

# Original BMW Accessories.

## Installation Instructions.



### M Performance Aerodynamics Package Retrofit Kit.

**BMW 4 Series Coupé (F32)**

**BMW 4 Series Convertible (F33)**

**BMW 4 Series Gran Coupé (F36)**

#### Retrofit kit number

Single-sided Twin-pipe	Twin-sided Single-pipe	Component designation	Type	Installation time (h)
51 19 2 334 543	51 19 2 339 218	Rear diffuser, matt black	F32/F33/F36	0.25
51 19 2 334 548		Carbon front add-on section	F32/F36	1.00
51 19 2 408 993		Carbon front add-on section	F32/F36	1.00
51 19 2 348 911		Side skirt film	F32/F33/F36	0.75
51 62 2 334 545		Carbon rear spoiler	F32	0.75
51 62 2 407 543		Carbon rear spoiler	F36	0.75
51 19 2 354 500		Matt black rear spoiler	F32	0.75
51 19 2 361 679		Matt black left side skirt add-on section	F32/F33/F36	0.50
51 19 2 361 680		Matt black right side skirt add-on section	F32/F33/F36	0.50

#### Installation time

Installation time see table. This may vary depending on the condition of the vehicle and the equipment in it. The installation time shown does not include any time spent on programming/coding.

The calculation of the total costs for the programming time must be factored into the calculation of retrofitting costs (no invoicing via warranty).

#### Important information

These installation instructions are primarily designed for use within the BMW dealership organisation and by authorised BMW service companies.

These installation instructions are intended for use by qualified specialist staff trained on BMW vehicles with the relevant expert knowledge.

All work must be completed using the latest BMW repair manuals, wiring diagrams, servicing manuals and work instructions, in a rational order, using the prescribed tools (special tools) and observing current health and safety regulations.

**If you experience installation or function problems, restrict troubleshooting to approx. 0.5 hours for mechanical work and 1.0 hour for electrical work.**

To avoid unnecessary extra work and/or costs, send an inquiry straight away to the technical parts support team via the Aftersales Assistance Portal (ASAP).

Quote the following information:

- Chassis number,
- Retrofit kit part number,
- A detailed description of the problem,
- Any work already carried out.

Do not archive the hard copy of these installation instructions since daily updates are provided via ASAP.

## Pictograms



Denotes instructions that draw your attention to dangers.



Denotes instructions that draw your attention to special features.

- ◀ Denotes the end of the instruction or other text.

## Installation information

- All contact/bonding surfaces on the components being installed must be absolutely dry, clean, and free of wax, silicon and grease. These surfaces must be treated with suitable BMW cleaner or BMW primer (see EPC for details), as set out in the appropriate product application instructions
- If you use adhesive tape, it must be applied using a contact pressure of between 10 N/cm<sup>2</sup> and 50 N/cm<sup>2</sup>
- Take care not to damage the parts when opening the packaging
- Check that all the parts fit accurately on the car before fitting them
- All affected components and their bonding surfaces must be at room temperature for installation. The ideal relative humidity is 50%. Different values will change the specified times
- After completing the gluing and installation work, the car must remain stationary at room temperature for at least 12 hours
- If adhesives are used the car may be driven after 24 hours, and may be taken through a car wash after 48 hours. The car must not be driven above a speed of  $v_{\max} < 100 \text{ km/h}$  for 24-48 hours
- The installed parts may become loose and fly off the car if you fail to wait for the full reaction time of the primer/adhesive. Danger of accidents!
- Some of the installation steps are shown only on one side of the car. Proceed in the same way on the other side of the car.
- All pictures show LHD cars; proceed accordingly on RHD cars



If an M Performance rear spoiler is to be installed, any rear spoiler already in place must be removed / dismantled as per ISTA. ◀

## Painting instructions

Check that all the parts fit accurately on the car before painting them. Primed parts must be pre-treated accordingly before painting.

To ensure correct painting, the EBA must be provided to the painter.

The BMW painting instructions must be observed (see ISTA No. 99 00 ...).

## Ordering instructions

The material such as liquid adhesive, cleaner and activators are assigned to the relevant products in the EPC (see EPC for instructions and part numbers). If the EPC does not explicitly specify the materials, always use cleaner, adhesive and activator from the BMW product range.

When the carbon front add-on section is installed on cars of a light colour, a black paint pen is also required.

## Recommended special tools

None

## Information to be provided to the customer



Once the carbon front add-on section has been installed, the ramp angle and floor clearance are reduced. ◀



The carbon front add-on section may only be installed in conjunction with the rear spoiler (for part number and instructions, see EPC). ◀

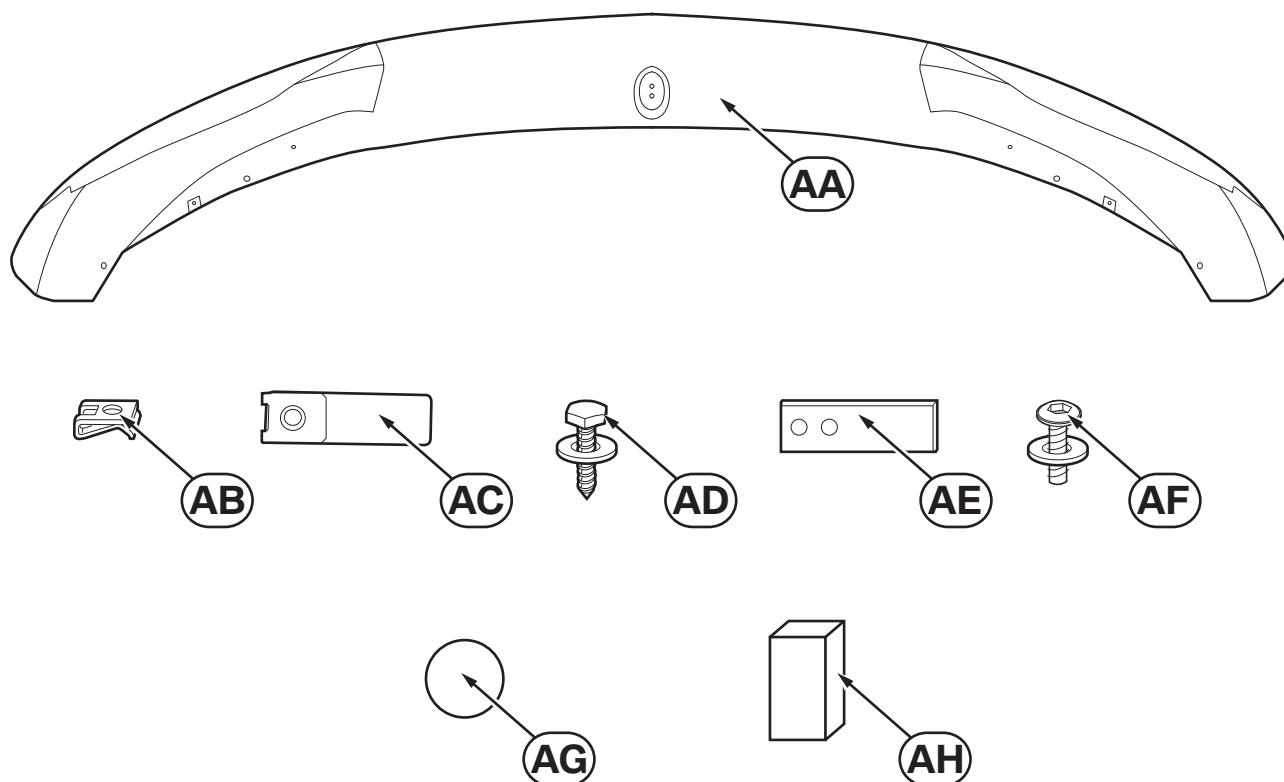


The carbon front add-on section reduces the car's floor clearance and reduces the overhang angle at the front. The carbon front add-on section must be checked at regular intervals for damage caused by collisions and, in the event of any such damage, replaced by trained specialist personnel. ◀

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## 1. Carbon front add-on section parts list only for part number 51 19 2 334 548 (F32/F36)

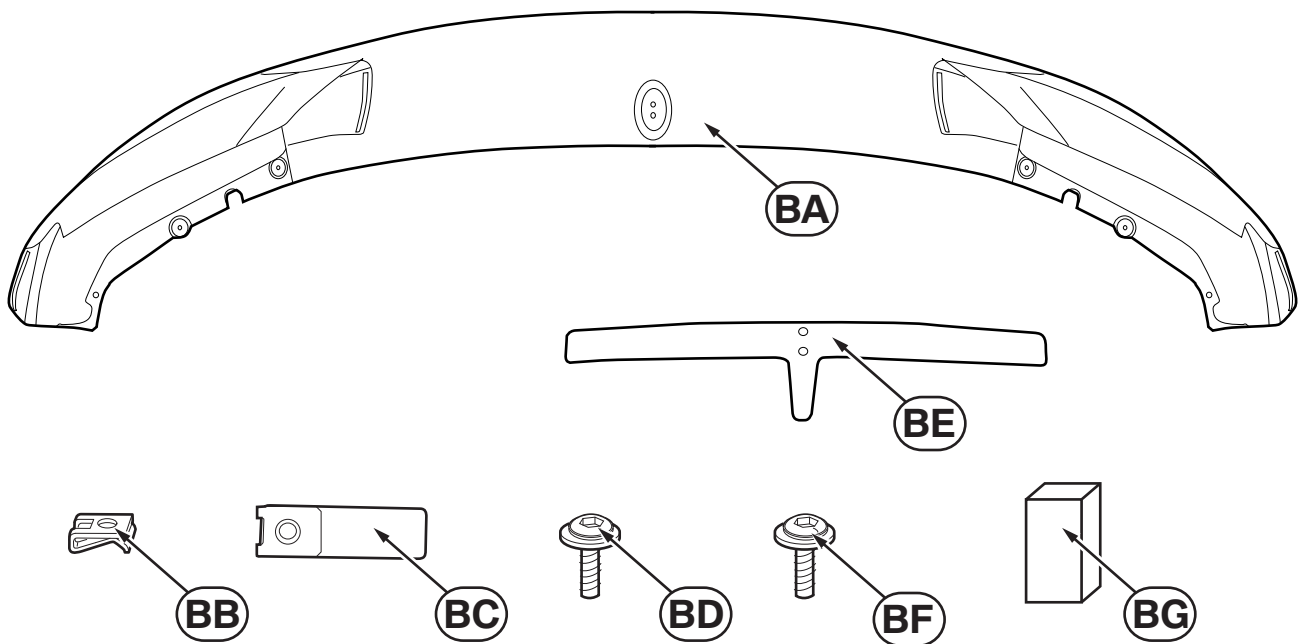


F32 0063 V

### Legend

- AA** Carbon front add-on section
- AB** C-clip (2 x)
- AC** Installation plate incl. C-clip (2 x)
- AD** Hexagon screw incl. washer (6 x)
- AE** Installation plate
- AF** Oval-headed screw incl. washer (2 x)
- AG** Cover cap (2 x)
- AH** Liquid adhesive (not included in kit, see EPC for details)

