

# Original BMW Accessories.

## Installation Instructions.



### M Performance Aerodynamics Package Retrofit Kit.

**BMW 3 Series Saloon (F30)**

**BMW 3 Series Saloon Long Version China (F35)**

**BMW 3 Series Touring (F31)**

**BMW M3 Saloon (F80)**

#### Retrofit kit number

A **primed** M Performance Aerodynamics package comprises several retrofit kit numbers, depending on the engine and exhaust system type.

Single-sided Single-pipe	Single-sided Twin-pipe	Twin-sided Single-pipe	Component designation	Type	Install- ation time (h)
51 19 2 291 417	51 19 2 291 418	51 19 2 291 414	Matt black rear diffuser	F30/F31/F35	0.25
	51 19 2 291 364		Matt black front add-on section	F30/F31/F35	1.0
	51 19 2 291 404		Matt black right side skirt add-on section	F30/F31	0.75
	51 19 2 291 407		Matt black left side skirt add-on section	F30/F31	0.75
	51 19 2 240 983		Side skirt film left/right	F30/F31	0.75
	51 19 2 349 308		Side skirt film left/right	F35	0.75
	51 71 2 240 832		Carbon rear spoiler	F30/F35/F80	0,75
	51 19 2 349 678		Matt black rear spoiler	F30/F35/F80	0,75
	51 19 2 298 300		Matt black ventilated rear spoiler	F31	0.75

#### 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), following the appropriate product 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  $v_{max} < 100$  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. ◀

Installation instructions for the F31 matt black ventilated rear spoiler

 Template **EB** is included with the parts kit for the matt black ventilated rear spoiler. The drilling template on page 33 can optionally be used to install the F31 matt black ventilated rear spoiler. Page 33 must then be printed out in its original size (DIN A4); it must not be scaled.

When displaying the PDF in Windows, ensure the following setting is made:

**File -> Print -> Page Setup -> Shrink oversized pages: None** 

### **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 M Performance matt black front add-on is installed in cars of a light colour, a black paint pen is also required.

### **Recommended special tools**

None

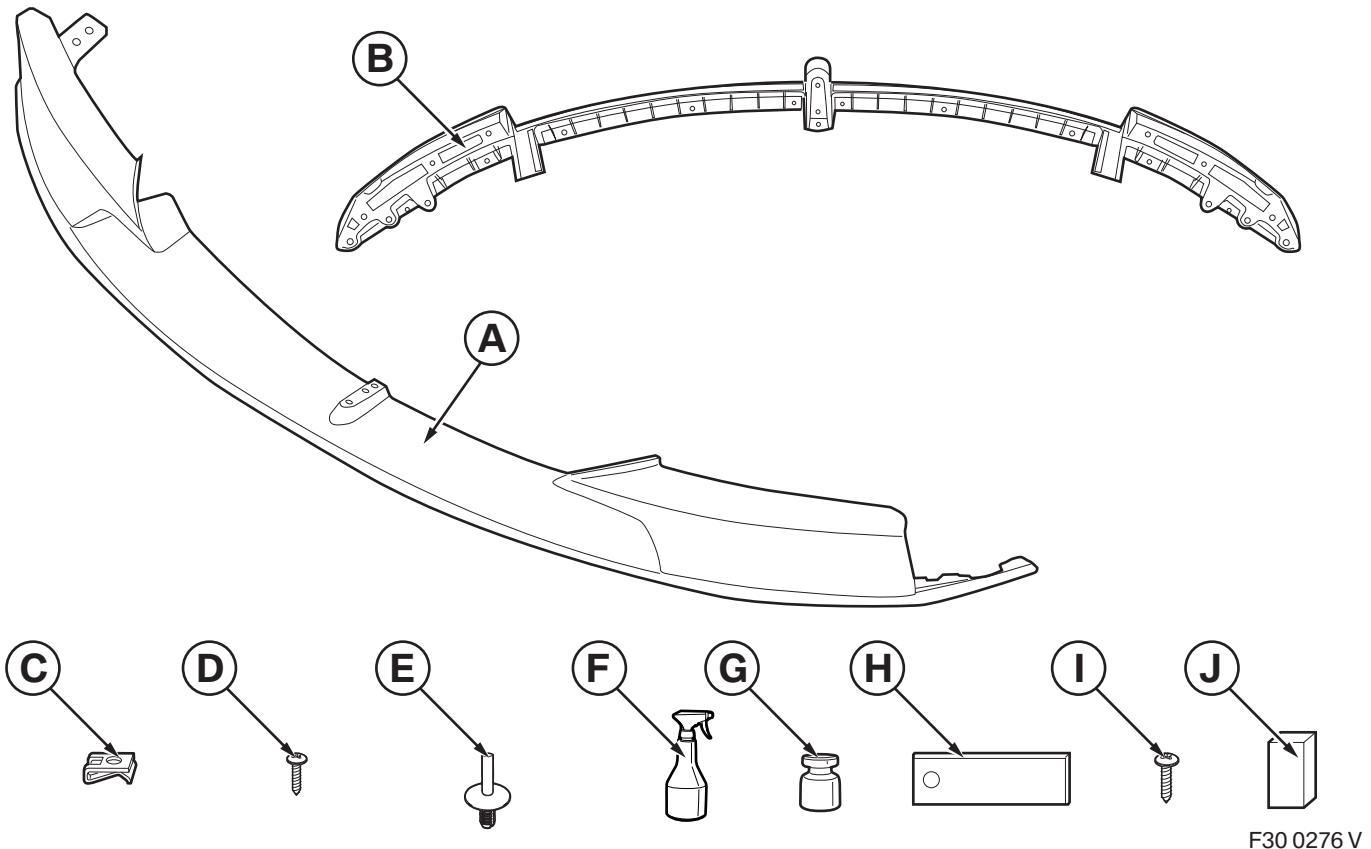
### **Information to be provided to the customer**

-  Once the M Performance front attachment has been installed, the ramp angle and floor clearance are reduced. 
-  The M Performance front attachment may only be installed in conjunction with the M Performance rear spoiler (for part number and instructions, see EPC). 
-  The M Performance front attachment reduces the car's floor clearance and reduces the overhang angle at the front. The BMW M Performance front add-on 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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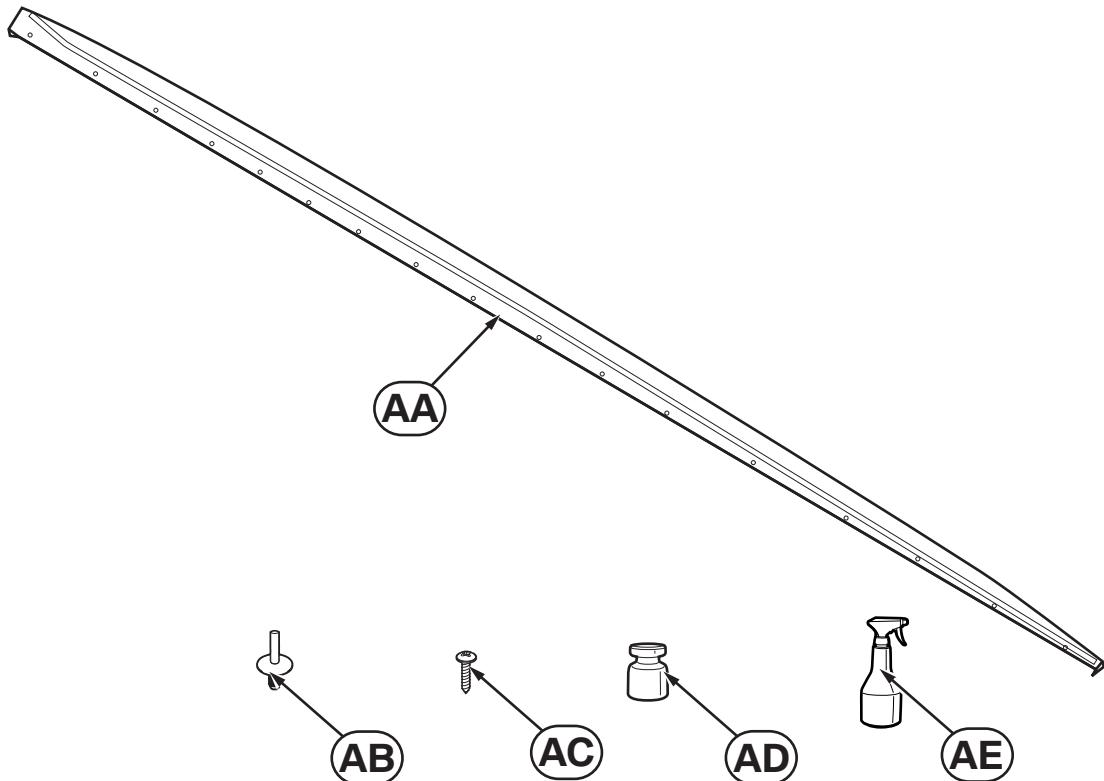
## 1. M Performance matt black front add-on parts list (F30/F31/F35)



### Legend

- A** Matt black front add-on section
- B** Adapter
- C** C-clip, 4.8 mm (2 x), part number 6 951 655
- D** Torx screw, 4.8 x 32 mm (2 x), part number 9 112 637
- E** Blind rivet, 5.0 x 10.0 mm (22 x), part number 7 002 953
- F** Cleaner (not included in kit, see EPC for details)
- G** Primer (not included in kit, see EPC for details)
- H** Installation plate
- I** Oval-headed screw TS, 5 x 20 mm (1 x), part number 6 986 938
- J** Liquid adhesive (not included in kit, see EPC for details)

## 2. M Performance matt black side sill add-on parts list (F30/F31)

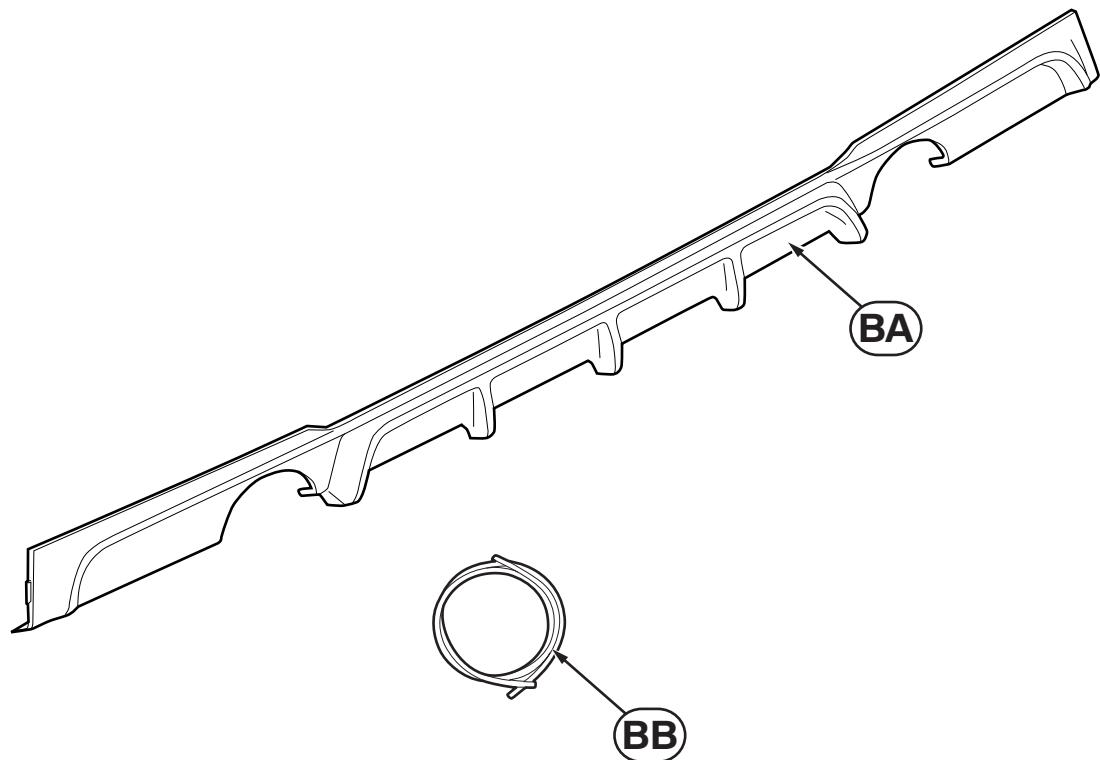


F30 0277 V

### Legend

- AA** Left matt black side skirt add-on section (right not shown)
- AB** Blind rivet, 5.0 x 8.0 mm (17 x per side skirt package), part number 7 002 953
- AC** Oval-headed screw, 4.2 x 14 mm (11 x per side skirt package), part number 7 133 553
- AD** Primer (not included in kit, see EPC for details)
- AE** Cleaner (not included in kit, see EPC for details)

