



2005 FOCUS



AFTERMARKET BODY KIT INSTALLATION MANUAL

2005 2.0-liter Ford Focus

SALEEN

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***IF YOU ARE NOT EXPERIENCED IN THE
AREA OF AUTOMOTIVE MECHANICS, WE
STRONGLY URGE THAT YOU REFER THIS
INSTALLATION TO A CERTIFIED INSTALLER
OR TECHNICIAN***



Saleen Speedlab 2005 Focus Body Kit Installation Guide for 2005 Ford Focus

Thank you for buying the Saleen 2005 Focus Body Kit for the 2005 Ford Focus. We appreciate your business, and we hope you enjoy your product.

For your benefit, please read the following instructions completely and thoroughly before attempting to install the body kit. Many questions we have received from customers about the installation of our products could have been easily solved by information listed in the accompanying installation guide. We want you to enjoy the product in its fully functional state, and reading this tutorial is a great first step to getting you on your way to a more rare and powerful Focus.

Again, thank you for choosing Saleen!

I Front Fascia Removal

Obtain the following tools:

- 1/4" drive air ratchet
- 7mm socket, 1/4" drive
- 4" extension, 1/4" drive
- 8" extension, 1/4" drive
- "drill fitting?" (for Torx bit...)
- T30 Torx bit
- Pick
- Small flat head screwdriver

1. Using the pick, remove the three plastic screws holding the front shroud in place.
2. Using the 1/4" drive air ratchet and the 7 mm socket, remove the center 4 of the six bolts located underneath the front lip of the fascia. (Figure 2)
3. With a pick, remove all 5 plastic screws from the shroud underneath and behind the fascia. (2 screws indicated in Figure 1)
4. Use the pick to remove the two plastic screws on top of the fascia, one on either side of the hood latch.
5. Turn the steering wheel all the way clockwise. Using the 1/4" drive air ratchet and 7 mm socket, remove the one bolt from the driver side wheel well (middle arrow in Figure 3). Repeat on passenger side with steering wheel turned fully counterclockwise.



FIGURE 1



FIGURE 2



FIGURE 3

6. Remove the remaining two bolts from the lower shroud (outer arrows in Figure 2) using the 7 mm socket and ratchet, and pull out the lower shroud from the fascia.
7. Use the pick to remove the two plastic screws from the front of the wheel well liner (Figure 3) and three plastic screws from the inboard side of the wheel well liner (one indicated in Figure 4), and remove the wheel well liner from each side.
8. With the ¼" drive air ratchet, the 4" extension and the 8" extension (or one 12" extension) and the 7 mm socket, remove the three bolts going up through the inside/top of the fascia in front of each wheel well. (Figure 5)
9. Disconnect each turn signal electrical connector from the front fascia harness by hand. Pull the fascia forward just enough to clear the bumper and set it on the ground. (Figure 6)
10. Using the small flat head screwdriver, carefully pry the electrical connector for each fog light loose from the front fascia harness. (Figure 7)