## 2. Carbon front add-on section parts list only for part number 51 19 2 408 993 (F32/F36)

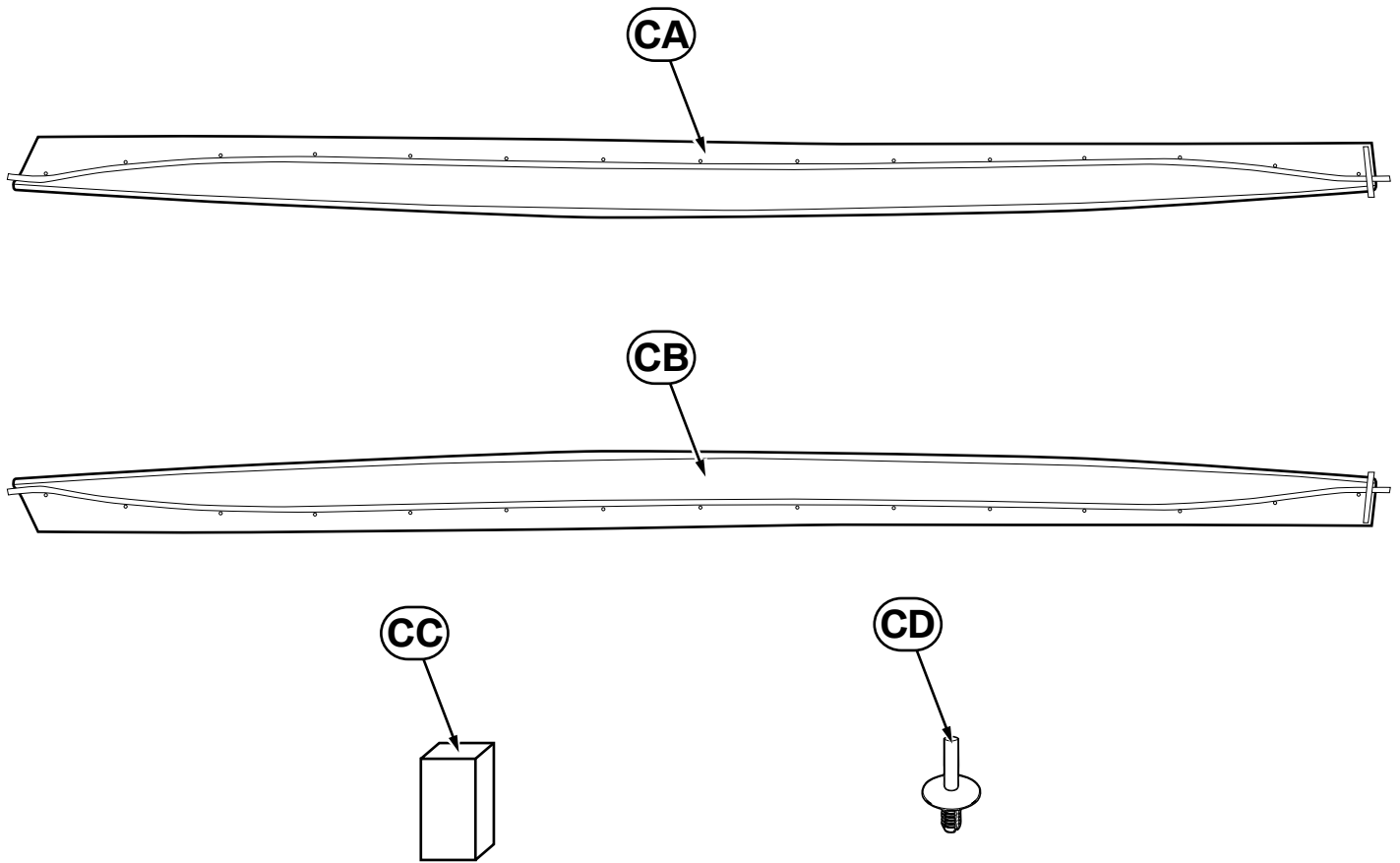


F32 0064 V

### Legend

- BA** Carbon front add-on section
- BB** C-clip (4 x)
- BC** Installation plate incl. C-clip (4 x)
- BD** Oval-headed screw incl. washer M5 (4 x)
- BE** Installation plate
- BF** Oval-headed screw incl. washer M6 (2 x)
- BG** Liquid adhesive (not included in kit, see EPC for details)

### 3. Matt black side skirt add-on section parts list (F32/F33/F36)

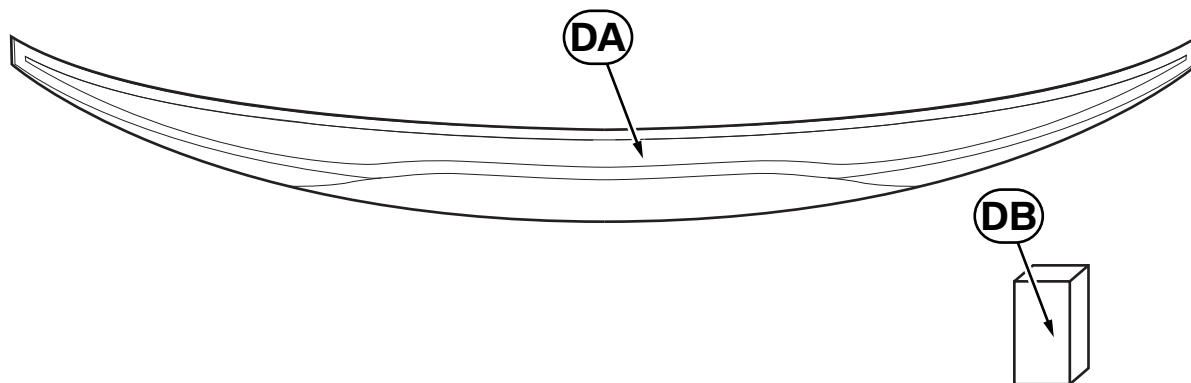


F82 0168 V

#### Legend

- CA** Matt black right side skirt add-on section
- CB** Matt black left side skirt add-on section
- CC** Liquid adhesive (not included in kit, see EPC for details)
- CD** Expanding rivet (15 x per side)

#### 4. Carbon rear spoiler parts list (F32)



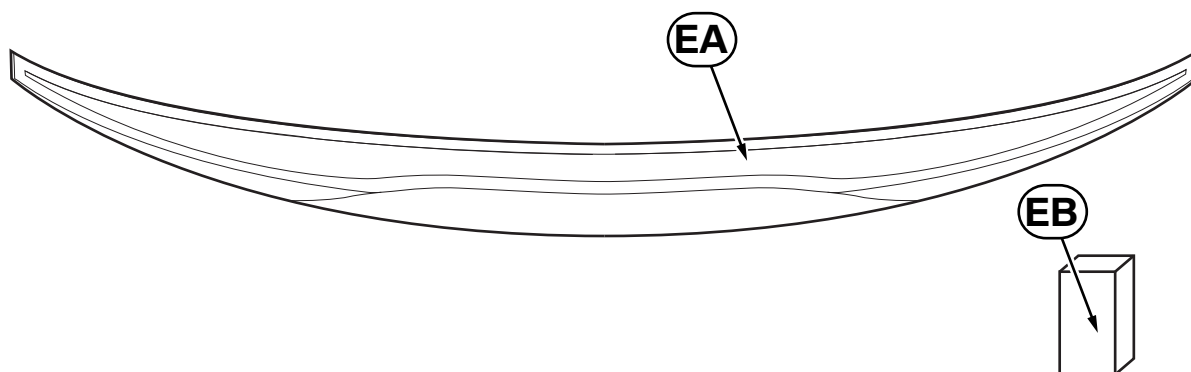
F32 0065 V

#### Legend

- DA** Rear spoiler
- DB** Liquid adhesive (not included in kit, see EPC for details)



## 5. Carbon rear spoiler parts list (F36)

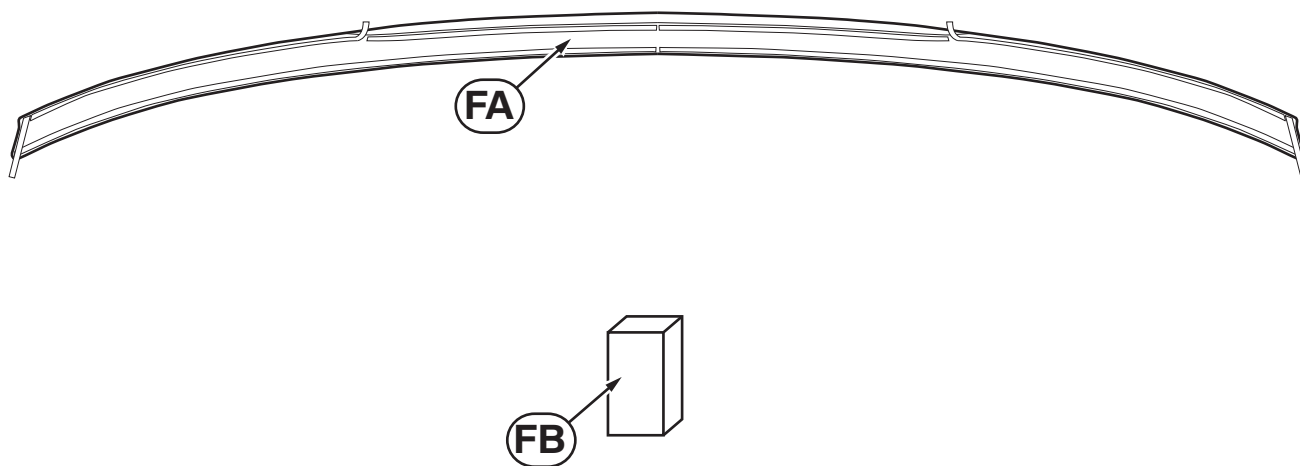


F36 0004 V

### Legend

- EA** Rear spoiler
- EB** Liquid adhesive (not included in kit, see EPC for details)

## 6. Matt black rear spoiler parts list (F32)

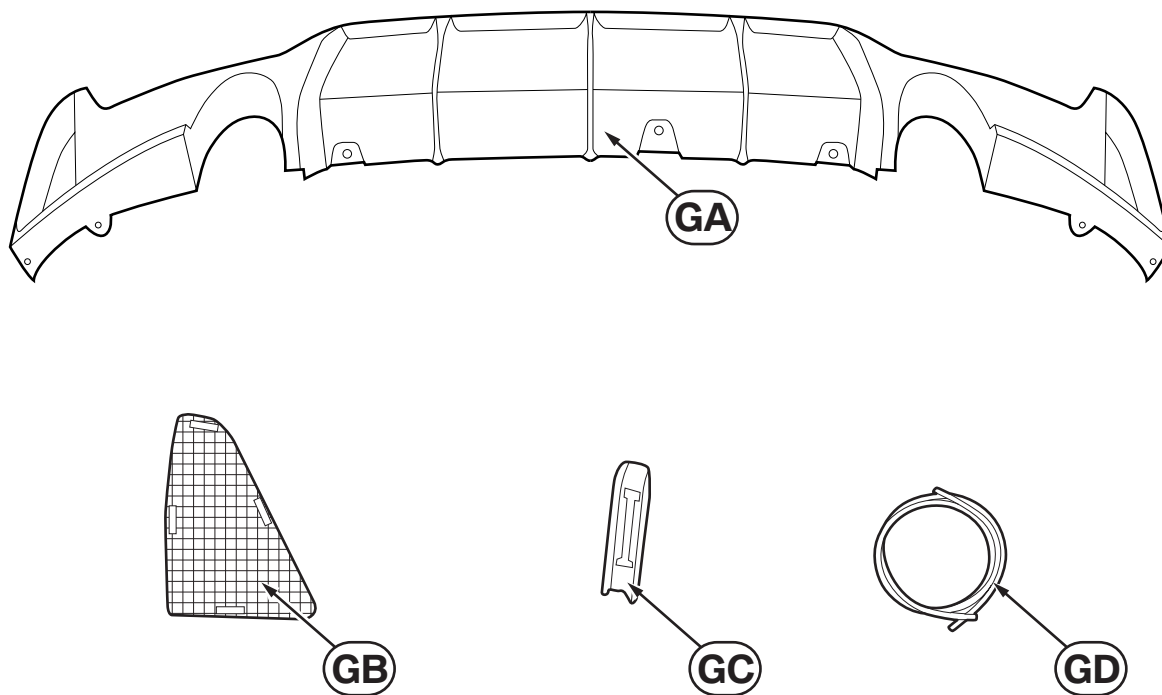


F32 0066 V

### Legend

- FA** Rear spoiler
- FB** Liquid adhesive (not included in kit, see EPC for details)

