

# Original BMW Parts and Accessories. Installation Instructions.



## M Performance Carbon Exterior Components Retrofit Kit. BMW 2 Series Coupé (G42)

### Retrofit kit numbers

Number	Component designation	Installation time (h)	Installation as described in ISTA/AIR*
51 19 5 A27 0F2	Carbon right side skirt attachment	0.30	-
51 19 5 A27 0F3	Carbon left side skirt attachment	0.30	-
51 19 5 A34 857	Carbon centre front attachment	0.20	-
51 19 5 A34 858	Carbon right front attachment	0.20	-
51 19 5 A34 859	Carbon left front attachment	0.20	-
51 19 5 A36 950	Carbon rear spoiler	0.75/1.00**	-
51 19 5 A51 348	Carbon rear spoiler US	0.75/1.00**	-
51 71 9 627 307	Carbon front ornamental grille	-	x
51 47 2 472 521	Sill trim, left/right	-	x
51 44 5 A36 8A5	Aramide antenna cover	-	x
51 19 5 A36 893	Carbon rear diffuser	-	x
51 16 2 462 824	Carbon exterior mirror covers (for MSP*** only) LHD (left-hand drive) right	-	x
51 16 2 462 825	Carbon exterior mirror covers (for MSP*** only) LHD (left-hand drive) left	-	x
51 16 2 462 826	Carbon exterior mirror covers (for MSP*** only) RHD (right-hand drive) right	-	x
51 16 2 462 827	Carbon exterior mirror covers (for MSP*** only) RHD (right-hand drive) left	-	x

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

\*\* Depending on whether the standard gurney has been installed.

\*\*\* MSP = M Sport package

### 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 (must not be invoiced under the 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 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.

After installing the carbon rear diffuser retrofit kit and the right/left carbon front attachment retrofit kit **A**, **B** and carbon front attachment **C**, the retrofit must be programmed/coded via the – **Retrofits** – path.

**The front attachment must only be installed with the standard gurney flap or rear spoiler.**

**Furthermore, the rear spoiler may only be installed with the standard front attachment lip or front attachment.**

**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 other 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 a suitable BMW cleaner or BMW primer (see EPC for details), using 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 may only be driven at a speed of  $v_{max} < 100$  km/h for a period of 24 to 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 illustrations show LHD (left-hand drive) cars; proceed in the same way on RHD (right-hand drive) cars.

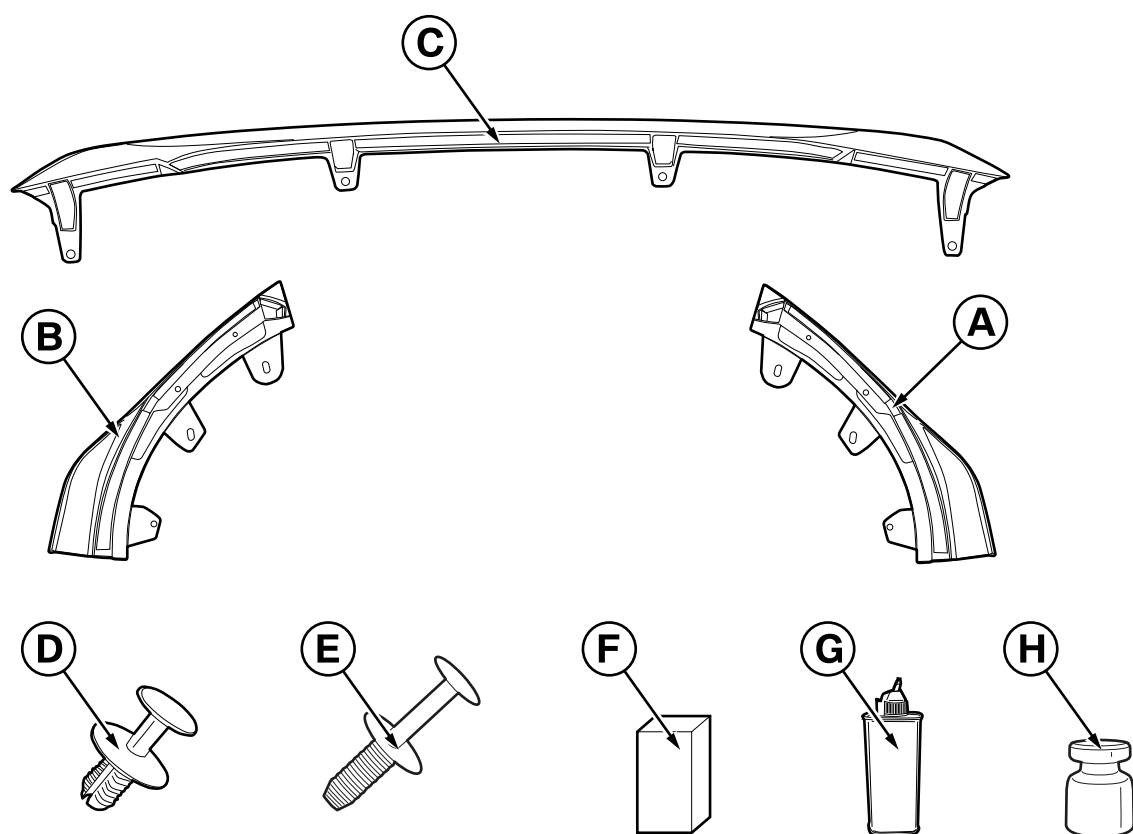
### Special tools required

- None

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## 1. Carbon front attachment parts list