### 3. M Performance matt black rear diffuser parts list (F30/F31/F35)

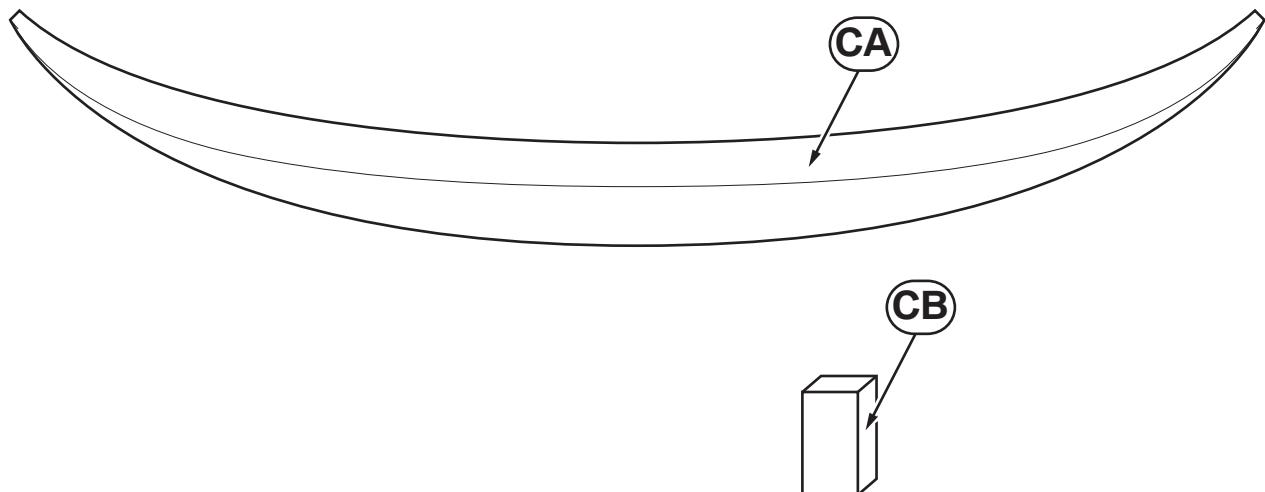


F30 0124 V

#### Legend

**BA** Matt black rear diffuser (illustration shows double-sided and single-pipe exhaust system version)  
**BB** Masking string

#### 4. M Performance carbon rear spoiler parts list (F30/F35/F80)



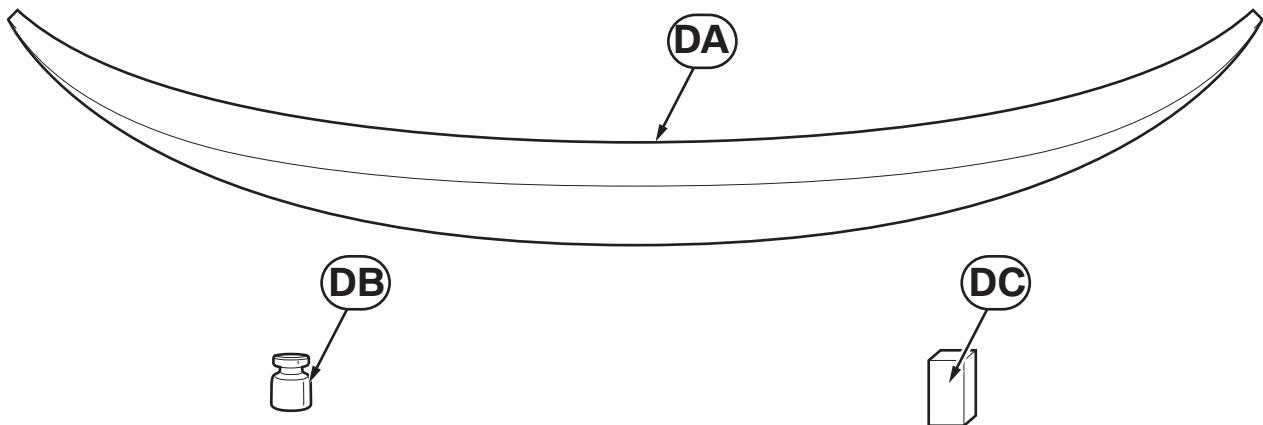
F30 0210 V

#### Legend

**CA** Carbon rear spoiler

**CB** Liquid adhesive (not included in kit, see EPC for details)

## 5. M Performance matt black rear spoiler parts list (F30/F35/F80)

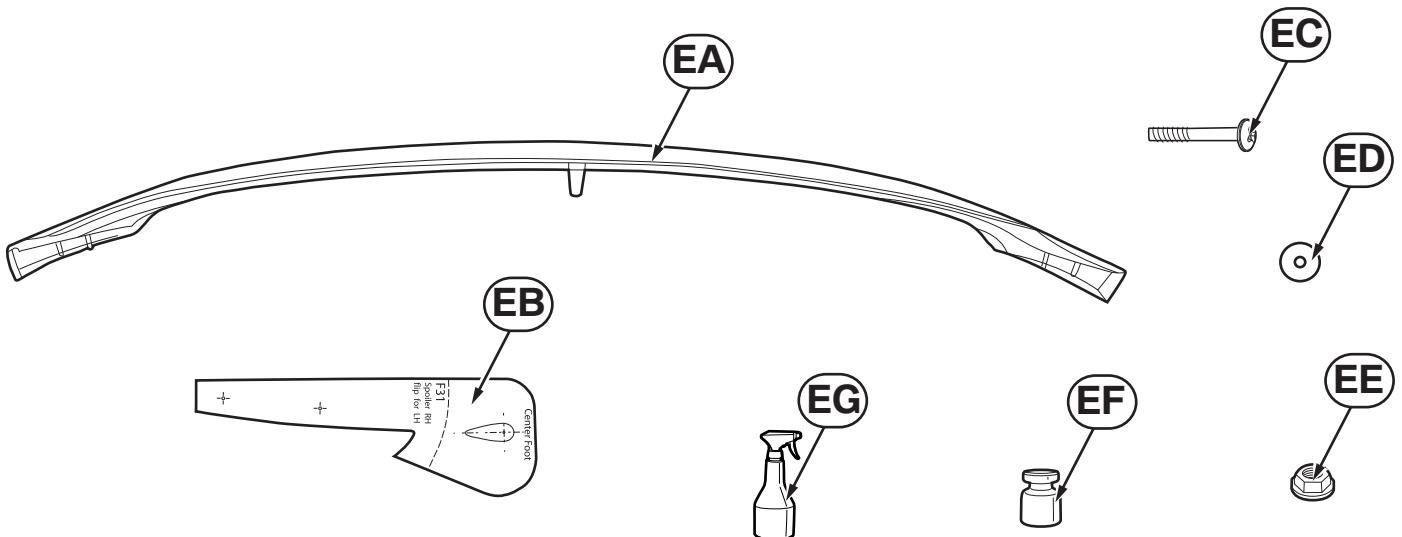


F30 0278 V

### Legend

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

## 6. M Performance matt black ventilated rear spoiler parts list (F31)



F31 0024 V

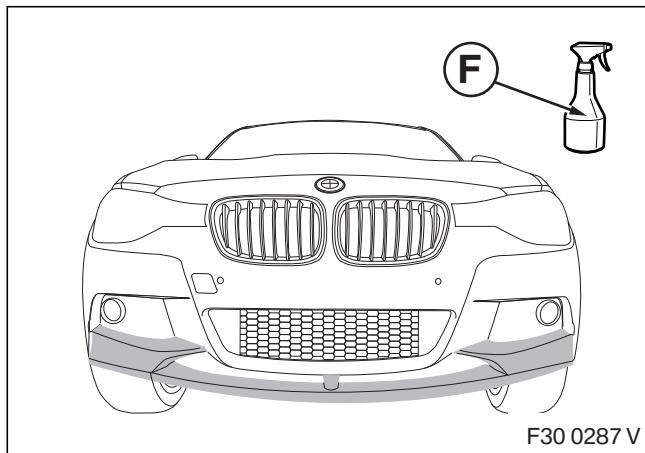
### Legend

- EA** Matt black ventilated rear spoiler
- EB** Template
- EC** Screw 4.2 x 45 mm S/T
- ED** Shim M5 x 2 mm
- EE** Self-locking nut M6 (4 x)
- EF** Primer (not included in kit, see EPC for details)
- EG** Cleaner (not included in kit, see EPC for details)

## 7. Preparatory work

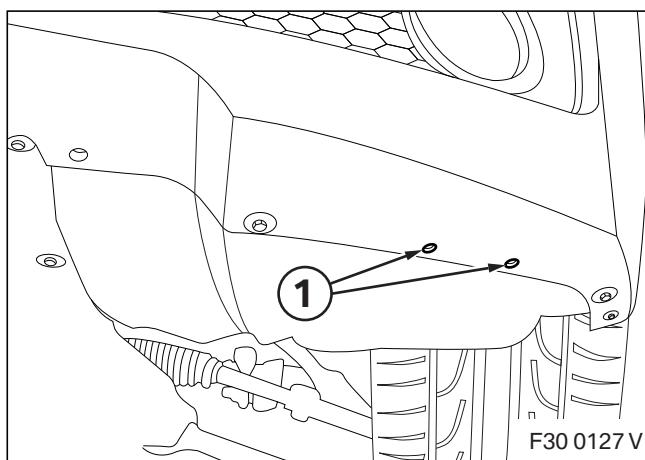
	ISTA No.
<b>The following components must be removed first of all only for the M Performance matt black rear diffuser retrofit kit</b> Lower rear bumper trim (keep the screws and rivets, they will be required again for later installation)	51 12 ...
<b>The following components must be removed first of all only for the M Performance matt black ventilated rear spoiler (F31)</b>	
Third brake light	51 71 412

## 8. Installing the M Performance matt black front add-on (F30/F31/F35)

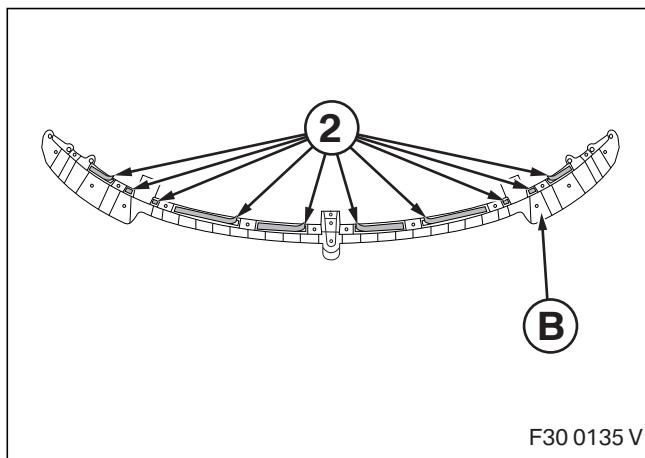


► The bonding surface must be completely clean, dry and free from grease. ◀

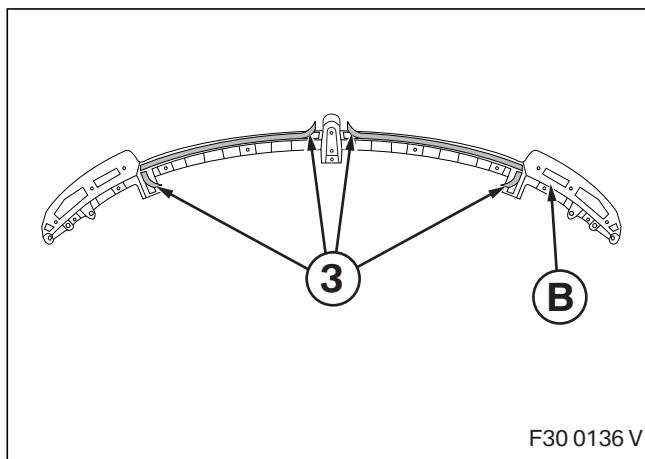
Clean all the bonding surfaces and primer surfaces on the car with a suitable cleaner **F** before the priming or bonding work.