## 7. Matt black rear diffuser (F32/F33/F36)



F32 0067 V

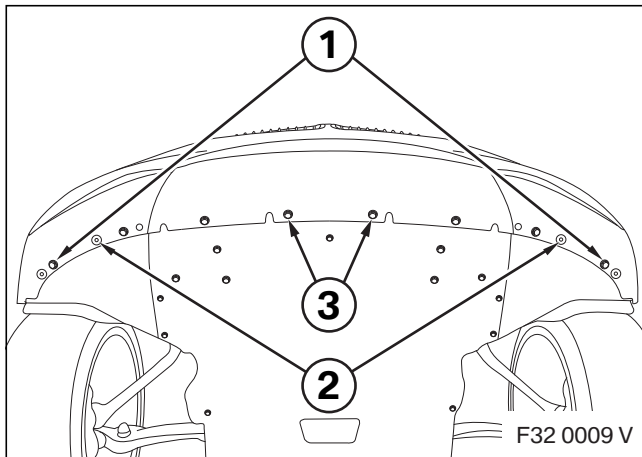
### Legend

- GA** Diffuser insert (illustration shows double-sided and single-pipe exhaust system version)
- GB** Expanded grille (2 x)
- GC** Clamp (8 x)
- GD** Masking tape

## 8. Preparatory work

The following components must be removed first of all	ISTA No.
Lower rear bumper trim (keep the screws and rivets, they will be required again for later installation)	51 12 ...

## 9. Fitting the carbon front add-on section for part number 51 19 2 334 548 (F32/F36)



Remove the outer screws (1) and the expanding rivets (2). The screws (1) and expanding rivets (2) are no longer required.

Loosen the inner screws (3), but do not remove them.

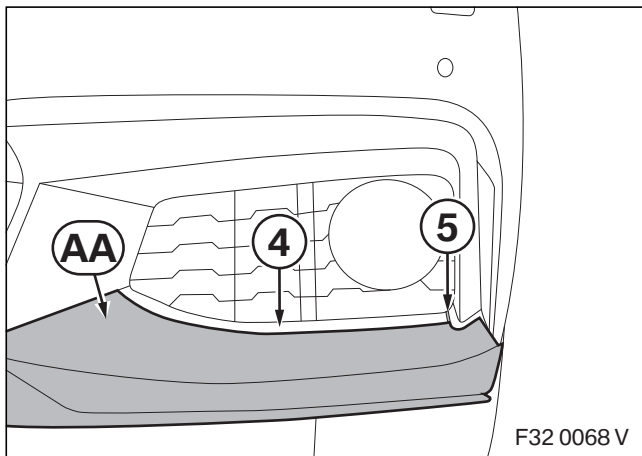
### Only for cars of a light colour

▶ For cars of a light colour, the gap (4) must be blackened. ◀

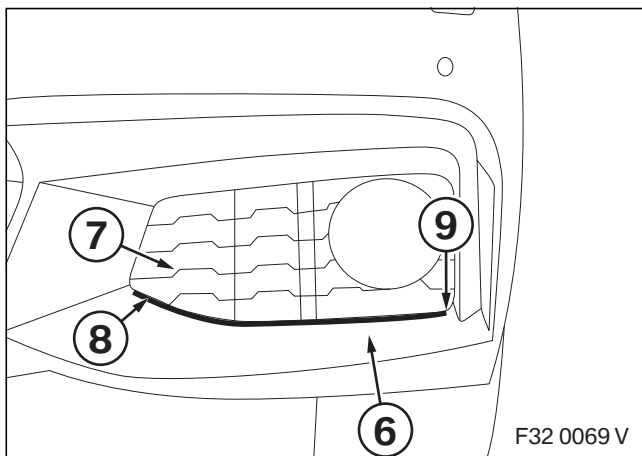
Place carbon front add-on section **AA** on the front apron and align.

Using a suitable tool, draw a mark (5) on the front apron to demarcate the area to be blackened.

Remove carbon front add-on section **AA**.



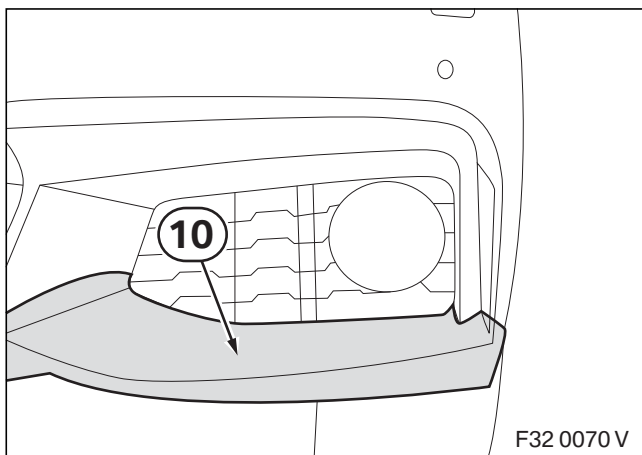
Using a black paint pen, draw a line around 2-3 mm thick (8) on the front apron (6) along the air inlet cover (7) up to the mark (9).



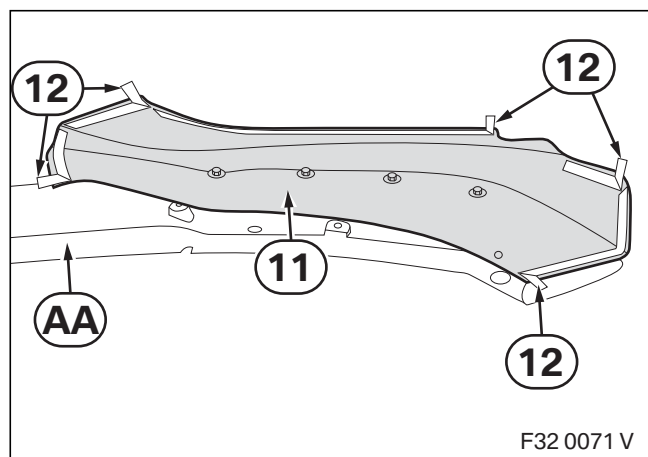
### For all cars

▶ The car surface (10) must be completely dry, clean and free from wax and grease. ◀

Clean car surface (10) with a suitable cleaner.



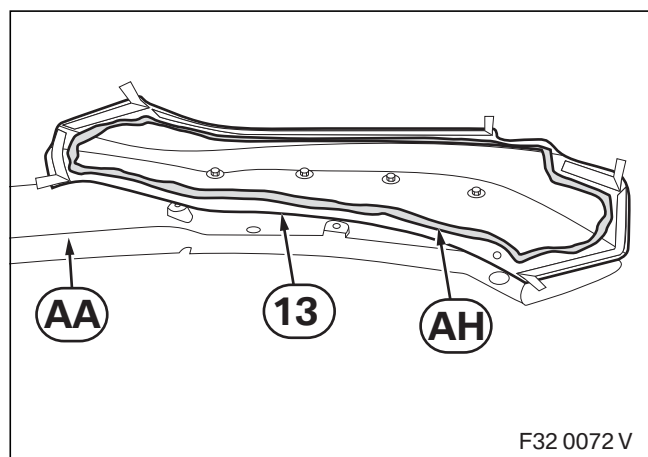
## 9. Fitting the carbon front add-on section for part number 51 19 2 334 548 (F32/F36)



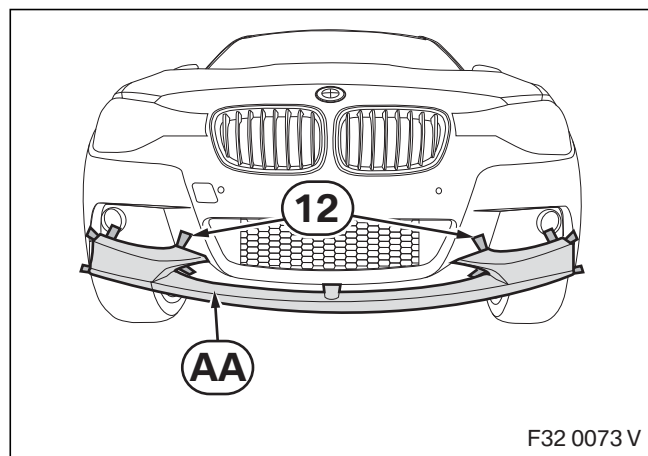
▶ The surface (11) must be completely dry and free from wax or grease. ◀

Clean the surface (11) of carbon front add-on section **AA** using a suitable cleaner.

Bend back the ends of the adhesive backing film just enough to form small tabs (12).



Apply liquid adhesive **AH** approx. 30 mm from the edge (13) and along the edge (13) on the inside of carbon front add-on section **AA** as shown.

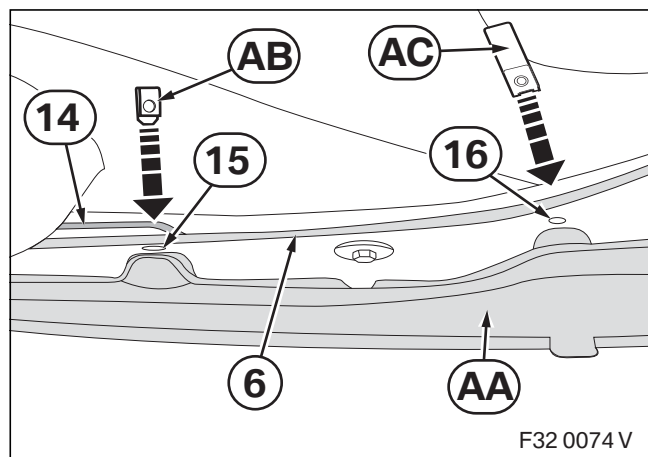


▶ The bonding surfaces must be completely clean, dry and free from wax or grease. Ensure that all tabs (12) on the adhesive backing film are visible. ◀

Place carbon front add-on section **AA** on the car's front apron and align.

Gradually remove the adhesive backing films in sequence using the tabs (12) to assist you and firmly and **repeatedly** press carbon front add-on section **AA** into position.

