06-08 Mercury Milan 4-Cyl

3dCARBON™

Installation Instructions

Rev. 05-08

QTY	3D PN.	FCS PART NUMBER	DESCRIPTION
1	691217	A6MIL-17B635-AAPLN	MILAN FRONT AIR DAM
1	691202	A6MIL-5410154-AAPLN	MILAN SIDE SKIRT RH
1	691203	A6MIL-5410155-AAPLN	MILAN SIDE SKIRT LH
1	691050	A6MIL-17E957-BAPLN	MILAN REAR LOWER SKIRT 4 CYL.
1	691223	A6MIL-5K238-BACHR	MILAN EXHAUST EXTENSION 4 CYL.
1	691207	A6MIL-5444210-AAPLN	MILAN ROOF SPOILER
1	N/A	N/A	3M PRIMER 94 ADHESION PROMOTER

HARDWARE SUPPLIED	
2	BRACKETS FRONT-AIR DAM
2	BRACKETS SIDE SKIRTS
2	BRACKETS REAR LOWER
2	10mm x ¾" COARSE THREAD SCREWS
33	FEET 3M 4218 TAPE
37	#8 X ¾" SELF DRILLING SCREWS

FRONT AIR DAM BRACKET -2- Req'd

SIDE SKIRT BRACKET -2- Req'd

REAR LOWER BRACKET -2- Req'd

TOOLS & MATERIALS REQUIRED

- ¼" Drive Socket Set with Metric Sockets
- Phillips Screw Tip
- 90 Degree Angle Screw Gun
- Clean Wiping Cloths
- Air or Electric Drill Motor 1/8" Drill Bit & 1/4" Drill Bit
- Lacquer Thinner
- Grinder – For Exhaust Extension installation only
- Welder – For Exhaust Extension installation only

CAUTION!!!! IF A HEATED SPRAY BOOTH IS USED FOR BAKING THE PRIMER OR PAINT. DO NOT BAKE OR CURE GREATHER THAN 120 F DEGREES FARENHEIT. THE SPOILER CAN BE DISTORTED AND PERMANENTLY DAMAGED.

PREPPING THE KIT PRIOR TO PAINT

The first step is to inspect the parts to make sure you have the correct parts. Refer to the part numbers on the back of the parts to confirm the Year – Make – Model. Parts that are Prepped and Painted cannot be returned or exchanged.

Using lacquer thinner and a clean cloth – clean the tape flange surface on the back of each part where the double sided tape will be applied. Using 1" masking tape apply the tape 1/8" below the top edge of the part. This will protect the tape flange from getting contaminated during the prepping and painting process.

Refer to Prepping and Painting Instructions for "Step by Step" procedures.

APPLYING THE 3M TAPE TO THE KIT

After the kit has been prepped and painted the double face tape should be applied to the parts. The tape is not pre-installed on parts prior to shipping because the tape can be contaminated during the sanding/ priming and painting process.

The first step is to clean the tape flange on the back of the parts where the tape will be applied. Make sure the complete tape flange is clean and free of all primer and paint. Using lacquer thinner on a clean rage thoroughly clean the tape flanges on the front air dam, side skirts and rear lower skirt and upper roof spoiler.

Using the adhesion promoter bottle with felt tip supplied, apply it to the tape flanges – be careful not press too hard causing too much to be applied. The adhesion promoter will leave a thin clear polymer primer film that will increase the bonding strength of the double face tape.

The tape should be applied 1/8" down from the top edge of the part so that it cannot be seen after the kit is installed. Start with the front air dam and apply the tape as shown in Image #1. The tape is to be applied from the wheel well to the center and on the underneath side of the center section. Press the tape firmly to the surface to insure good condition.

Repeat the cleaning and adhesion promoter steps on the side skirts and the rear lower skirt. Repeat the cleaning and adhesion promoter steps on the Upper rear roof spoiler.

INSTALLATION STEPS - FRONT AIR DAM

Step 1) Place the air dam on the front factory bumper and check the fit. The front center section should fit flush inside the opening on the bumper. The top edge of the air dam should parallel the body line on the factory bumper. Using a grease pencil, draw a line along the top edge of the part for reference during final installation.

Step 2) Remove the part from the car using lacquer thinner on a clean, lint-free cloth by wiping the paint surface where the tape will attach. Be careful not to remove the grease pencil marks. Using the adhesion promoter
supplied, apply the adhesion promoter to the paint surface where the tape will attach.