FIGURE 4

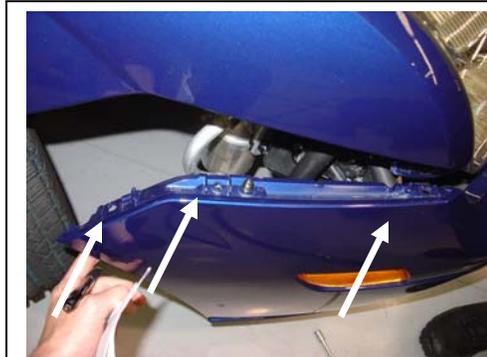


FIGURE 5

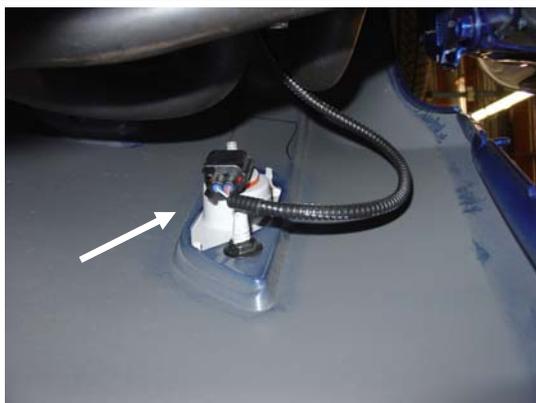


FIGURE 6



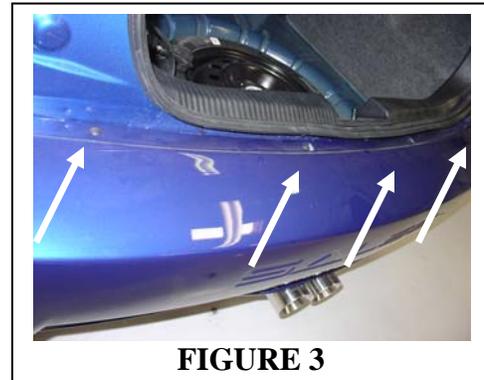
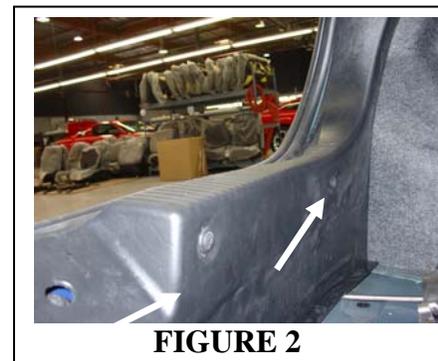
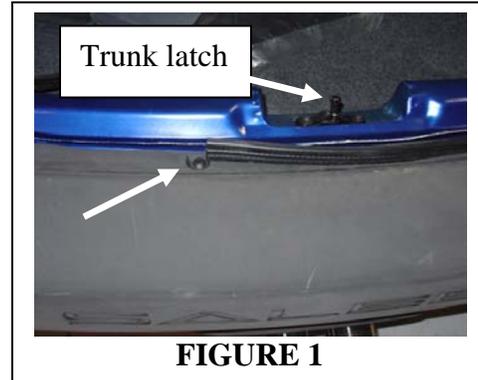
FIGURE 7

IV Rear Fascia Removal

Obtain the following tools:

- 1/4" drive air ratchet
- 7 mm socket???, 1/4" drive
- 8" extension, 1/4" drive
- 4" extension, 1/4" drive
- Pick

1. Disconnect two ends of weather stripping at the bottom of the trunk doorway, on the driver side of the trunk latch, and pull stripping away from bottom of trunk doorway. (Figure 1)
2. Using the pick, remove the four plastic screws from the inside of the vertical plastic trunk liner that is attached to the rear wall of the trunk. The two screws on the driver side of the trunk are indicated in Figure 2.
3. Remove the liner.
4. Using the pick, remove four plastic screws from top of rear fascia (Figure 3).
5. Using the pick, remove the plastic plugs from the back of the wheel well liner, and pull the back of the liner out of the way to access the cavity inside the rear fascia.
6. Using the 7 mm socket and the 4" and 8" extensions together on the 1/4" drive air ratchet, remove the two bolts going up through the inside upper lip of the fascia into the body; these are located in the cavity inside the fascia, behind the rear of the wheel well liner. The locations of bolts on the rear fascia are indicated in Figure 4.
7. Repeat steps 4 and 5 on both sides of the car.
8. Remove the wiring harness connectors and pull the fascia off the car.



IV Front Bumper Brace Installation

Part Number	Description	Qty.
05-1101-C08133	Front Bumper Brace Rh	1
05-1101-C08134	Front Bumper Brace Lh	1
00-9011-C08254*	Screw Front Bumper Brace	2

Obtain the following tools:

- Socket
- Impact gun
- Drill
- Philips #2 bit

1. Remove the front power steering cooler retaining screws. See Figure 1.
2. Place the front bumper brace "LH" on the drivers side, and front bumper brace "RH" on the passenger side. The braces go in between the bumper beam and the plastic holder. Re-install the bolts. Orient the braces so they are perpendicular to the radiator, and so that they protrude away from the radiator.
3. Tighten the two bolts.