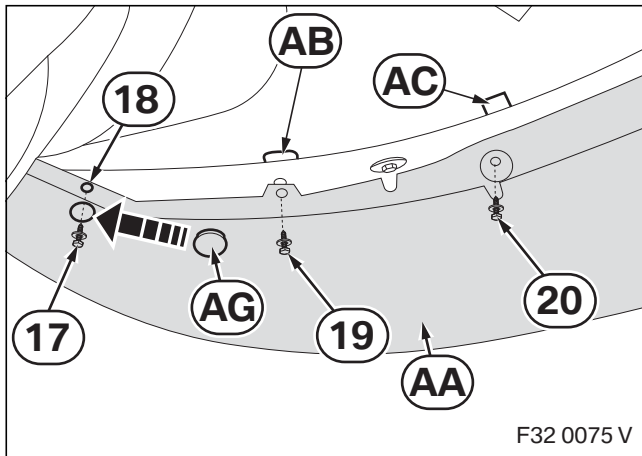
Remove any excess liquid adhesive immediately.



Place C-clip **AB** on the plastic plate (14) above the front apron (6) and position it over the hole (15) in the front apron (6).

Position installation plate incl. C-clip **AC** over the drill hole (16) for carbon front add-on section **AA** on the front apron (6).

## 9. Fitting the carbon front add-on section for part number 51 19 2 334 548 (F32/F36)

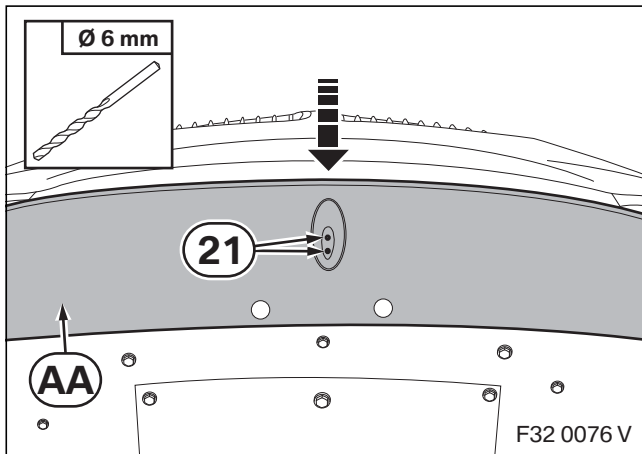


Screw in screws (17) through the drill hole (18) of carbon front add-on section **AA** and tighten them.

Screw in screw (19) into C-clip **AB** and tighten it.

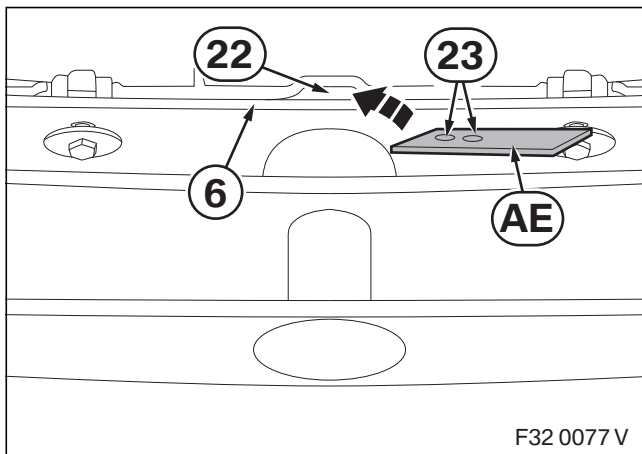
Screw in screw (20) into the installation plate incl. C-clip **AC** and tighten it.

Place cover cap **AG** on the drill hole (18).

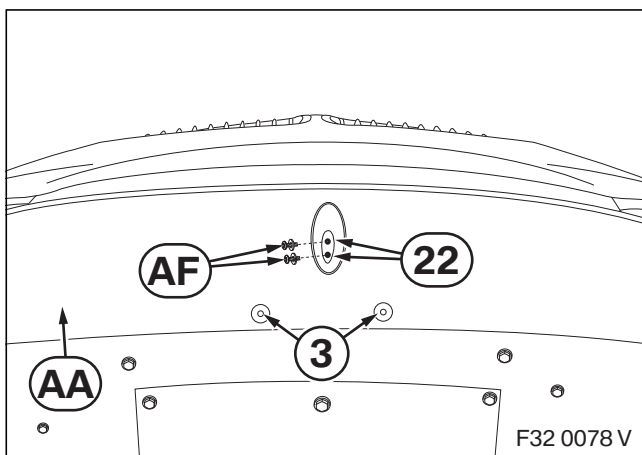


⚠ When drilling down to the drilling depth, take care not to damage any parts/the metal support underneath. ◀

Drill holes (21) from carbon front add-on section **AA** through the front apron using a **6 mm** drill bit.



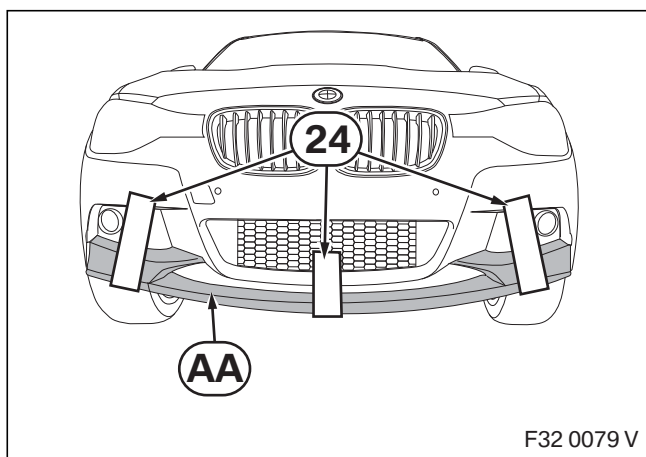
Pull the front apron (6) slightly downwards and slide installation plate **AE** into the depression (22). Align the drill holes (23) on installation plate **AE** over the previously-drilled holes in the front apron.



Screw in oval-headed screws **AF** through the drill holes (21) on front splitter **AA** into the installation plate (concealed).

Tighten the screws (3).

## 9. Fitting the carbon front add-on section for part number 51 19 2 334 548 (F32/F36)



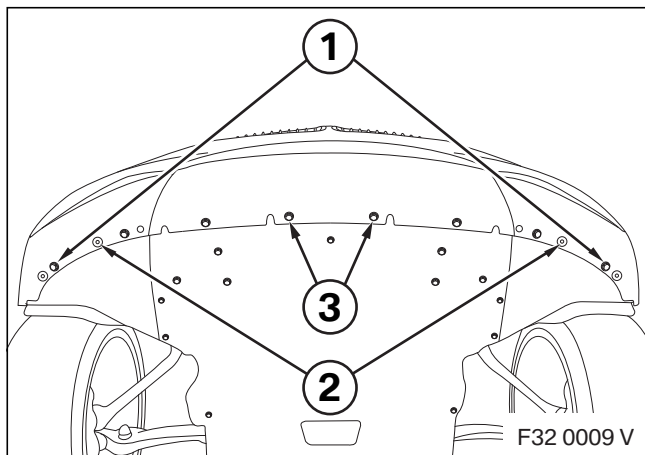
Secure carbon front add-on section **AA** using a suitable adhesive strip (24) as shown.

▶ Do not remove the adhesive strips (24) for around 24 hours and do not move the car.

Note the painting instructions on page 2. ◀



## 10. Fitting the carbon front add-on section for part number 51 19 2 408 993 (F32/F36)



Remove the outer screws (1) and the expanding rivets (2). The screws (1) and expanding rivets (2) are no longer required.

Unscrew the inner screws (3) and keep them safe.

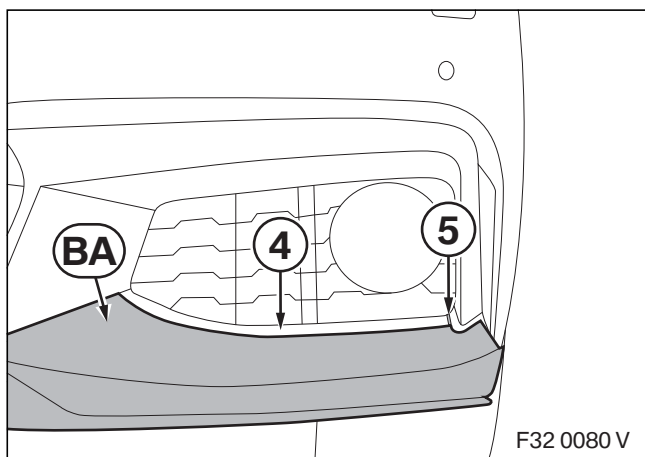
### Only for cars of a light colour

▶ For cars of a light colour, the gap (4) must be blackened. ◀

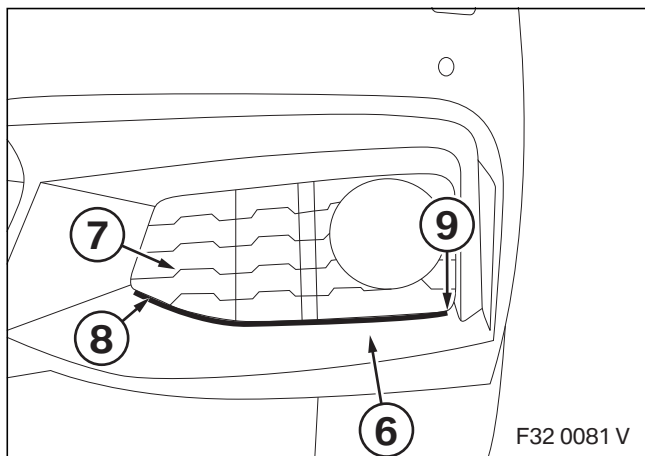
Place carbon front add-on section **BA** on the front apron and align.

Using a suitable tool, draw a mark (5) on the front apron to demarcate the area to be blackened.

Remove carbon front add-on section **BA**.



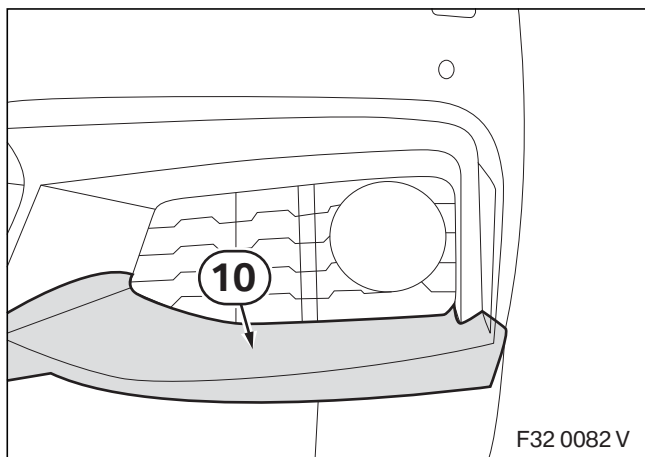
Using a black paint pen, draw a line around 2-3 mm thick (8) on the front apron (6) along the air inlet cover (2) up to the mark (9).