Step 3) Peel back a small piece of the red plastic backing from the tape, making a tail that can be pulled when the air dam is installed. (See Image #1). Place the air dam on the car positioning it using the grease pencil marks previously made as a reference. Starting with the center section, pull the red backing tail and press the air dam to the paint surface to ensure good adhesion of the double-face tape.

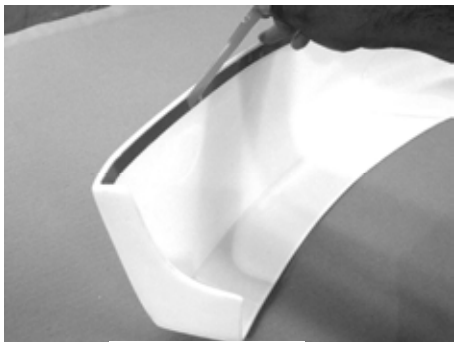

IMAGE #1

Step 4) Using the supplied #8 x ¾" self tapping screws, secure the air dam in the wheel wells through the pre-drilled holes in the air dam. Note there are (2) screws in each wheel well. Using a screw gun, secure the front air dam with (3) #8 x ¾" self tapping screws through the air dam into the bottom of the bumper. (See Image #2 & 3)

Step 5) Remove the (2) 7mm screws that secure the black plastic air deflector. Secure the bracket to the air dam through the pre-drilled hole with the #8 x ¾" Self Tapping Screws provided then secure the other end of the bracket with the previously removed 7mm screws.

IMAGE #2

INSTALLATION STEPS – SIDE SKIRTS

Step 1) Check the fit of the Milan side skirts on the car.

IMAGE #3

Step 2) Remove the part from the car and using lacquer thinner on a clean lint free cloth wipe the paint surface where the tape will attach. Using the 3M Primer 94 adhesion promoter supplied, apply the adhesion promoter to the paint surface where the tape will attach.

Step 3) Peel back a small piece of the red plastic backing from the tape making a tail that can be pulled when the side skirt is installed. (See Image #4).

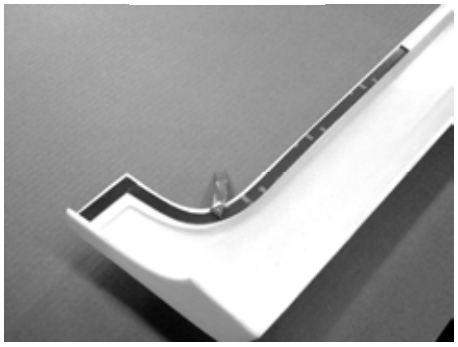

IMAGE #4

Step 4) Place the side skirt on the car positioning it using the bottom edge of the door sill as a reference line. Starting with either end, pull the red backing tail and press the side skirt to the paint surface to insure good adhesion.

Step 5) Using the supplied #8 x ¾" self taping screws secure the side skirt in the front wheel well through the pre-drilled holes in the side skirt.

Step 6) Place the supplied brackets behind the side skirt in the rear wheel well and secure it to the side skirt through the two pre-drilled holes in the side skirt with the two #8 x ¾" self taping screws. Secure the bracket to the inner fender well with two #8 x ¾" self taping screws. (See Image #5).

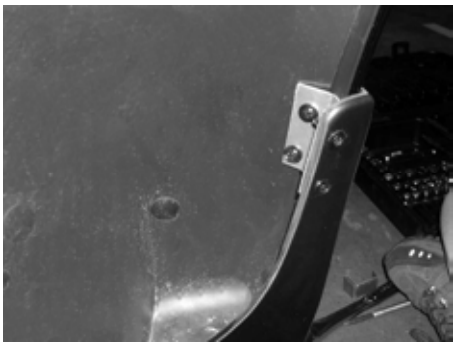

IMAGE #5

Note: Do not place this bracket between the plastic and the sheet metal. Position it as shown over the plastic wheel well

Step 7) Locate the (4) pre-drilled holes on the bottom of the side skirts and secure the side skirt to the bottom of the car with (4) #8 x ¾" screws provided on each side.

INSTALLATION STEPS – REAR LOWER

Step 1) Check the fit of the rear lower wrap on the rear factory bumper using the body line as a reference. Using a grease pencil, draw a line around the top edge of the part so that you have reference to line the part up during the final installation.