Remove the rivets (1) on the left and right-hand side.

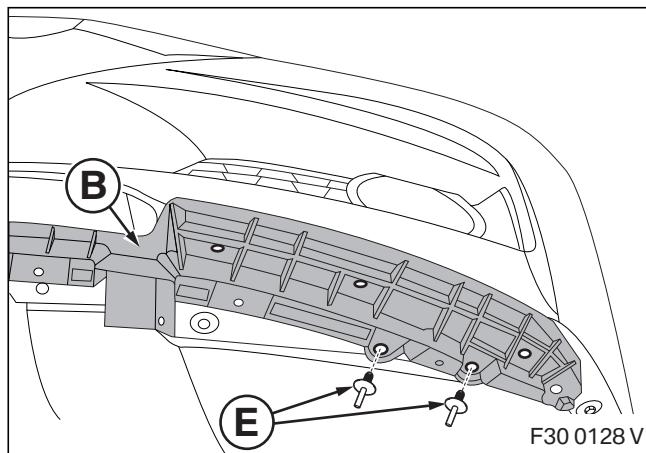


On the front of adapter **B**, fold the protective film (2) on the adhesive strips outwards at the ends.



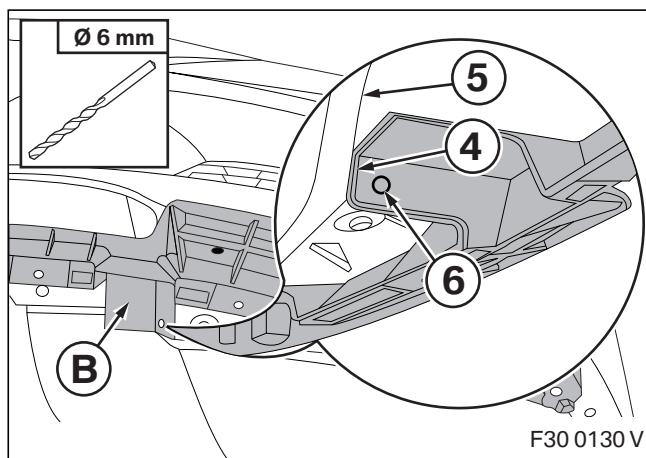
On the back of adapter **B**, fold the protective film (3) on the adhesive strips outwards at the ends.

## 8. Installing the M Performance matt black front add-on (F30/F31/F35)



Secure adapter **B** using blind rivets **E**.

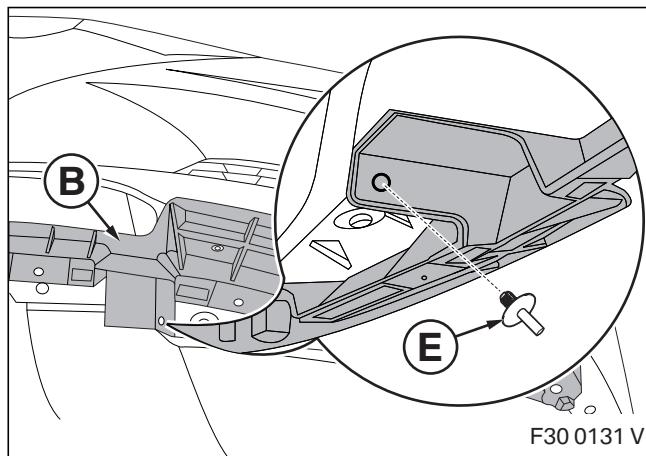
► Then carry out the same step on the right-hand side. ◀



► When drilling, note the maximum drilling depth. ◀

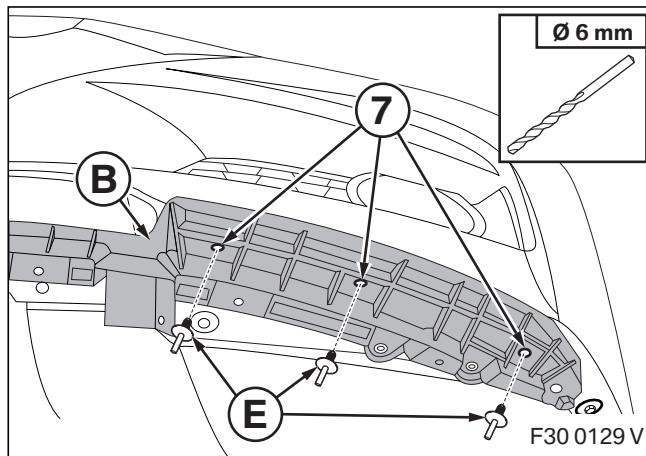
Press adapter **B** upwards flush onto the front apron. Then hold the edge (4) of adapter **B** flush with the edge (5) of the front apron and drill a hole (6) using a **6 mm diameter** drill bit.

► Then carry out the same step on the right-hand side. ◀



Secure adapter **B** using blind rivet **E**.

► Then carry out the same step on the right-hand side. ◀



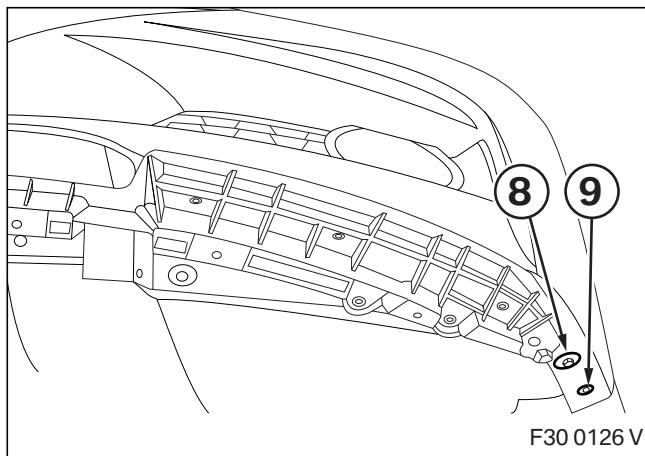
► When drilling, note the maximum drilling depth. ◀

Drill through the front apron at the drill holes (7) using a **6 mm diameter** drill bit.

Then secure adapter **B** using blind rivets **E**.

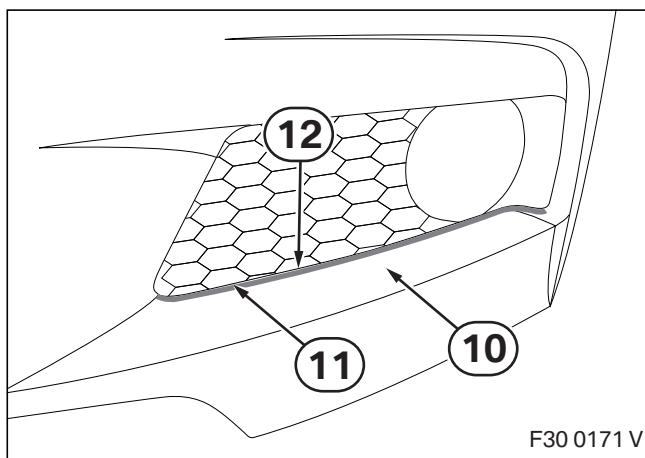
► Then carry out the same step on the right-hand side. ◀

## 8. Installing the M Performance matt black front add-on (F30/F31/F35)



Remove the screw (8) and rivet (9).

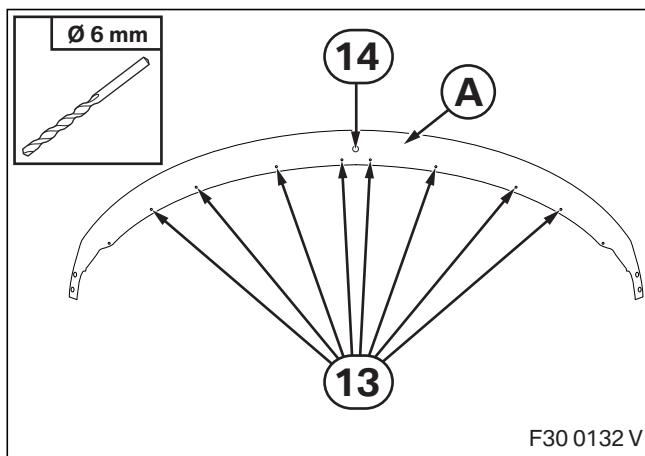
► Then carry out the same step on the right-hand side. ◀



### Only for cars of a light colour

Using a black paint pen, draw a line around 1-3 mm thick (12) on the front apron (10) along the air inlet cover (2).

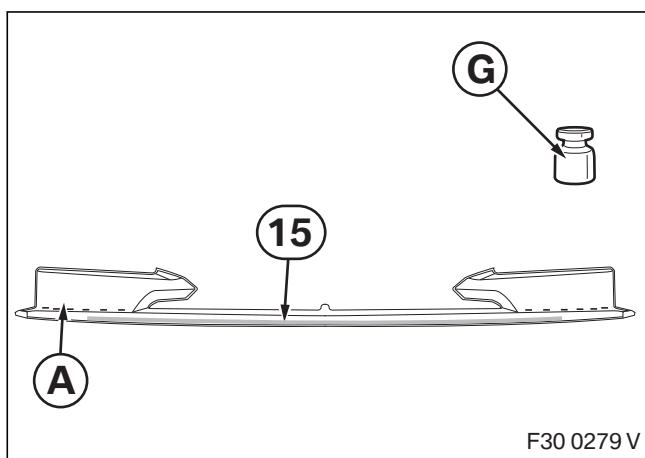
► Then carry out the same step on the right-hand side. ◀



### For all cars

Drill matt black front add-on **A** at the eight pre-drawn drill hole points (13) using a **6 mm diameter** drill bit.

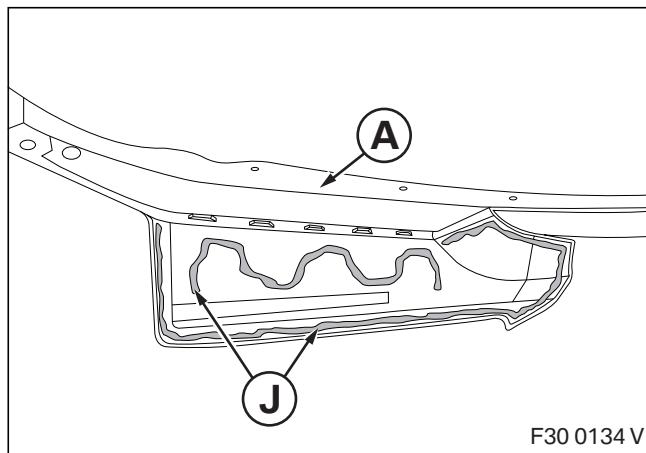
Enlarge the drawn-on drill hole (14) using a suitable tool to a diameter of **15 mm**.



