

# Original BMW Parts and Accessories.

## Installation Instructions.



### M Performance Exterior Components Retrofit Kit.

**BMW 5 Series Saloon (G30 LCI)**

**BMW 5 Series Touring (G31 LCI)**

**BMW M5 (F90 LCI)**

#### Retrofit kit number

Number	Component designation	Type	Install- ation time (h)	Installation as described in ISTA/AIR*
51 19 2 472 301	Carbon left front attachment	F90 LCI	0.3	
51 19 2 472 302	Carbon right front attachment	F90 LCI	0.3	
51 19 2 472 299	Carbon centre front attachment	F90 LCI	0.3	
51 19 2 472 187	Carbon left front attachment	G30 LCI, G31 LCI	0.3	
51 19 2 472 190	Carbon right front attachment	G30 LCI, G31 LCI	0.3	
51 19 2 472 192	Carbon centre front attachment	G30 LCI, G31 LCI	0.3	
51 71 2 469 540	Front ornamental grille with lcam	F90 LCI		x
51 71 2 475 452	Front ornamental grille without lcam	F90 LCI		x
51 71 2 469 541	Front ornamental grille with lcam	G30 LCI, G31 LCI		x
51 71 2 475 453	Front ornamental grille without lcam	G30 LCI, G31 LCI		x
51 71 2 447 093	Carbon left side ornamental grille	F90 LCI		x
51 71 2 447 094	Carbon right side ornamental grille	F90 LCI		x
51 71 9 627 255	Carbon left side Competition ornamental grille	F90 LCI		x
51 71 9 627 254	Carbon right side Competition ornamental grille	F90 LCI		x
51 71 2 464 947	Carbon left side ornamental grille	G30 LCI, G31 LCI		x
51 71 2 464 948	Carbon right side ornamental grille	G30 LCI, G31 LCI		x
51 19 2 455 951	Matt black left side skirt attachment	G30 LCI, G31 LCI	0.50	
51 19 2 455 950	Matt black right side skirt attachment	G30 LCI, G31 LCI	0.50	
51 19 2 447 015	Carbon left side skirt attachment	F90 LCI	0.50	
51 19 2 447 016	Carbon right side skirt attachment	F90 LCI	0.50	
51 19 2 414 142	Carbon rear spoiler	G30 LCI, F90 LCI	0.75/1.00	
51 19 2 457 441	Carbon Pro rear spoiler	G30 LCI, F90 LCI	0.75/1.00	
51 19 2 414 144	Matt black rear spoiler	G30 LCI	0.75	
51 19 2 412 405	Carbon rear diffuser	G30 LCI, G31 LCI	0.50	
51 19 2 446 628	Carbon rear diffuser	F90 LCI	0.50	x
51 19 2 412 406	Matt black rear diffuser	G30 LCI, G31 LCI	0.50	
51 19 2 469 556	Black high gloss bumper cover (MSP)	G30 LCI, G31 LCI	0.25	
51 19 2 469 558	Black high gloss bumper cover (MPA)	G30 LCI, G31 LCI	0.25	
51 16 2 446 821	Carbon exterior mirror cover (LHD, left-hand drive), left	F90 LCI		x
51 16 2 446 822	Carbon exterior mirror cover (LHD, left-hand drive), right	F90 LCI		x

Number	Component designation	Type	Install- ation time (h)	Installation as described in ISTA/AIR*
51 16 2 446 823	Carbon exterior mirror cover (RHD, right-hand drive), left	F90 LCI		x
51 16 2 446 826	Carbon exterior mirror cover (RHD, right-hand drive), right	F90 LCI		x
51 16 2 466 669	Carbon exterior mirror cover (LHD, left-hand drive), left	G30 LCI, G31 LCI		x
51 16 2 466 670	Carbon exterior mirror cover (LHD, left-hand drive), right	G30 LCI, G31 LCI		x
51 16 2 466 671	Carbon exterior mirror cover (RHD, right-hand drive), left	G30 LCI, G31 LCI		x
51 16 2 466 672	Carbon exterior mirror cover (RHD, right-hand drive), right	G30 LCI, G31 LCI		x

\* This installation work is carried out as described in the relevant ISTA/AIR repair instructions and is not shown in these installation instructions.

## Installation time

Installation time, see table. This may vary depending on the condition of the car and its equipment package.

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 (must not be invoiced under the warranty).

## Important information

**!** For the G30, the carbon front attachment **AC** may only be installed on the car with a carbon rear spoiler **DA** or carbon Pro rear spoiler **EA** (see EPC for details and part numbers).

For the G30 LCI, the carbon rear spoiler **DA** may only be installed on the car with a carbon front attachment **AC** or centre air guide (see EPC for information and part numbers).

For the G30, the carbon Pro rear spoiler **EA** may only be installed on the car with a carbon front attachment **AC** and with the air guide (see EPC for information and part numbers).

For the F90 LCI, the carbon Pro rear spoiler **EA** may only be installed on the car with a carbon front attachment **A**, **B** and **C** (see EPC for information and part numbers). ▲

The carbon rear diffuser **IA** **cannot** be installed on cars with trailer tow hitch (**SA 3AC**). The installation of the carbon rear diffuser **IA** on cars with Comfort Access (**SA 322**) results in the "Smart Opener" function of this option being no longer available which means that it can no longer be used.

After installing the carbon rear diffuser retrofit kit **IA** and the right/left carbon front attachment retrofit kit **AA'**, **AB'** and carbon front attachment **AC** on 550i and 550d (G30, G31 LCI MPA) cars, the retrofit must be programmed/coded via the – **Retrofits** – path.

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 cars 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 logical order, using the prescribed tools (special tools), and observing current health and safety regulations.

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

To avoid unnecessary extra work and/or costs, send an inquiry to the technical parts support team.

Quote the following information:

- VIN,
- retrofit kit part number,
- a detailed description of the problem,
- any work already carried out.

Do not archive the printout of these installation instructions. The current version can be found in the EPC.

### 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 warning text.

### Installation information

- All contact/bonding surfaces on the components being installed must be absolutely dry, clean, and free of wax, silicone 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 installing them.
- All the 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 bonding 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  $v_{max} < 100$  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!**
- Installation is shown in some instances on one side of the car only; proceed in the same way on the other side.
- All illustrations show LHD (left-hand drive) cars; proceed in the same way on RHD (right-hand drive) cars.

### Terminology used

**Initial installation:** The carbon front attachment **AC** is installed for the first time.

**Re-installation (for example in the event of a repair):** The appropriate carbon front attachment **AC** is reinstalled.

### Painting instructions

Check that all the kit components fit accurately on the car before painting them. Primed kit components must be pre-treated appropriately before painting.

These installation instructions must be given to the painter to ensure that the painting work is completed correctly.

Follow the BMW painting instructions (see **ISTA/AIR No. 99 00 ...**).

## Ordering instructions

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

## Special tools required

None

## Advice to be given to the customer

The following attachments can be painted if required by the customer:

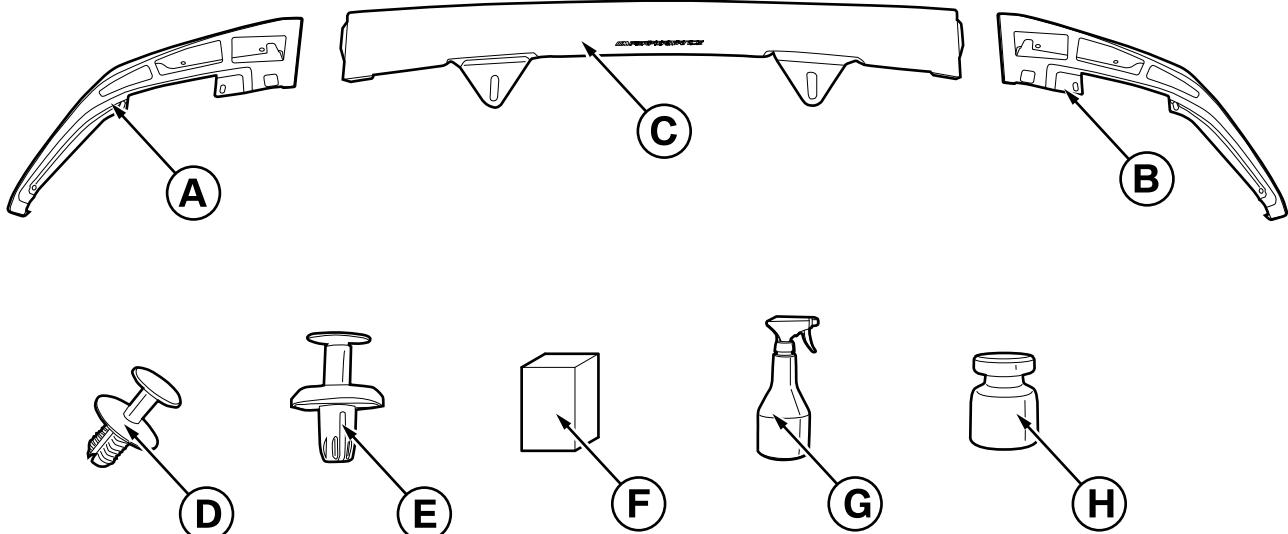
- Matt black side skirt attachment, right **BA**
- Matt black side skirt attachment, left **BB**
- Matt black rear spoiler **FA**
- Black high gloss bumper cover **GB**
- Matt black rear diffuser **JA**

 The installation of the carbon front attachment **AC** reduces the car's ground clearance and reduces the overhang angle at the front. Check the carbon front attachment **AC** at regular intervals for damage caused by collisions and, if it is damaged, have it replaced by trained personnel. 

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## 1. Carbon front attachment parts list F90 LCI

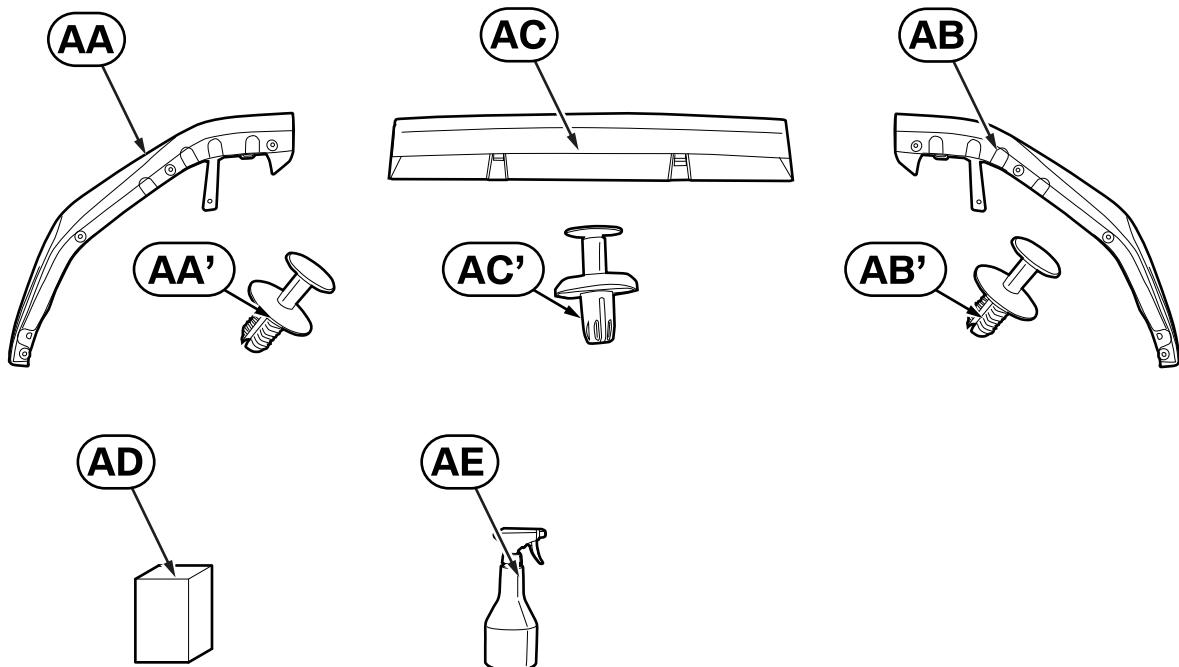


F90 0051 V

### Legend

		Quantity included in kit	BMW part number
A	Carbon right front attachment	1	51 19 2 472 302
B	Carbon left front attachment	1	51 19 2 472 301
C	Carbon centre front attachment	1	51 19 2 472 299
D	Expanding rivet	6	51 47 1 911 992
E	Expanding rivet	6	07 14 7 401 727
F	Liquid adhesive (not included in kit, see EPC for details)	---	---
G	Cleaner (not included in kit, see EPC for details)	---	---
H	Primer (not included in kit, see EPC for details)	---	83 19 9 407 777

## 2. Carbon front attachment parts list G30 LCI, G31 LCI

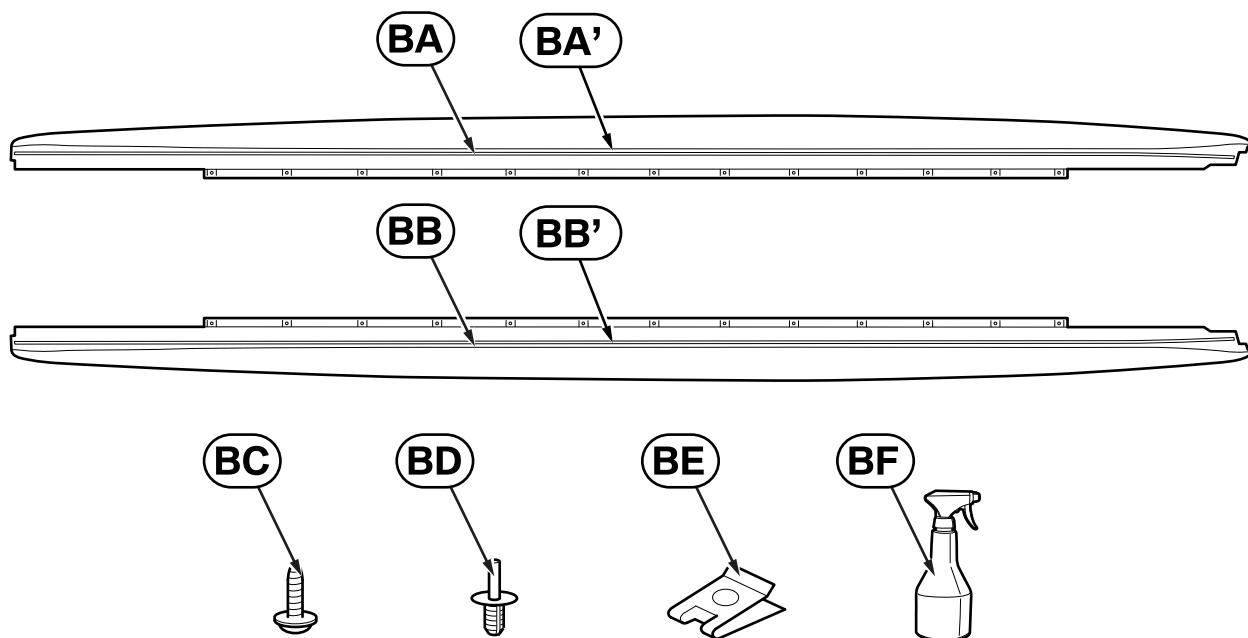


G30 0281 V

### Legend

		Kit consists of the following	BMW part number (kit)
<b>AA</b>	Carbon right front attachment (kit) Only the complete kit can be ordered.	1x Carbon right front attachment <b>AA</b> Part No. 51 19 2 472 188 3x Expanding rivet <b>AC'</b> Part No. 51 47 1 911 992 1x Expanding rivet <b>AA'</b> Part No. 51 71 7 002 953	51 19 2 472 190
<b>AB</b>	Carbon left front attachment (kit) Only the complete kit can be ordered.	1x Carbon left front attachment <b>AA</b> Part No. 51 19 2 472 189 3x Expanding rivet <b>AC'</b> Part No. 51 47 1 911 992 1x Expanding rivet <b>AA'</b> Part No. 51 71 7 002 953	51 19 2 472 187
<b>AC</b>	Carbon centre front attachment (kit) Only the complete kit can be ordered.	1x Carbon centre front attachment <b>AC</b> Part No. 51 19 2 472 193 2x Expanding rivet <b>AC'</b> Part No. 51 49 8 166 702	51 19 2 472 192
<b>AD</b>	Liquid adhesive (not included in kit, see EPC for details)	---	---
<b>AE</b>	Cleaner (not included in kit, see EPC for details)	---	---