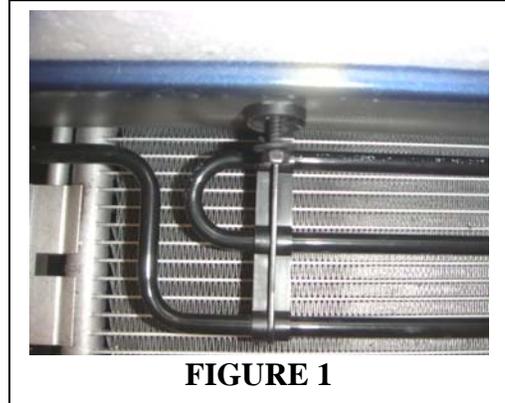


FIGURE 1



FIGURE 2

FIGURE 3

V Front Fascia Screens Installation

Part Number	Description	Qty.
05-1102-C08458	Body Screen Front Gills	2
05-1102-C08454	Body Screen 3 X 5	2
05-1102-C08459	Body Screen Front 2.5 X 5	2
05-1102-C08460	Body Screen Front 12.75 X 5.25	2
039-215	Screen Screws	24

Obtain the following tools:

- Drill
- Philips #2 bit

1. Place screens over appropriate openings and screw body screws into provided bosses in fascia.
2. Do not install bottom screws on 12.75x5.25 screens. This is where the front bumper braces get screwed in using part number 00-9011-C08254*.



FIGURE 1

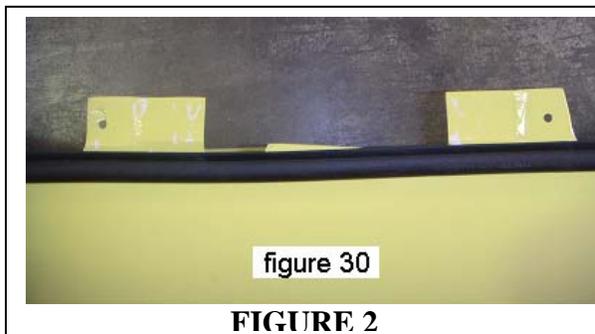
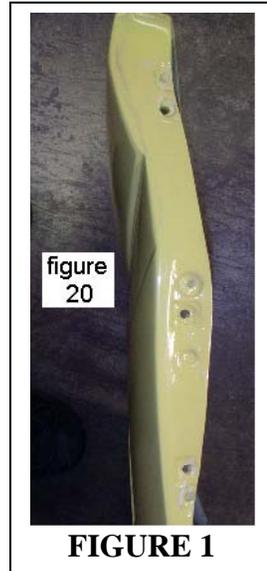
V Front Fascia Installation

Part Number	Description	Qty.
05-1101-C08180		
00-1105-C00234*		

Obtain the following tools:

- Socket
- Impact gun

1. Drill 6 holes with a 1/4" drill bit as shown. (3 on the left, 3 on the right, hole pattern is the same on either side) (Figure 1)
2. Drill two 1/4" holes in the top center as shown. (Figure 2)
3. Install weather-stripping (W.S.) onto top of front fascia. (Figure 3)
 - W.S. should start and finish with a clean line cut with a pair of sharp scissors
 - The W.S. should be applied so that the small rubber flap is pointing towards the upper rear of the car.
 - Apply W.S. at the corner where the headlight starts, approx. 1/2" away from the radius' edge (you may trim off any excess weather stripping, but it's not necessary)
4. Once past the headlight region, increase the distance from the W.S. to the radius' edge to 1", so that the back edge of the W.S. is flush with the bumper.
5. Install front fascia using stock hardware and attachment methods. Attach to bumper braces?....