► Only prime the bonding surfaces that come into contact with the adhesive strip of adapter **B**. ◀

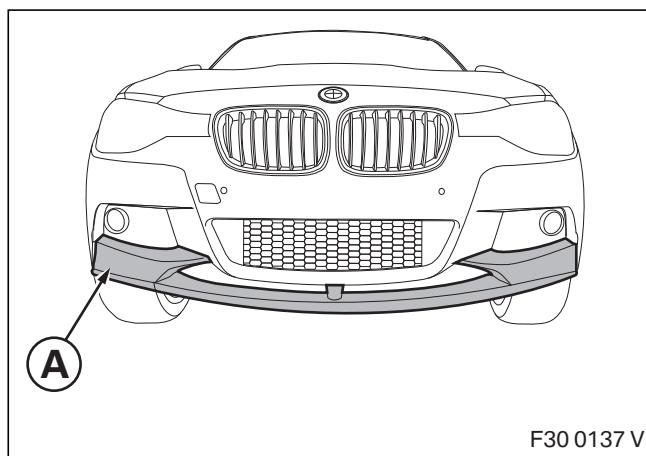
Prime the inside of matt black front add-on section **A** at the point indicated (15) using primer **G**.

## 8. Installing the M Performance matt black front add-on (F30/F31/F35)



Apply liquid adhesive **J** at the points indicated on the inside of matt black front add-on section **A**.

► Then carry out the same step on the right-hand side. ◀

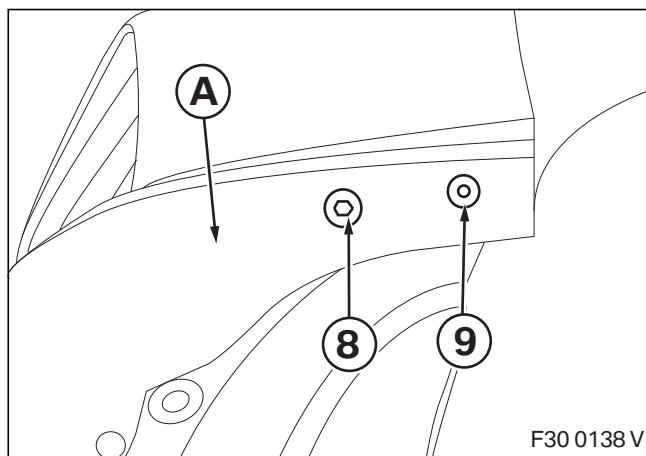


► The bonding surfaces must be completely clean, dry and free from grease.

Matt black front add-on **A** must audibly engage. ◀

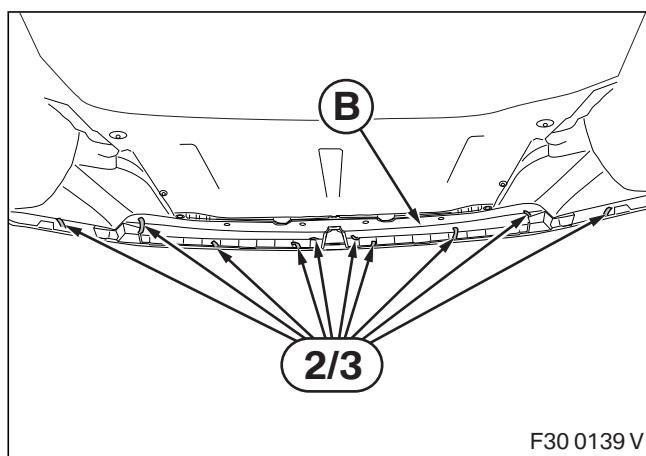
Place matt black front add-on **A** on the front apron of the car, align it, press it into place and allow it to engage.

► Remove any excess liquid adhesive immediately. ◀



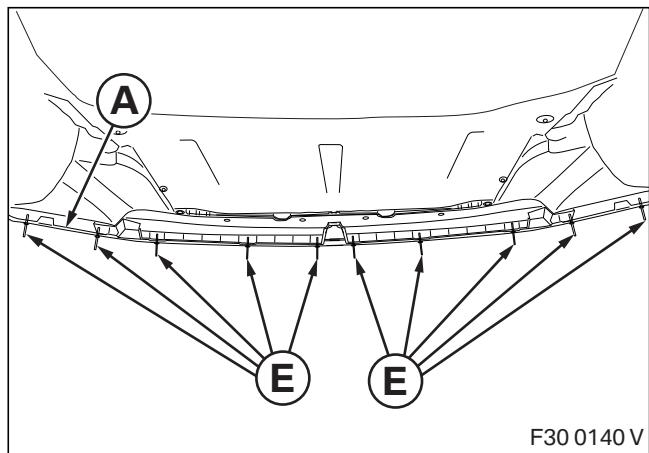
Tighten or insert the existing screw (8) and rivet (9) on the outer side of matt black front add-on **A**.

► Then carry out the same step on the right-hand side. ◀

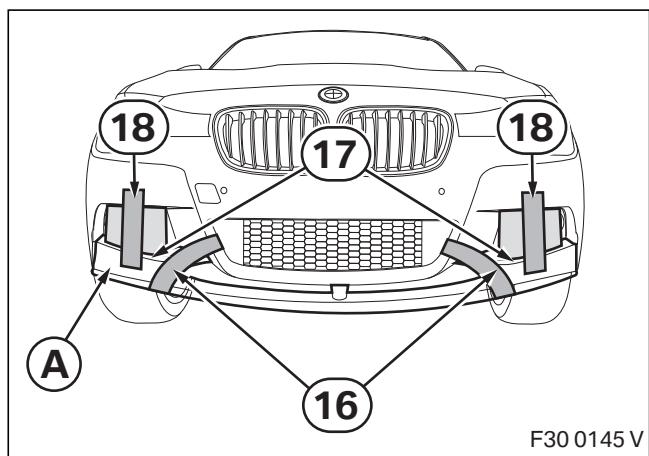


Remove the protective films (2) and (3) from adapter **B**.

## 8. Installing the M Performance matt black front add-on (F30/F31/F35)



Secure matt black front add-on **A** from underneath using ten blind rivets **E**.



Secure matt black front add-on **A** using suitable adhesive strips (16) to the front apron.

A large surface area of pressure must then be generated on the internal surfaces (17) of matt black front add-on **A** using suitable means. These means must be secured in place using suitable adhesive strips (18).

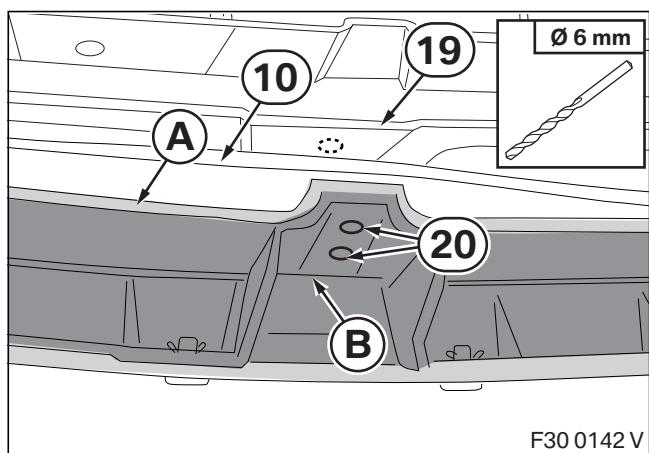
► Remove any excess liquid adhesive immediately. Fill any tolerance adjustment gaps with liquid cleaner. ◀

Allow matt black front add-on **A** to remain in this position for 2 hours. Then remove the adhesive strips (16) and (18) again.

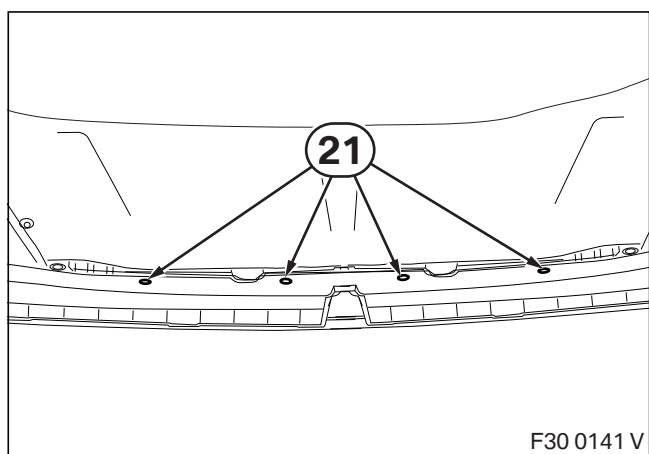
► When drilling, note the maximum drilling depth. The level (19) must also be drilled through. ◀

Press matt black front add-on **A** upwards, aligning the contours of the front apron (10) and matt black front add-on **A** with each other as you do so.

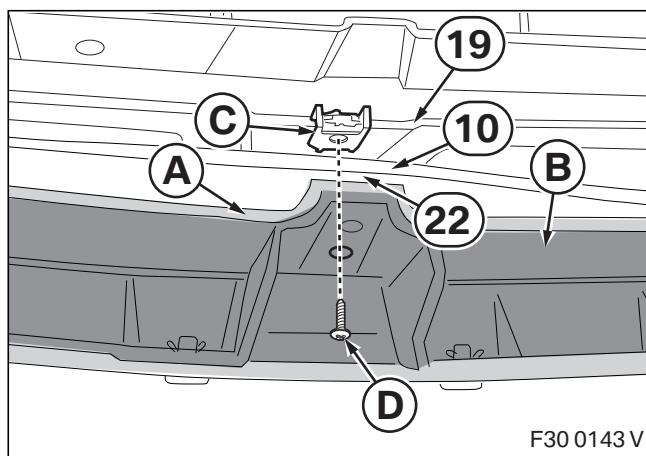
Then drill two holes (20) with a **6 mm diameter** drill bit from underneath through matt black front add-on **A** to through the level (19).



Remove the four expanding rivets (21).



## 8. Installing the M Performance matt black front add-on (F30/F31/F35)

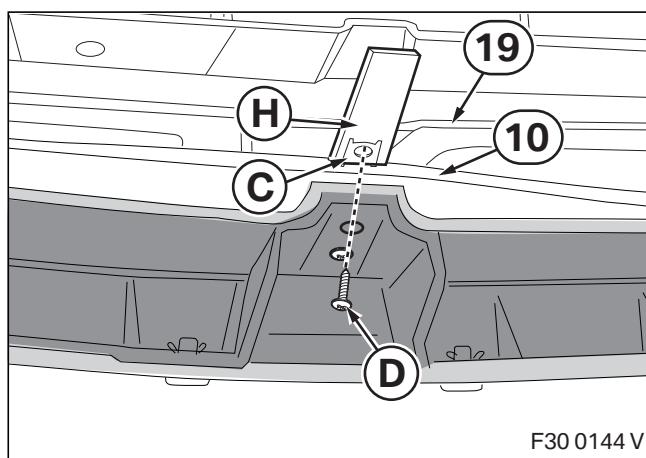


Position C clip **C** on the edge of the level (19).

Pull matt black front add-on **A** slightly downwards and apply liquid adhesive in the area (22) between the front apron (10) and matt black front add-on **A**.

Screw Torx screw **D** through adapter **B** into C-clip **C**.