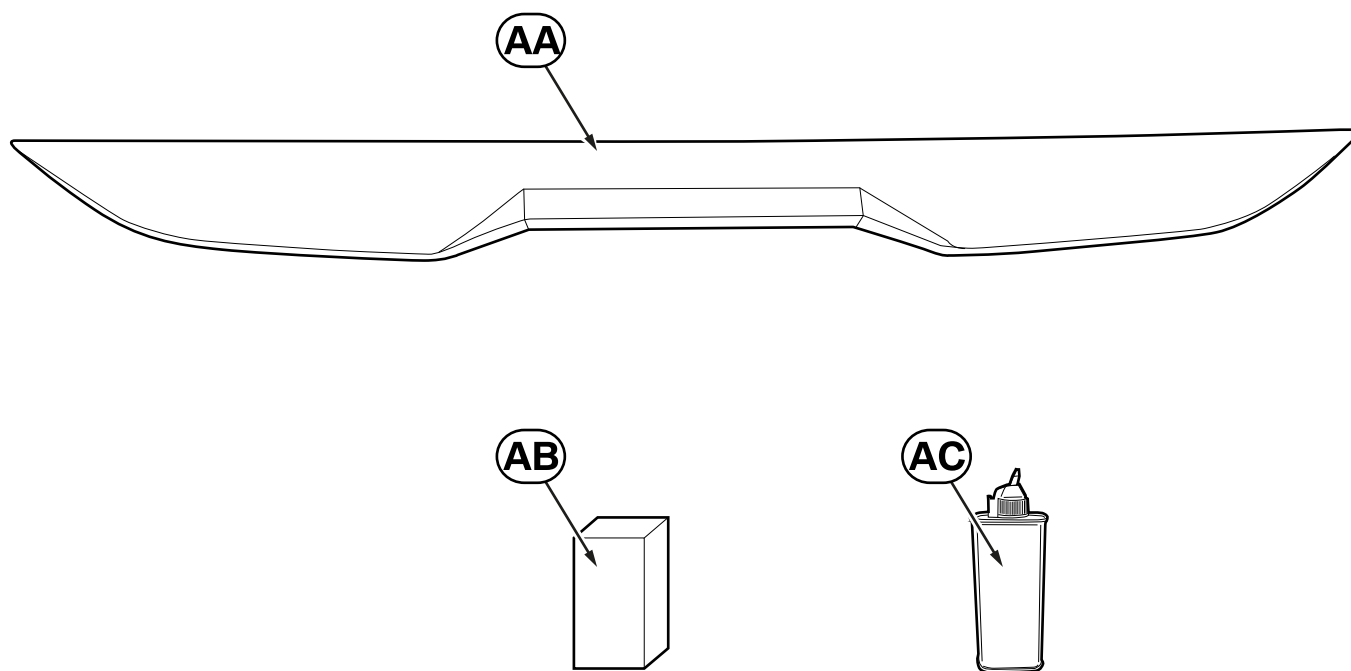


G42 0016 V

### Legend

- A** Front attachment, right (Part No. 51 19 5 A34 858)
- B** Front attachment, left (Part No. 51 19 5 A34 859)
- C** Front attachment, centre (Part No. 51 19 5 A34 857)
- D** Expanding rivet (12 x, Part No. 51 47 1 911 992)
- E** Expanding rivet (2 x, Part No. 51 12 7 004 445)
- F** Liquid adhesive (included in parts kit No. 83 19 5 A32 6D0)
- G** Cleaner (included in parts kit No. 83 19 5 A32 6D0)
- H** Primer (included in parts kit No. 83 19 5 A32 6D0)

## 2. Carbon rear spoiler parts list

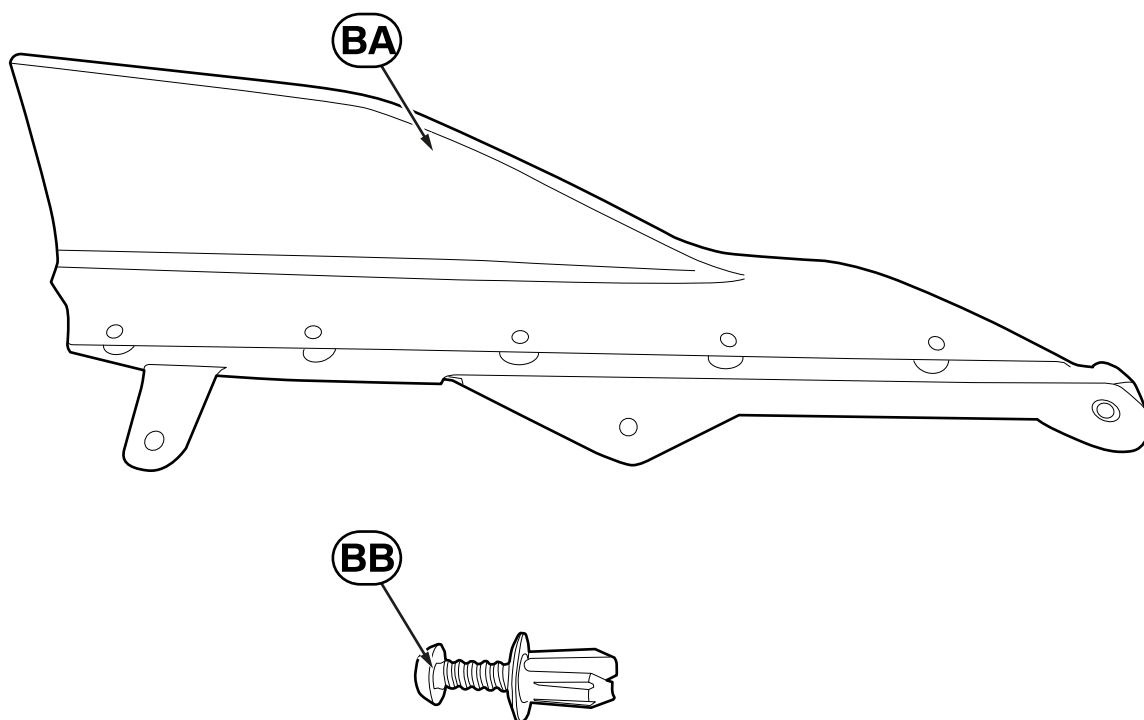


G42 0008 V

### Legend

- AA** Carbon rear spoiler
- AB** Liquid adhesive (not included in kit, see EPC for details)
- AC** Cleaner (not included in kit, see EPC for details)

### 3. Carbon side skirt attachment parts list



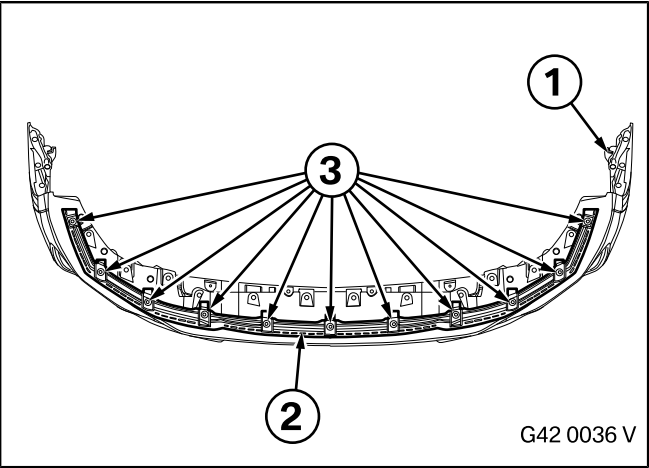
G42 0001 V

#### Legend

- BA** Carbon side skirt attachment, left/right (left side shown)
- BB** Expanding rivet (5 x, Part No. 07 14 9 193 301)

