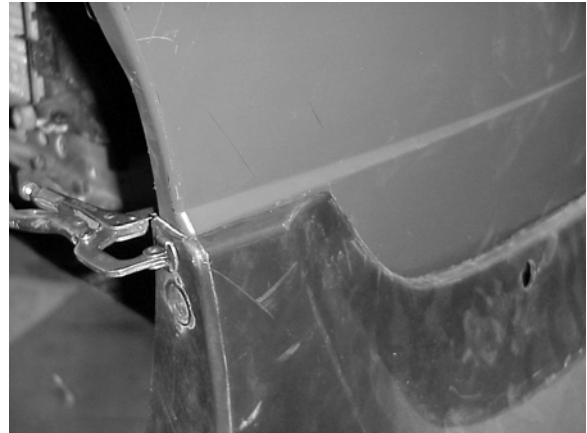


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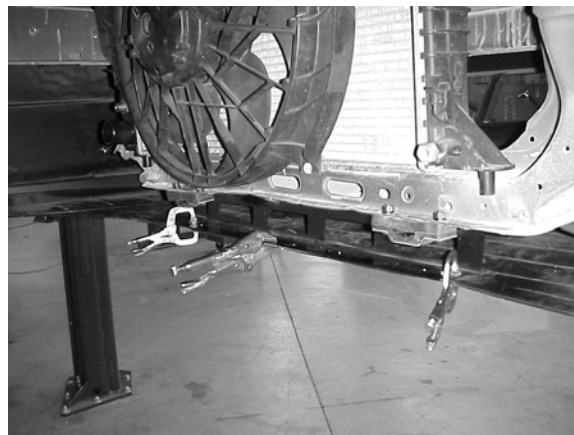
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**STEP 4:** Using suitable clamps like Vise Grip® model (4SP), clamp the air dam to the bumper cover and the "C" bracket in the installed position.

**STEP 5:** Using the air dam as a guide, scribe the locations for the (9) panel fastener holes onto the bumper cover. Remove the air dam with the "C" bracket installed. Drill (4) 1/8" rivet holes through the "C" bracket and the air dam. Leave the "C" bracket clamped in place for final test fit before painting



**STEP 6:** Using one of the panel fastener "S" springs as a guide, mark and drill the (18) 1/8" rivet holes in the bumper cover next to the (9) scribed panel fastener hole locations. These holes need to be drilled before the 11/16" holes. The holes should be in line with the rivet holes on the air dam. Using the 90° die grinder and the carbide burr, grind/drill the (9) 11/16" holes in the bumper cover.



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**STEP 7:** Install the (9) panel fastener “S” springs on the back side of the bumper cover using the 1/8" pop rivets. Mount the spring wires to hang approximately 1/8" below the back side of the bumper cover. Test fit the air dam to the bumper cover with the panel fasteners. **DO NOT** install pop rivets to retain the panel fasteners on the air dam until painting is complete (See picture 7-1).



Picture 7-1

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### PAINTING OVERVIEW:

The following directions make reference to painting supplies produced by PPG. Consult an automotive refinishing professional for comparable products if you choose to use products other than those listed.

### **WARNINGS:**

**DO NOT USE POWER SANDERS ON THE AIR DAM.** The heat generated by the sander can melt the urethane.

**DO NOT USE MINERAL SPIRITS OR LACQUER THINNER ON THE AIR DAM.** These products can take up to 1 week to completely evaporate and could cause the paint to lift.

### **SAFETY:**

- WEAR PROTECTIVE CLOTHING, GLOVES AND EYEWEAR WHILE WORKING.
- WORK ONLY IN PROPERLY VENTILATED AREA.
- READ THE PAINT MANUFACTURER'S DIRECTIONS CAREFULLY PRIOR TO BEGINNING.

THE FOLLOWING DIRECTIONS DO NOT LIST MIXING RATIOS OR DRYING TIMES DUE TO THE VARIABLES INVOLVED. CONSULT THE MANUFACTURER'S SPECIFICATIONS FOR INFORMATION AND PROPER USAGE INSTRUCTIONS.