### 3. Parts list for PUR side skirt attachment G30 LCI, G31 LCI and carbon side skirt attachment F90 LCI

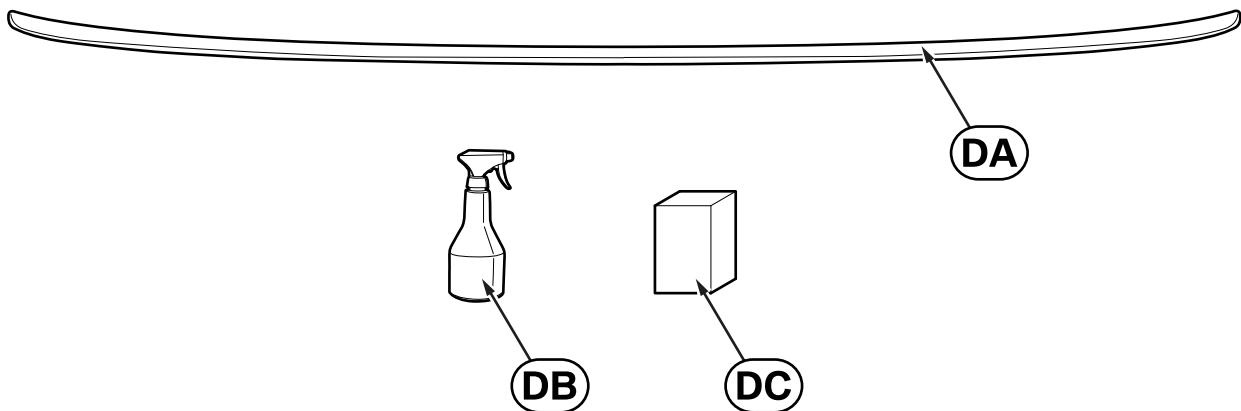


F90 0052 V

#### Legend

		Matt black side skirt attachment, left Quantity included in kit 51 19 2 411 019	Carbon left side skirt attachment Quantity included in kit 51 19 2 447 015	Matt black side skirt attachment, right Quantity included in kit 51 19 2 411 020	Carbon right side skirt attachment Quantity included in kit 51 19 2 447 016	BMW part number
BA	Matt black side skirt attachment, right	---	---	1	---	51 77 2 411 018
BA'	Carbon right side skirt attachment	---	---	---	1	51 77 2 447 020
BB	Matt black side skirt attachment, left	1	---	---	---	51 77 2 411 015
BB'	Carbon left side skirt attachment	---	1	---	---	51 77 2 447 019
BC	Oval-head self-tapping screw	14	14	14	14	07 14 7 133 553
BD	Expanding rivet	18	18	18	18	51 71 7 002 953
BE	Speed nut	1	1	1	1	07 14 9 282 347
BF	Cleaner (not included in kit, see EPC for details)	---	---	---	---	---

#### 4. Carbon rear spoiler parts list F90 LCI

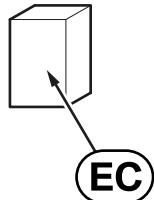
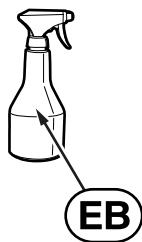
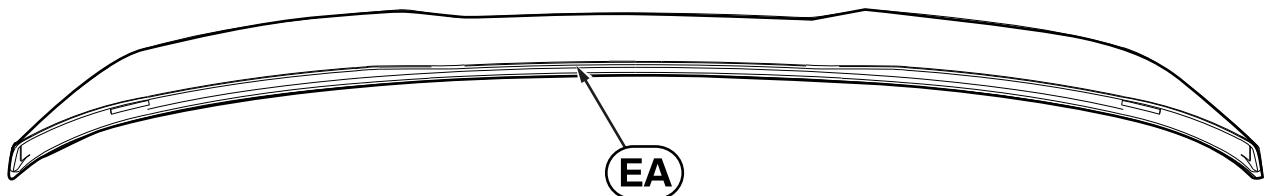


F90 0053 V

#### Legend

- DA** Carbon rear spoiler
- DB** Cleaner (not included in kit, see EPC for details)
- DC** Liquid adhesive (not included in kit, see EPC for details)

## 5. Carbon Pro rear spoiler parts list F90 LCI

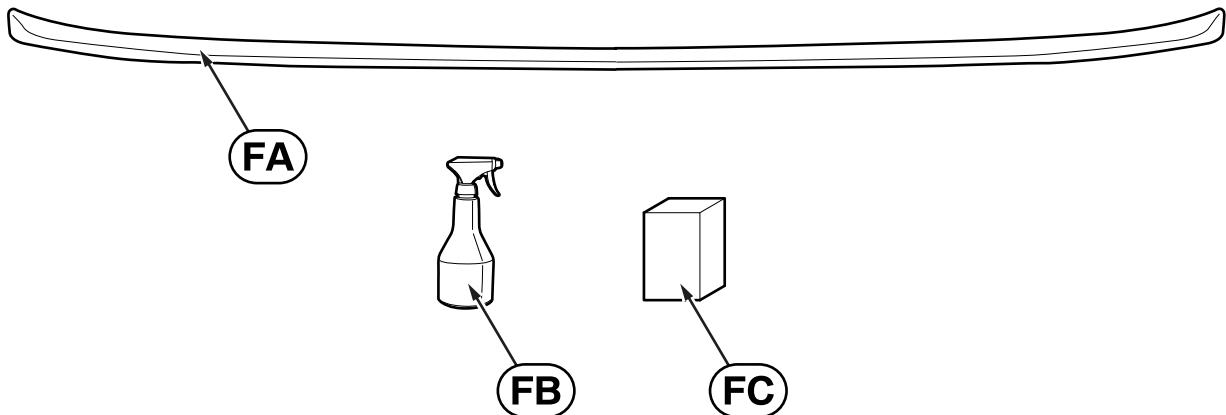


F90 0054 V

### Legend

- EA** Carbon Pro rear spoiler
- EB** Cleaner (not included in kit, see EPC for details)
- EC** Liquid adhesive (not included in kit, see EPC for details)

## 6. Matt black rear spoiler parts list G30 LCI, G31 LCI

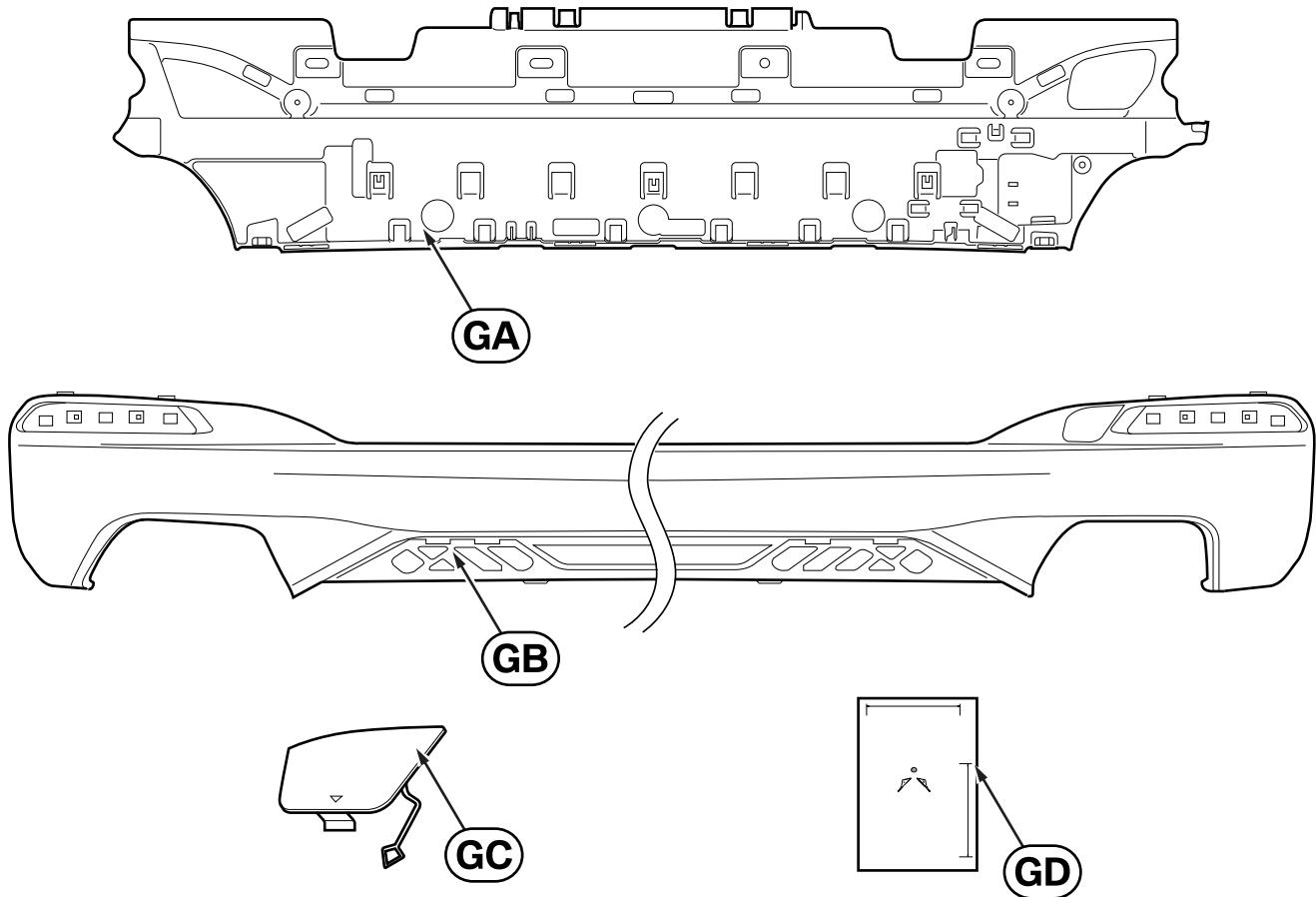


G30 0218 V

### Legend

- FA** Matt black rear spoiler
- FB** Cleaner (not included in kit, see EPC for details)
- FC** Liquid adhesive (not included in kit, see EPC for details)

## 7. Black high gloss bumper cover parts list G30 LCI, G31 LCI



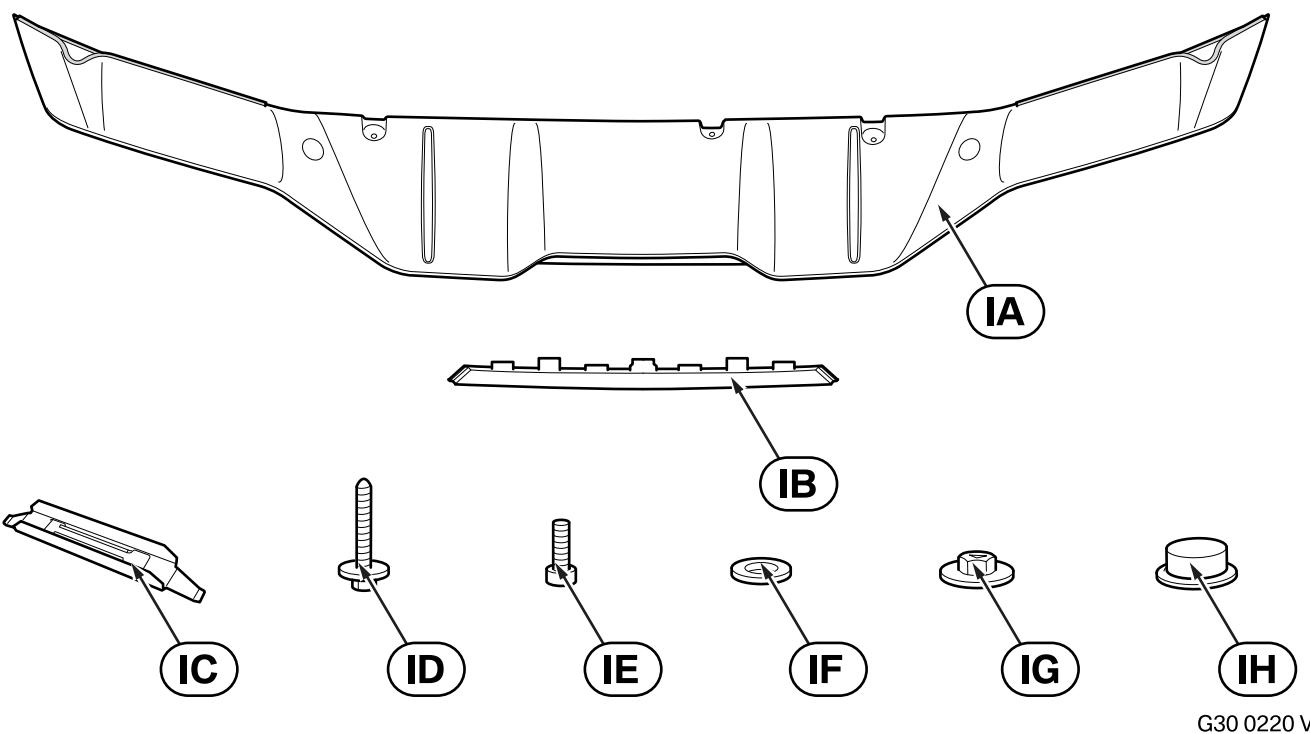
G30 0219 V

### Legend

		Black high gloss bumper cover (MSP) 51 19 2 469 556 (see EPC for details) Quantity included in kit	Black high gloss bumper cover (MPA) 51 19 2 469 558 (see EPC for details) Quantity included in kit	BMW part number
<b>GA</b>	Exhaust system support adapter cover	1	1	51 12 2 469 562
<b>GB</b>	Black high gloss bumper cover (MSP)	1	---	51 12 2 469 559
<b>GB'</b>	Black high gloss bumper cover (MPA)	---	1	51 12 2 469 560
<b>GC</b>	Towing eyelet cover	1	1	51 12 2 469 561
<b>GD</b>	Cutting template (only required for cars with large underfloor trim)	1	1	In the appendix to these installation instructions
Print on DIN A4 paper <b>without</b> scaling. To do this, in printer settings go to " <b>Actual size</b> ". The printer setting must not be set to "Fit". Check the reference dimension with a ruler on the hard copy.				

For the sake of simplicity, all illustrations show the black high gloss bumper cover (MSP) **GB**. Use same procedure to install the black high gloss bumper cover (MPA) **GB'**. ◀

## 8. Carbon rear diffuser parts list G30 LCI, G31 LCI

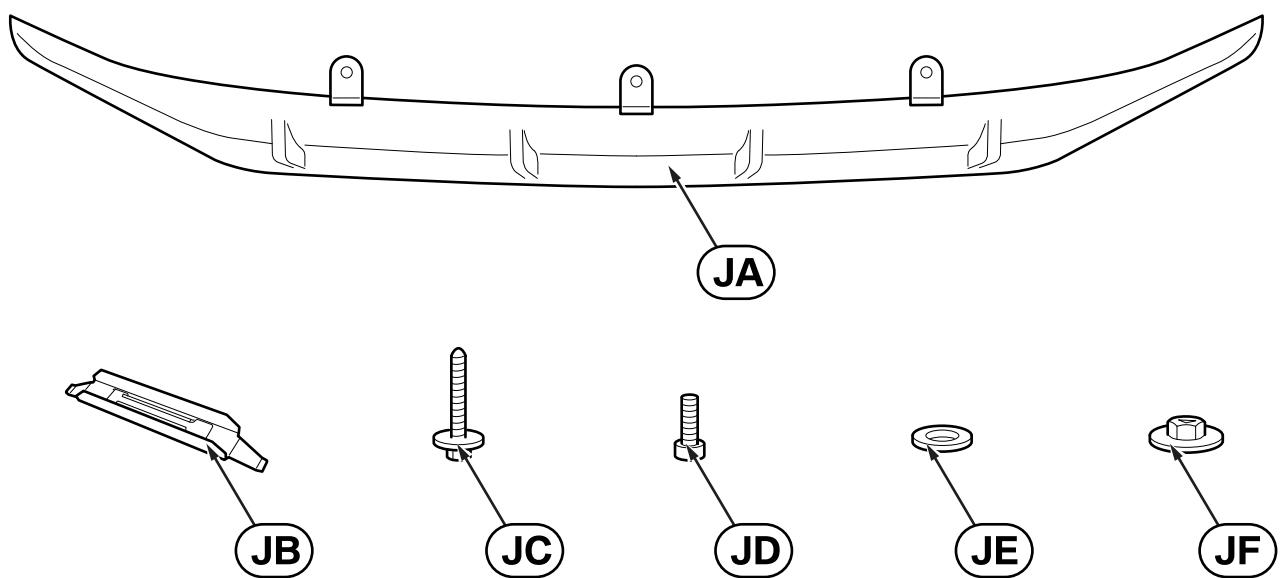


G30 0220 V

### Legend

		Carbon rear diffuser Quantity included in kit 51 19 2 412 405	BMW part number
<b>IA</b>	Carbon rear diffuser (including pre-installed edge protector)	1	51 12 2 412 412
<b>IB</b>	Matt black rear finisher	1	51 12 2 412 407
<b>IC</b>	Clamp	15	07 14 9 241 763
<b>ID</b>	Hexagon screw	2	07 14 9 213 164
<b>IE</b>	ISA screw with washer	2	07 12 9 905 262
<b>IF</b>	Washer	2	07 11 9 904 206
<b>IG</b>	Hexagon nut with washer	2	51 16 9 157 035
<b>IH</b>	Sealing bung Ø25.5 mm	2	---