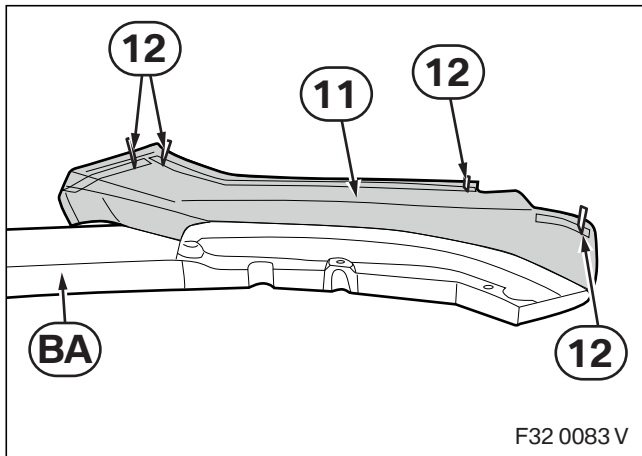
### For all cars

▶ The car surface (10) must be completely dry, clean and free from wax and grease. ◀

Clean car surface (10) with a suitable cleaner.



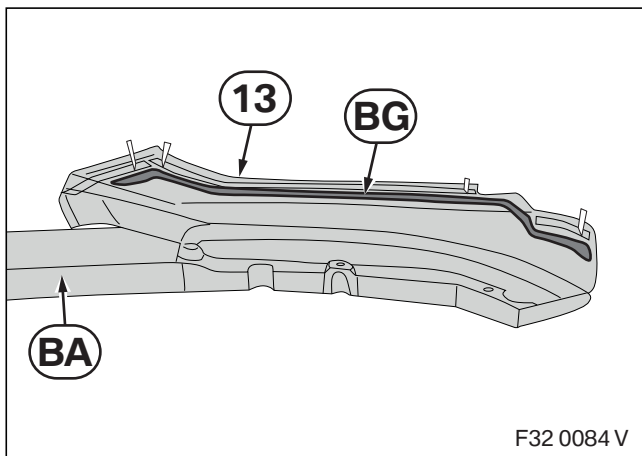
## 10. Fitting the carbon front add-on section for part number 51 19 2 408 993 (F32/F36)



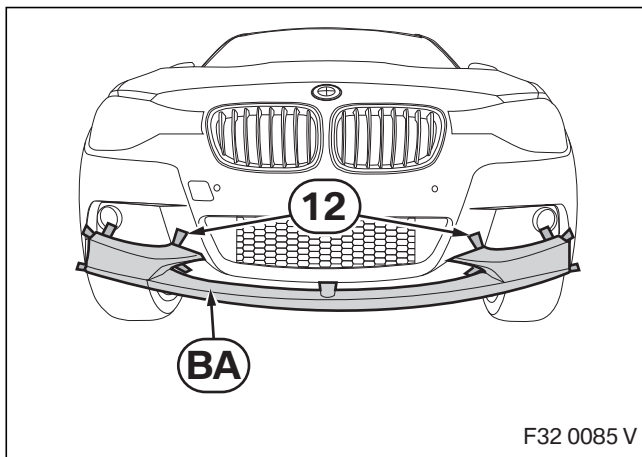
▶ The surfaces (11) must be completely dry and free from wax or grease. ◀

Clean the surfaces (11) of carbon front add-on section **BA** using a suitable cleaner.

Bend back the ends of the adhesive backing film just enough to form small tabs (12).



Apply liquid adhesive **BG** approx. 30 mm from the edge (13) and along the edge (13) on the inside of carbon front add-on section **BA** as shown.

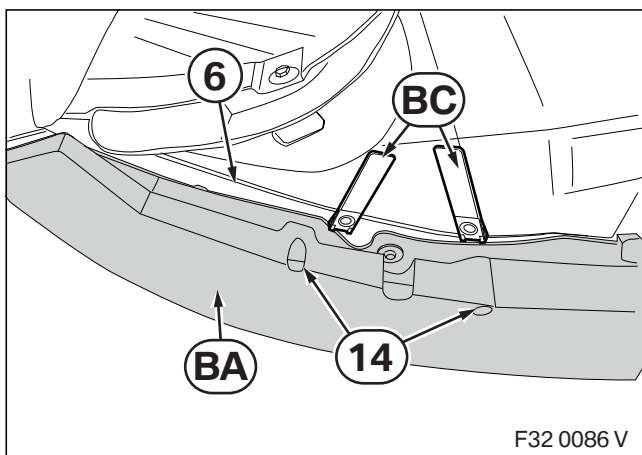


▶ The bonding surfaces must be completely clean, dry and free from wax or grease. Ensure that all tabs (12) on the adhesive backing film are visible. ◀

Place carbon front add-on section **BA** on the car's front apron and align.

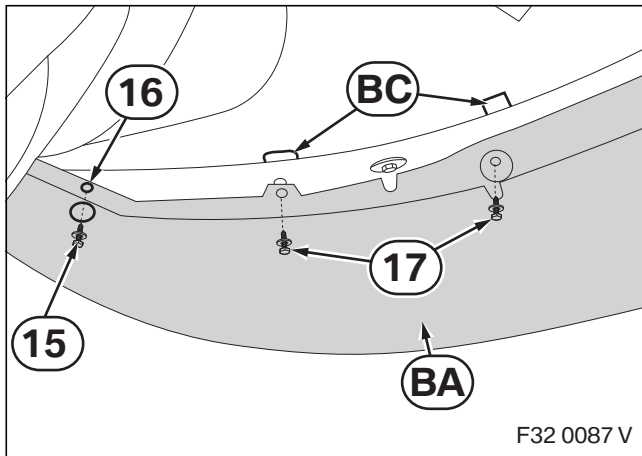
Gradually remove the adhesive backing films in sequence using the tabs (12) to assist you and **firmly** and **repeatedly** press carbon front add-on section **BA** into position.

Remove any excess liquid adhesive immediately.



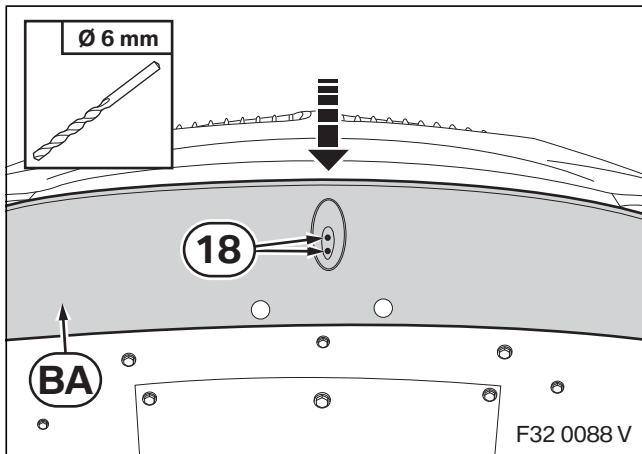
Position installation plate incl. C-clip **BC** over the drill holes (14) for carbon front add-on section **BA** on the front apron (6).

## 10. Fitting the carbon front add-on section for part number 51 19 2 408 993 (F32/F36)



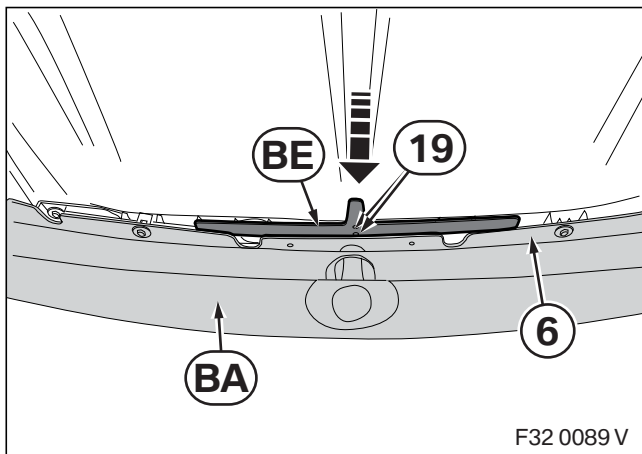
Screw in screw (15) through the drill hole (16) of front splitter **BA** and tighten them.

Screw in screws (17) into the installation plate incl. C-clip **BC** and tighten them.

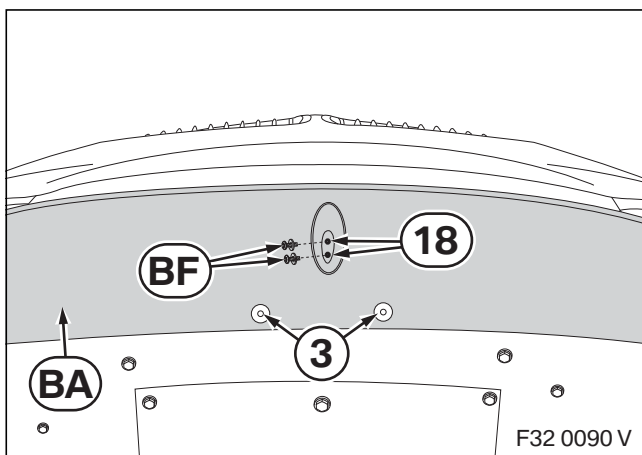


▶ When drilling down to the drilling depth, take care not to damage any parts / the metal support underneath. ◀

Drill holes (18) from carbon front add-on section **BA** through the front apron using a **6 mm** drill bit.



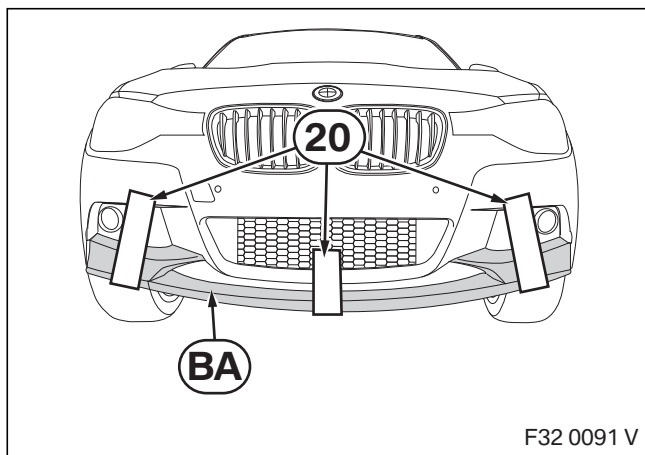
Pull the front apron (6) slightly downwards and slide installation plate **BE** in. Align the drill holes (19) on installation plate **BE** over the holes in the front apron (6) you drilled previously.



Screw in oval-headed screws **BF** through the drill holes (18) on carbon front add-on section **BA** into the installation plate (concealed).

Insert and tighten the existing screws (3).

## 10. Fitting the carbon front add-on section for part number 51 19 2 408 993 (F32/F36)

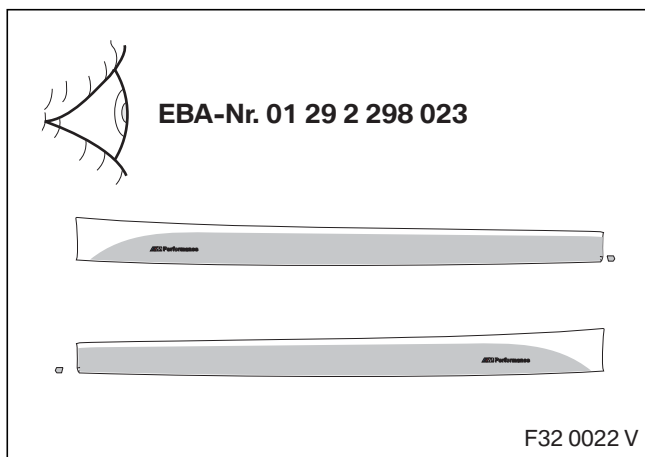


Secure carbon front add-on section **BA** using a suitable adhesive strip (20) as shown.