V Rear Fascia Closeout Panel Installation (for '04 Focus only)

Part Number	Description	Qty.
05-1104-C08303		1
00-9006-C08351		2

Obtain the following tools:

- Socket
- Impact gun

1. There will be two close out panels for each car. There will be two rivets and one Christmas tree for each close out panel. Figure (1).
2. Tape the top and bottom of the close out panel. Place the close out panel on the fender so that it is not sticking out past the fender and line up the hole for the Christmas tree. see Figure (2)
3. Bend the close out panel to fit the contour of the fender. Mark the hole locations for the rivets: see Figure (2)
4. Drill out the hole. Remove the tape.
5. Place the close out panel behind the rear fender and rivet it to the fender: see Figure (3)
6. Place the cloth behind the close out panel and in front of the plastic black bracket. Line up the hole in the cloth with the plastic bracket and insert the Christmas tree into hole indicated by arrow in Figure 3.



FIGURE 1



FIGURE 2



FIGURE 3

V Fender Flares Subassembly

Part Number	Description	Qty.
3M Double sided tape		
Fender flares (4 unique)		

Obtain the following tools:

- Dremel
- 80 grit tip for Dremel
- 3M Automotive adhesion promoter
- Paint thinner

1. Sand inside of upper rim of each fender flare with the Dremel tool and 80 grit tip/head. Sand these areas well; failure to do so may cause the parts to fall off. (Figures 1, 2)
2. Clean sanded area with paint thinner.
3. Apply adhesive promoter to sanded area
4. Apply tape to sanded area. Do not allow tape to go over the lip of the "B" side; the tape should not be visible when the flare is installed. (Figure 3)



FIGURE 1



FIGURE 2



FIGURE 3

VI Rocker Panels Installation

Part Number	Description	Qty.
05-1102-C08178A		
05-1102-C08179A		
00-9006-C04974*		
00-9006-C08519*		
00-9006-C09103*		
069-311		

Obtain the following tools:

- Socket
- Impact gun

1. Sand, scuff, and clean with acetone the inside of the side skirt where indicated. (Figure 1)
2. Apply adhesion promoter to prepared surface, and mating surface on car. (let promoter cure for at least 1 min) (Figure 1)
3. Apply double sided tape to prepared surface. (Figure 1)
4. Stick side skirt to car so that the inside of the side skirt butts up tight against the inside of the door sill.



FIGURE 1

5. Drill 3/16" hole 8 places (4 left 4 right) using the Drill Jigs PN 05-3102-C09101A, & 05-3102-C09102A. See figure 60 for reference locations.
6. Use 8, PN 00-9006-C04974*, rivets through the skirt sill holes.
7. Drill and squeeze 10 rivets, PN 00-9006-C09103*, (5 per side) spaced along the bottom of the side skirt and through the pinch weld at locations shown on figure 80.