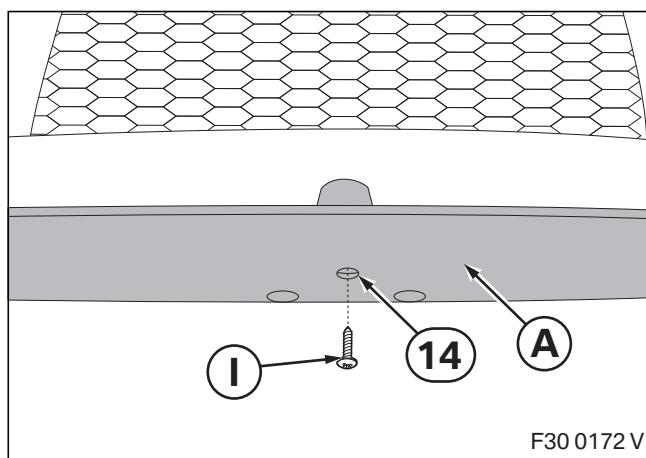
► Remove any excess liquid adhesive immediately. ◀



Slide C-clip **C** onto installation plate **H**.

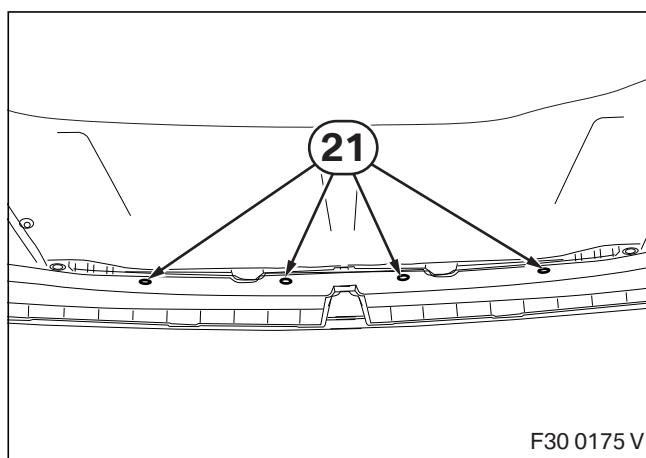
Insert installation plate **H** between level (19) and front apron (10) with the sheet metal nut first, align C-clip **C** on the second drill hole and screw in Torx screw **D**.

Then tighten both Torx screws **D**.



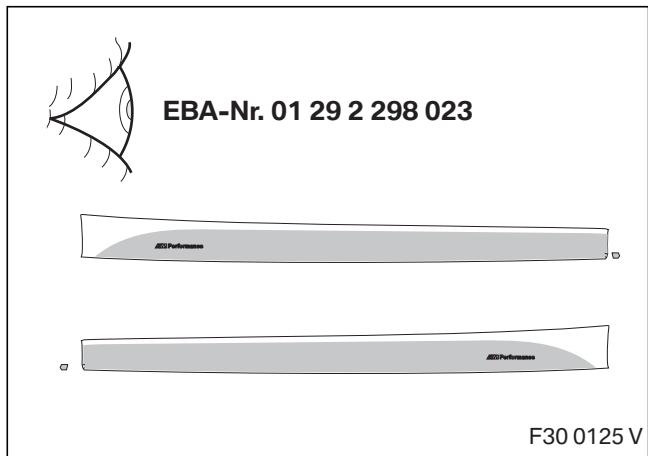
Screw oval-headed screw **I** through the drill hole (14) in the centre of matt black front add-on **A**.

► Remove any excess liquid adhesive immediately. ◀



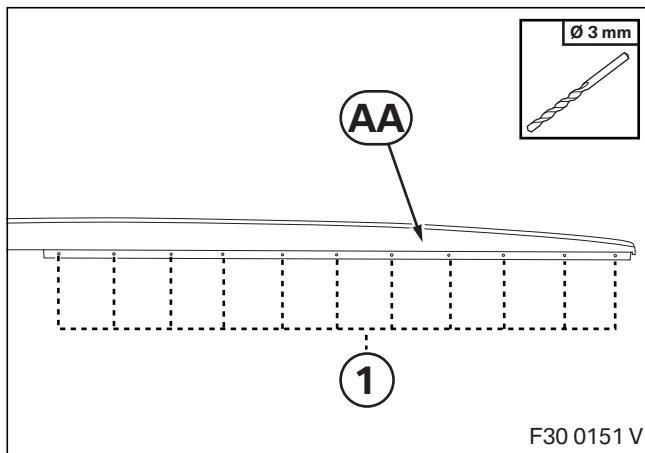
Reinsert the four expanding rivets (21).

## 9. Installing the M Performance side sill foil (F30/F31/F35)

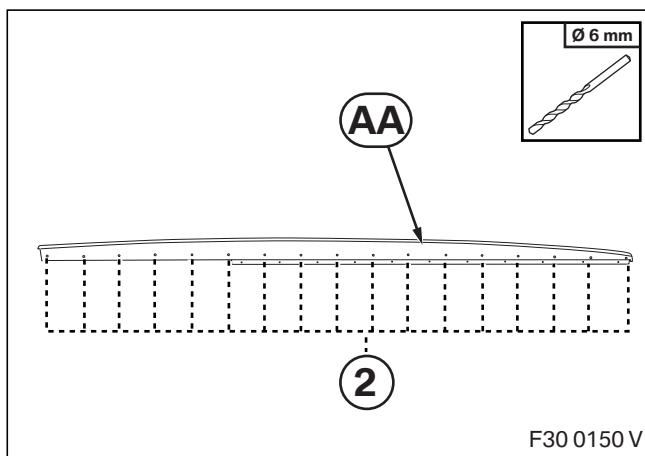


► Before installing the M Performance left/right matt black side skirt add-on section, the M Performance left/right side skirt films must be installed in accordance with the installation instructions bearing part number 01 29 2 298 023. ◀

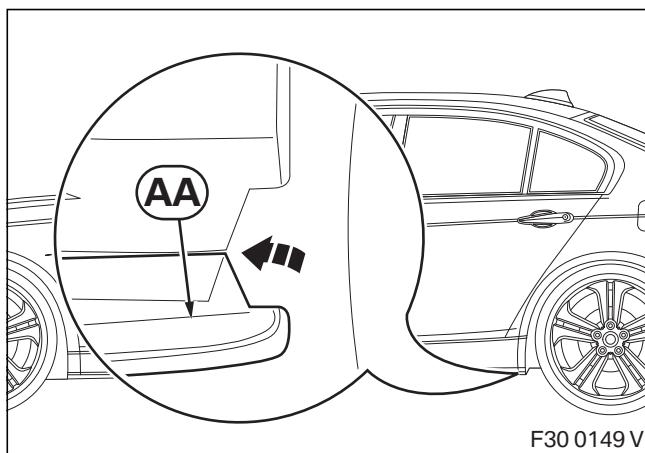
## 10. Installing the M Performance matt black side sill add-on (F30/F31)



Carefully drill the narrow surface of the side sill at the 11 drill holes (1) on left side matt black sill add-on **AA** using a **3 mm diameter** drill bit.

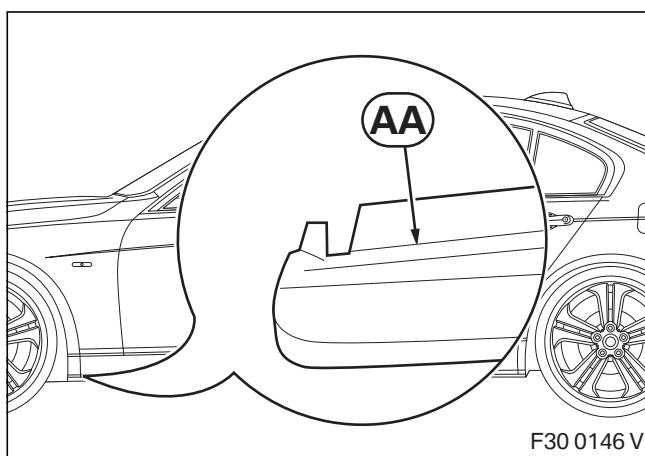


Carefully drill the side sill at the 17 drill holes (2) on left matt black side sill add-on **AA** using a **6 mm diameter** drill bit.



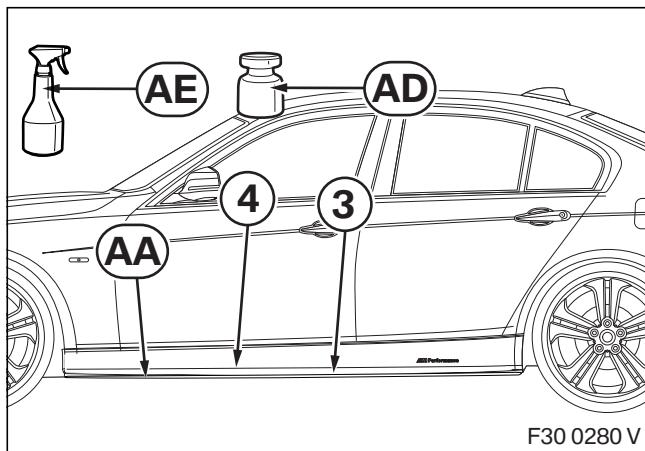
The bonding surfaces must be completely clean, dry and free from grease. ▲

Attach left matt black side sill add-on **AA** to the rear on the side sill, push it forwards and align it.



Secure left matt black side sill add-on **AA** to the front on the side sill.

## 10. Installing the M Performance matt black side sill add-on (F30/F31)

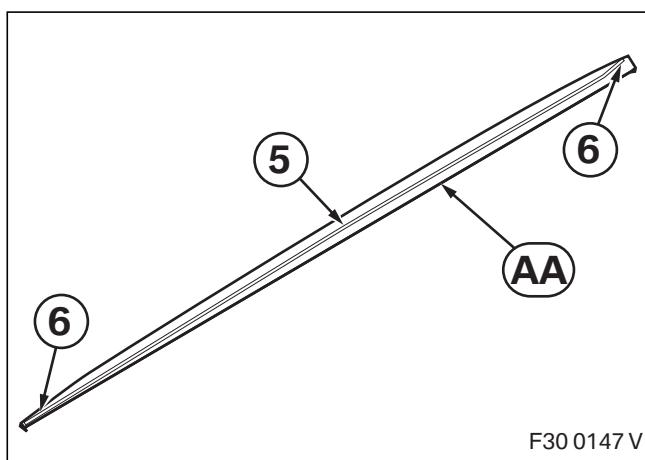


Push left matt black side sill add-on **AA** upwards and using a suitable tool draw a line (3) at the upper edge of left matt black side sill add-on section **AA** on the side sill.

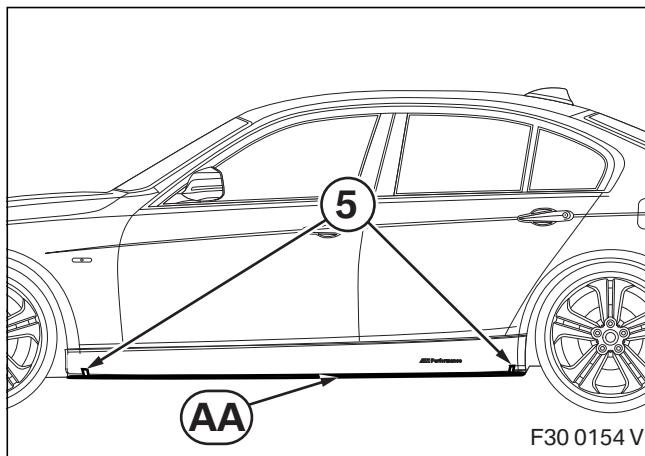
Affix masking tape (4) above and along the drawn-on line (3).

Remove left matt black side sill add-on **AA**.

Clean the bonding surface below the masking tape (4) with cleaner **AE** and prime it with primer **AD**.