▶ Do not remove the adhesive strips (20) for **around 24 hours** and do not move the car.

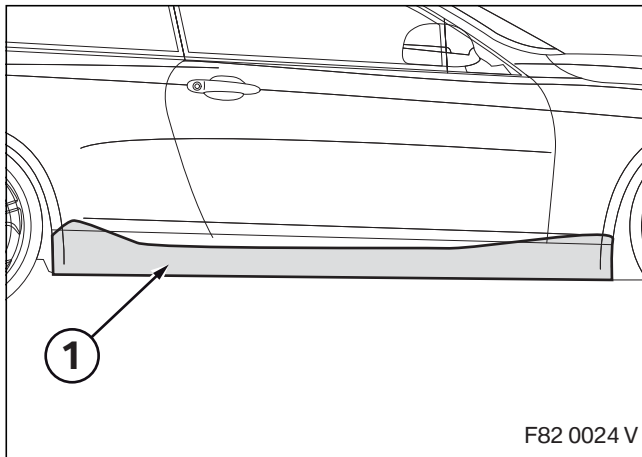
Note the painting instructions on page 2. ◀

## 11. Fitting the side skirt films (F32/F33/F36)



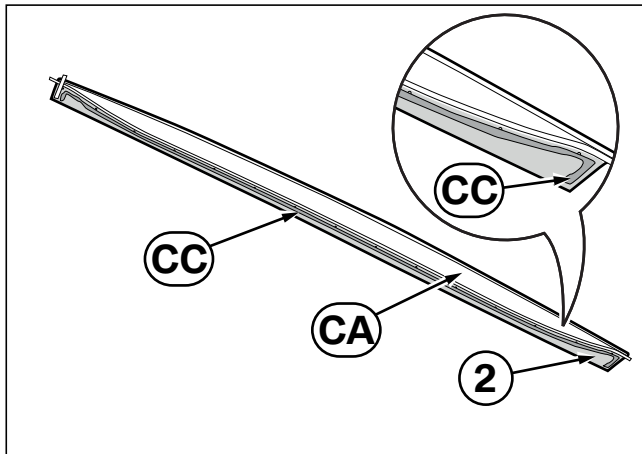
▶ Install the side sill films in accordance with the installation instructions bearing part number 01 29 2 298 023. ◀

## 12. Fitting the matt black side skirt add-on section (F32/F33/F36)



▶ The bonding surfaces must be completely dry, clean and free from wax or grease. ◀

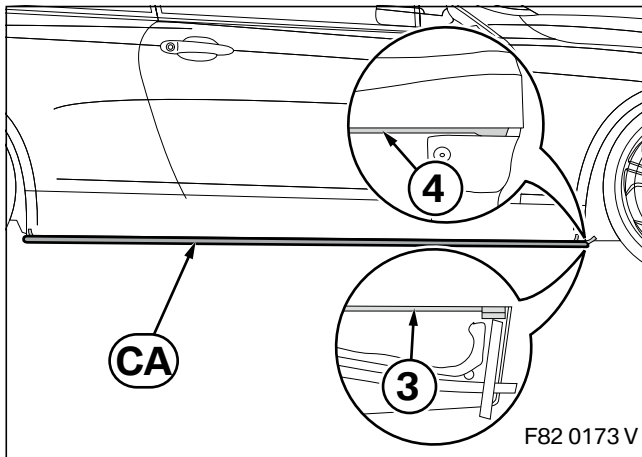
Clean the surface (1) of the car with a suitable cleaner.



▶ The bonding surfaces must be completely dry, clean and free from wax or grease. ◀

Clean the surface (2) of matt black side skirt add-on section CA with a suitable cleaner.

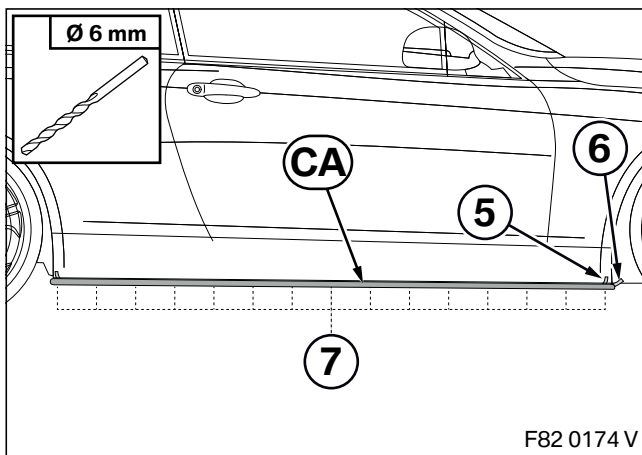
Apply liquid adhesive CC as shown to matt black side skirt add-on section CA.



▶ Ensure that all tabs on the adhesive backing film are visible. ◀

Position matt black side skirt add-on section CA so that the edge (3) of matt black side skirt add-on section CA lies behind the edge (4) of the car.

▶ Remove any excess liquid adhesive immediately. ◀



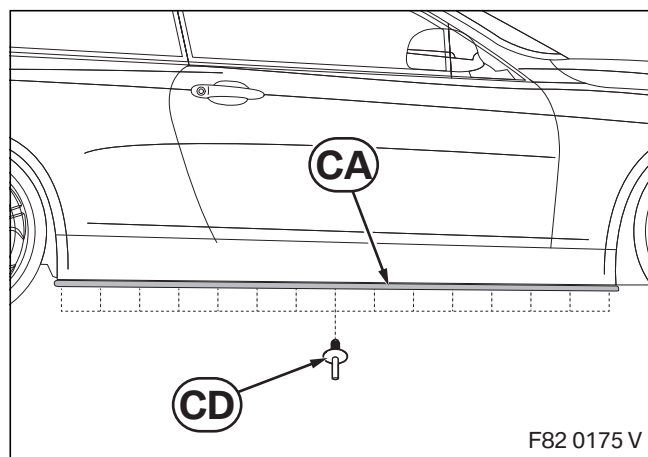
Carefully remove the adhesive strip (5) from front to back and firmly press on matt black side skirt add-on section CA.

Carefully remove the adhesive strip (6) from the outside inwards and firmly press on matt black side skirt add-on section CA.

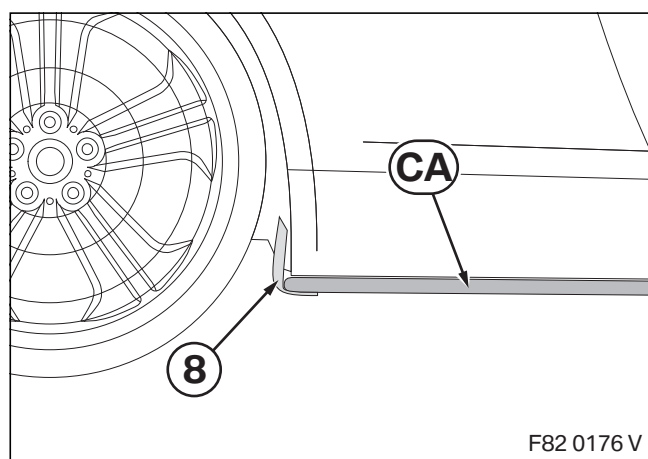
▶ When drilling down to the drill depth, take care not to damage parts underneath. ◀

Using a 6 mm drill bit, transfer the 15 holes (7) from matt black side skirt add-on section CA to the side skirt.

## 12. Fitting the matt black side skirt add-on section (F32/F33/F36)



Secure matt black side skirt add-on section **CA** using 15 blind rivets **CD**.

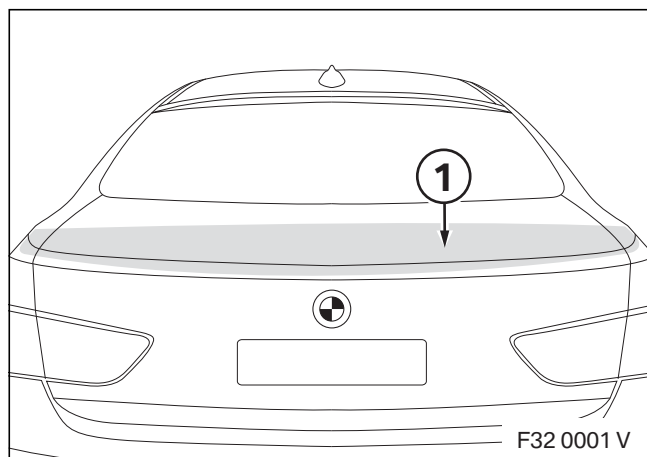


Secure the rear part of matt black side skirt add-on section **CA** as shown using a suitable adhesive strip (8).



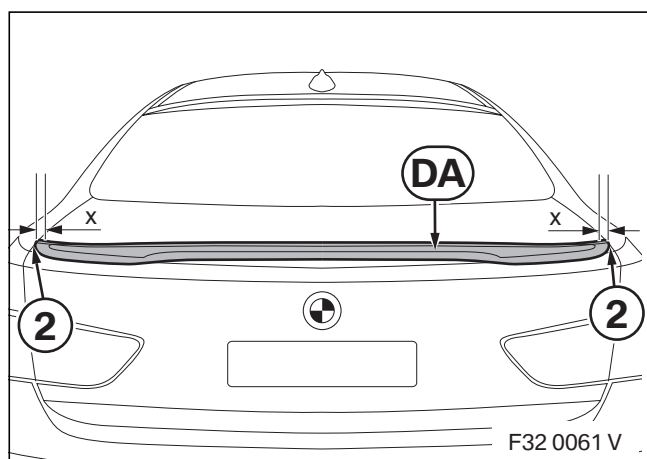
Note the painting instructions on page 2. ◀

### 13. Fitting the carbon rear spoiler (F32)

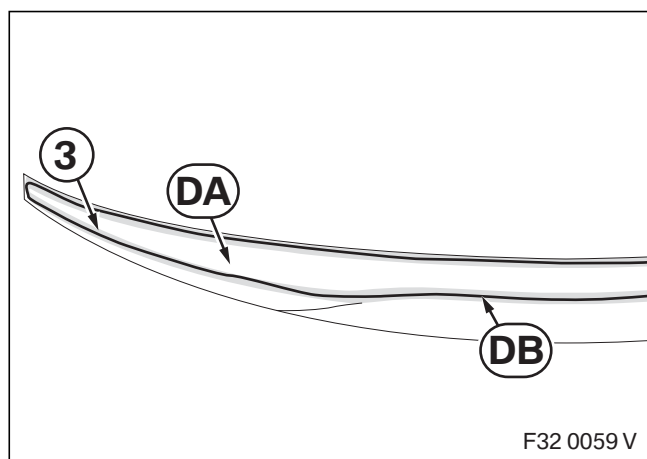


▶ The car surface (1) must be completely dry, clean and free from wax and grease. ◀

Clean car surface (1) with a suitable cleaner.