Step 2) Remove the part from the car. Using lacquer thinner on a clean cloth, wipe the paint surface where the tape will attach. Be careful not to remove the grease pencil marks. Using the adhesion promoter supplied, apply the adhesion promoter to the paint surface where the tape will attach.

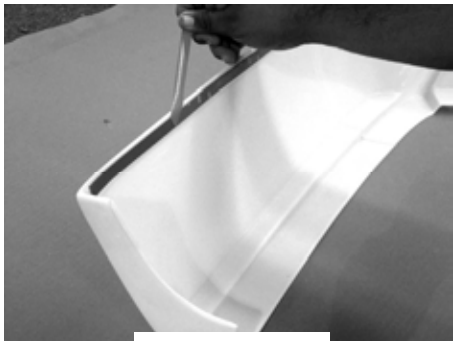

IMAGE #6

Step 3) Peel back a small piece of the red plastic backing from the tape, making a tail that can be pulled when the rear lower is installed. (See Image #6). Place the rear lower back on the car positioning it using the grease pencil marks as a reference. Starting with the either side – right or left – pull the red plastic tail and press the rear lower to the paint surface to ensure adhesion of the double-face tape.

IMAGE #7

Step 4) Using the supplied #8 x ¾" self taping screws supplied, secure the rear lower in the wheel wells through the (2) pre-drilled holes in each wheel well.

Step 5) Using a razor blade, locate and remove the tab that secures the rear bumper to the car. (See Image #7) .Place the supplied brackets inside the rear lower. (See Image #8) Line up the brackets with the two pre-drilled holes in the rear lower skirt. Secure the brackets to the rear lower with the (2) #8 x ¾" screws provided. Locate and remove the factory clip that secures the rear bumper to the reinforcement. Reinstall the factory clip through the bracket supplied to the rear reinforcement.

IMAGE #8

Step 6) Locate the (2) lower pre-drilled holes on the rear lower. Using the supplied 10mm x ¾" coarse thread screws, secure the rear lower wrap. Be sure not to over-tighten the screws, as they may strip.

INSTALLATION STEPS –UPPER GLASS SPOILER

Step 1) Check the fit of the upper glass spoiler on the rear glass. Using a grease pencil, draw a line along the bottom edge of the part and make a couple has marks on the glass and the spoiler so that you have a reference to line the part up during the final installation.

Step 2) Remove the part from the car. Using glass cleaner, clean the glass where the spoiler will attach. Using lacquer thinner on a clean cloth, wipe the glass surface where the tape will attach. Be careful not to remove the grease pencil marks. Using the adhesion promoter supplied, apply the adhesion promoter to the glass surface where the tape will attach.

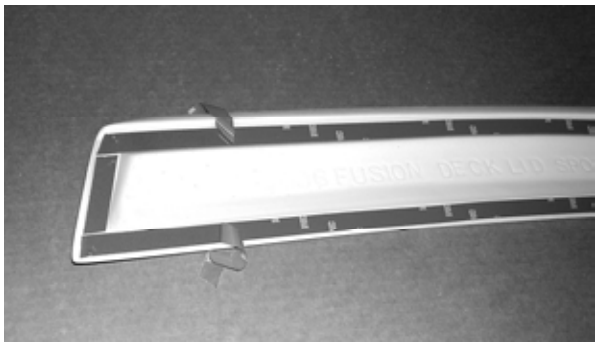

IMAGE #9

Step 3) Peel back a small piece of the red plastic backing from the tape, making a tail that can be pulled when the rear spoiler is installed. (See Image #9). Place the rear spoiler back on the car, positioning it using the grease pencil marks as a reference. Starting with the either side- right or left – pull the red plastic tail and press the rear spoiler to the glass surface to ensure adhesion of the double-face tape.

INSTALLATION STEPS – EXHAUST EXTENSIONS

Step 1) If the Milan has factory supplied chrome dual exhaust extensions, remove them by cutting the spot welds with a grinder wheel and reposition them ¾" out past the rear lower or replace them with the 3dCarbon Optional Exhaust Extensions.

Step 2) Slide the chrome exhaust extension over the factory exhaust pipe. Position it ¾" out past the rear lower skirt so the hot exhaust gases can exit without damaging the paint.

Step 3) Using a welder tack, weld the new tip on the top and the bottom.