## 9. Matt black rear diffuser parts list G30 LCI, G31 LCI



G30 0221 V

### Legend

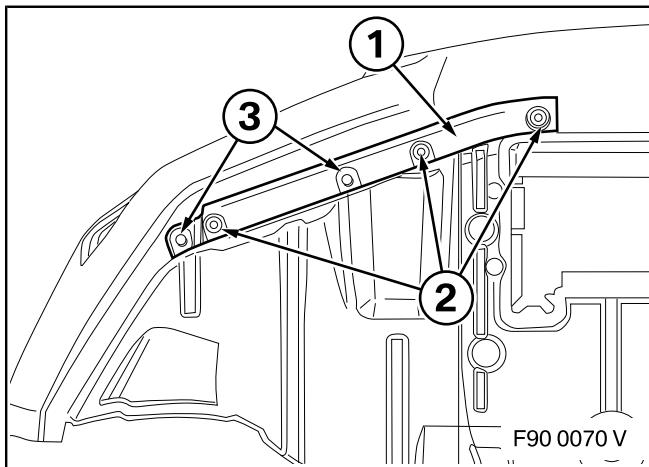
		<b>Matt black rear diffuser Quantity included in kit 51 19 2 412 406</b>	<b>BMW part number</b>
<b>JA</b>	Matt black rear diffuser	1	51 12 2 412 411
<b>JB</b>	Clamp	10	07 14 9 241 763
<b>JC</b>	Hexagon screw for plastic	3	07 14 9 110 670
<b>JD</b>	ISA screw with washer	2	07 12 9 905 262
<b>JE</b>	Washer	2	07 11 9 904 206
<b>JF</b>	Hexagon nut with washer	2	51 16 9 157 035

## 10. Preparatory work

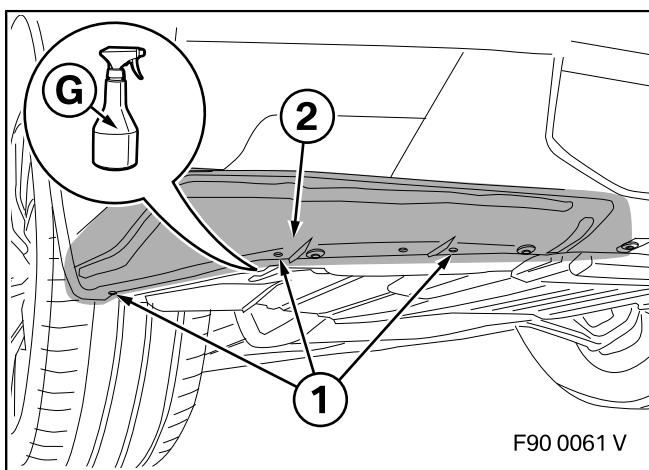
The following components must be removed first of all	ISTA No./AIR No.
<b>Only if installing the carbon left/right front attachment G30 LCI, G31 LCI</b>	
Left/right air guide	---
<b>Only if installing the left/right carbon front attachment G30 LCI, G31 LCI and carbon front attachment G30 LCI, G31 LCI</b>	
Left/right air guide and front engine shield	---
Top shock absorber (for 550i and 550d cars only)	---
<b>Only if installing the carbon rear spoiler</b>	
Rear spoiler (if standard component already installed)	---
<b>Only if installing the matt black rear diffuser G30 LCI, G31 LCI and carbon rear diffuser G30 LCI, G31 LCI</b>	
Underfloor trim	---
Rear trim	51 12 ...
Exhaust system support adapter cover	---
Control units and antennas from exhaust system support adapter cover	---
Left/right rear reflector	---

## 11. Installing the carbon front attachment F90 LCI

► All illustrations show the installation of the carbon right front attachment **A**. Proceed in the same way to install the carbon left front attachment **B**. ◀



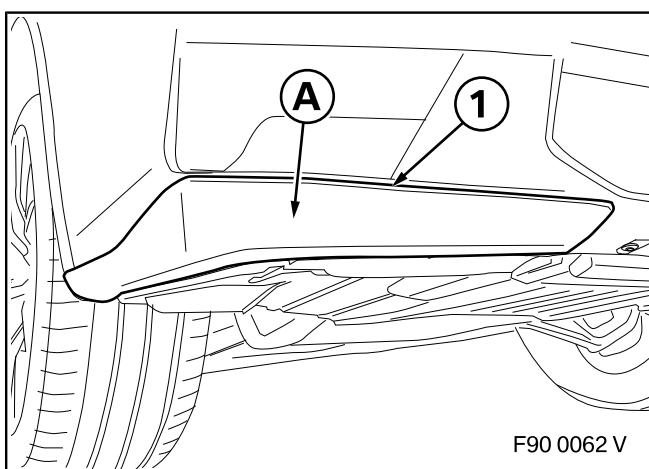
Remove the air guides (1) on both sides with the screws (2) and clips (3). They are no longer required.



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

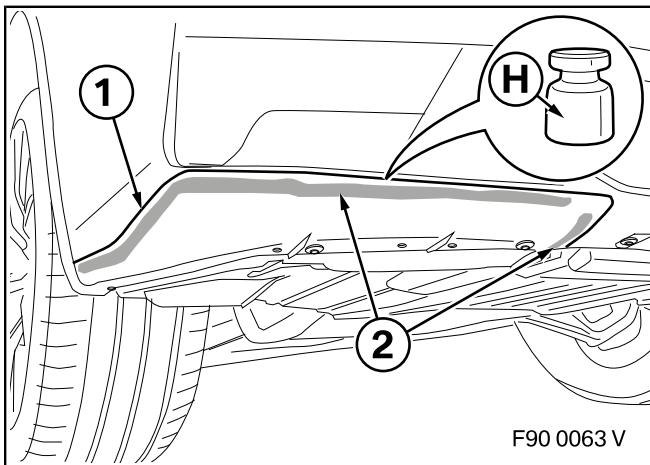
Remove the clips (1).

Clean the surface (2) of the car with cleaner **G** (not included in parts kit, see EPC further information).



Position carbon right front attachment **A** and mark the contour (1) on the front apron using suitable tools. Remove the carbon right front attachment **A**.

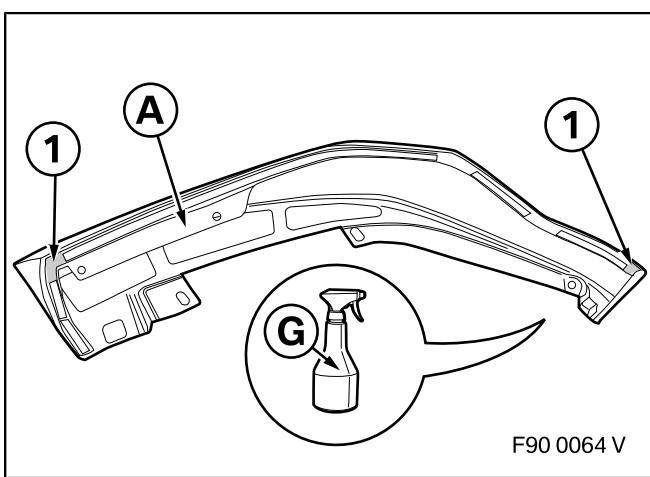
## 11. Installing the carbon front attachment F90 LCI



► Wait until the drying time has elapsed. ◀

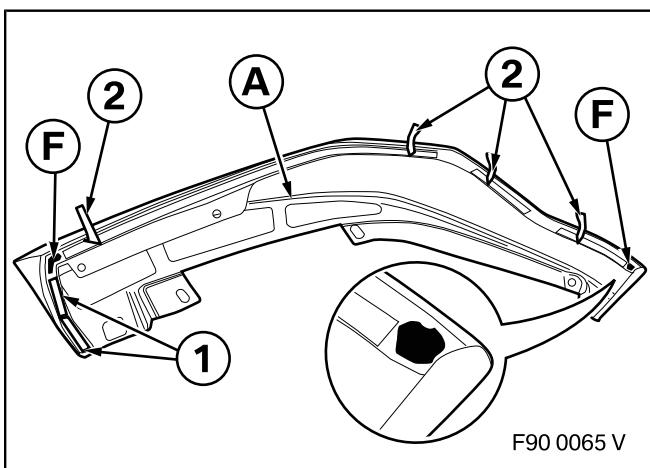
Prime the two surfaces (2) within the contour (1), as shown, with primer **H**. These surfaces are the contact points between the front apron and the adhesive tape on the front attachment.

Remove the contour (1) using suitable tools.



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

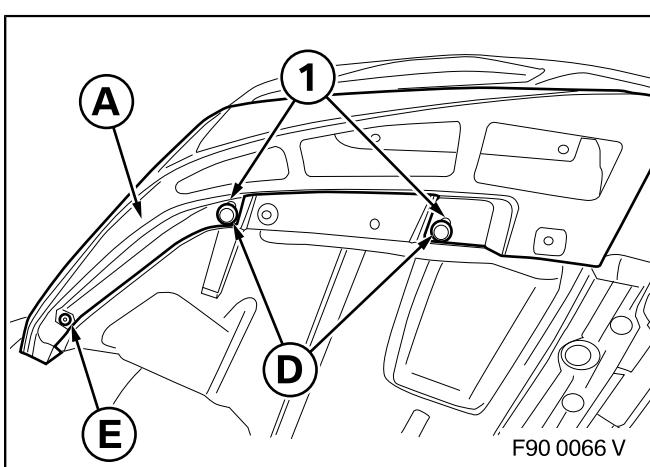
Abrade the surface (1) on the inside of the carbon right front attachment **A** using suitable tools and clean it with cleaner **G**.



Completely remove the backing films from the short adhesive strips (1).

Bend the ends of the backing films (2) to the outside.

Apply one dot of liquid adhesive **F** to the abraded surfaces.

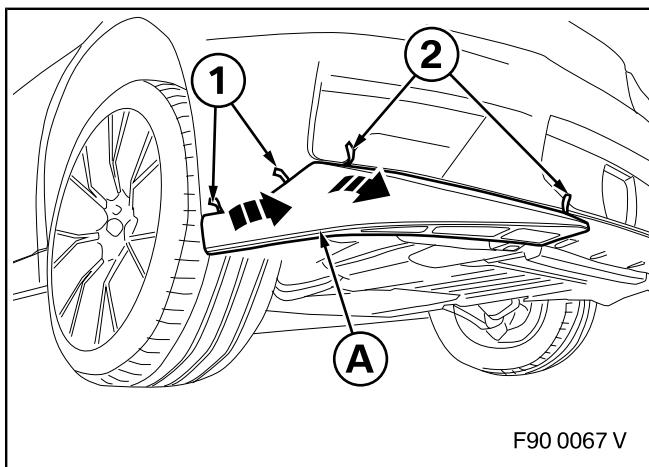


► Remove any excess liquid adhesive **F** immediately.

Position the expanding rivet **D** at the rear end of the overall hole (1). ◀

Position the carbon right front attachment **A** and first push in the external expanding rivet **E**. Then position the carbon right front attachment **A** and push in the two expanding rivets **D**.

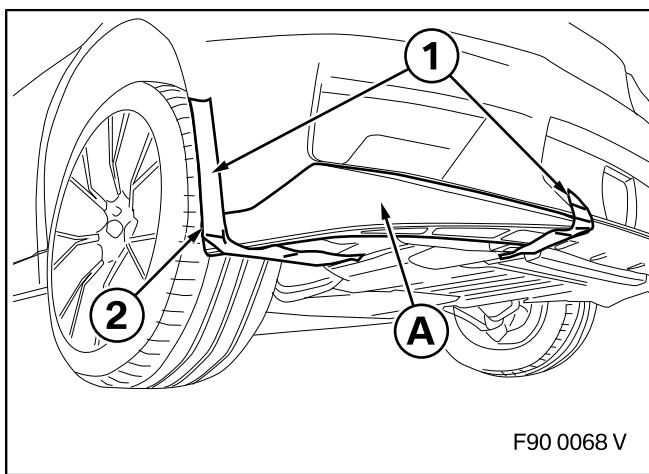
## 11. Installing the carbon front attachment F90 LCI



► Ensure that the gap is uniform. ◀

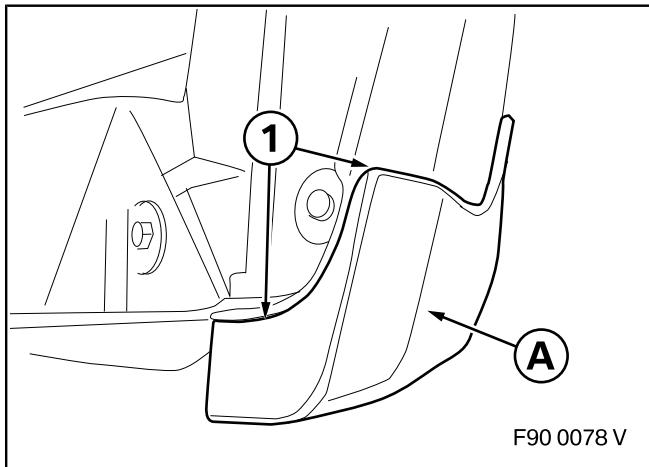
First pull out the film ends (1) and then (2) at an angle.

Press the carbon right front attachment **A** firmly onto the front apron several times.

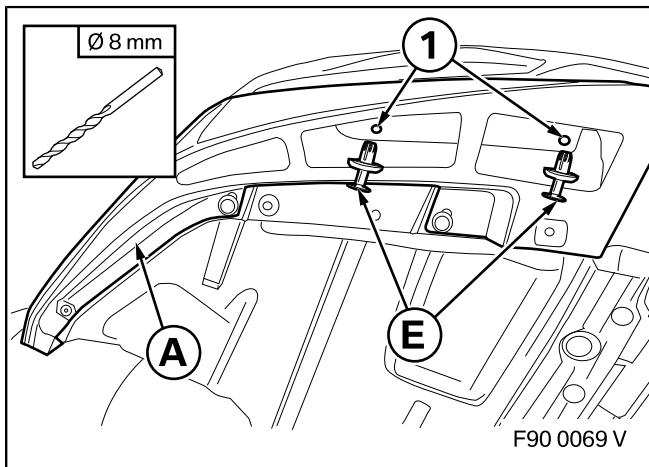


► Refer to the installation instructions on page 2. ◀

Secure the carbon right front attachment **A** with adhesive tapes (1) and a piece of foam (2) so that the gap is uniform.



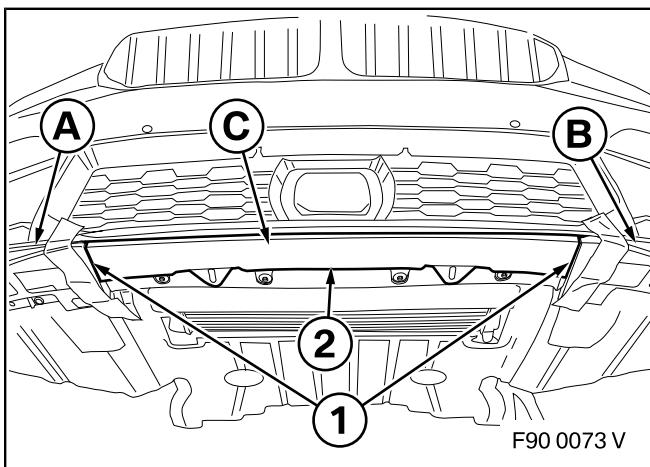
Use a clamp on the side of the carbon right front attachment **A** to ensure that it runs along the contour (1).



Drill the two holes (1) with a **diameter of 8 mm** through the front apron and press in the expanding rivet **E**.

► Repeat the whole installation procedure for the carbon left front attachment **B**. ◀

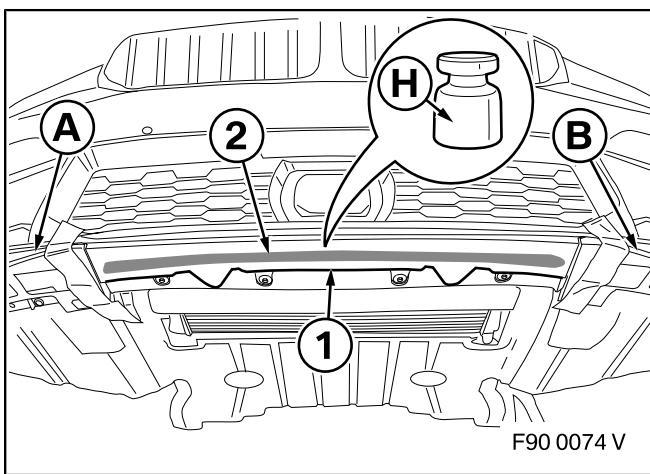
## 11. Installing the carbon front attachment F90 LCI



Push the carbon centre front attachment **C** between the two front attachments **A** and **B** and ensure that the gap is uniform (1) on both sides.

Mark the contour (2) (the internal edge) on the front apron using suitable tools.