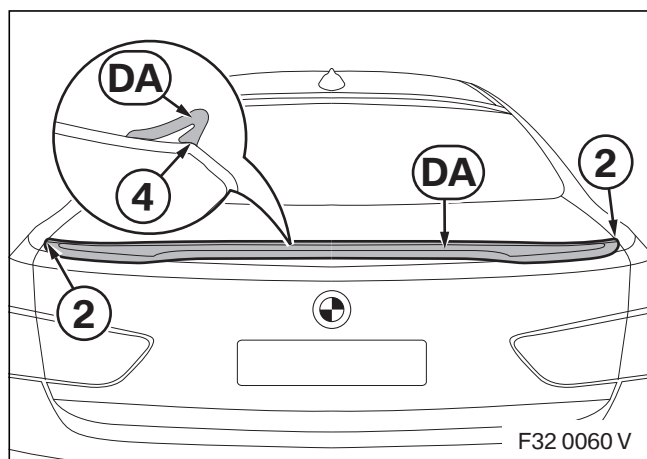


Place the rear spoiler **DA** on the boot lid, centre it and mark the position (2) at the left and right using a suitable tool.



▶ For clarity, only one side of rear spoiler **DA** is shown. ◀

Sand and clean the side surface (3) on the underside of the rear spoiler **DA** using suitable tools. Then apply liquid adhesive **DB** in a bead with a diameter of **3 mm** to the edge surface (3).

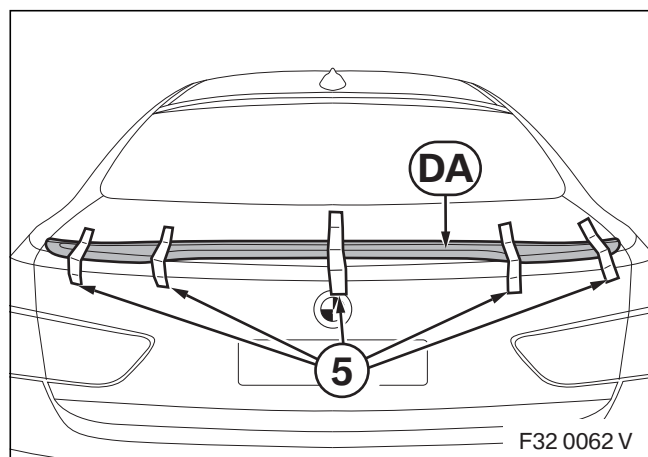


Centre the rear spoiler **DA** using the two marks (2), place it on the edge (4) of the boot lid and press it into place.

▶ Remove any excess liquid adhesive immediately. ◀

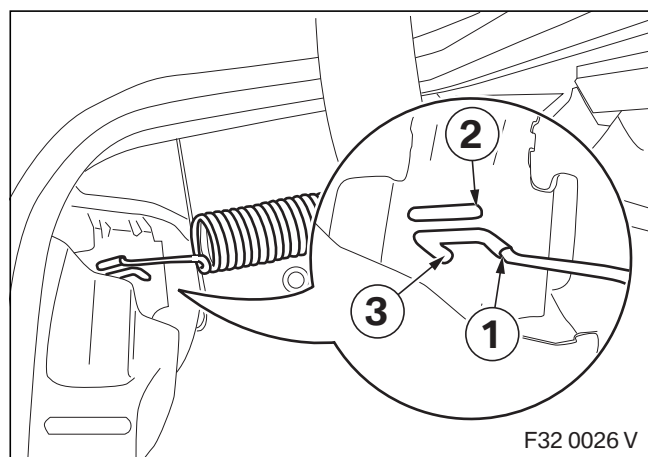


### 13. Fitting the carbon rear spoiler (F32)



Secure rear spoiler **A** using suitable adhesive tape (5) at several points for at least **24 hours**.

► Note the painting instructions on page 2. ◀

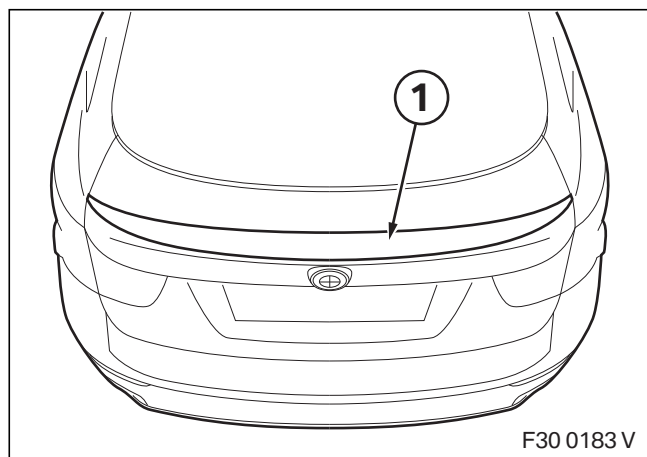


► Positions (1), (2) and (3) are provided for the tailgate's tension spring. ◀

Move the tailgate's tension spring to position (3).

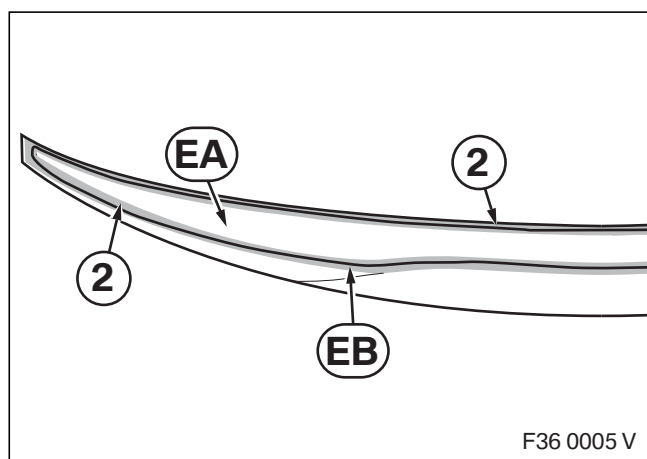
► After repositioning the tension springs, check that the tailgate is able to open properly and adjust the position of the tension springs accordingly if necessary. ◀

## 14. Fitting the carbon rear spoiler (F36)

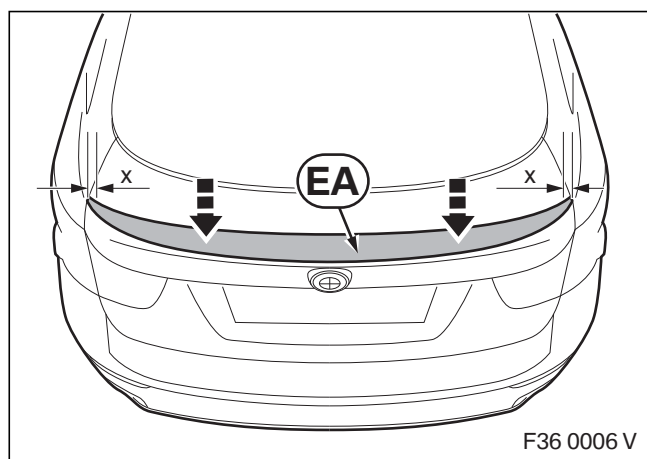


► The car surface (1) must be completely dry, clean and free from wax and grease. ◀

Clean car surface (1) with a suitable cleaner.

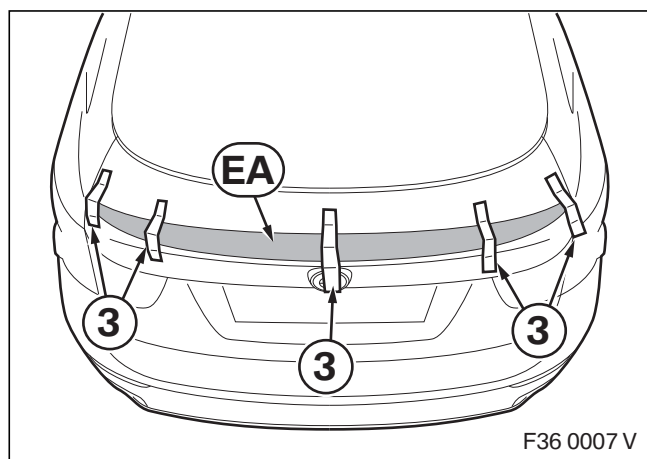


Sand and clean the areas (2) of the rear spoiler **EA** using suitable materials and then apply liquid adhesive **EB** to the areas (2).



Place rear spoiler **EA** on the edge of the boot lid and adjust it so that it is in the centre.

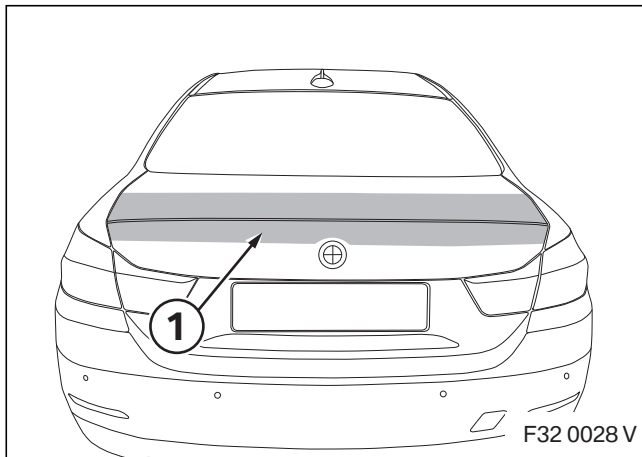
► Remove any excess liquid adhesive immediately. ◀



Secure rear spoiler **EA** using suitable adhesive tape (3) at several points for at least **24 hours**.

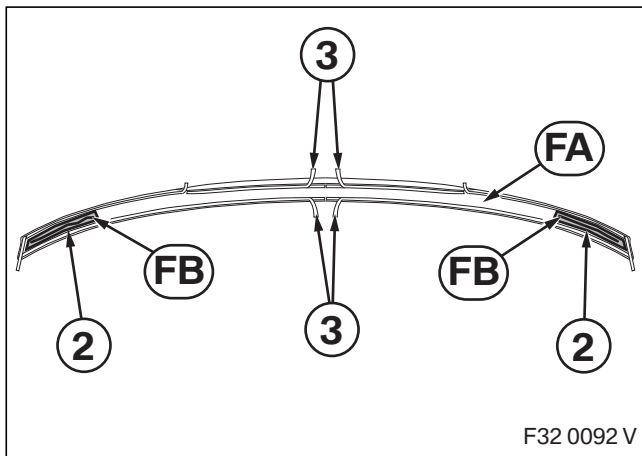
► Note the painting instructions on page 2. ◀

## 15. Fitting the matt black rear spoiler (F32)



▶ The car surface (1) must be completely dry, clean and free from wax and grease. ◀

Clean car surface (1) with a suitable cleaner.

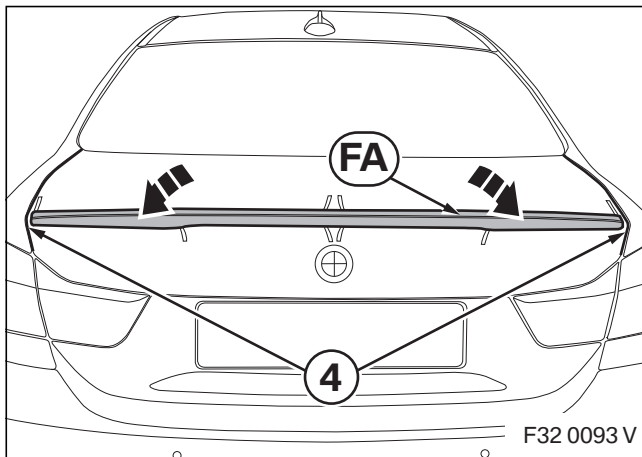


▶ The surfaces (2) must be completely dry and free from wax or grease. ◀

Sand and clean the surfaces (2) of rear spoiler **FA** with suitable materials.