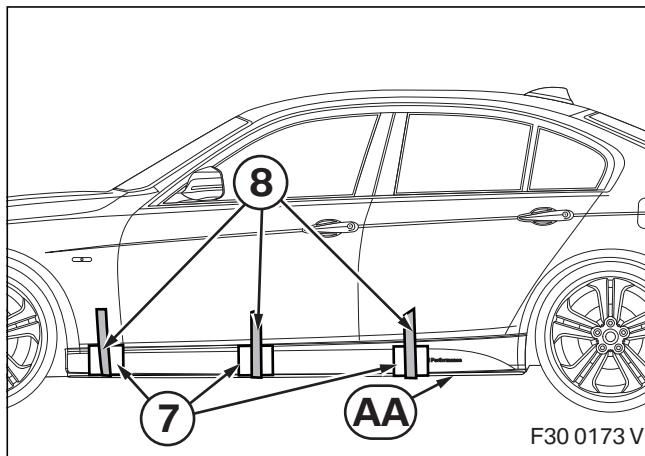


Remove the backing film (5) from the adhesive tape at the ends (6) of left matt black side sill add-on **AA** and folded outwards at an angle of 90°.



Allow left matt black side skirt add-on section **AA** to engage in the rear side skirt and align it towards the front.

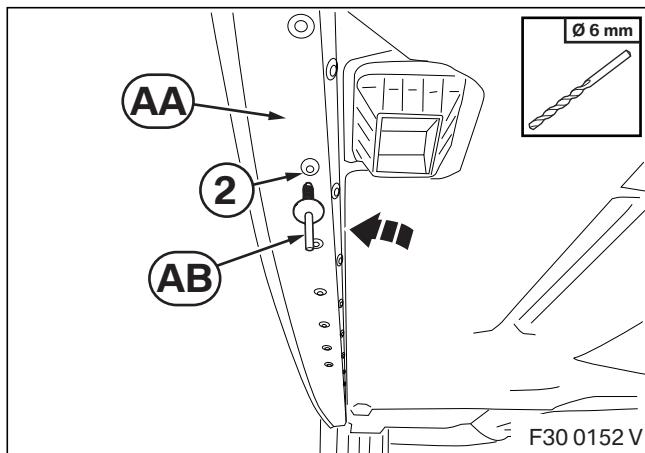
Remove the backing film (5) from the adhesive strip and press left matt black side sill add-on **AA** on.



In order to avoid damage caused by adhesive strips, the M Performance side sill foil must be protected with suitable materials (7). ▲

Secure left matt black side sill add-on **AA** as shown using suitable adhesive strips (8).

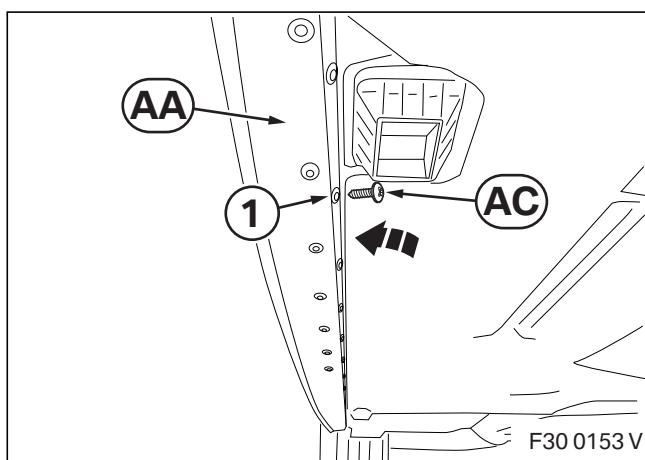
## 10. Installing the M Performance matt black side sill add-on (F30/F31)



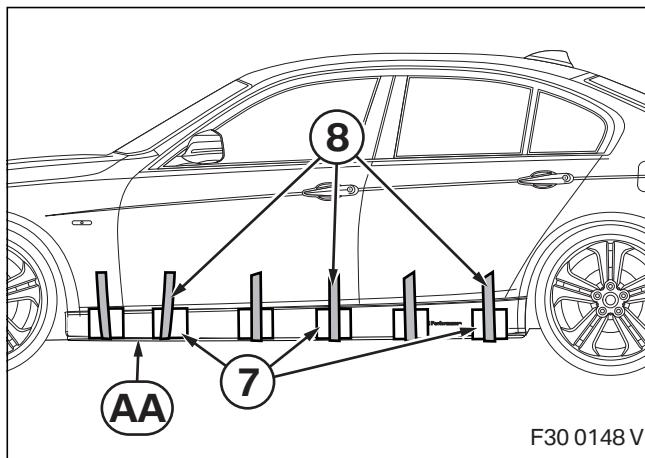
► When drilling, note the maximum drilling depth. ◀

Using the pre-drilled holes (2) in left matt black side sill add-on **AA**, drill through the side sill with a **6 mm diameter** drill bit.

Insert the 17 blind rivets **AB** and secure.



Screw the 11 oval-headed screws **AC** into the pre-drilled holes (1) on left matt black side skirt add-on section **AA**.

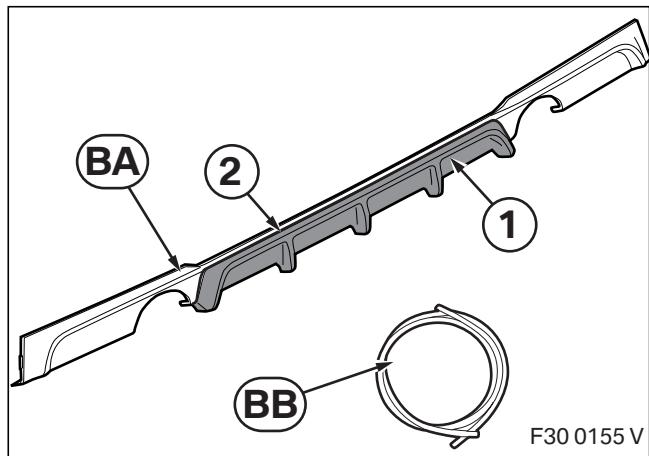


► In order to avoid damage caused by adhesive strips, the M Performance side sill foil must be protected with suitable materials (7). ◀

Secure left matt black side sill add-on **AA** as shown using further adhesive strips (8).

After around 30 minutes, carefully remove the adhesive strips (8) from left matt black side sill add-on **AA** from the bottom to the top.

## 11. Installing the M Performance matt black rear diffuser (F30/F31/F35)

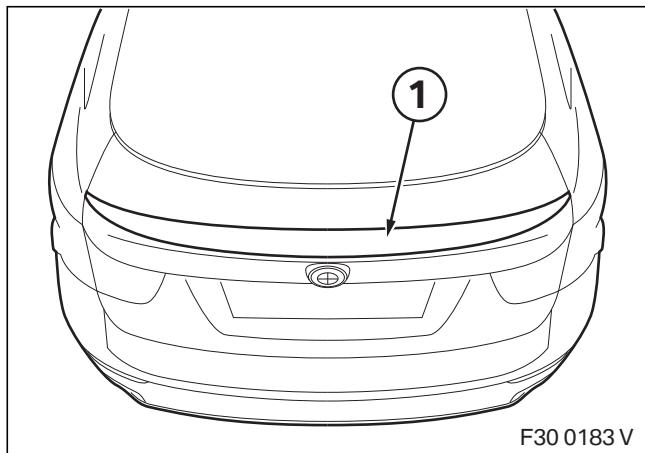


► Paint the unmasked areas in the colour of the car. ◀

Before painting, mask the marked areas (1) of matt black rear diffuser **BA** using masking tape and masking string **BB** and using the gap (2) provided.

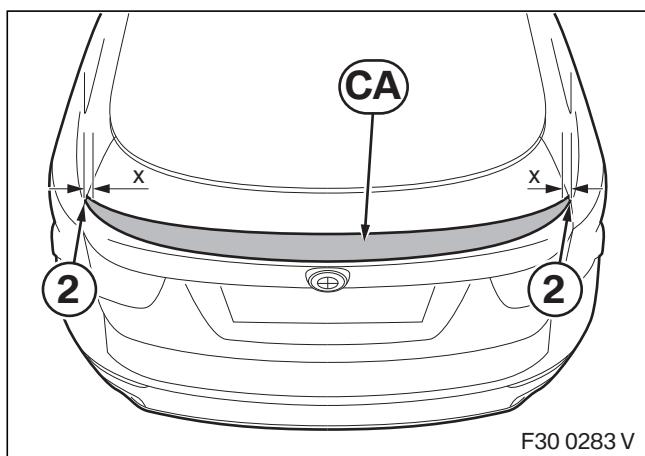
Fit matt black rear diffuser **BA** as per ISTA No. 51 12 ....

## 12. Installing the M Performance carbon rear spoiler parts list (F30/F35/F80)

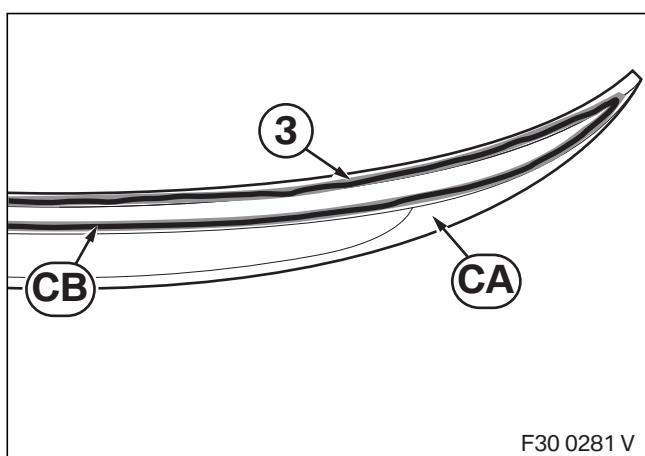


► The bonding surface must be completely clean, dry and free from grease. ◀

Clean the bonding surface (1) on the car using suitable means.

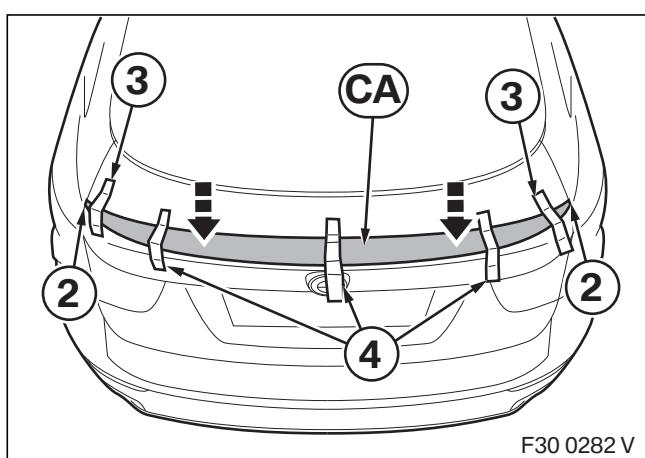


Place the carbon rear spoiler **CA** on the boot lid, centre it and mark the position (2) at the left and right using a suitable tool.



Sand the edge (3) of the carbon rear spoiler **CA**, clean it and leave it to dry.

Apply liquid adhesive **CB** in the form of a bead with a **diameter of 3 mm** to the edge (3).

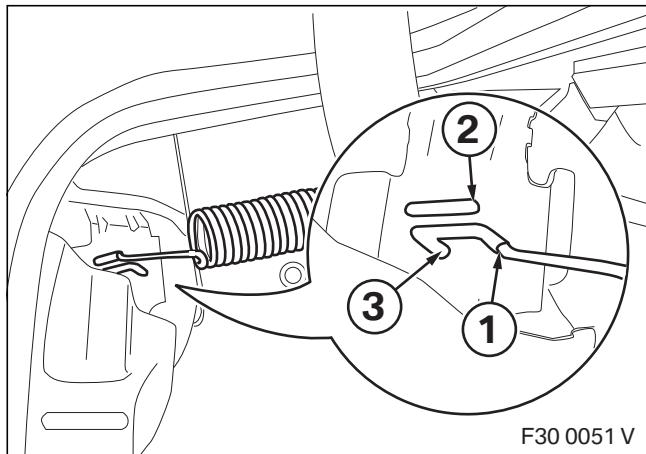


► Centre the carbon rear spoiler **CA** between the marks (2) and press it into position. First secure the outer adhesive tape (3) and then the inner adhesive tape (4). Press carbon rear spoiler **CA firmly** onto the boot lid.