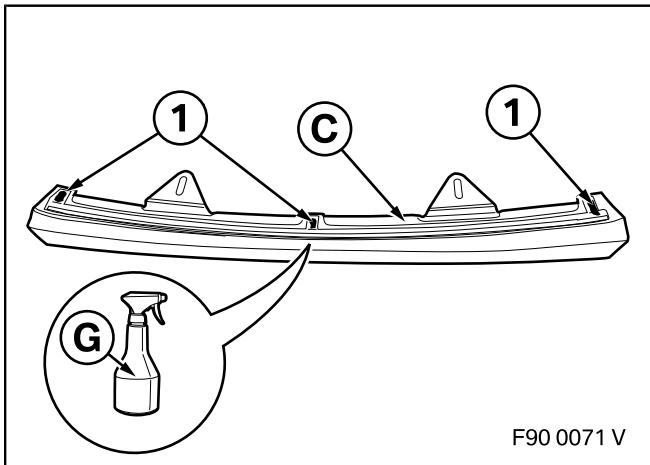
Remove the carbon centre front attachment **C**.



► Wait until the drying time has elapsed. ◀

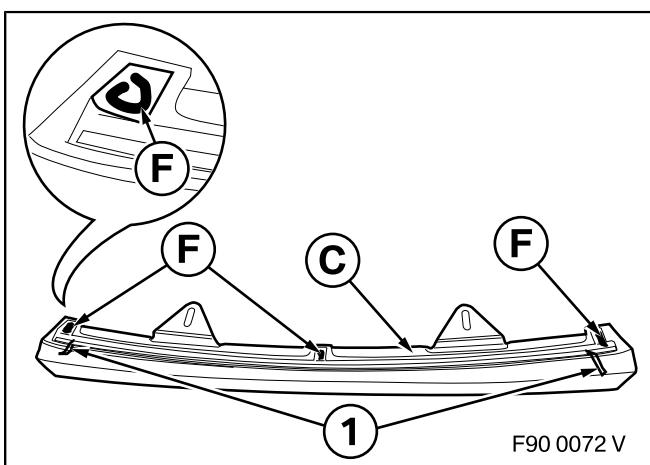
Prime the surface (2) within the contour (1), as shown, with primer **H**. These surfaces are the contact points between the front apron and the adhesive tape on the front attachment.

Remove the contour (1) using suitable tools.



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

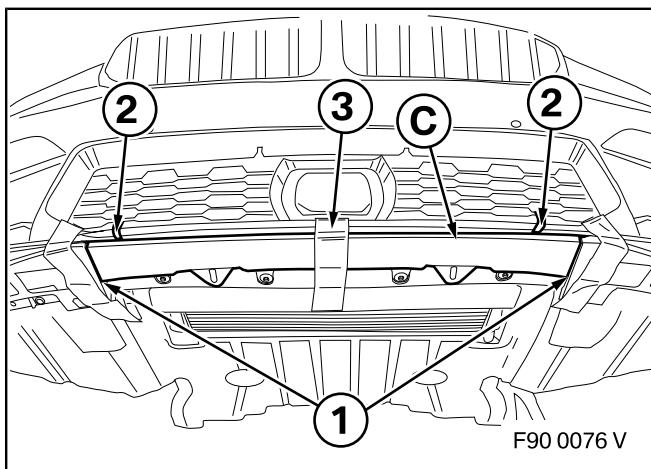
Abrade the three small surfaces (1) on the inside of carbon centre front attachment **C** using suitable tools and clean it with cleaner **G**.



Bend the ends of the backing film (1) to the outside.

Apply one dot of liquid adhesive **F** to the abraded surfaces.

## 11. Installing the carbon front attachment F90 LCI



► Carefully insert the front attachment between the two side sections. Ensure that no liquid adhesive is left on the front apron. Positioning: Position the centre front attachment **C** in the centre between the two side sections. Ensure it is flush with the front edge. ◀

Position the carbon centre front attachment **C** so that the gap (1) is uniform on both sides.

Pull out the two ends of the backing foil (2) at an angle.

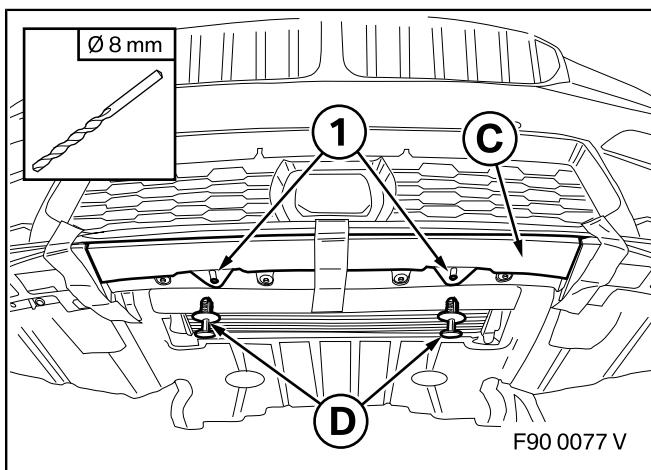
Apply firm pressure to all bonding surfaces on the inside from below (not shown).

Secure the carbon centre front attachment **C** with adhesive tape (3) and a foam piece if necessary so that the gap is uniform.

► Drill the two holes (1) in the oval holes as far to the rear as possible. ◀

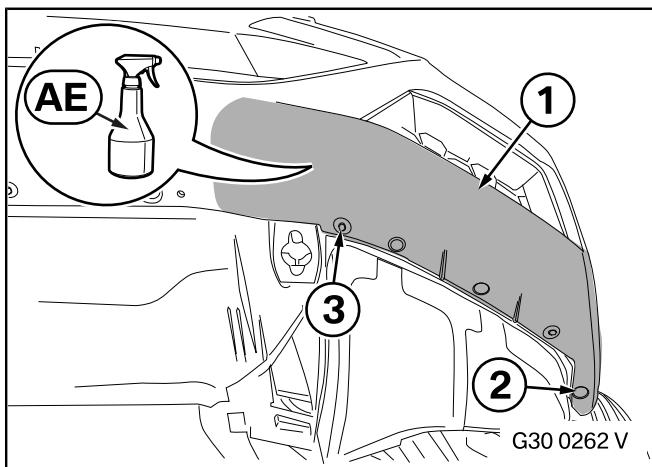
Drill the two holes (1) with a **diameter of 8 mm** through the front apron and press in the expanding rivet **D**.

► Refer to the installation instructions on page 2. ◀



## 12. Installing the carbon front attachment G30 LCI, G31 LCI

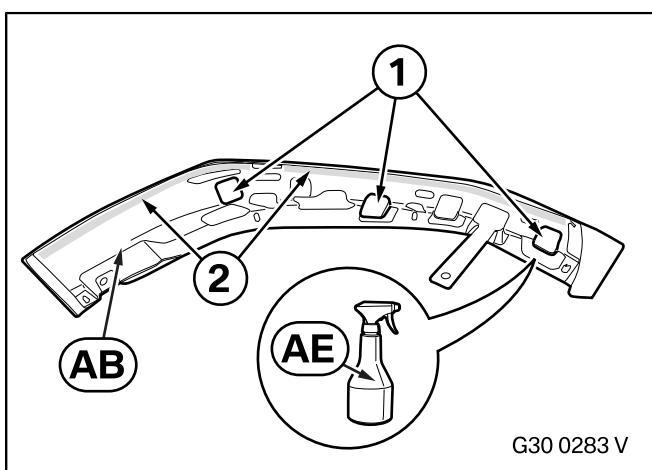
► All illustrations show the installation of the carbon left front attachment **AB**.  
Use the same procedure to install the carbon right front attachment **AA**. ◀



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

Clean the surface (1) of the car with cleaner **AE** (not included in parts kit, see EPC further information).

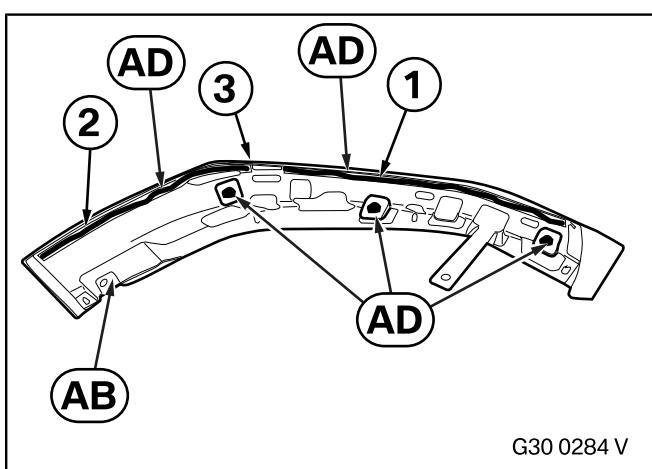
Remove the clip (2) and screw (3).



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

Wait until the drying time has elapsed. ◀

Abrade the small surfaces (1) on the inside of the carbon left front attachment **AB** and the surfaces (2) using suitable tools and clean them with cleaner **AE**.

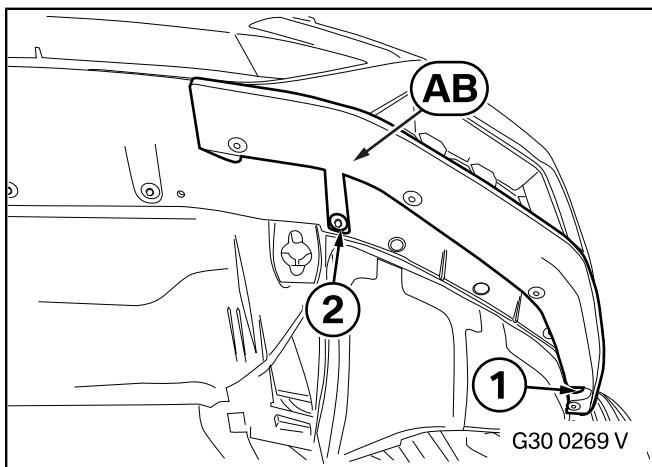


Apply one dot of liquid adhesive **AD** to the surfaces you abraded earlier.

Also apply the liquid adhesive **AD** to surfaces (1) and (2) over their full length. Start at the edge of the PU substructure and apply it right into the radius (3) as shown.

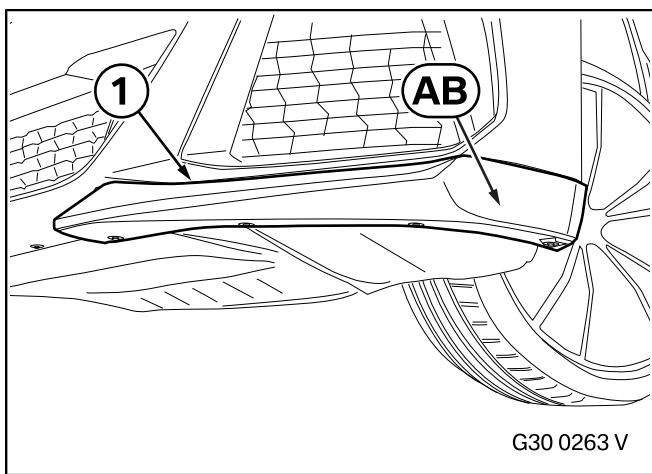
Within the radius (between **AD** and (3)), ensure that sufficient liquid adhesive is applied to the carbon shell so that it can bond firmly direct to the bumper trim.

## 12. Installing the carbon front attachment G30 LCI, G31 LCI



► Remove any excess liquid adhesive **AD** immediately. ◀

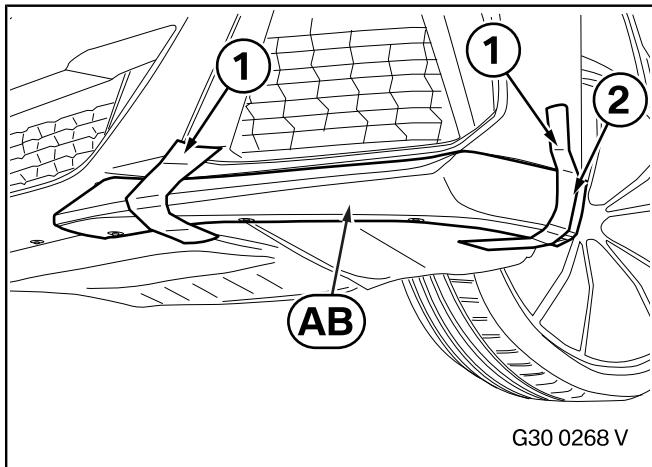
Position the carbon left front attachment **AB** and push in the existing expanding rivet (1). Then tighten the existing screw (2).



► Ensure that the gap (1) is uniform. ◀

Press the carbon left front attachment **AB** firmly onto the front apron several times.

► Remove any excess liquid adhesive immediately using suitable tools. ◀

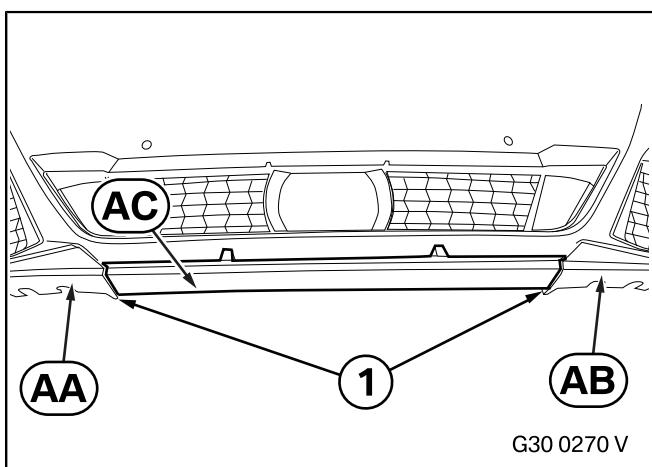


Secure the carbon left front attachment **AB** with strips of adhesive tape (1) and a piece of foam (2) so that the gap is uniform. It is possible that more than the two pieces of adhesive tape/foam may be required.

► Ensure that the various adhesion points on the underside of the front apron are correctly positioned. If necessary, secure them with adhesive tape, including towards the underbody.

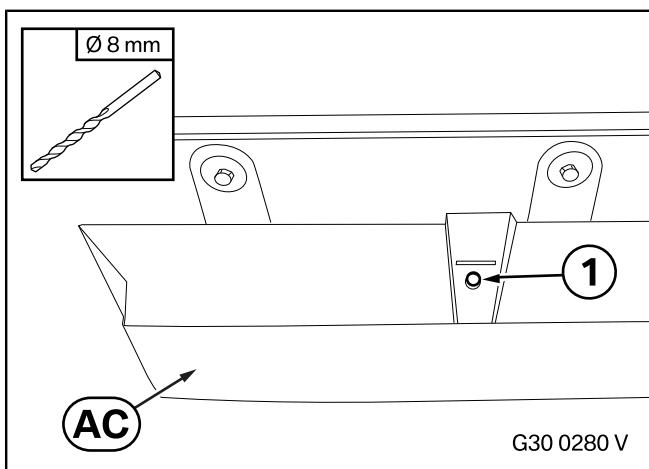
Refer to the installation instructions on page 2.

Then repeat the same steps for the carbon right front attachment **AA**. ◀



Push the carbon centre front attachment **AC** between the two front attachments **AA** and **AB** and ensure that the gap is uniform (1) on both sides.

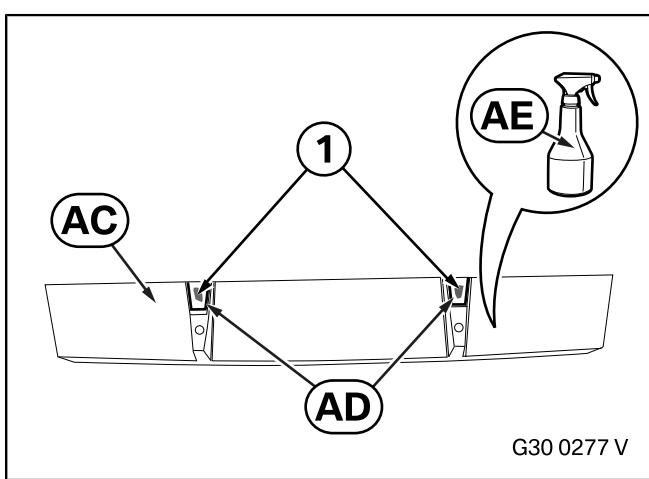
## 12. Installing the carbon front attachment G30 LCI, G31 LCI



Mark the two holes (1) on the front apron.

Remove the carbon centre front attachment **AC**.