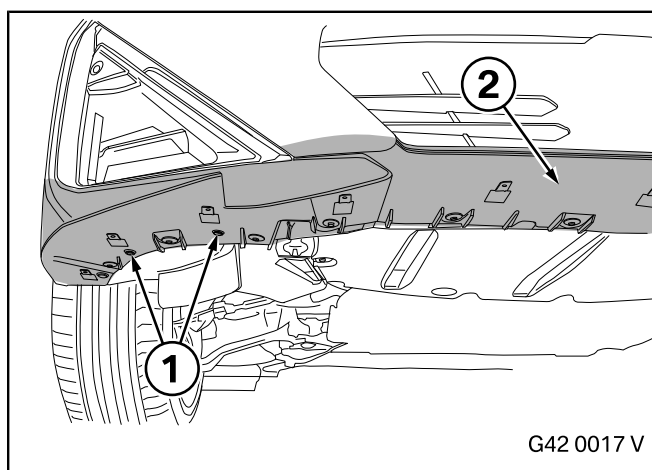
4. Preparatory work

	ISTA/AIR No.
<b>The following components must be removed first of all</b>	
<b>For installing the rear spoiler only</b> The standard rear spoiler may already be installed	---
<b>For installing the front attachment only</b> For M240i and M240iX cars, the standard front attachment lip on the basic car must be removed before installing the M Performance front attachment.	



There is a front attachment lip (2) on the underside of the front apron (1). Undo and remove the 11 screws (3) on the front attachment lip (2).

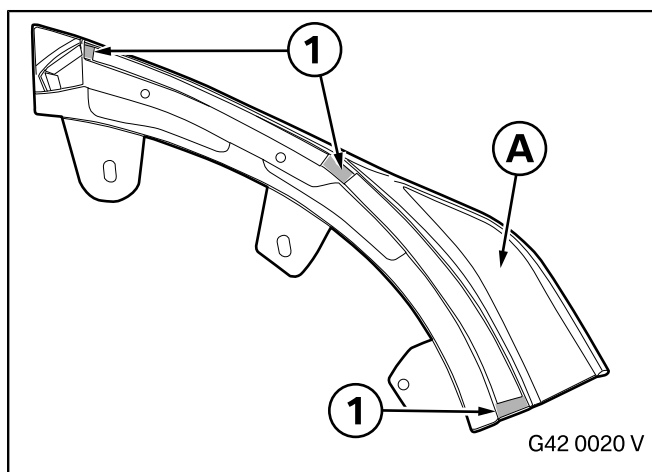
## 5. Carbon front attachment installation



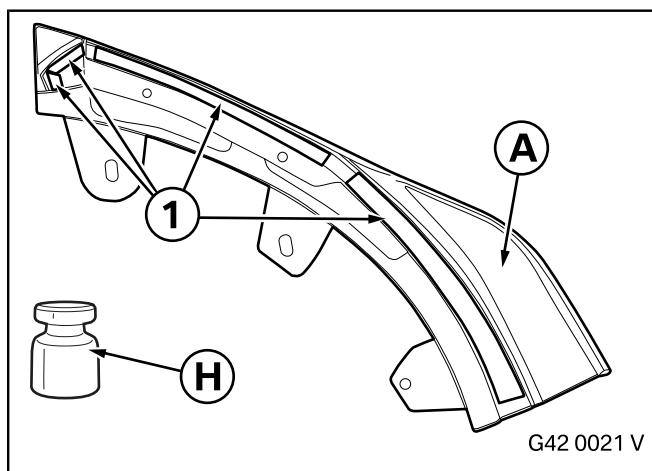
☐ The bonding surfaces must be completely dry, clean, and free from wax or grease. ◀

Remove the four expanding rivets (1) on both sides.

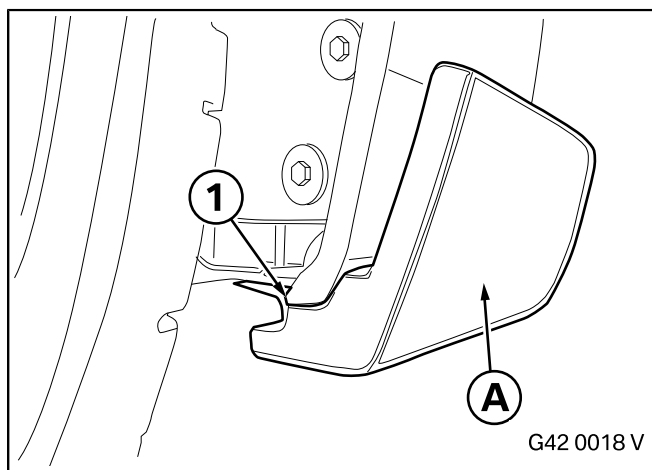
Clean the surface (2) on the car with cleaner **G**.



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



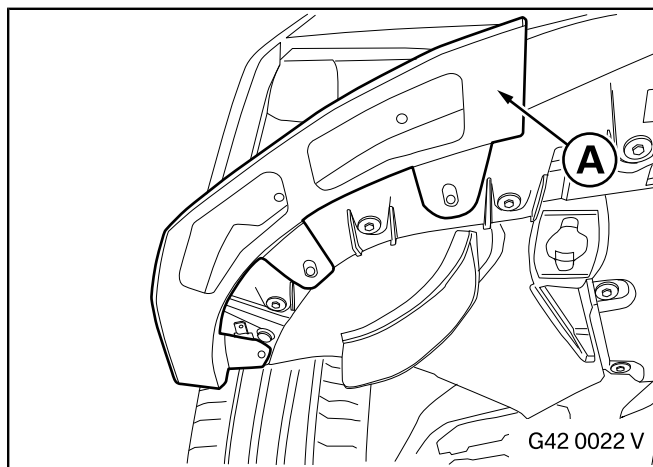
Apply the primer **H** to the backing foils on the adhesive tape (1) with suitable tools.