### SURFACE PREPARATION AND PAINTING INSTRUCTIONS:

- Step 1:** Clean surface with soap and water to remove water soluble residue.
- Step 2:** Clean surface with Acryli-Clean<sup>®</sup> wax and grease remover PPG DX 330\*.
- Step 3:** Lightly scuff with 400-600 grit sandpaper or a gray/white Scotchbrite.
- Step 4:** Clean surface with Acryli-Clean<sup>®</sup> wax and grease remover PPG DX 330\* and then apply a fast evaporating cleaner PPG DX 220\*. Final wipe with PPG DX103 Multi-Prep<sup>™</sup>.
- Step 5:** Post-bake at 150 degrees for thirty minutes.
- Step 6:** Clean surface using gray Scotchbrite<sup>®</sup> with PPG DX 330\* and final wipe with PPG DX 103\*.
- Step 7:** Bake at 150 degrees for thirty minutes.
- Step 8:** Clean surface using gray Scotchbrite<sup>®</sup> with PPG DX 330\* and final wipe with PPG DX 103\*.

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- Step 9:** Apply Universal Plastics Adhesion Promoter PPG DPX801\*.
- Step 10:** Clean surface with Acryli-Clean<sup>®</sup> wax and grease remover PPG DX 330\*.
- Step 11:** Lightly sand the surface with 220 grit sand paper.
- Step 12:** Clean surface with Acryli-Clean<sup>®</sup> wax and grease remover PPG DX 330\* and then apply a fast evaporating cleaner PPG DX 220\*. Final wipe with PPG DX103 Multi-Prep<sup>™</sup>.
- Step 13:** Apply tinted sealer PPG K-93\*.  $\frac{K-93}{4}$   $\frac{DCC}{2}$   $\frac{DT}{2}$   $\frac{DCX8}{1}$ , one wet coat.
- Step 14:** Apply top coat PPG DCC4861F\* with flex agent.  $\frac{DCC}{4}$   $\frac{DT}{2}$   $\frac{DCX6}{1}$  10% DX 814\*. Three wet coats.
- Step 15:** Bake at 140 degrees for one hour.
- Step 16:** Polish to desired finish.

\* THESE ITEMS ARE PART OF A PPG PAINT SYSTEM THAT HAS BEEN SPECIALLY FORMULATED TO HAVE CERTAIN CHEMICAL PROPERTIES. IN ORDER FOR THEM TO ACHIEVE THOSE PROPERTIES IT IS IMPORTANT THAT THE MANUFACTURER'S SPECIFICATIONS BE FOLLOWED EXACTLY. (I.E. MIXTURES, APPLICATIONS, AND DRYING TIME.)

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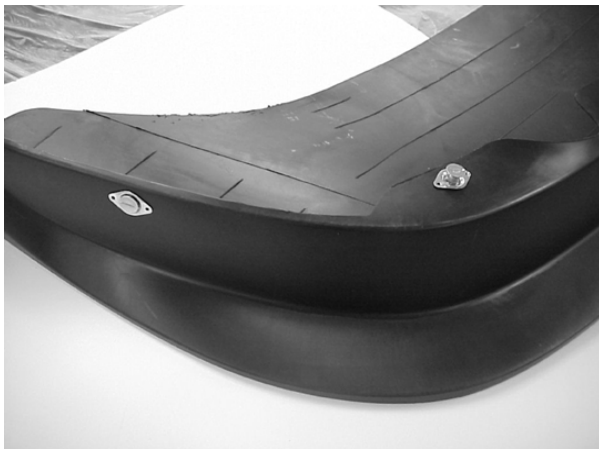
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**STEP 9:** Install the panel fasteners onto the air dam. This can be done with pop rivets supplied (STEP 9a) or with semi-hollow tubular rivets (STEP 9b).

**Note:** Step 9b requires the optional tools listed on page 1 and rivets not supplied.

**STEP 9a:** Using the pop rivets supplied, attach the panel fasteners to the outside of the painted air dam (See picture 9-1). Using a grinding disc in the 90° die grinder (See picture 9-2), grind the back side of the rivets flush with the back of the air dam (See picture 9-3). Use wet shop towels to cool the rivet during the grinding process.



Picture 9-1



Picture 9-2



Picture 9-3

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### STEP 9b: **Optional Installation Method:**

This is the way the production Cobra "R" air dams were installed, however, most body shops and auto mechanics do not have the special tools needed. If you want to purchase these rivets and tools, call Marshall Sales, Detroit, MI, 313-491-1700, [www.marshallsales.com](http://www.marshallsales.com). Using 1/8" diameter by 1/4" long stainless steel semi-hollow rivets (not supplied) attach the panel fasteners to the outside of the air dam (See picture 9-4). This will require the special riveting tools listed in the Optional Tools list on page 1.



Picture 9-4

**STEP 10:** Pop rivet metal "C" bracket to air dam (as positioned in STEP 5). Install air dam to the bumper cover with the panel fasteners.

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