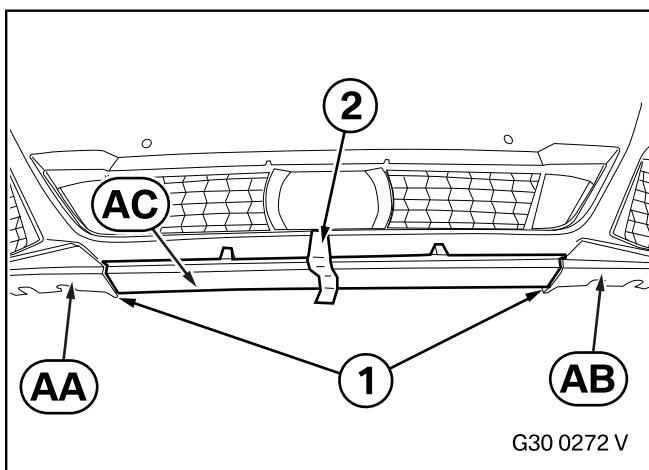
Then drill the two holes (1) with a **diameter of 8 mm** through the front apron.



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

Abrade the small surfaces (1) on the carbon centre front attachment **AC** using suitable tools and clean it with cleaner **AE**.

Apply a large dot of liquid adhesive **AD** to the abraded surfaces.

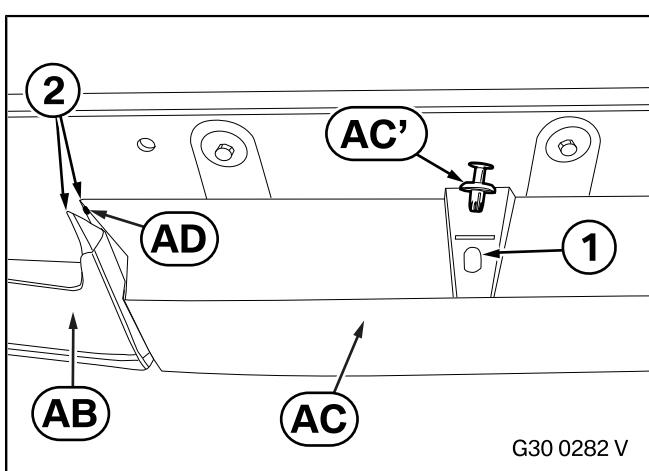


► Remove any excess liquid adhesive **AD** immediately. ◀

Position the carbon centre front attachment **AC** so that the gap (1) is uniform on the both sides.

Secure the carbon centre front attachment **AC** with adhesive tape (2) and a foam piece if necessary so that the gap is uniform.

► If necessary, adjust the carbon front attachments **AA** and **AB** slightly. Then recheck and clean all the joints. ◀



Push the two expanding rivets **AC'** into the two boreholes (1).

Then glue the carbon centre front attachment **AC** to the carbon front attachment **AB** flush at the corners (2) using a dot of liquid adhesive **AD**. Fix the corners (2) temporarily using suitable equipment (clips for adhesive tape).

Repeat this process with the carbon front attachment **AA**.

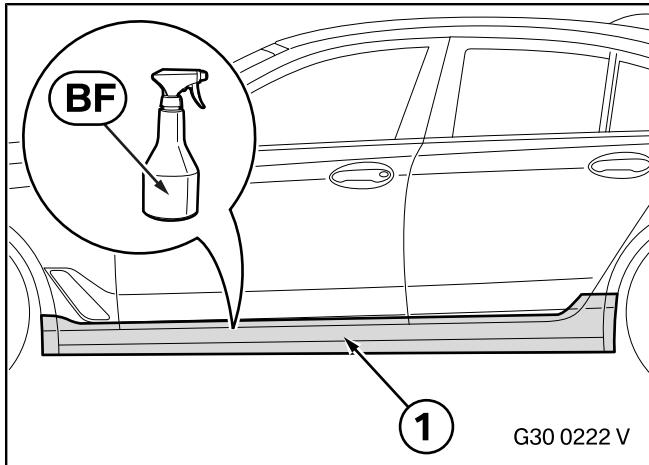
► Remove any excess liquid adhesive **AD** immediately. ◀

Refer to the installation instructions on page 2. ◀

### 13. Installing the matt black side skirt attachment G30 LCI, G31 LCI and carbon side skirt attachment F90 LCI

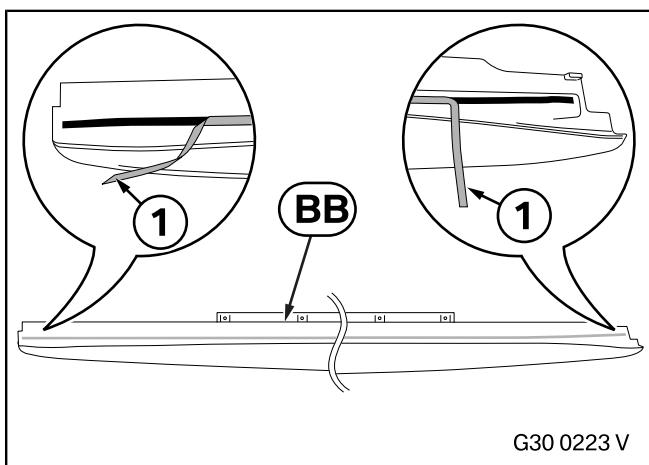
- All illustrations show the installation of the matt black left side skirt attachment **AB**. Use the same procedure to install the matt black right side skirt attachment **BA**, carbon right side skirt attachment **BA'** and carbon left side skirt attachment **BB'**. ◀
- Please note that if you are also installing the side skirt film, it must be affixed to the car before you install the matt black side skirt attachment **BA** and **BB**, and the carbon side skirt attachment **BA'** and **BB'**.

Complete the installation work as described in installation instructions No. **01 29 2 298 023**. ◀

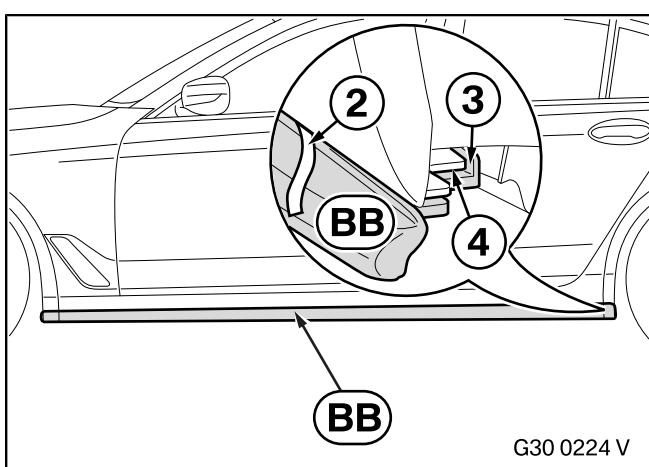


➤ The bonding surfaces must be completely dry, clean, and free from wax or grease. ◀

Clean the surface (1) of the car with cleaner **BF** (not included in the parts kit, see EPC for further details).



Release a little of the backing film (2) on both sides of the matt black left side skirt attachment **BB**.

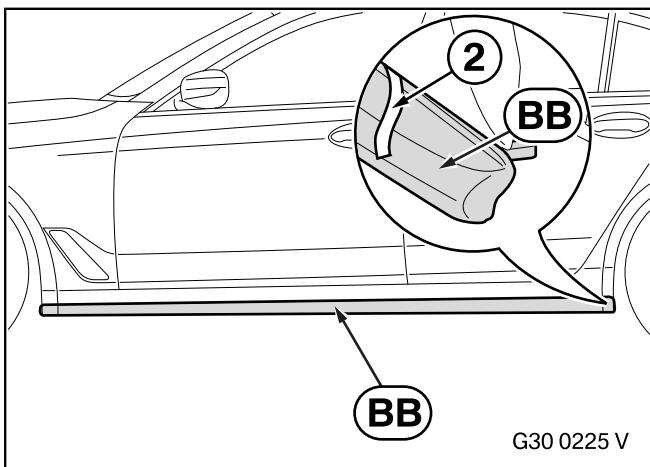


➤ Ensure that the released ends of the adhesive backing film (2) are visible. ◀

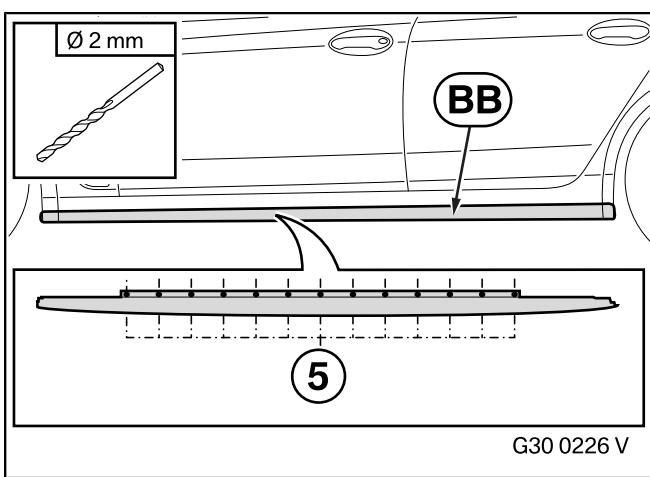
Position the matt black left side skirt attachment **BB** so that the stop (3) is behind the car edge (4).

Centre the matt black left side skirt attachment **BB**.

### 13. Installing the matt black side skirt attachment G30 LCI, G31 LCI and carbon side skirt attachment F90 LCI

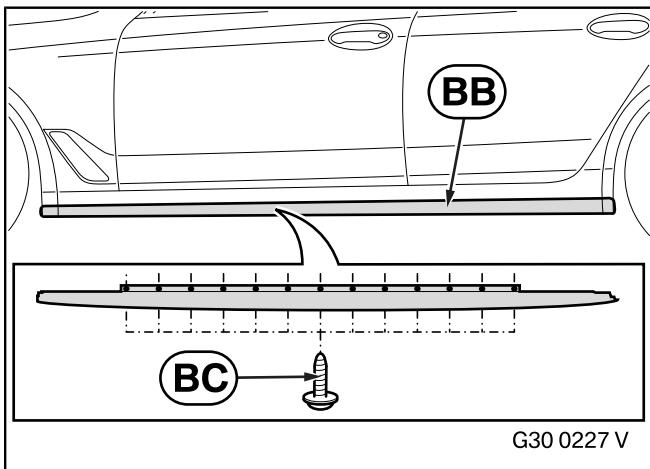


Carefully remove the backing film (2) from outside to inside and firmly press the matt black left side skirt attachment **BB** into position.

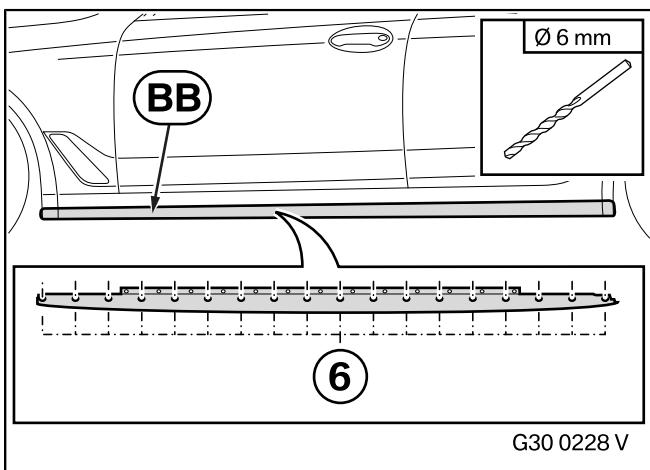


► When drilling down to the drill depth, take care not to damage parts underneath. ◀

Use a Ø 2 mm drill bit to mark the 13 holes (5) in the matt black left side skirt attachment **BB** on the side skirt.



Install the matt black left side skirt attachment **BB** using oval-head self-tapping screws **BC**.



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

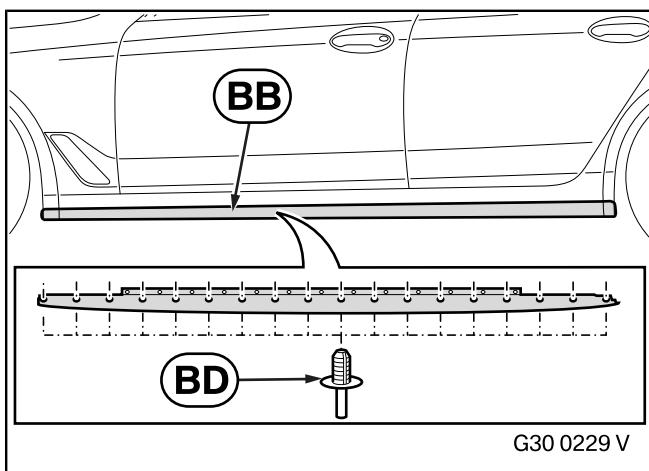
**For matt black side skirt attachment G30 LCI, G31 LCI only:**

Use a Ø 6 mm drill bit to drill through the 18 hole marks (6) in the matt black left side skirt attachment **BB** and transfer them to the side skirt.

**For carbon side skirt attachment F90 LCI only:**

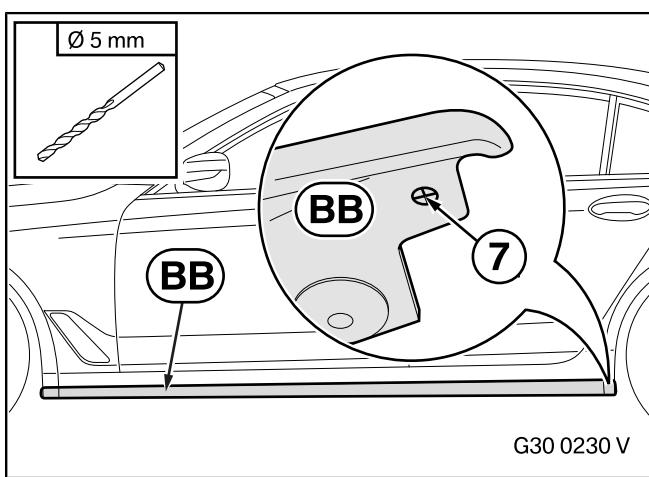
Use a Ø 6 mm drill bit to drill the 18 holes (6) in the side skirt.

### 13. Installing the matt black side skirt attachment G30 LCI, G31 LCI and carbon side skirt attachment F90 LCI



Install the matt black left side skirt attachment **BB** using expanding rivets **BD**.

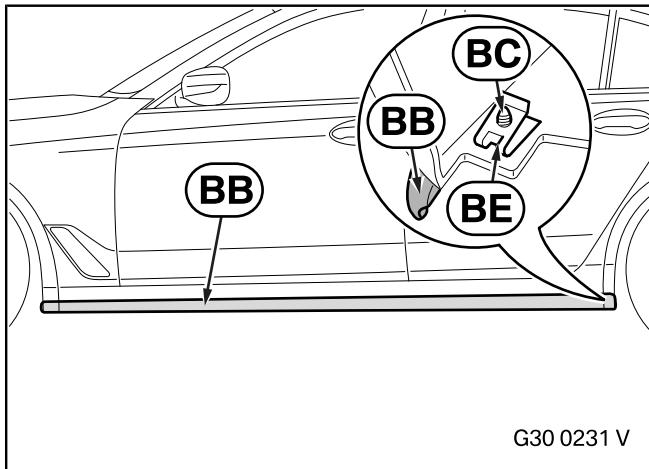
Release the rear wheel arch trim a little.



**For matt black side skirt attachment G30 LCI, G31 LCI only:**

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

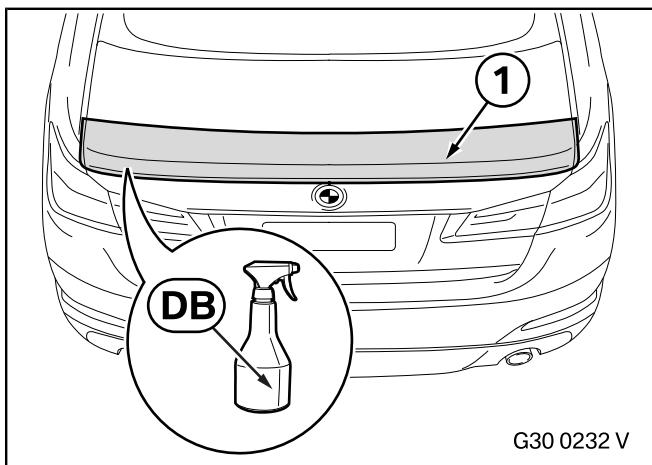
Use a Ø 5 mm drill bit to transfer the hole (7) at the mark on the matt black left side skirt attachment **BB** to the side skirt.



Install speed nut **BE** using oval-head self-tapping screw **BC** on the matt black left side skirt attachment **BB**.

Return the rear wheel arch trim to its original position.