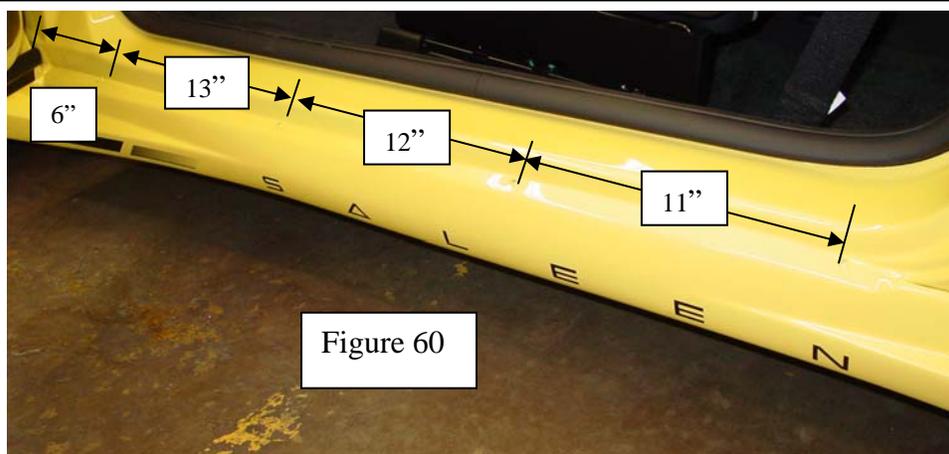


FIGURE 2

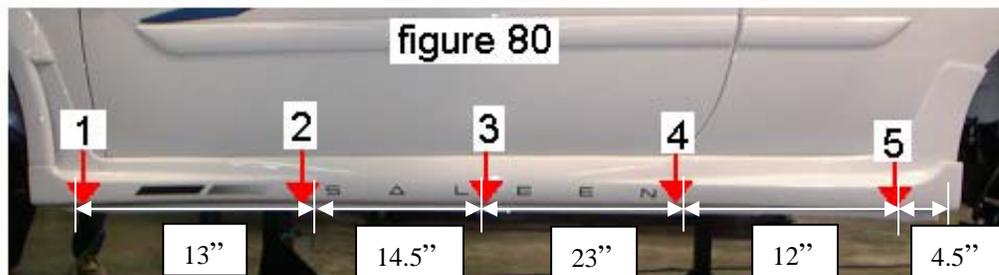


FIGURE 3

VI Rear Bumper Foam Modification (for '00 -'04 Focus only)

Part Number	Description	Qty.
05-1101-C08354	Rear Bumper Foam	

Obtain the following tools:

- Hot glue gun, hot glue sticks
- Saws-all

1. Using the saws-all cut the top of the stock bumper foam off. Use the metal bumper beam as a guide. Cut straight off.
2. Place a bead of hot glue on the stock bumper foam top. The newly cut section will lay on top of it. Place the foam so that the cut outs line up with the bumper beam bracket studs, and is pushed all the way against the sheet metal. Figure 3 shows the bottom side of the foam.
3. Quickly place the rear bumper foam on top of the stock bumper and let glue dry.



FIGURE 1



FIGURE 3



FIGURE 2

VI Rear Fascia Subassembly

Part Number	Description	Qty.
05-1102-C08454	Body Screen 3 X 5	2
05-1102-C08456	Body Screen Rear 5.25 X 4	2
05-1102-C08455	Body Screen Rear 12.75 X 4	2
039-215	Screen Screws	24
00-9006-C08351*	Rivet 3/16"DIA .376-.500" Al/Al	4

Obtain the following tools:

- Drill
- 1/8" bit
-

1. Place screens over appropriate openings and screw body screws into provided bosses in fascia.
2. Drill holes in locations shown