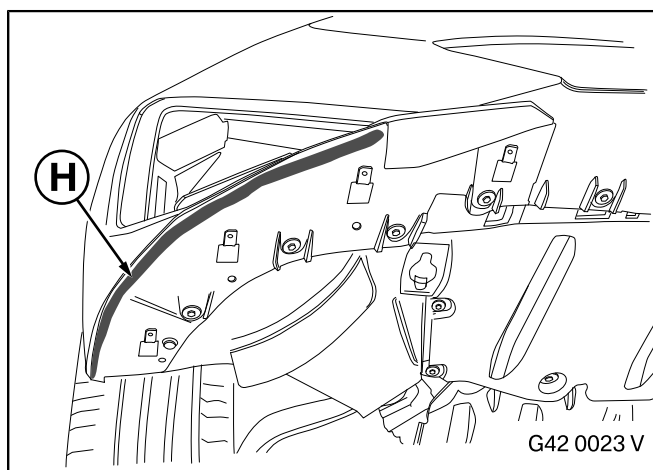
Position the carbon right front attachment **A**. Check the contour (1), it must finish flush with the wheel arch trim.



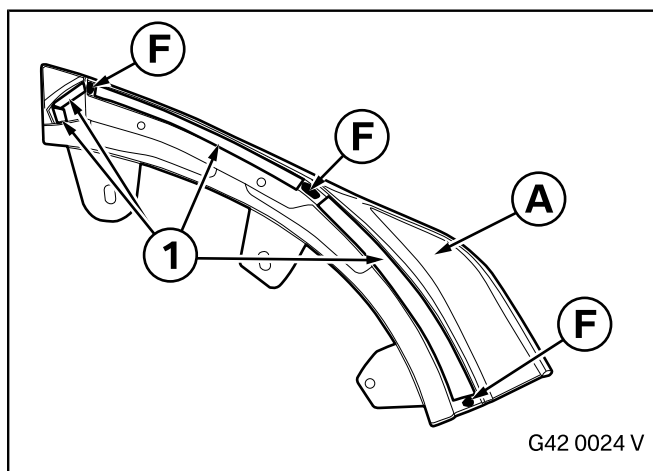
## 5. Carbon front attachment installation



Press the carbon right front attachment **A** to form a positive connection on the front apron and press it firmly against the car, then remove it.

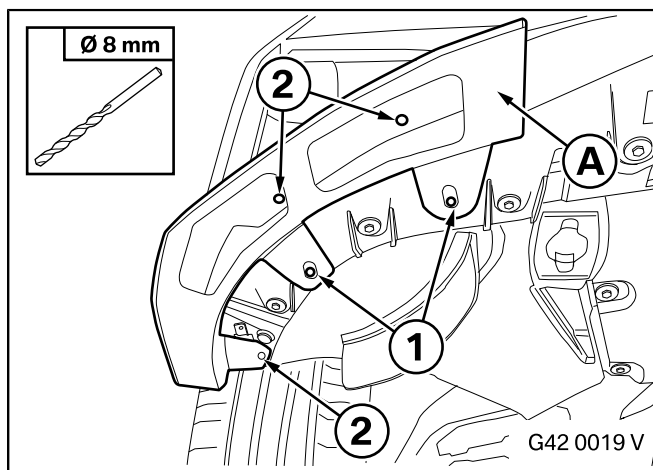


Apply primer **H** to the impression on the front apron as shown.



Remove the backing foils (1) from the adhesive tapes in full.

Apply a bead of liquid adhesive **F** to each of the abraded surfaces.

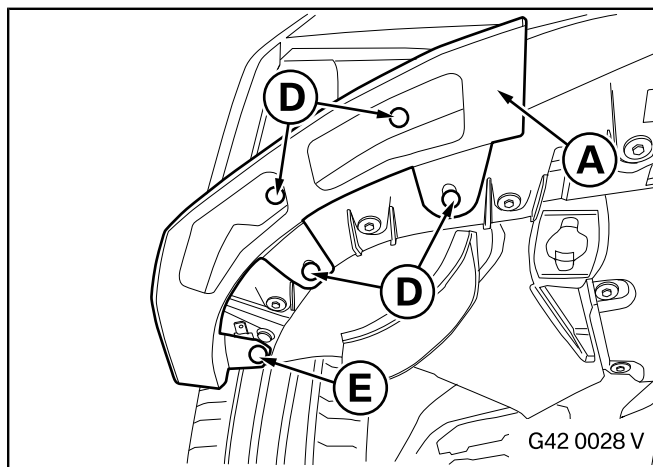


Position the two holes (1) as far to the rear end of the oval hole as possible. ◀

Place the carbon right front attachment **A** in position and press all the adhesive bonds firmly.

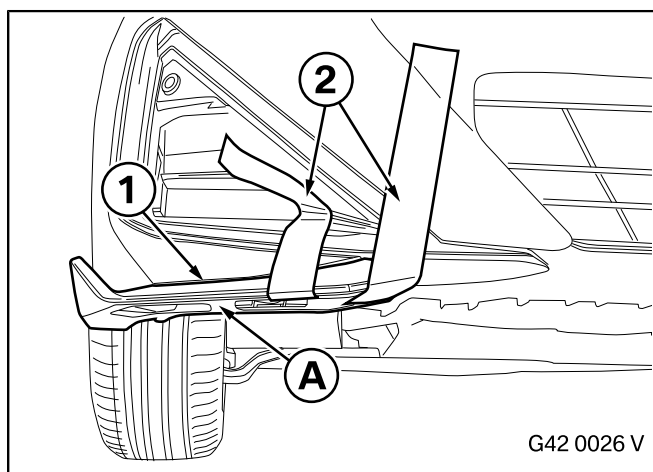
Use the two holes (1) as a guide and drill three holes (2) with an **8 mm** drill bit.

## 5. Carbon front attachment installation



Push the expanding rivet **E** into the outside.

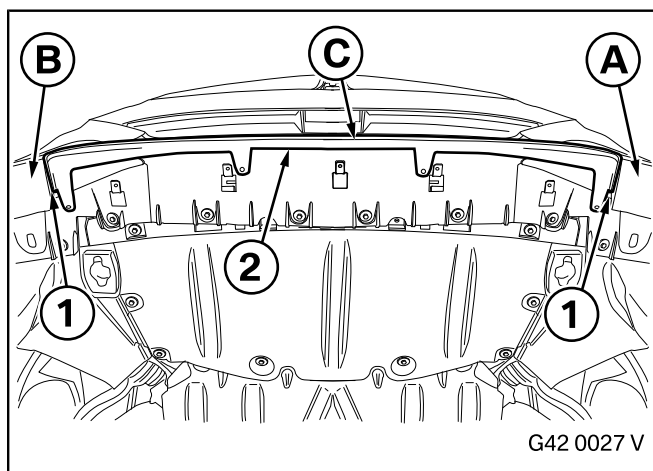
Push in the four expanding rivets **D**.