## 14. Installing the carbon rear spoiler G30 LCI, F90 LCI



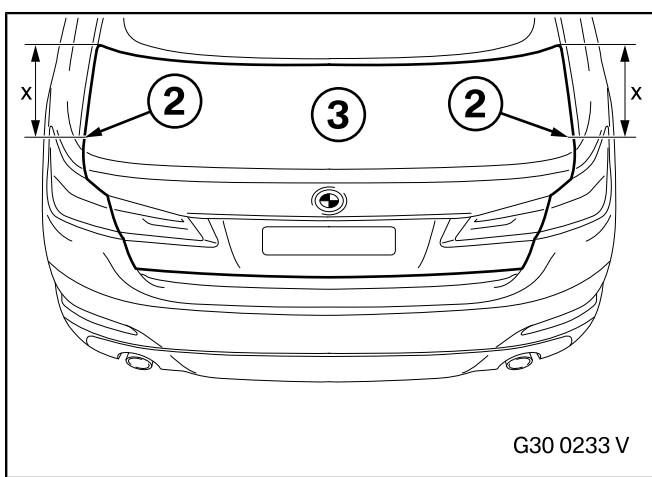
### For F90 LCI only:

Remove the standard rear spoiler as described in **ISTA/AIR**.

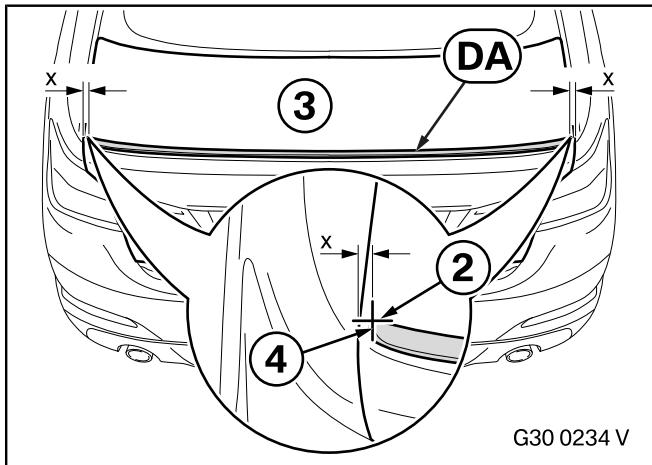
### For all cars:

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

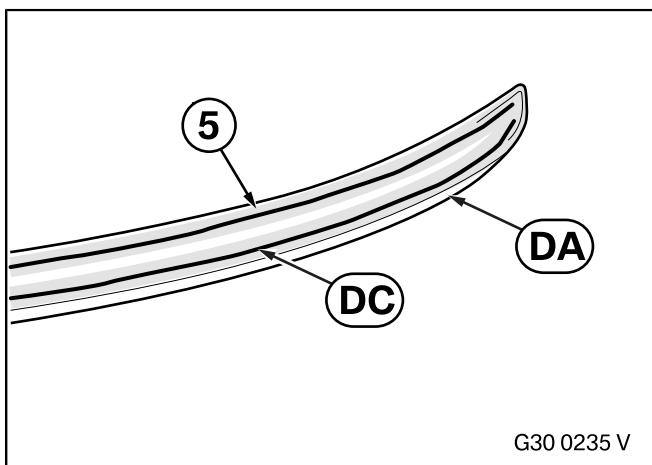
Clean the surface (1) of the car with cleaner **DB** (not included in the parts kit, see EPC for further details).



Make a mark (2) with the dimension  **$x = 441 \text{ mm}$**  measured from the front corner of the boot lid (3) using suitable tools.



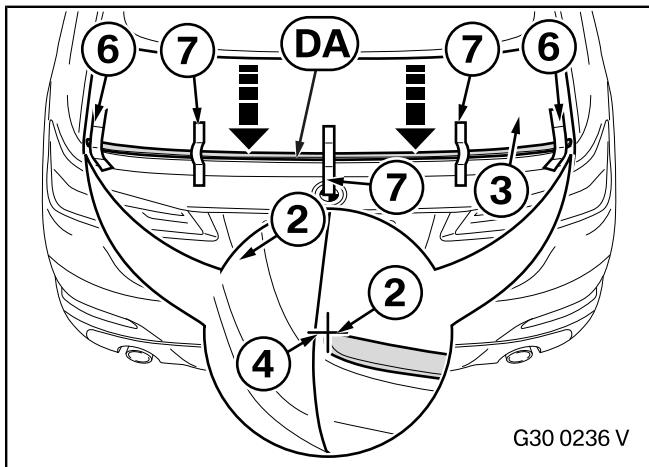
Position the carbon rear spoiler **DA** on the marks (2) you made earlier on the boot lid (3), centre it and mark the position (4) with suitable tools.



Abrade and clean the edge area (5) of the carbon rear spoiler **DA** using suitable tools.

Apply an adequate quantity of liquid adhesive **DC**, as shown, in the form of a bead, **generously** to the carbon rear spoiler **DA**.

## 14. Installing the carbon rear spoiler G30 LCI, F90 LCI



► Remove any excess liquid adhesive **DC** immediately.

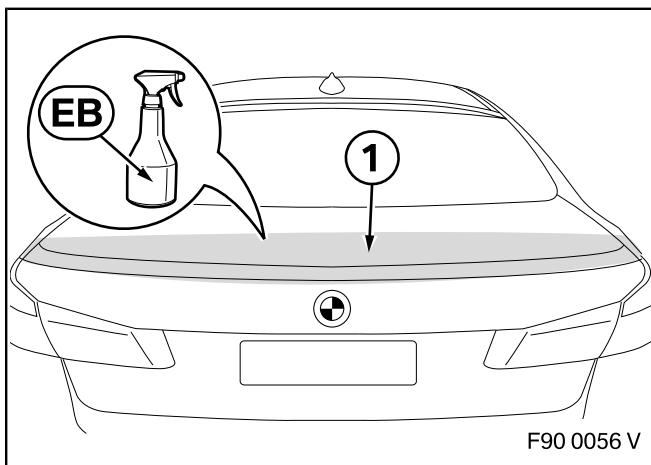
Ensure that the gap is uniform. ◀

Position the carbon rear spoiler **DA** between the marks (2) and (4), align it and press it firmly into position.

Secure the carbon rear spoiler **DA** first with the outer adhesive tapes (6) and then with the inner adhesive tapes (7). Ensure that the gap is uniform.

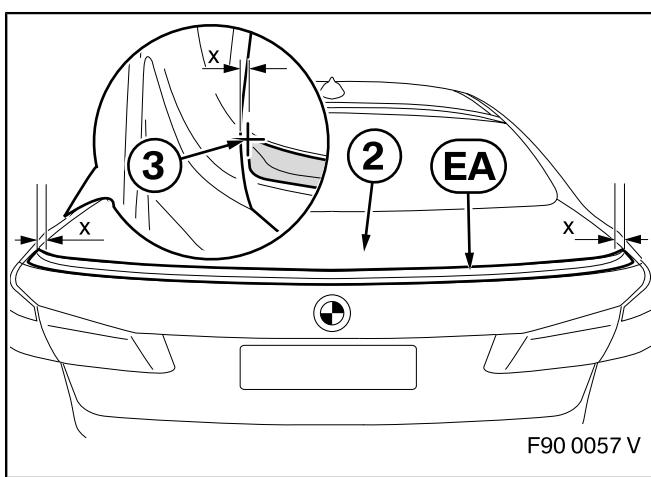
Do not remove the adhesive tapes (6) and (7) for at least 6 hours.

## 15. Installing the carbon Pro rear spoiler G30 LCI, F90 LCI

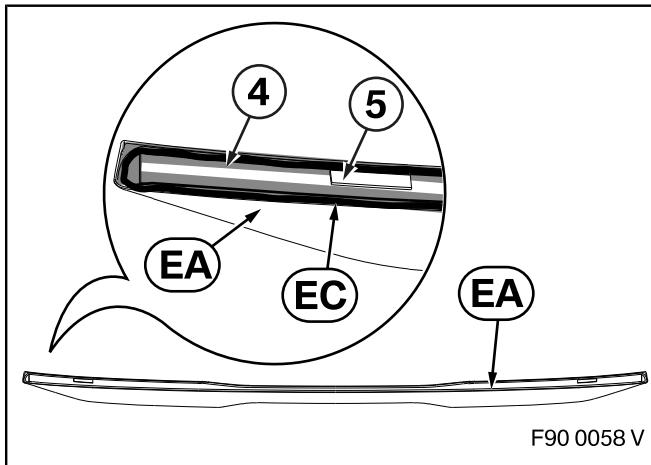


► The bonding surfaces must be completely dry, clean, and free from wax or grease. ◀

Clean the surface (1) of the car with cleaner **EB** (not included in the parts kit, see EPC for further details).



Position the carbon Pro rear spoiler **EA** on the boot lid (2), centre it and mark the position (3) with suitable tools.

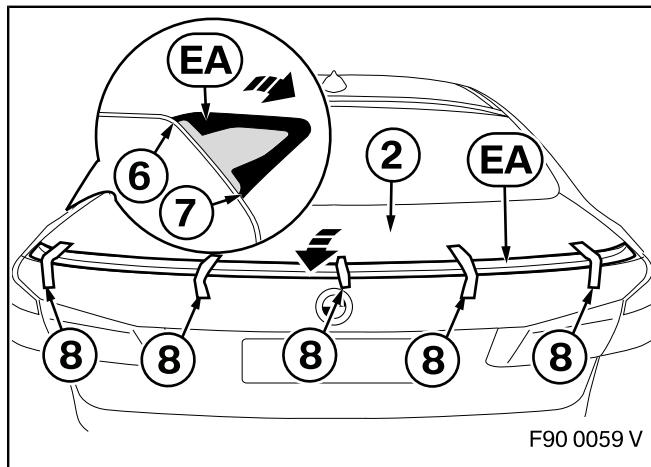


Abrade and clean the edge area (4) of the carbon Pro rear spoiler **EA** using suitable tools.

Apply an adequate quantity of liquid adhesive **EC**, as shown in the form of a bead, **generously** to the carbon Pro rear spoiler **EA**.

Remove the backing foil (5) in full.

## 15. Installing the carbon Pro rear spoiler G30 LCI, F90 LCI



► Remove any excess liquid adhesive **EC** immediately. ↗

Position the carbon Pro rear spoiler **EA** between the marks (3) and align it.

Pull the centre of the carbon Pro rear spoiler **EA** to the rear in the direction shown by the arrow until the front gap (6) has closed. Then press the carbon Pro rear spoiler **EA** onto the boot lid (2) so that the bottom gap (7) closes.

Secure the carbon Pro rear spoiler **EA** with adhesive tape (8) first in the centre and then on the outside. Do not remove the adhesive tape (8) for at least 6 hours.

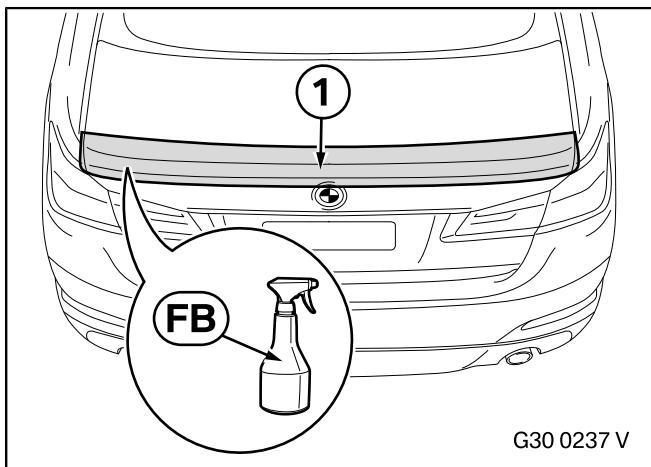
## 16. Installing the matt black rear spoiler G30 LCI, G31 LCI

### Painting instructions

Check that all the kit components fit accurately on the car before painting them. Primed kit components must be pre-treated appropriately before painting.

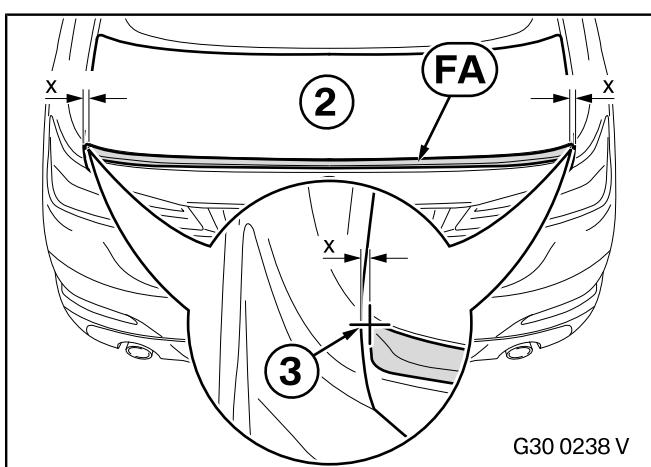
Follow the BMW painting instructions (see **ISTA/AIR 99 00 ...**).

 The matt black rear spoiler **FA** can be painted as required by the customer. ◀

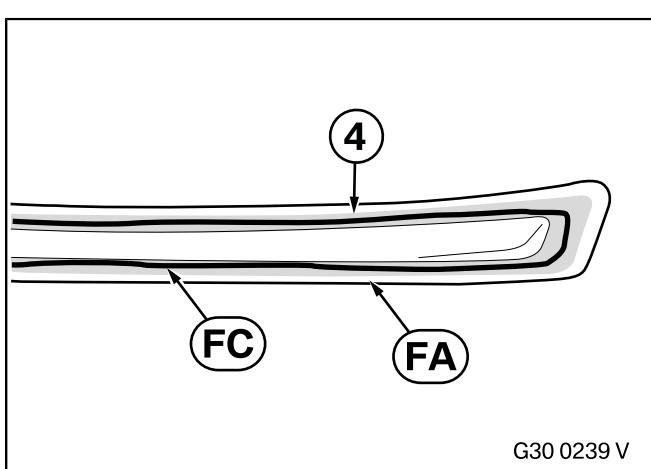


 The bonding surfaces must be completely dry, clean, and free from wax or grease. ◀

Clean the surface (1) of the car with cleaner **FB** (not included in the parts kit, see EPC for further details).



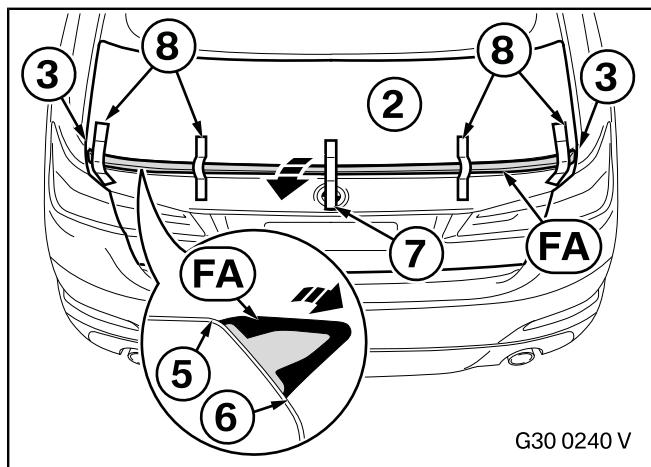
Position the matt black rear spoiler **FA** on the boot lid (2), centre it and mark the position (3) using suitable tools.



Abrade and clean the edge area (4) of the matt black rear spoiler **FA** using suitable products.

Apply an adequate quantity of liquid adhesive **FC**, as shown, in the form of a bead, **generously** to the matt black rear spoiler **FA**.

## 16. Installing the matt black rear spoiler G30 LCI, G31 LCI



► Remove any excess liquid adhesive **FC** immediately. ▲

Position the matt black rear spoiler **FA** between the marks (3) and align it.

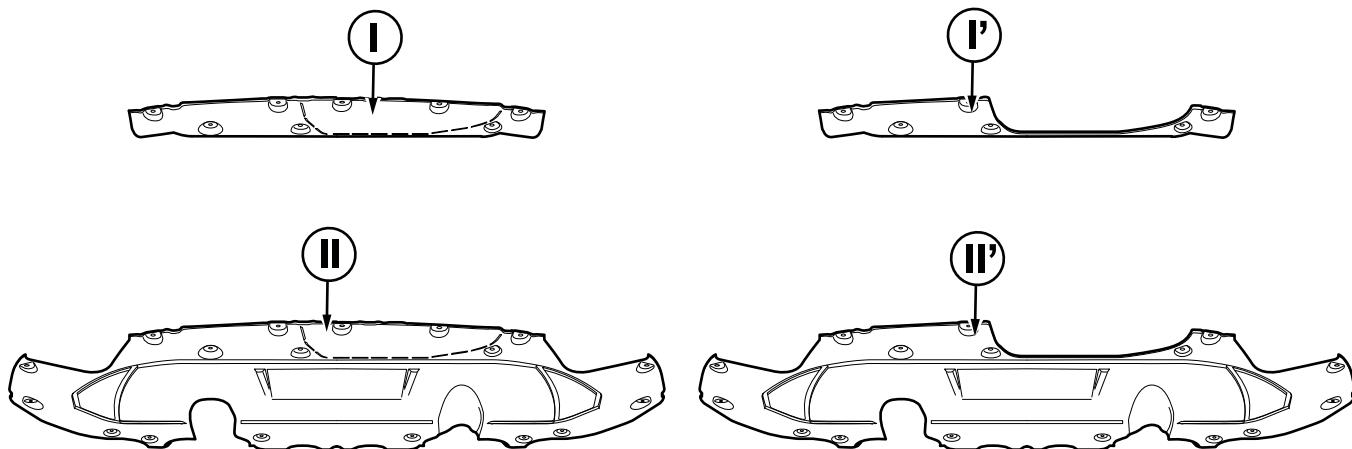
Pull the centre of the matt black rear spoiler **FA** to the rear in the direction shown by the arrow until the front gap (5) has closed. Then press the matt black rear spoiler **FA** onto the boot lid (2) so that the bottom gap (6) also closes.