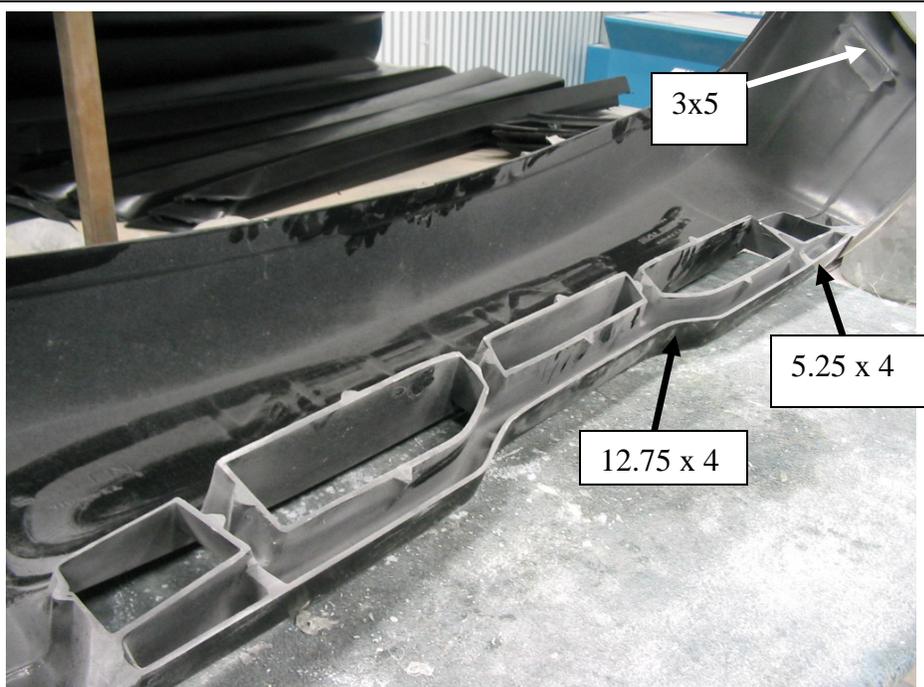


FIGURE 1

2. Drill 1/8" pilot holes in locations shown in Figure 2. Open up holes to 3/16".
3. Obtain the two rear fascia side brackets from the stock rear fascia.
4. Rivet the brackets into place with two rivets (00-9006-C08351*).

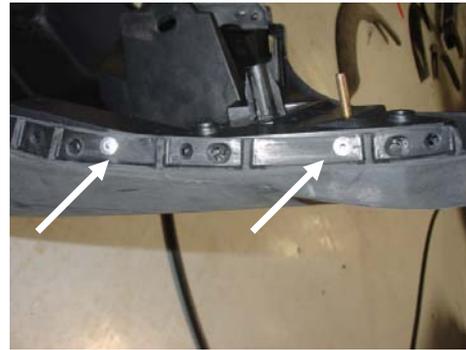


FIGURE 2



FIGURE 3

VIII Rear Fascia Installation

Part Number	Description	Qty.
05-1102-C08181		

Obtain the following tools:

- Drill
- 1/8" bit
- 7/16" bit

1. Notch top of fascia to clear metal tab on focus metal bumper. (Notch should be 1.5" wide by 1" deep. *Approx.*)
2. Notch bottom of fascia to clear rear most exhaust hanger. (Notch should be 6" wide by 1" deep. *Approx.*)



FIGURE 1

3. Drill 1/8" pilot hole, then open up to 7/16", on inside flange of fascia. (left and right sides are identical) Hole should be 3/4" forward and 3/4" down from where the triangle flange meets the top of the fascia.

NOTE: If you are installing other Saleen kits, the exhaust should be installed before the rear fascia is put on.

4. Install rear fascia using stock hardware and attachment methods.

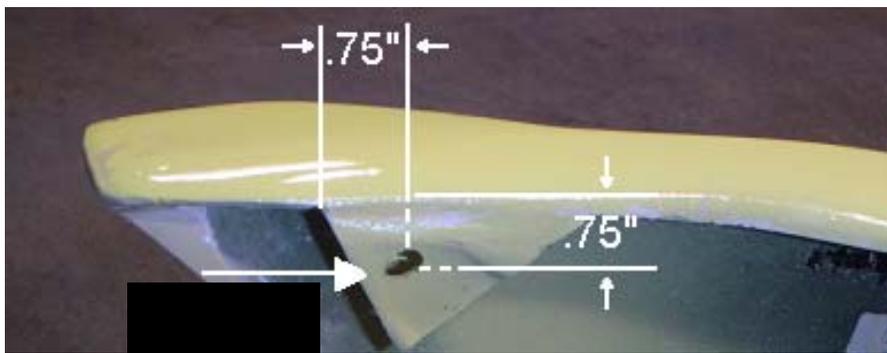


FIGURE 2

V Fender Flares Subassembly

Part Number	Description	Qty.
3M Double sided tape		
Fender flares (4 unique)		

Obtain the following tools:

- Dremel
- 80 grit tip for Dremel
- 3M Automotive adhesion promoter
- Paint thinner

5. Sand inside of upper rim of each fender flare with the Dremel tool and 80 grit tip/head. Sand these areas well; failure to do so may cause the parts to fall off. (Figure 1)
6. Clean sanded area with paint thinner.
7. Apply adhesive promoter to sanded area
8. Apply tape to sanded area. Do not allow tape to go over the lip of the "B" side; the tape should not be visible when the flare is installed. (Figure 2)



FIGURE 1



FIGURE 2

VI Fender Flares Installation

Part Number	Description	Qty.
05-1102-C08182A		
05-1102-C08183A		
05-1102-C08184A		
05-1102-C08185A		
00-9001-C06884*		
00-9004-C00172*		
00-9006-C08519*		

Obtain the following tools:

- Hot glue gun, hot glue sticks
- Saws-all

NOTE: Front left fender flare is shown in pictures, procedure for all four corners are the same.