☐ Remove any excess liquid adhesive immediately using suitable equipment. ◀

Check the contour (1) and secure the carbon right front attachment **A** using suitable adhesive tapes (2).

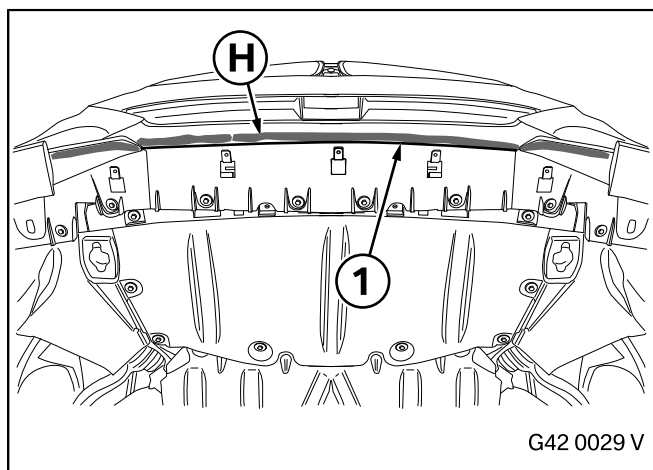
☐ Repeat the whole installation procedure for the carbon left front attachment **B**. ◀



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.

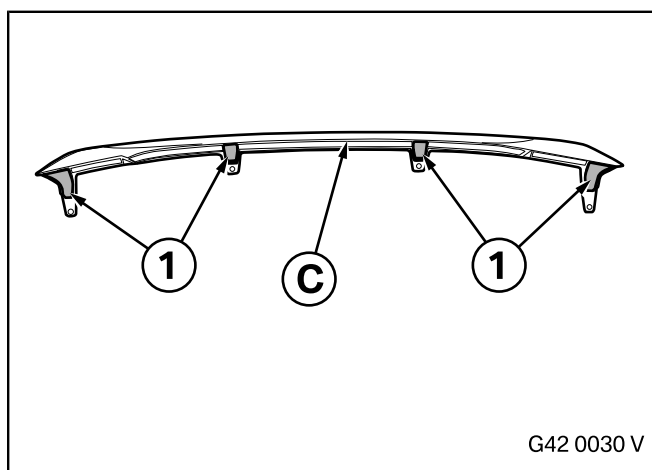
Mark the contour (2) (the internal edge) on the front apron using suitable tools.

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

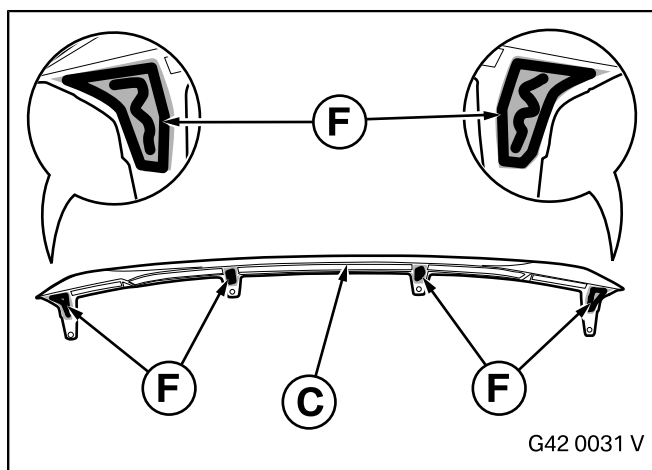


Apply the primer **H** to the surface within the contour (1) you marked earlier using suitable tools only where the surfaces contain adhesive tape, as shown.

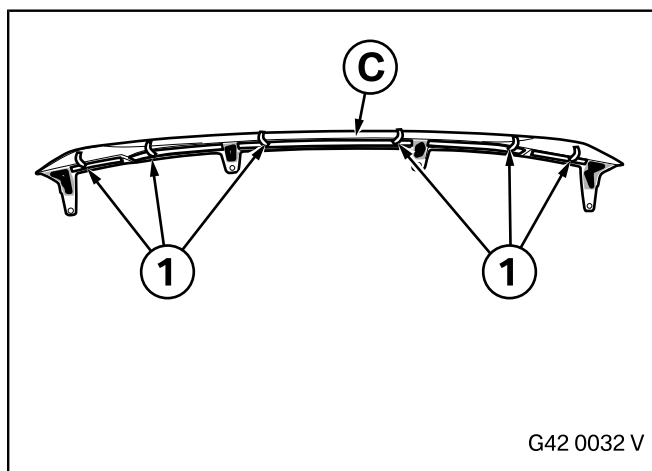
## 5. Carbon front attachment installation



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

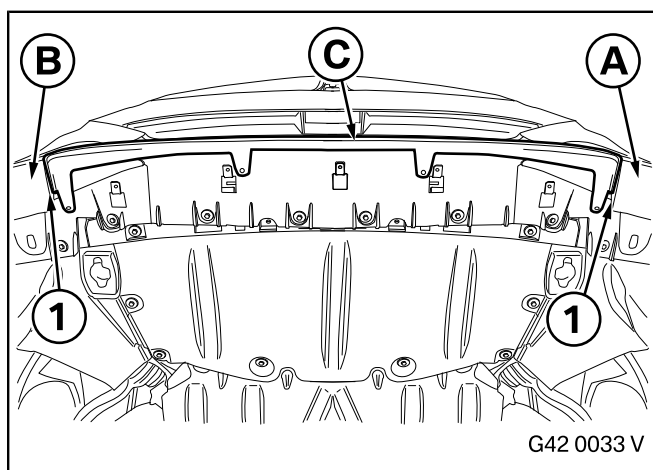


Apply liquid adhesive **F** to the abraded surfaces, on the two outer surfaces, also right up to the left and right edges.



Bend the backing foils on the adhesive tapes (1) at the end to the outside.