Secure the matt black rear spoiler **FA** first in the centre with adhesive tape (7) and then with the outer adhesive tapes (8).

Do not remove the adhesive tapes (7) and (8) for at least 6 hours.

## 17. Installing the exhaust system support adapter cover G30 LCI, G31 LCI

### Underfloor trim versions



G30 0254 V

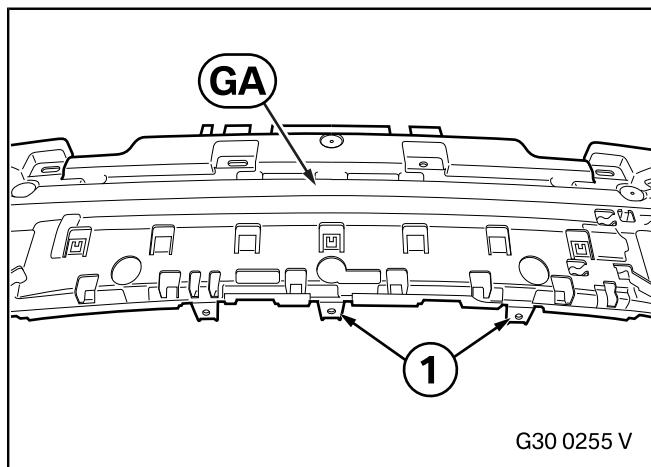
- I Small underfloor trim for cars without trailer tow hitch (SA 3AC)
- II Large underfloor trim for cars without trailer tow hitch (SA 3AC)
- I' Small underfloor trim for cars with trailer tow hitch (SA 3AC)
- II' Large underfloor trim for cars with trailer tow hitch (SA 3AC)

For the sake of simplicity, all the illustrations for installing the matt black rear diffuser **JA** and carbon rear diffuser **IA** on the car show the small underfloor trim for cars without a trailer tow hitch (SA 3AC) **I**.

Proceed in the same way to install it on cars with the **II**, **I'** and **II'** versions of the underfloor trim. ◀

For the sake of simplicity, the designations small underfloor trim **I** and large underfloor trim **II** are used in the following description. ◀

### For all retrofitted items



#### For cars with trailer tow hitch (SA 3AC):

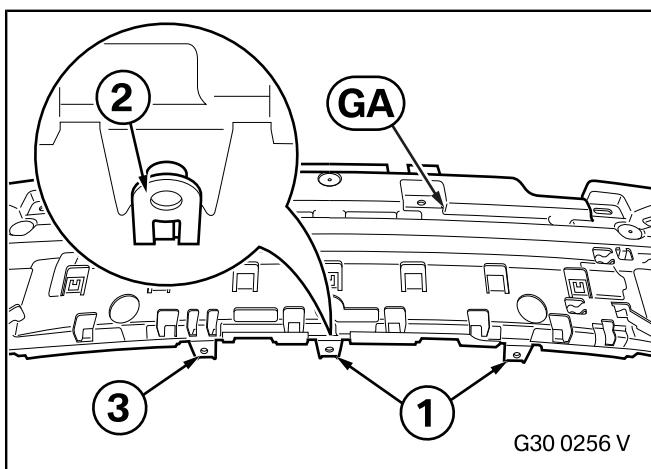
Break the lugs (1) off the exhaust system support adapter cover **GA** with a suitable tool.

#### For all cars:

Install the control units and antennas from the standard exhaust system support adapter cover on the exhaust system support adapter cover **GA** as described in **ISTA/AIR**.

Install the exhaust system support adapter cover **GA** as described in **ISTA/AIR**.

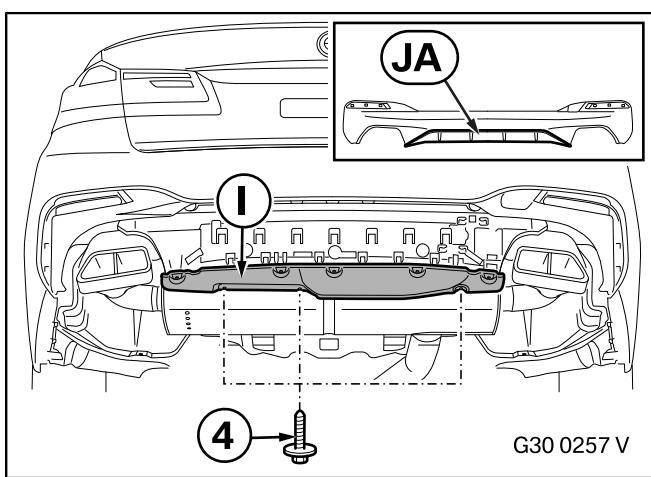
## 17. Installing the exhaust system support adapter cover G30 LCI, G31 LCI



► The lugs (1) are only present on cars without a trailer tow hitch (SA 3AC). ◀

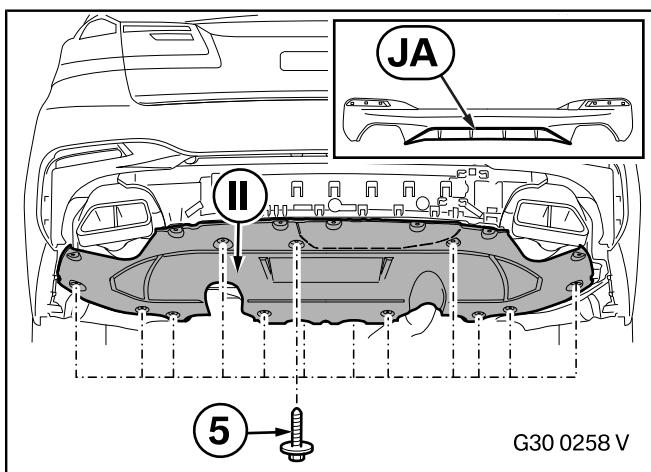
Place clips (2) from the standard exhaust system support adapter cover on the lugs (1) and (3) of the exhaust system support adapter cover **GA**.

Install the rear cover without the bottom rear trim as described in **ISTA/AIR**.



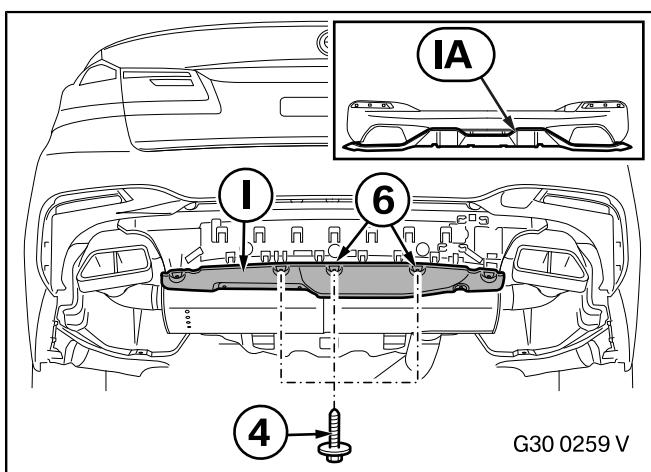
### For cars with small underfloor trim I to install matt black rear diffuser JA:

Install small underfloor trim **I** as described in **ISTA/AIR**. Only tighten the hexagon screws (4) on the standard component shown here.



### For cars with large underfloor trim II to install matt black rear diffuser JA:

Install large underfloor trim **II** as described in **ISTA/AIR**. Only tighten the hexagon screws (5) on the standard component shown here.

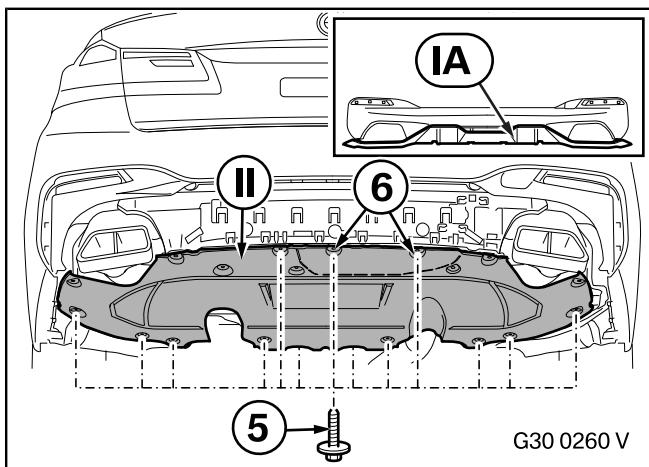


### For cars with small underfloor trim I to install carbon rear diffuser IA:

► The fastening points (6) are only to be installed on cars without a trailer tow hitch (SA 3AC). ◀

Install small underfloor trim **I** as described in **ISTA/AIR**. Only tighten the hexagon screws (4) on the standard component shown here.

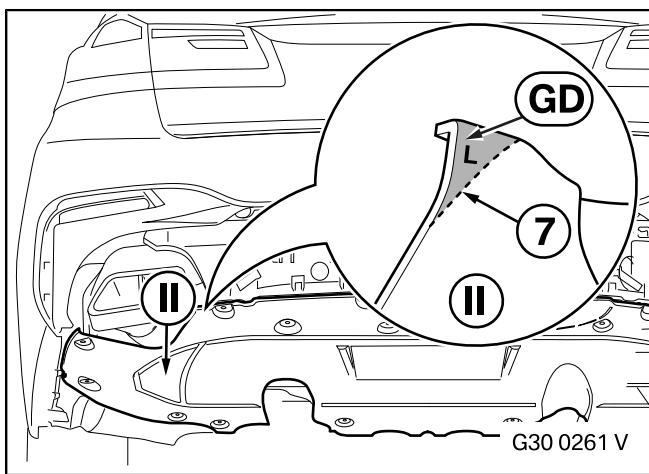
## 17. Installing the exhaust system support adapter cover G30 LCI, G31 LCI



### For cars with large underfloor trim II to install carbon rear diffuser IA:

► The fastening points (6) are only to be installed on cars without a trailer tow hitch (SA 3AC). ◀

Install large underfloor trim II as described in **ISTA/AIR**. Only tighten the hexagon screws (5) on the standard component shown here.



### For cars with large underfloor trim II:

► Print the cutting template **GD** on DIN A4 paper **without** scaling. To do this, in printer settings go to **“Actual size”**. The printer setting must not be set to **“Fit”**. Check the reference dimension with a ruler on the hard copy. ◀

Affix the cutting template **GD** with the **“L”** at the top on the left-hand side at the corner of the large underfloor trim **II** using suitable adhesive tape.

Affix the cutting template **GD** with the **“R”** at the top on the right-hand side at the corner of the large underfloor trim **II** using suitable adhesive tape.

Cut the large underfloor trim **II** along the cutting edge (7) using a suitable tool.

## 18. Installing the carbon rear diffuser G30 LCI, G31 LCI

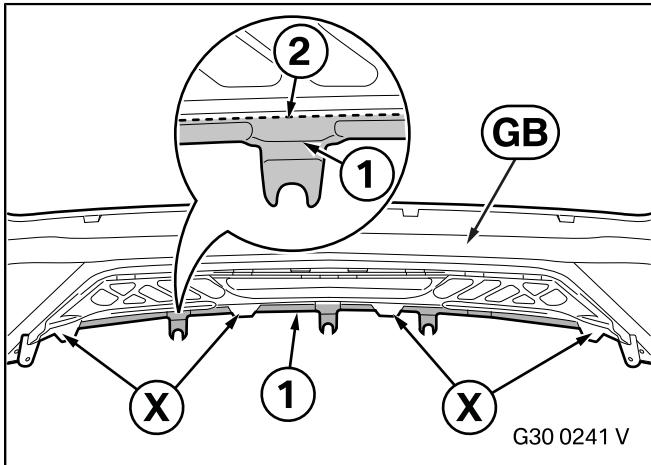
### Painting instructions

Check that all the kit components fit accurately on the car before painting them. Primed kit components must be pre-treated appropriately before painting.

Follow the BMW painting instructions (see **ISTA/AIR 99 00 ...**).

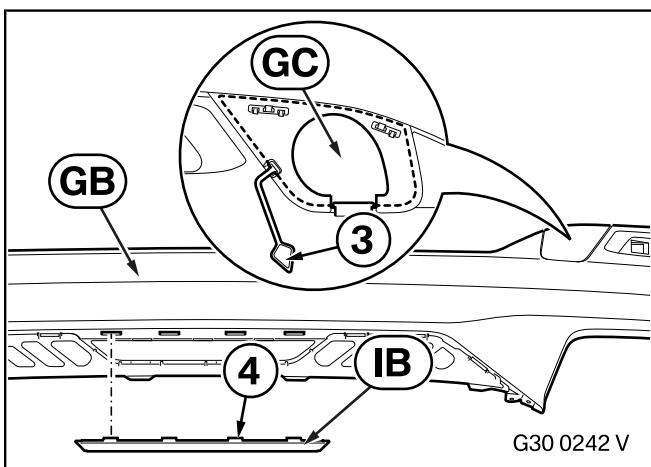
► The black high gloss bumper cover **GB** and the matt black finisher **IB** can be painted as required by the customer. ◀

► Ensure that the exhaust system support adapter cover **GA** has been installed. ◀



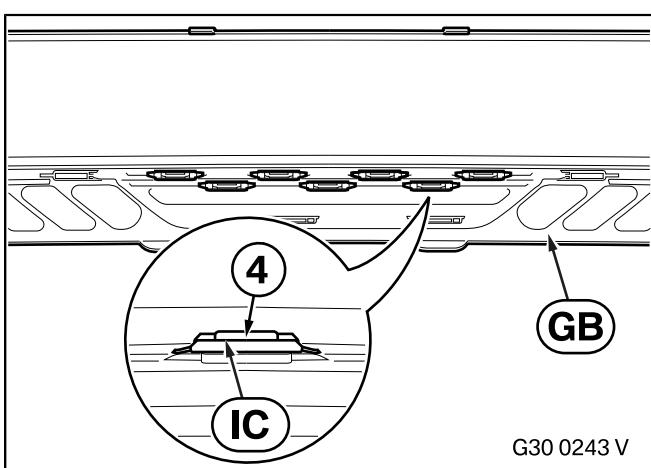
► Ensure that the four lugs **X** are not removed from the black high gloss bumper cover **GB**. ◀

Cut the flange (1) along the cutting line (2) using a suitable tool.



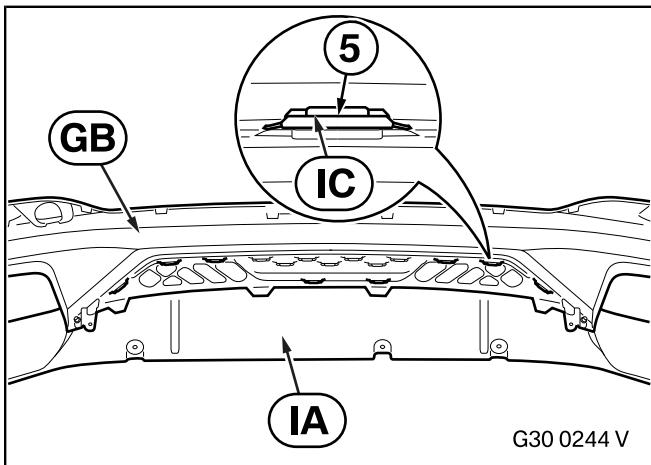
Fit the towing eyelet cover **GC** with retaining hook (3) into the black high gloss bumper cover **GB** as shown.

Fit the lugs (4) on the matt black finisher **IB** into the black high gloss bumper cover **GB**.



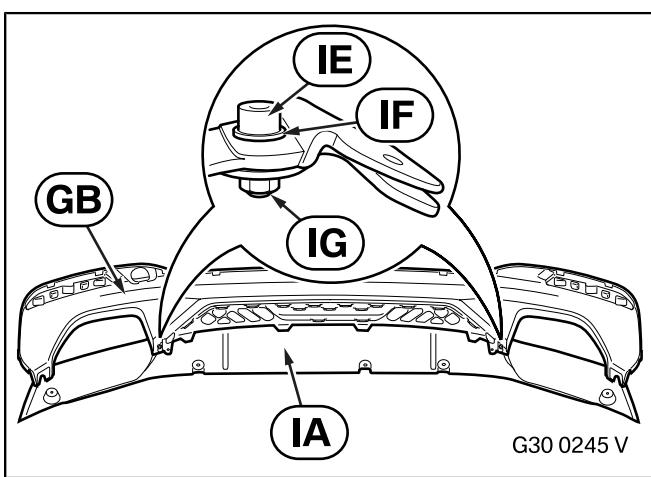
Install the clips **IC** on the lugs (4) using a suitable tool.