Apply liquid adhesive **FB** liberally (length: approx. 8 cm) to the middle of the surfaces (2).

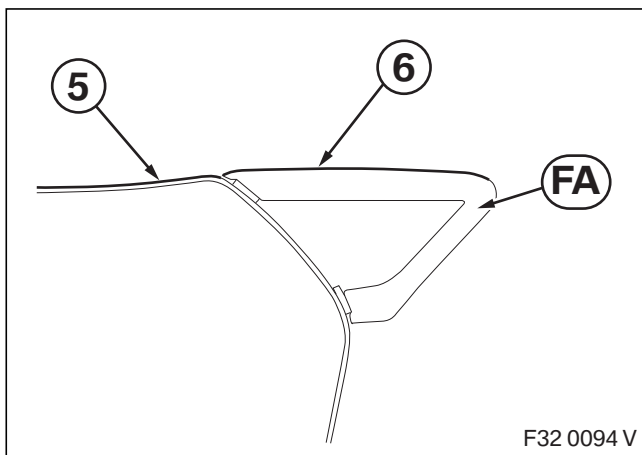
Then pull back the ends of the adhesive backing films on rear spoiler **FA** far enough so that small tabs (2) form.



▶ Make sure that all tabs on the adhesive backing film and the liner projections are visible after contact has been made. ◀

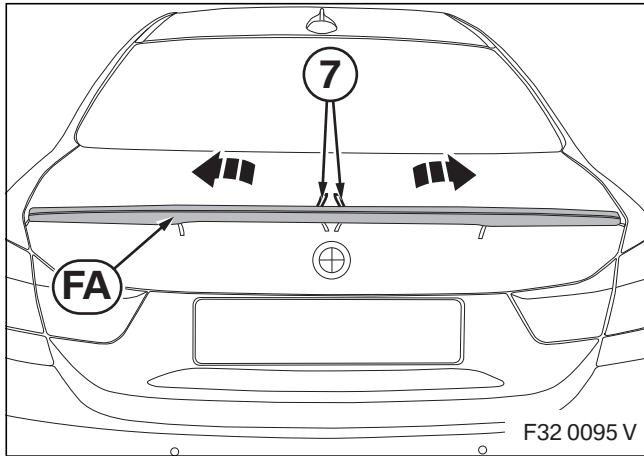
Place rear spoiler **FA** on the boot lid and centre it between the edges (4).

Remove any excess liquid adhesive immediately.

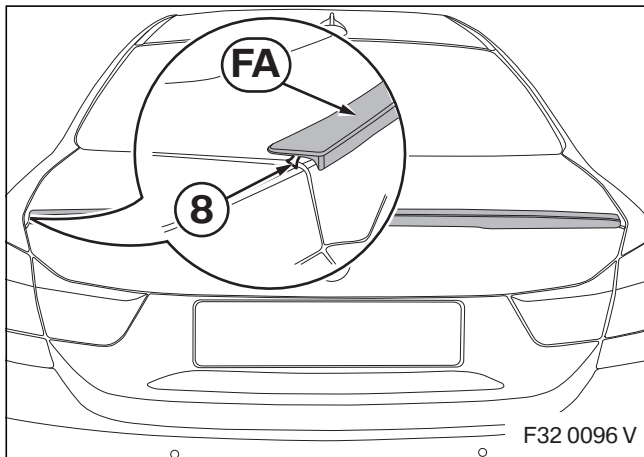


Align rear spoiler **FA** so the surfaces (5) and (6) transition into one another.

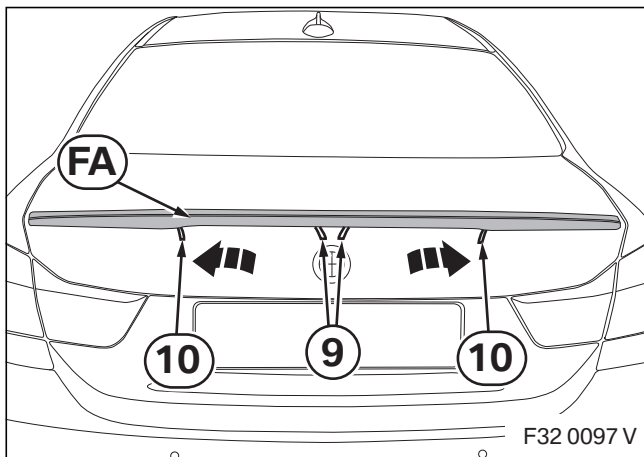
## 15. Fitting the matt black rear spoiler (F32)



Pull off the upper adhesive backing films (7) of rear spoiler **FA** starting from the middle.



Pull off the side adhesive backing films (8) of rear spoiler **FA**.

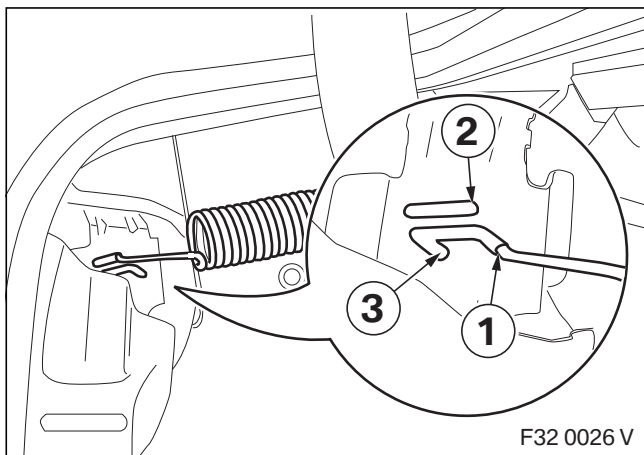


Pull off the lower adhesive backing films (9) of rear spoiler **FA** starting from the middle.

Then pull the lower adhesive backing films (10) of rear spoiler **FA** off outwards.

Press rear spoiler **FA** firmly and repeatedly onto the boot lid.

► Note the painting instructions on page 2. ◀

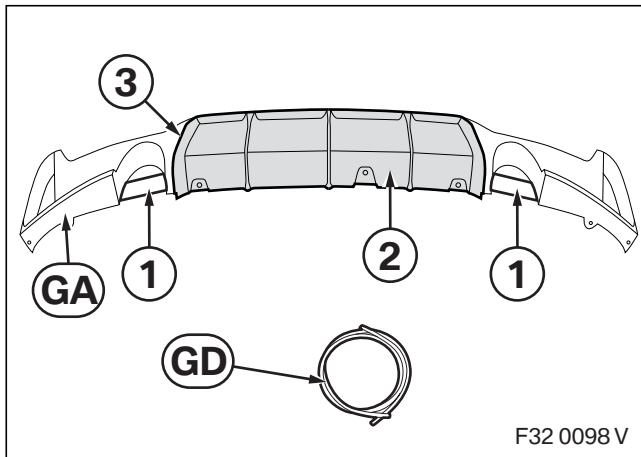


► Positions (1), (2) and (3) are provided for the tailgate's tension spring. ◀

Move the tailgate's tension spring to position (3).

► After repositioning the tension springs, check that the tailgate is able to open properly and adjust the position of the tension springs accordingly if necessary. ◀

## 16. Fitting the matt black rear diffuser (F32/F33/F36)



Remove the bar (1) of the diffuser insert **GA** using a suitable knife and deburr the cut edges of the diffuser insert **GA**.

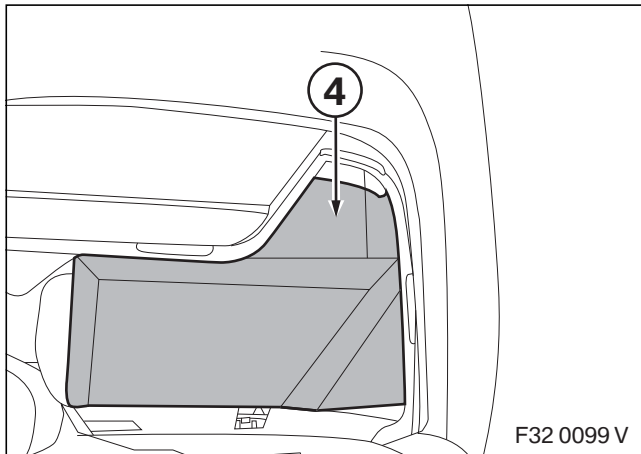
▶ Diffuser insert **GA** can be partially painted in the car colour if the customer so wishes. See painting instructions. ◀

Before painting, mask the marked area (2) of diffuser insert **GA** using masking tape and masking tape **GD** using the painting spaces (3) provided.

Do not paint the masked areas.

### Only for cars of a light colour

Blacken the area (4) of the car at the rear right using suitable means.

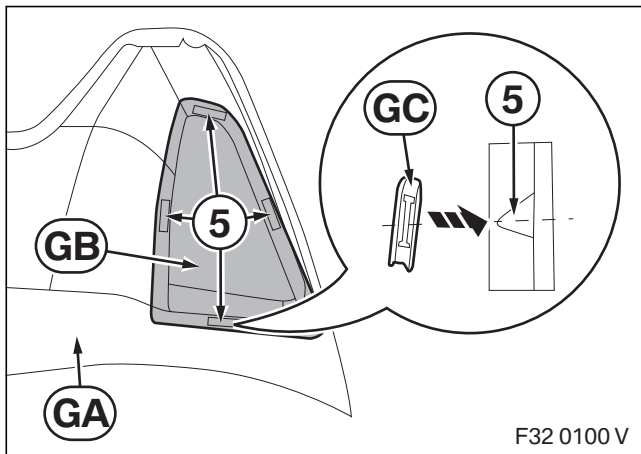


### For all cars

Place extended grille **GB** on the four tabs (5) of diffuser insert **GA**.

▶ Start with the clamps at the bottom. ◀

Secure extended grille **GB** with clamps **GC**.



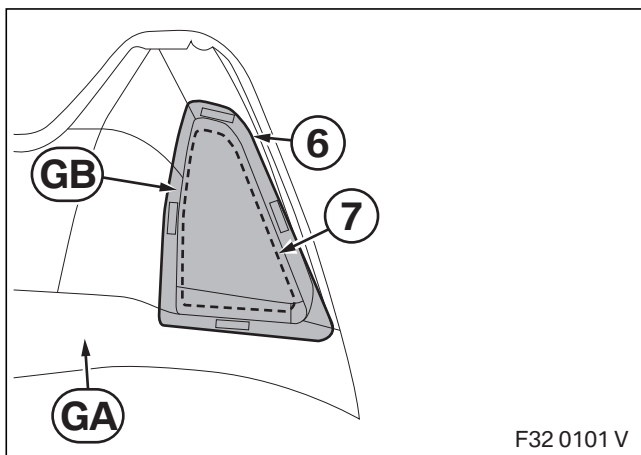
▶ Extended grille **GB** must be curved outwards. ◀

Bend the edge (6) of extended grille **GB** inwards into the diffuser.

Then push extended grille **GB** slightly outwards along the line (7) so that extended grille **GB** curves outwards.

Install the extended grille **GB** on the right-hand side in the same way.

Fit diffuser insert **GA** as described in **ISTA No. 51 12 ....**



## 17. Concluding work and coding

The retrofit system does not require coding.

- Conduct a brief test
- Conduct a function test

Re-assemble the car