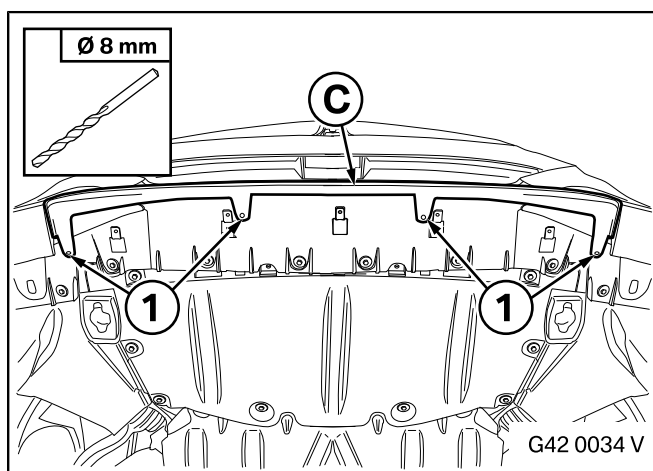
## 5. Carbon front attachment installation



- ▢ Carefully insert the front attachment between the two side sections. Ensure that no liquid adhesive is left on the front apron. Positioning: Position the carbon centre front attachment **C** in the centre between the two side sections. Ensure it is flush with the front edge. The ends of the backing files on the adhesive tapes must be visible. ◀

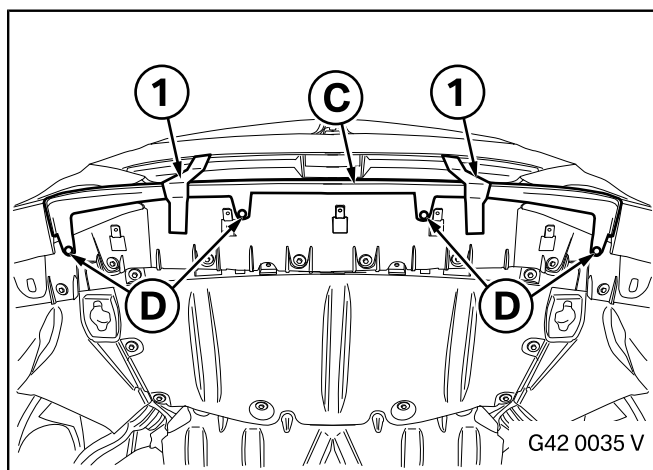
Position the carbon centre front attachment **C** so that the gap (1) is uniform on both sides.

Pull the backing files off the adhesive tapes and press the carbon centre front attachment **C** repeatedly and firmly into position in the areas with adhesive tapes.



- ▢ Do not drill too deeply. Remember that there is a package space behind. ◀

Drill the four holes (1) with an **8 mm** drill bit through the front apron.



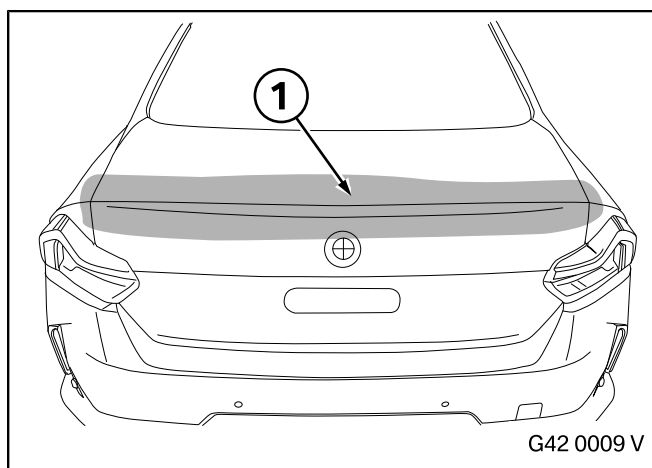
Push in the expanding rivets **D**. Secure the carbon centre front attachment **C** in the centre with adhesive tape (1).

- ▢ This system requires coding. For further details see **Important information** on page 1 and **Concluding work** in section 8.

Leave the car to stand for **24 hours** before removing the adhesive tapes. Refer to the installation instructions on page 2. ◀

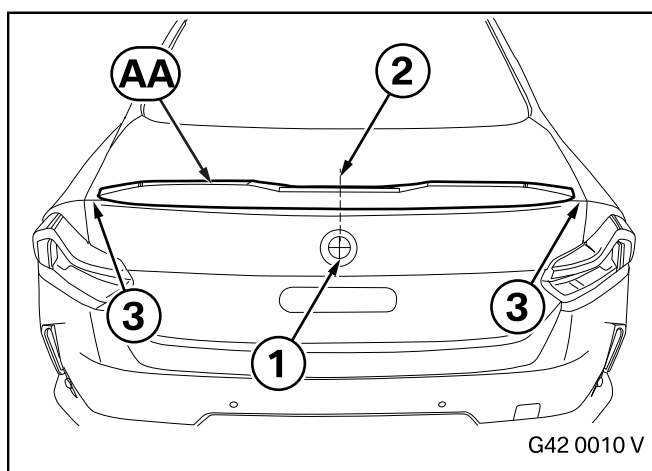
## 6. Installing the carbon rear spoiler

▶ Remove the standard rear spoiler as described in ISTA/AIR if there is one. ◀



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

Clean the bonding surface (1) with cleaner **AC**.



Using a plumb line, for example on the BMW badge (1), find the centre of the boot lid (2) and continue it upwards to the edge, and mark it using a water-soluble pen.

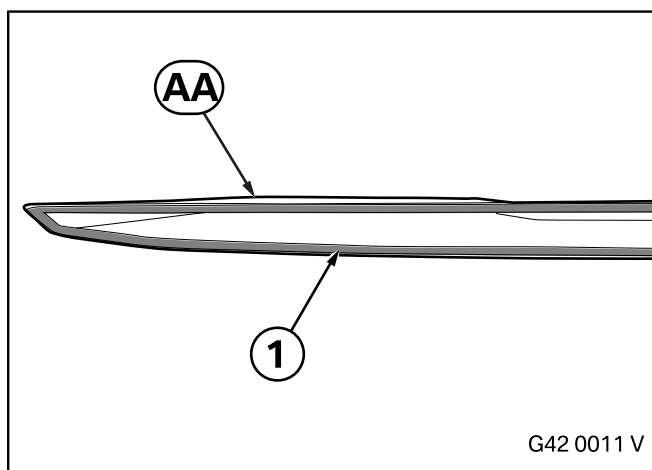
Measure the centre of the carbon rear spoiler **AA** and mark it using a water-soluble pen. Place the carbon rear spoiler **AA** on the edge of the boot lid and adjust it so that it is central using the centre of the boot lid (2) the centre mark you made earlier. Check that the spacing (3) is identical on both sides.