1. Using the appropriate flare drill jig, securely place it into position. (FIGURE 1)
2. Drill an 1/8th hole through all three drill guides and into the fender. (*Using high speed and low pressure*) (FIGURE 2)

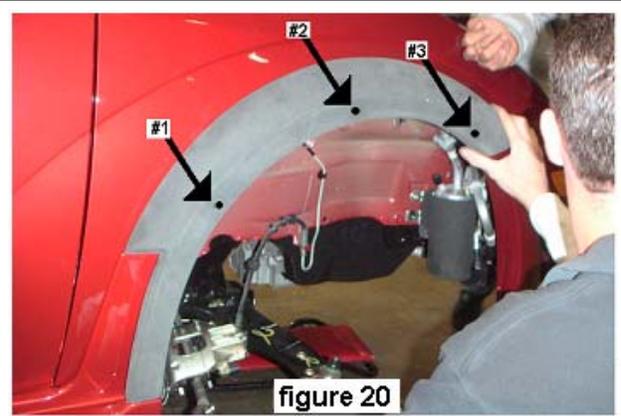


FIGURE 1



FIGURE 2

3. Re-Drill the holes to 3/16" and again to 1/4" (this insures that fender is not dented while drilling.)
4. Sand, scuff, and clean with acetone the inside of the fender flare where tape is shown in Figure 3.
5. Apply adhesion promoter to prepared surface, and mating surface on car. (let promoter cure for at least 1 min)
6. Apply double sided tape to prepared surface, leaving extra backing sticking out so that one can remove it once the bolts have been started through the fender and into the flare. (FIGURE 3)
7. Apply a small bead of black silicone on edge of drilled holes in fender. (To help seal unpainted surface from rusting.)
8. Prepare all 3 bolts with a small dab of red loc-tite and a washer. (FIGURE 4)
9. Start all three bolts with only one or two threads.
10. Remove the double sided tape backing and stick the flare.
11. Tighten the bolts until just snug. (Caution: do not over tighten as this may damage the flare.)

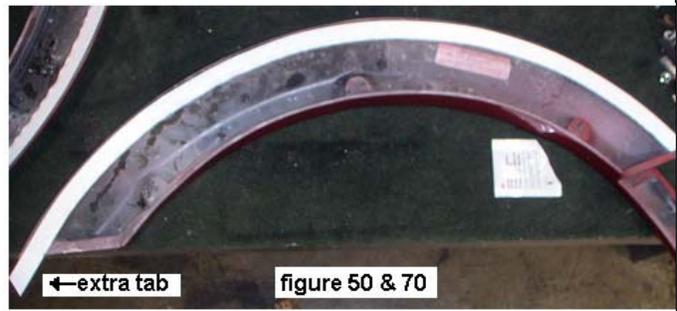


FIGURE 3

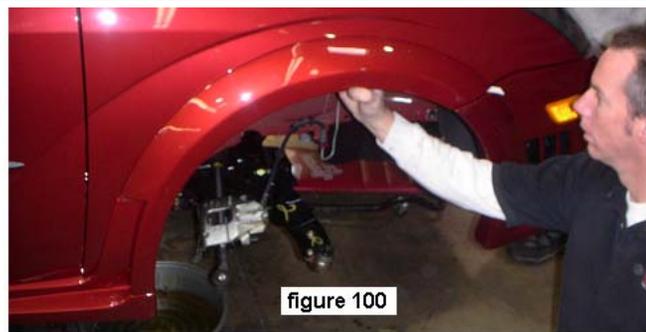


FIGURE 4

X Hood Scoop Installation

Part Number	Description	Qty.
05-1106-C08352		
05-1106-C08353		
00-9001-C01180*		
069-310		
00-9004-C00172*		
00-9006-C08159*		
05-3101-C08626		