Remove any excess liquid adhesive immediately.

Note the painting instructions on page 2. ◀

## 12. Installing the M Performance carbon rear spoiler parts list (F30/F35/F80)



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

Move the tailgate's tension spring to **position (2)**.

► 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. ▲

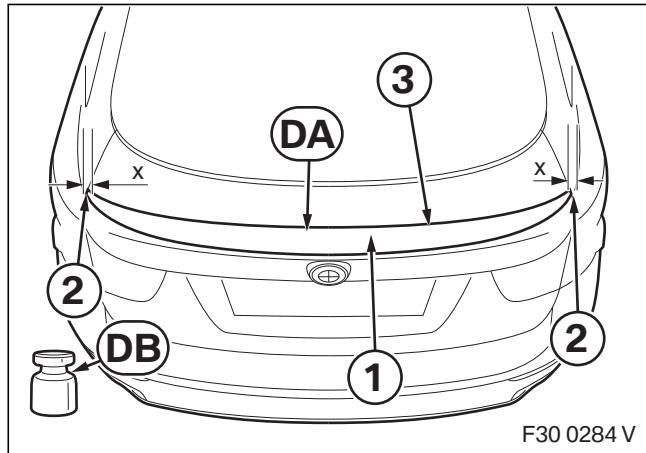
## 13. Installing the M Performance matt black rear spoiler parts list (F30/F35/F80)

### Painting instructions

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

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

► Retrofit kit 51 19 2 349 678 is supplied painted matt black. The rear spoiler can be fitted directly the way it is or painted in accordance with the customer's wishes before installation. ▲



► The bonding surface must be completely clean, dry and free from grease. ▲

Clean the bonding surface (1) on the car using suitable agents.

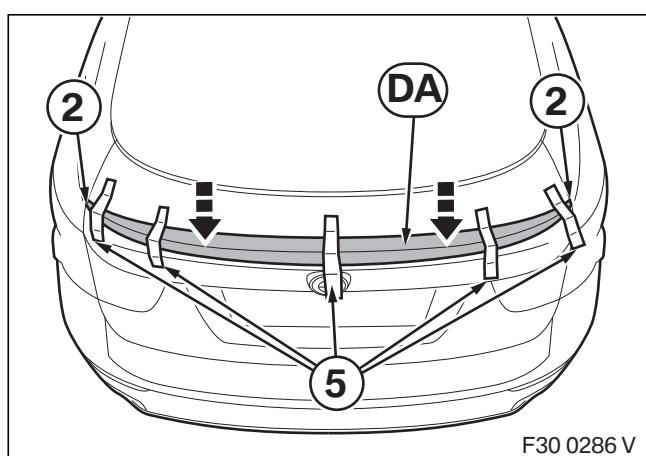
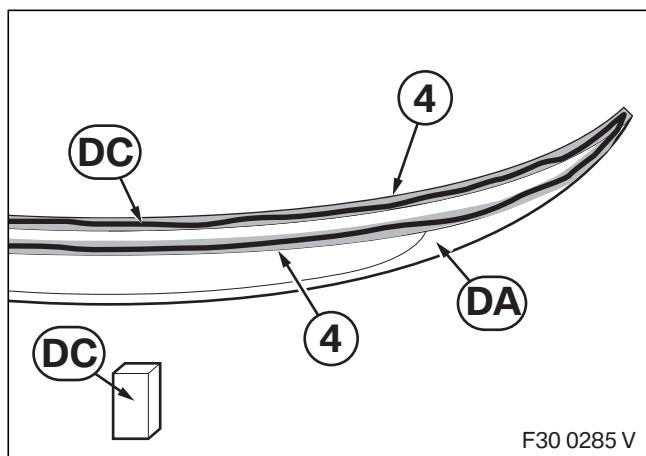
Place the matt black rear spoiler **DA** on the tailgate. Adjust it so it is central and make a mark (2) on the left and right and draw the surrounding contour (3) of the matt black rear spoiler **DA** on the tailgate using suitable means.

► The liquid adhesive kit in the EPC contains a primer which must be used. Obey the ventilation time and other instructions for use that come with the primer **DB**. **Only** treat the marked area (1) with primer **DB**. ▲

Then apply primer **DB** to the bonding surface (1).

Sand and clean the surfaces (4) with suitable agents.

Apply liquid adhesive **DC** to the surfaces (4) of matt black rear spoiler **DA**.



Centre the matt black rear spoiler **DA** using the two marks (2), position it and press it into place. Then secure it using suitable adhesive tape (5).

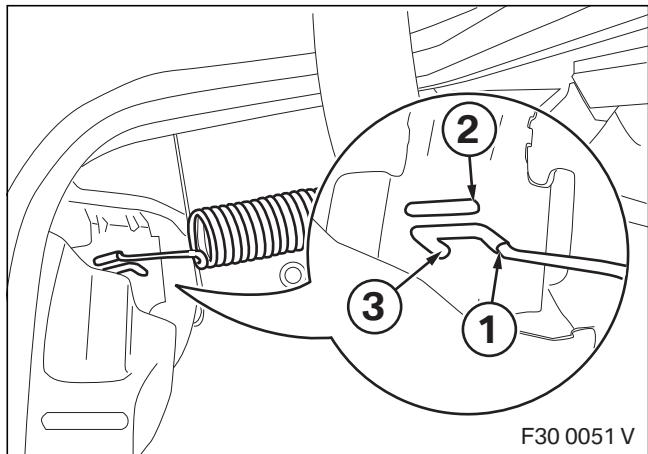
► Press the matt black rear spoiler **DA** firmly on to the tailgate.

Remove any excess liquid adhesive immediately.

Secure the matt black rear spoiler **DA** using suitable adhesive tape (5) at several points for at least **24 hours**.

Note the painting instructions on page 2. ▲

### 13. Installing the M Performance matt black rear spoiler parts list (F30/F35/F80)

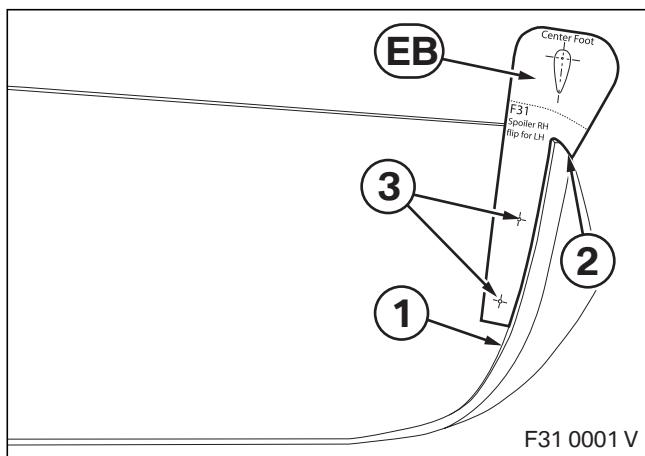


► Positions (1), (2) and (3) are provided for the tailgate's tension spring. ◀

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

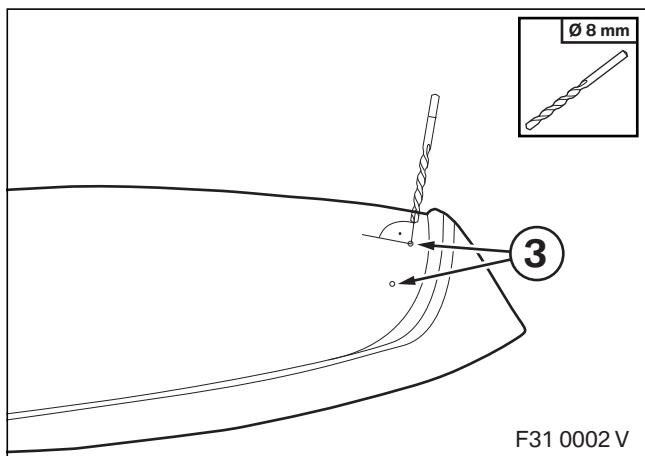
► After repositioning the tension springs, check that the tailgate is able to open properly and adjust the position of the tension springs accordingly if necessary. ◀

## 14. Installing the M Performance matt black ventilated rear spoiler (F31)



► The template **EB** must be used for marking the two sides of the standard spoiler. It is included in the parts kit and can optionally be used by the template on page 33. Note the lettering on the template. The contour edge (1) of the standard spoiler must be used to position template **EB**. ◀

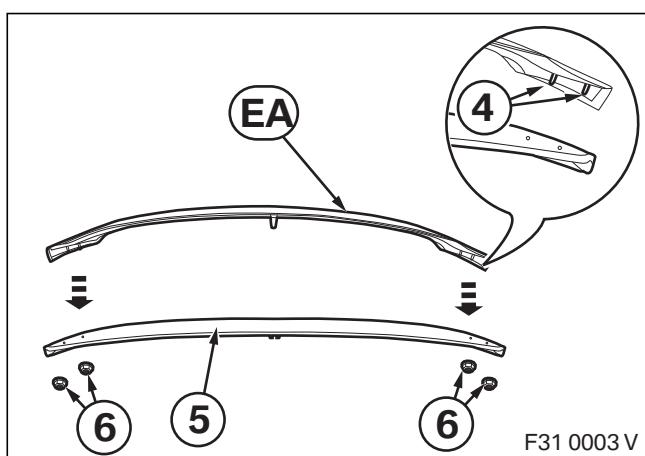
Position template **EB** on the contour edge (1) of the standard spoiler and note the outline (2) of template **EB**. Transfer the marks (3) to the standard spoiler using a suitable tool. Remove template **EB** and repeat the process on the opposite side.



► Ensure that the drill hole is made perpendicularly to the surface. ◀

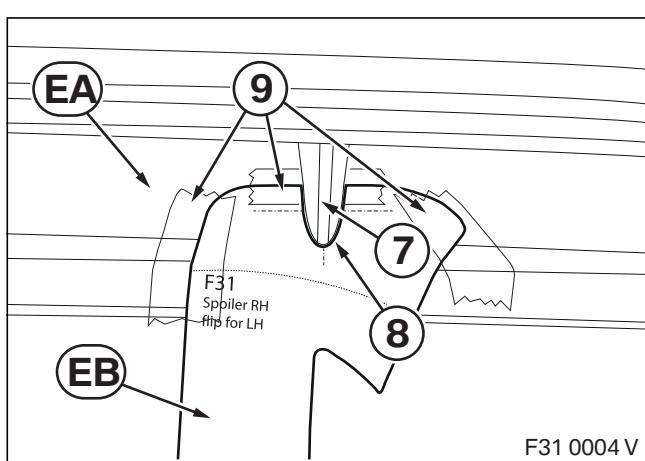
Drill the two markings (3) using a **8 mm** diameter drill bit and deburr.

Repeat the process on the opposite side.



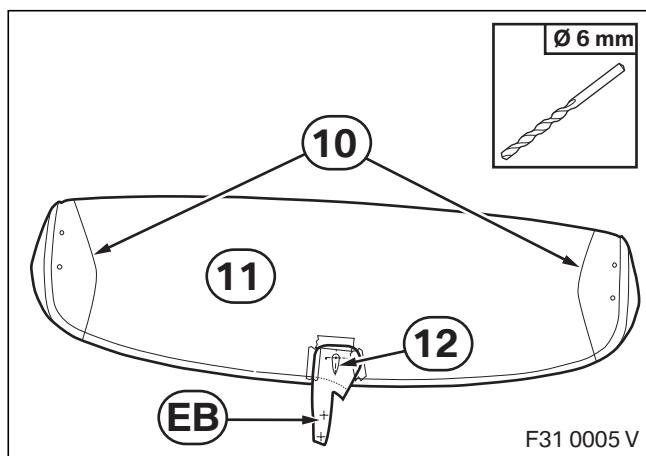
► Remove the protective caps on the four threaded bolts (4). Do not use the nuts included in the parts kit since these are self-locking. ◀

Place the matt black ventilated rear spoiler **EA** on the standard spoiler (5), centre it and secure it until hand-tight using conventional M6 nuts (6).