Then mark the contour of the carbon rear spoiler **AA** on the boot lid using a water-soluble pen.

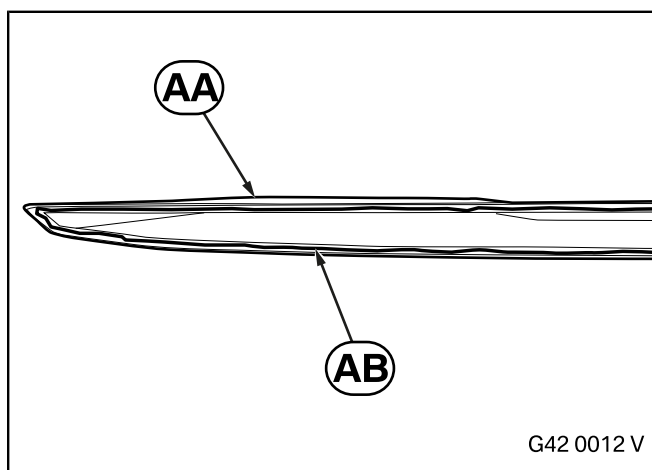
Remove the carbon rear spoiler **AA**.

Abrade the narrow outer surface (1) on the inside of the carbon rear spoiler **AA** using suitable tools.

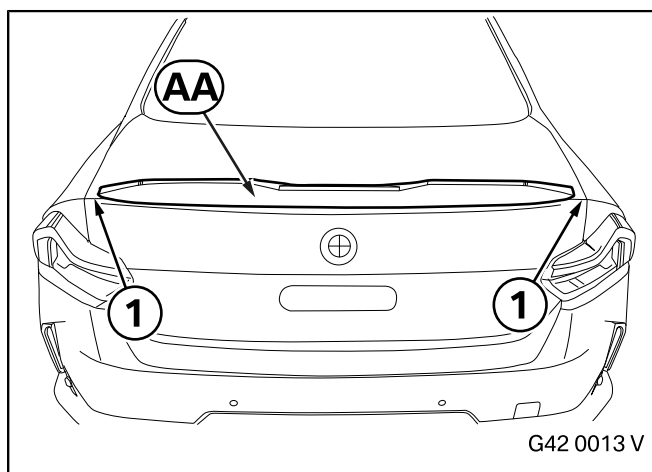
Then clean the surface (1) with cleaner **AC**.



## 6. Installing the carbon rear spoiler



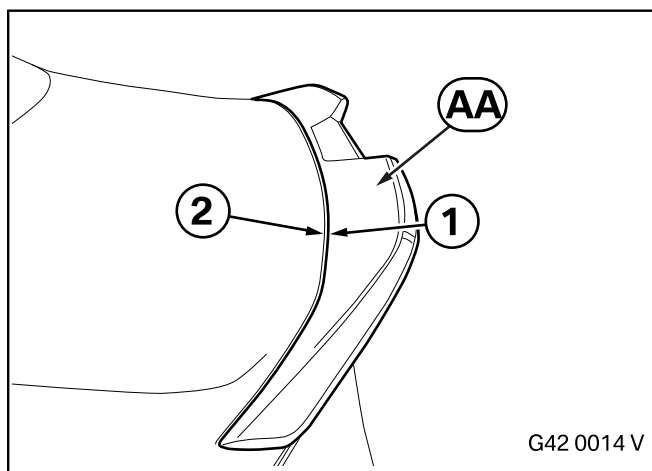
Apply a bead of liquid adhesive **AB** to the abraded surface of the carbon rear spoiler **AA**.



Position the carbon rear spoiler **AA** using the drawn contour on the boot lid.

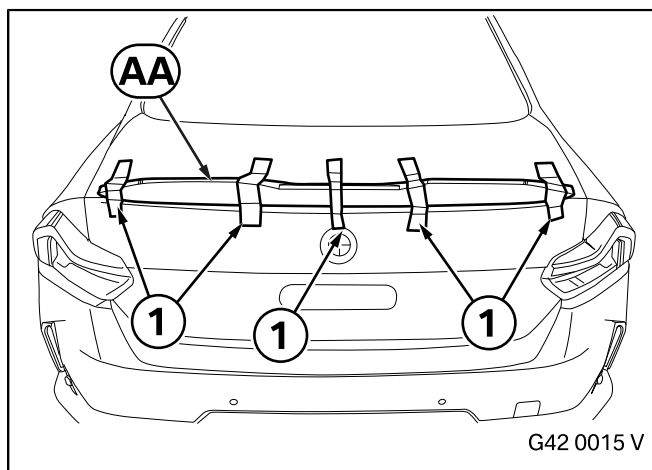
Recheck the position of the carbon rear spoiler **AA** at the left and right (1).

▶ Remove any excess liquid adhesive immediately using suitable equipment. ◀



Check that the contour (1) of the carbon rear spoiler **AA** lines up with the contour (2) of the boot lid.

▶ **The joint should be flat with no large gaps and straight.** ◀

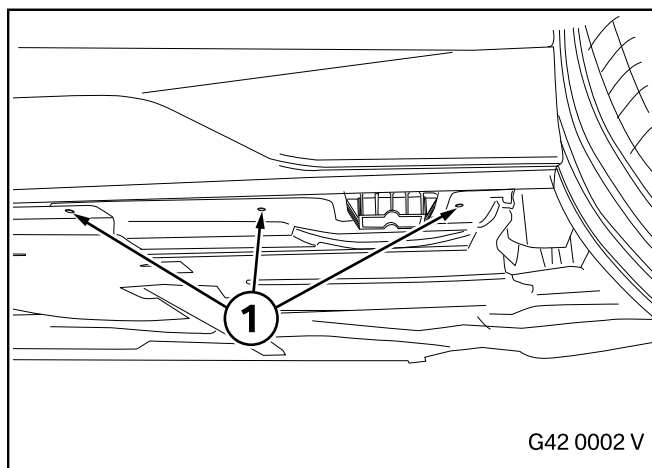


Secure the carbon rear spoiler **AA** in at least five places using suitable adhesive tapes (1).