Obtain the following tools:

- Hot glue gun, hot glue sticks
- Saws-all

20. Prepare insert by grinding where necessary to insure proper mating with hood scoop.

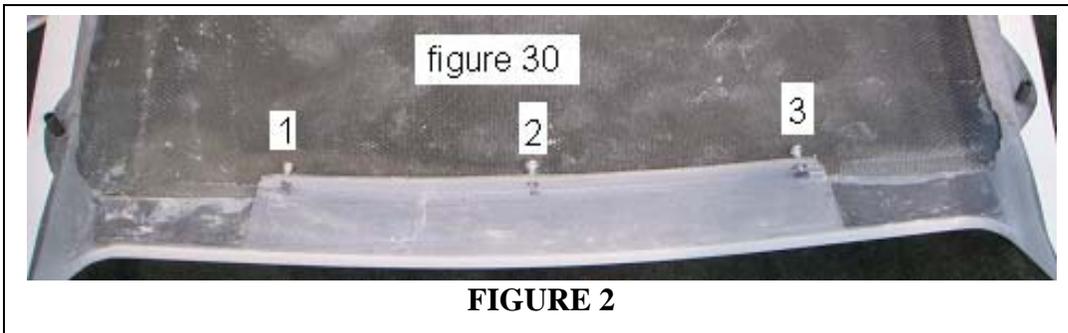
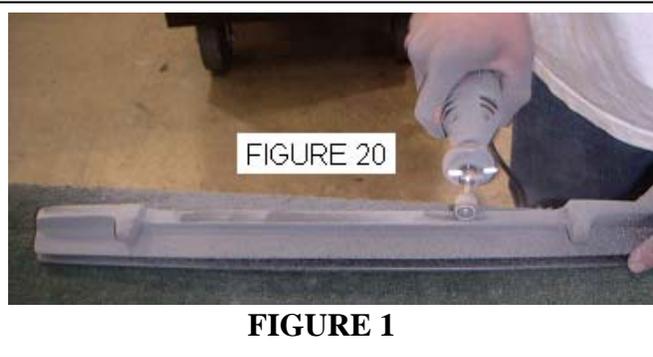
30. Using 3 phillips head self tapping screws, fasten insert to hood scoop where indicated in figure 30.

40. Sand, scuff, and clean with acetone the underside of the scoop where indicated. (+)

Also prepare and apply tape to hood mating surface of the insert as well.

50. Apply adhesion promoter to prepared surface. (let promoter cure for at least 1 min)

60. Apply double sided tape to prepared surface.



6. Adhere 2" masking tape to hood where holes are to be drilled.
7. Locate drill jig securely on hood by placing between creases and in front of the windshield washer sprayers.
8. Drill 1/8" hole 5 places using light pressure and high speed on the drill.
9. Remove fixture and re-drill holes with a 3/16" drill bit, and then again with a 1/4" drill bit.
10. Remove masking tape and clean surface of hood with windex. Then apply promoter where scoop will mate.
11. Partially remove a small segment of tape backing each piece of tape on the scoop. Then place the scoop on the hood. (this is so you can still move the scoop around w/out it sticking)
12. Start each bolt so that only 1 or 2 threads engage into scoop. (be sure to use a blue Loctite on every bolt.)
13. Remove the remainder of the tape backing and firmly press scoop to hood.
14. Tighten all bolts until snug.



FIGURE 3

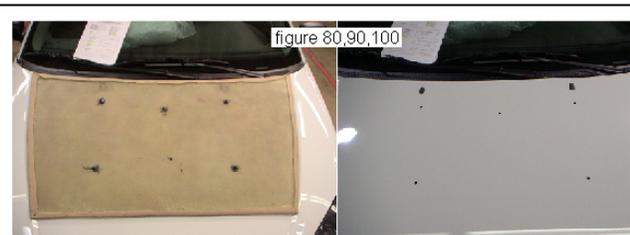


FIGURE 4



FIGURE 5