Clamp template **EB** between the centre lug (7) of the matt black ventilated rear spoiler **EA** and the standard spoiler and align with the outline (8) until it covers the outline of the central lug (7). Then secure the template **EB** with adhesive tape (9).

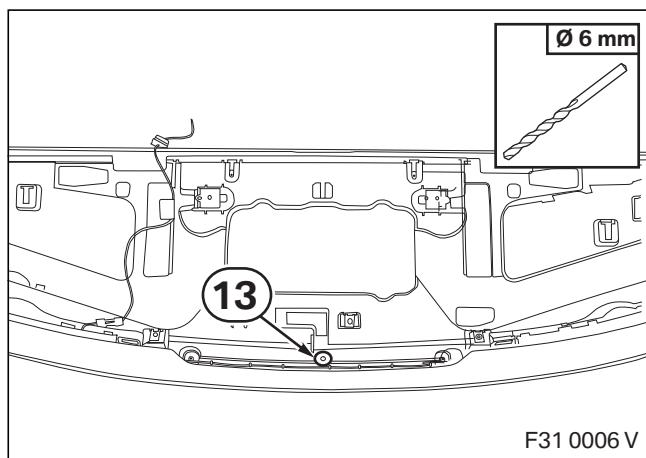
## 14. Installing the M Performance matt black ventilated rear spoiler (F31)



Transfer the outline (10) of matt black ventilated rear spoiler **EA** (for greater clarity, not shown here) to the standard spoiler (11) using suitable tools.

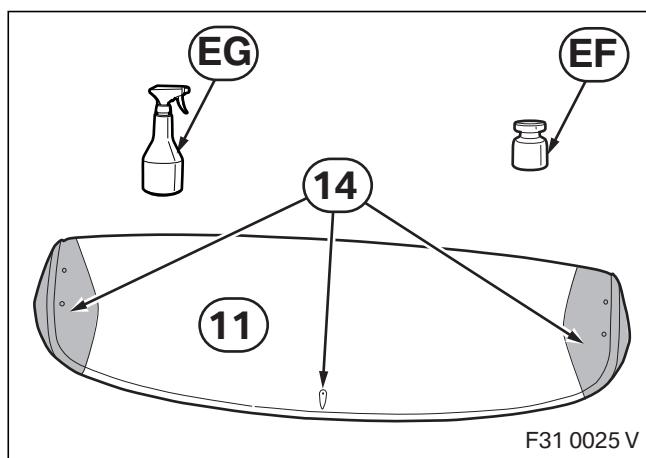
Undo nuts (6) (see graphic F31 0003 V) and remove the matt black ventilated rear spoiler **EA** from the standard spoiler (11).

Transfer a marking at position (12) onto the standard spoiler (11). Remove template **EB**. Drill a hole of **6 mm** diameter through the entire standard spoiler (11) and deburr the hole.



► The following hole must only be drilled through the inner shell. ◀

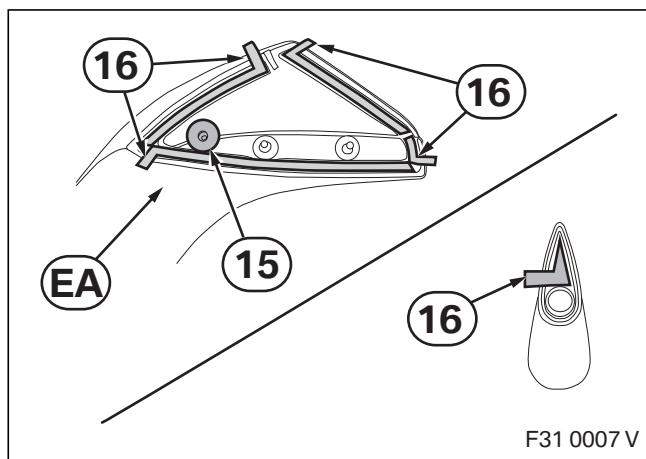
Enlarge the **6 mm** drill hole (13) on the inner shell using suitable tools to a diameter of **around 15 mm** and deburr.



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

Clean the bonding surfaces (14) of the standard spoiler (11) using cleaner **EG** and then prime with primer **EF**.

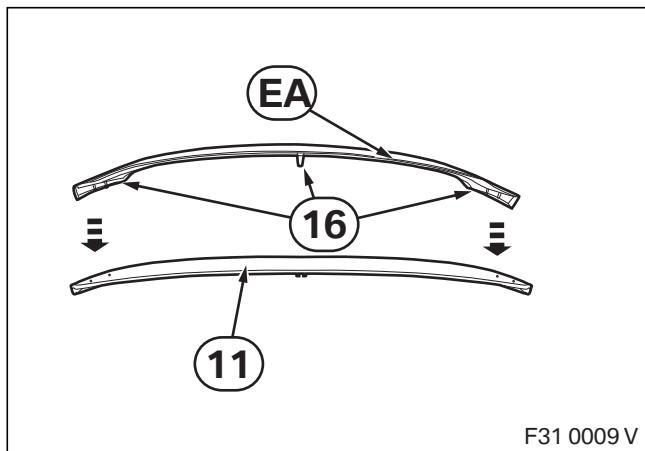
► Wait for the ventilation time. ◀



Remove the protective film (15) on both sides.

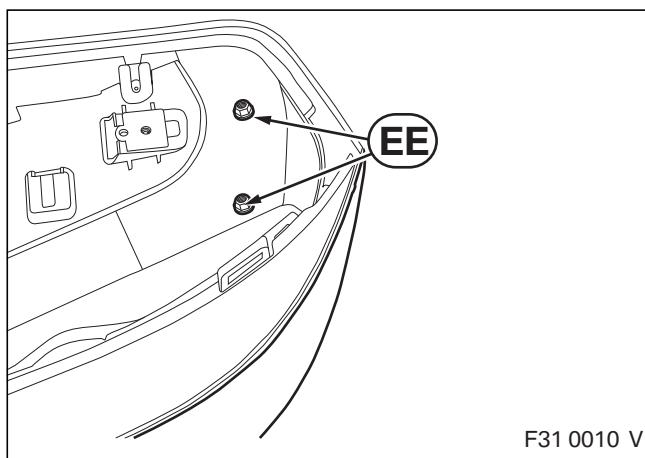
► Ensure that the tabs (16) on the matt black ventilated rear spoiler **EA** point outwards as you position it. ◀

## 14. Installing the M Performance matt black ventilated rear spoiler (F31)

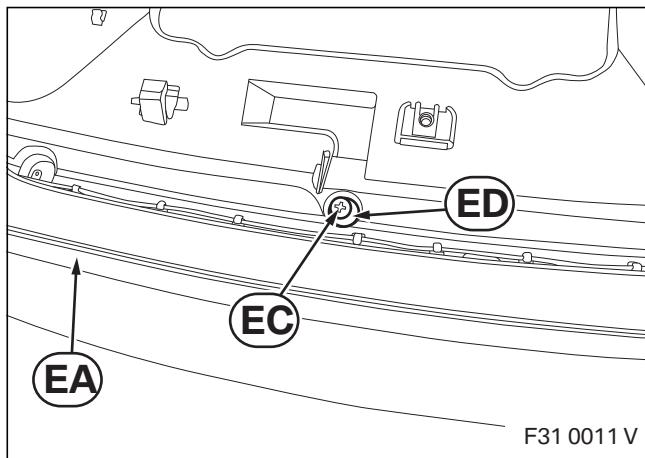


► Simultaneously insert matt black ventilated rear spoiler **EA** on the left and right into the drill holes on the standard spoiler (11), average out and position using conventional M6 nuts (6). ◀

Pull all adhesive backing films (16) on matt black ventilated rear spoiler **EA** outwards and press matt black ventilated rear spoiler **EA** firmly and **repeatedly** onto the standard spoiler (11).



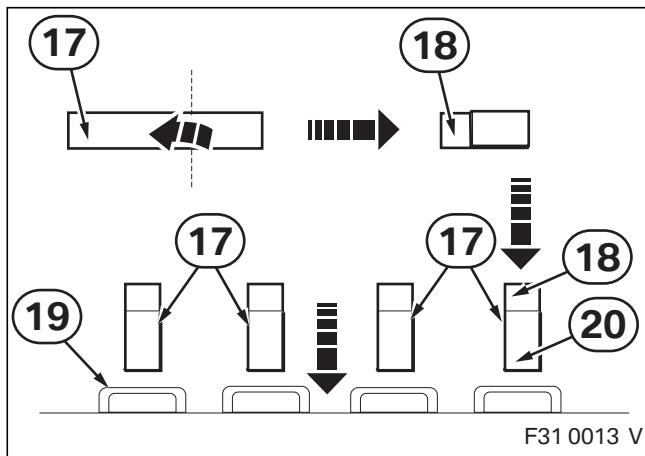
Replace the conventional nuts (6) with self-tapping nuts **EE** from the parts kit and tighten on both sides to **4 Nm**.



► Dip the tip of screw **EC** into liquid adhesive before inserting it. ◀

Insert screw **EC** and shim **ED** from underneath into matt black ventilated rear spoiler **EA** and tighten to **2.5 Nm**.

## 14. Installing the M Performance matt black ventilated rear spoiler (F31)



Fit the third brake light as per **ISTA**. Then fit the standard spoiler to the car as per **ISTA 51 71 412**. To prevent rubber seals from getting trapped in the edge of the standard spoiler, prepare adhesive tape to pull them out. ◀

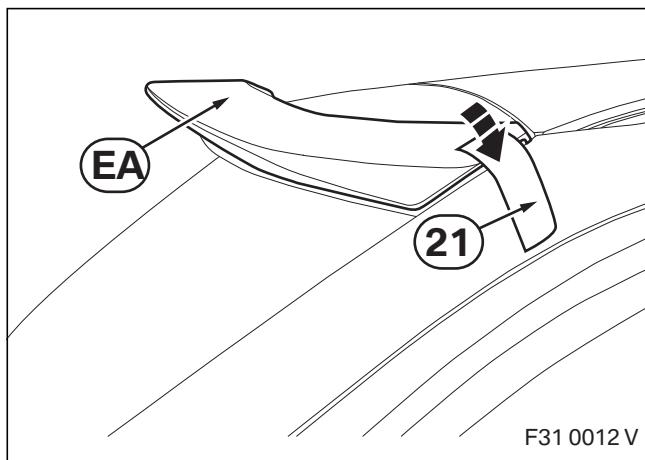
Cut four equal-sized strips of adhesive tape (17) or masking tape. Wrap the adhesive tape (17) eccentrically so that the two bonding surfaces stick together and still leave one bonding surface (18) free.

Stick the adhesive strips (17) with the bonding surface (18) onto the plate at the level of the four tabs (19) so that the non-adhesive area (20) is trapped below the tabs (19).

Fit the standard spoiler. As soon as the tabs (19) engage in the guide, remove the four adhesive strips (17).

Secure matt black ventilated rear spoiler **EA** on both sides using adhesive strips (21).

Do not remove the adhesive strips for **around 30 minutes**. ◀



## 15. Concluding work and coding

The retrofit system does not require coding.

- Conduct a brief test
- Conduct a function test
- Re-assemble the car

## 16. Drilling template (F31)