## 18. Installing the carbon rear diffuser G30 LCI, G31 LCI

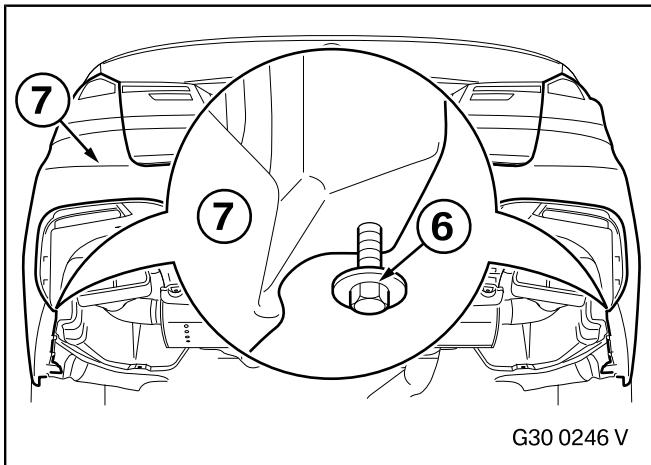


Fit the carbon rear diffuser **IA** with lugs (5) into the black high gloss bumper cover **GB**.

Install the clips **IC** on the lugs (5) using a suitable tool.



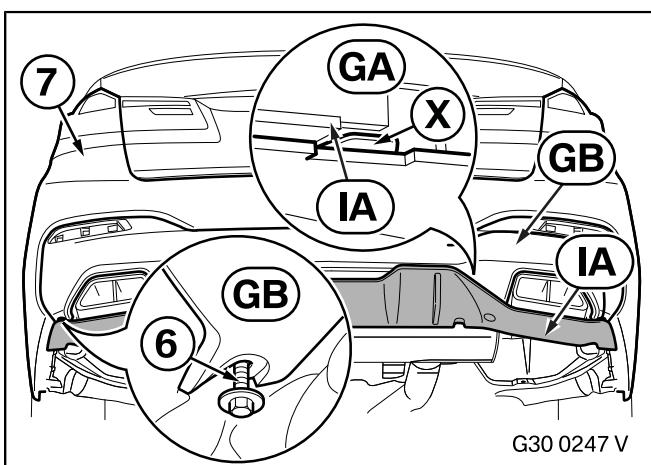
Secure the carbon rear diffuser **IA** to both sides of the black high gloss bumper cover **GB** using ISA screws **IE**, washers **IF** and hexagon nuts with washers **FG**.



For the sake of simplicity, the following illustrations show the small underfloor trim **I**.

All the screw connections are also to be made on cars with large underfloor trim **II**. ◀

Unscrew the hexagon screws (6) for the standard component a few turns out of the rear trim (7).

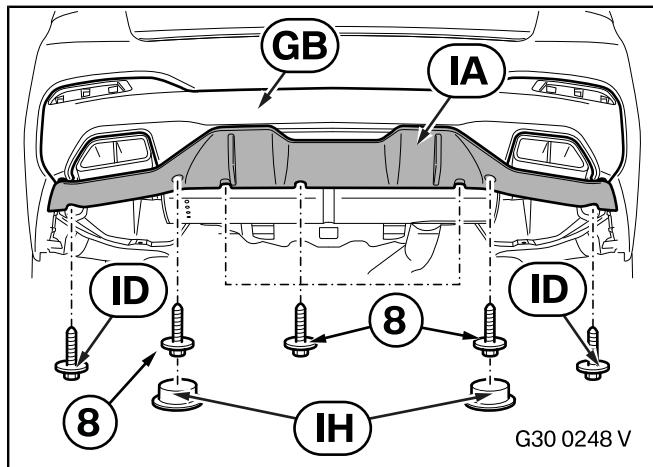


Fit the assembly of the black high gloss bumper cover **GB** and carbon rear diffuser **IA** into the rear trim (7) so that the four lugs **X** are fully inserted in the exhaust system support adapter cover **GA**.

Ensure that the hexagon screws (6) are positioned in the recess of the black high gloss bumper cover **GB**.

Tighten the hexagon screws (6) on both sides of the rear trim (7).

## 18. Installing the carbon rear diffuser G30 LCI, G31 LCI



► Ensure that the four lugs **X** inserted in the exhaust system support adapter cover **GA** do not slip out during the remainder of the installation work. ◀

Fit the assembly of the black high gloss bumper cover **GB** and carbon rear diffuser **IA** using hexagon screws **ID** and hexagon screws (8) from the standard component.

Insert sealing bung **IH** into the carbon rear diffuser **IA**.

Install the rear reflector from the standard component as described in **ISTA/AIR**.

## 19. Installing the matt black rear diffuser G30 LCI, G31 LCI

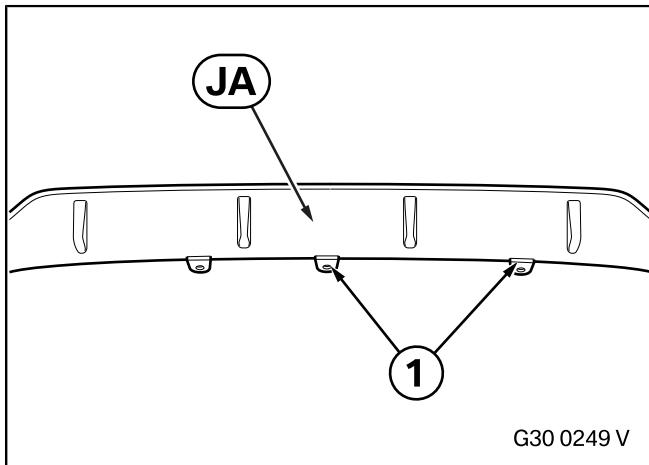
### Painting instructions

Check that all the kit components fit accurately on the car before painting them. Primed kit components must be pre-treated appropriately before painting.

Follow the BMW painting instructions (see **ISTA/AIR 99 00 ...**).

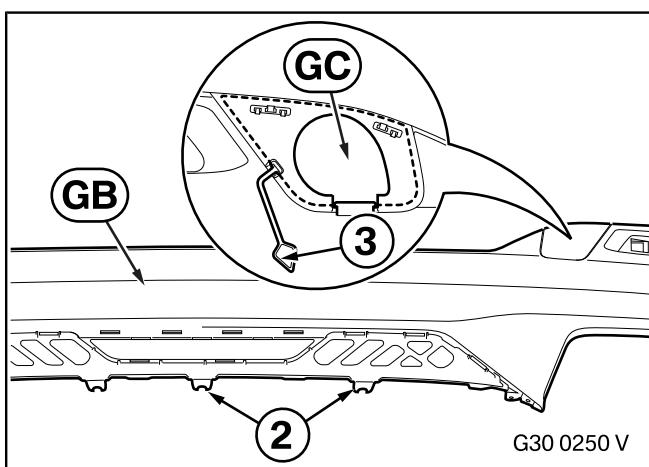
► The black high gloss bumper cover **GB** and the matt black rear diffuser **JA** can be painted as required by the customer. ◀

► Ensure that the exhaust system support adapter cover **GA** has been installed. ◀



### For cars with trailer tow hitch (SA 3AC):

Remove the lugs (1) from the matt black rear diffuser **JA** using a suitable tool.

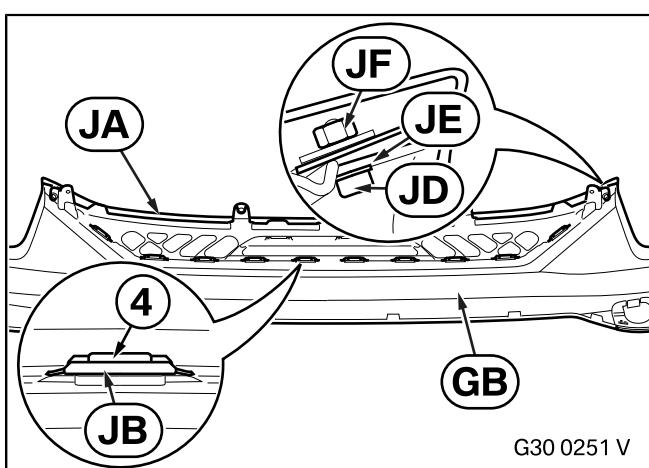


### For cars with trailer tow hitch (SA 3AC):

Remove the lugs (2) from the black high gloss bumper cover **GB** using a suitable tool.

### For all cars:

Fit the towing eyelet cover **GC** with retaining hook (3) into the black high gloss bumper cover **GB** as shown.

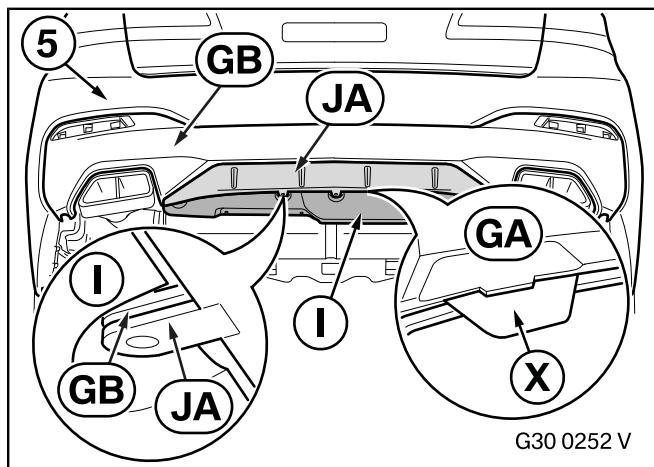


Insert the matt black rear diffuser **JA** with lugs (4) into the black high gloss bumper cover **GB**.

Install the clips **JB** on the lugs (4) using a suitable tool.

Secure the matt black rear diffuser **JA** to both sides of the black high gloss bumper cover **GB** using ISA screws **JD**, washers **JE** and hexagon nuts with washers **JF**.

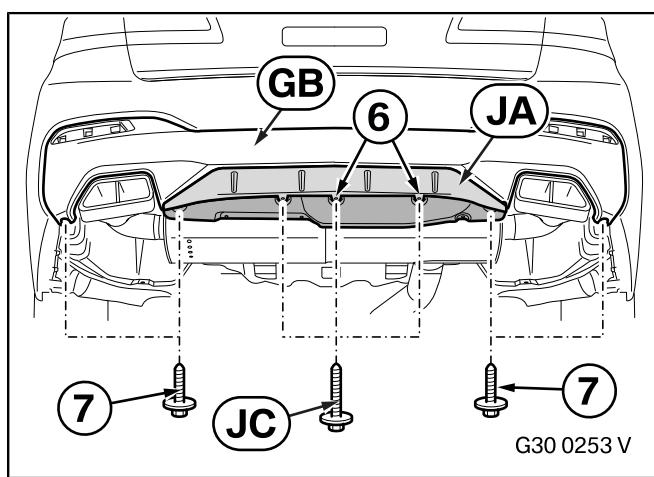
## 19. Installing the matt black rear diffuser G30 LCI, G31 LCI



For the sake of simplicity, the following illustrations show the small underfloor trim **I**.  
All the screw connections are also to be made on cars with large underfloor trim **II**. ◀

Fit the assembly of the black high gloss bumper cover **GB** and matt black rear diffuser **JA** into the rear trim (5) so that the four lugs **X** on the black high gloss bumper cover **GB** are fully inserted in the exhaust system support adapter cover **GA**.

The black high gloss bumper cover **GB** and matt black rear diffuser **JA** must be under the small underfloor trim **I**.



Ensure that the four lugs **X** inserted in the exhaust system support adapter cover **GA** do not slip out during the remainder of the installation work. ◀

The fastening points (6) are only to be installed on cars without a trailer tow hitch (SA 3AC). ◀

Install the assembly of the black high gloss bumper cover **GB** and matt black rear diffuser **JA** using hexagon screws **JC** and hexagon screws (7) from the standard component.

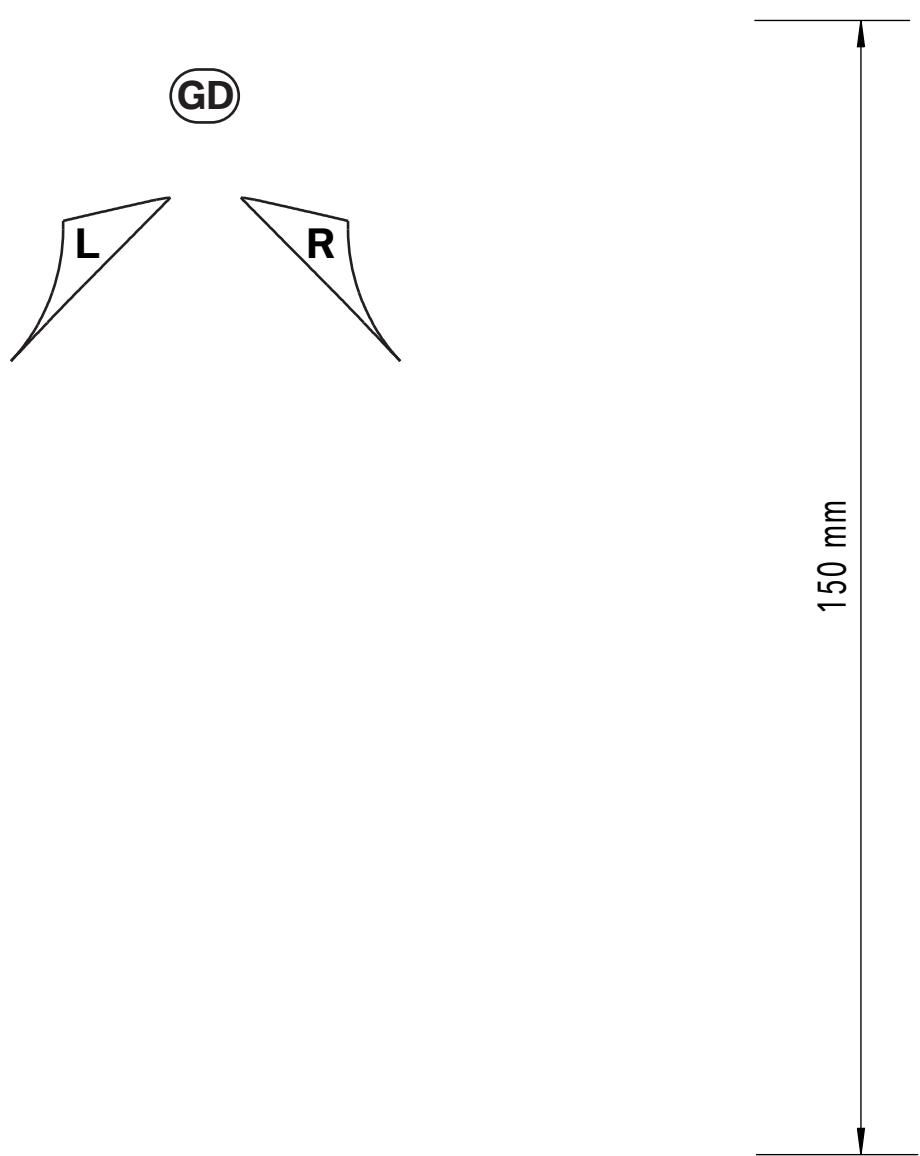
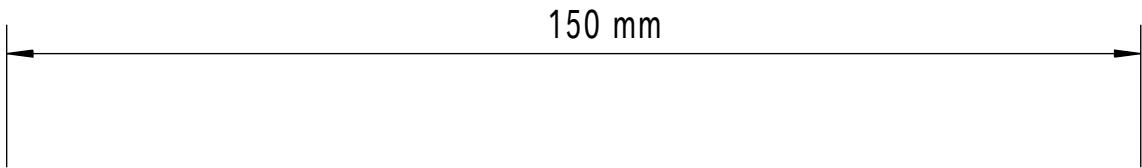
Install the rear reflector from the standard component as described in **ISTA/AIR**.

## 20. Concluding work and coding

The retrofit system requires programming/coding for all cars if the carbon rear diffuser retrofit kit **IA** is installed.

The retrofit system requires programming/coding for 550i and 550d cars if the carbon left/right front attachment retrofit kit **AA, AB** and the carbon front attachment retrofit kit **AC** are installed.

- Connect the battery
- Connect the battery charger to the car
- Connect the car to the ISTA workshop system
- Open the ISTA/P car programming facility
- If using ISTA/P, please refer to the instructions provided in the ISTA/P application documentation
- Retrofit customer service word for carbon rear diffuser **IA**: Select "DSMO" via the – **Retrofits** – path and work through the action plan
- Retrofit customer service word for carbon left/right front attachment **AA, AB** and carbon front attachment **AC**: Select M Performance front attachment coding of FGS parameters (MFSG) via the – **Retrofits** – path and work through the action plan
- If necessary, carry out a vehicle test using the ISTA system, and note, or work through, any errors that have been recorded
- Conduct a function test
- Re-assemble the car
- Give the customer the customer information



(GD)