▶ When it has been secured with the adhesive tapes (1), do not adjust the carbon rear spoiler **AA** any further. Remove any excess liquid adhesive immediately. Do not remove the adhesive tapes (1) for **24 hours**, also remove the water-soluble pen on the boot lid and refer to the installation instructions on page 2. ◀

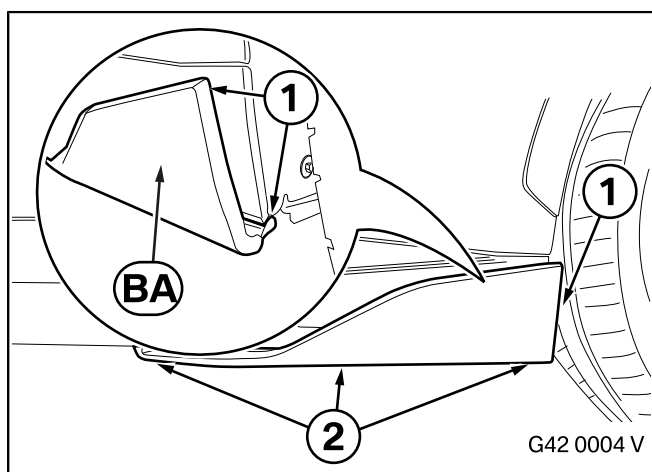
## 7. Installing the carbon side skirt attachment

- Use a suitable lifting platform or suitable action to provide good access to the installation position. ◀



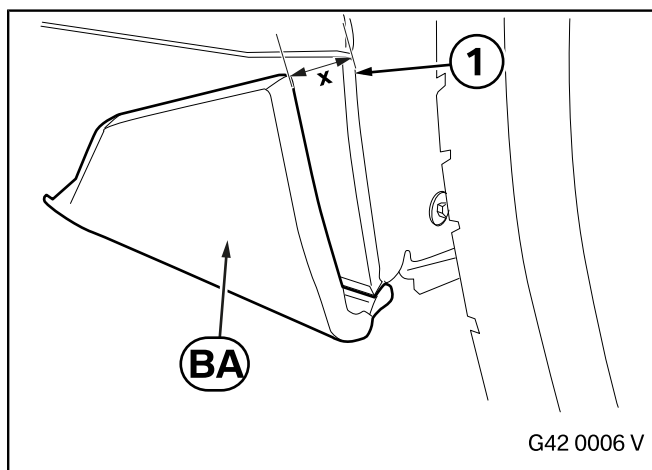
Remove the three fastening screws (1) and keep them safe. They will be reused later.

- Clean the installation position with suitable products. ◀



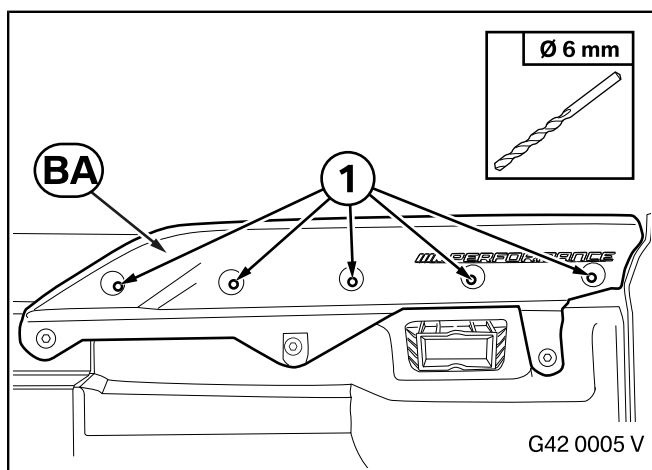
- When positioning the component, ensure that the end (1) of the carbon side skirt attachment **BA** is flush with the side skirt. ◀

Position the carbon side skirt attachment **BA** on the car and loosely screw in the three existing fastening screws (2).



- When you secure the carbon side skirt attachment **BA**, ensure that the spacing **x** to the car (1) is the same on both sides. ◀

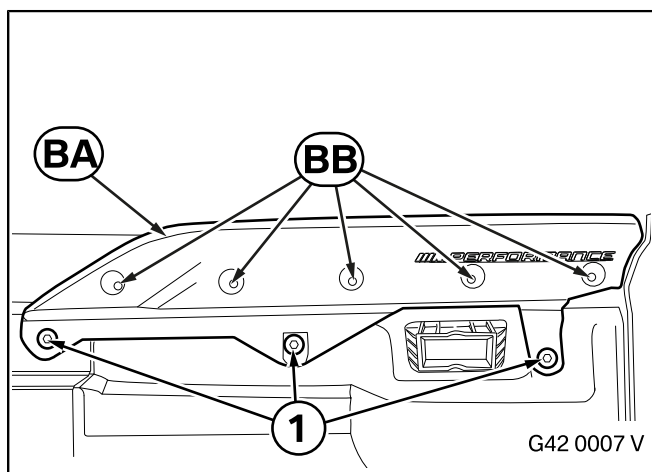
## 7. Installing the carbon side skirt attachment



▶ When you position the carbon side skirt attachment **BA**, the five holes (1) must have adequate support on the side skirt.

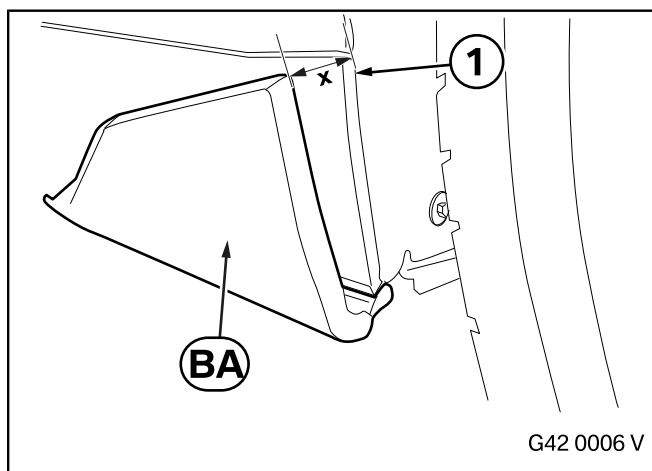
Use a **5 mm** drill stop so as not to damage the part below. ◀

Drill the five holes (1) with a **6 mm** bit.



Fully tighten the three existing fastening screws (1).

Push in the five expanding rivets **BB**.



▶ Recheck the spacing **x** to the car (1) on both sides and correct it if necessary. ◀



## 8. Concluding work and coding

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

The retrofit system requires programming/coding if the carbon right/left front attachment retrofit kit **A, B** and the carbon front attachment retrofit kit **C** 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: Select "DSMO" via the – **Retrofits** – path and work through the action plan
- Retrofit customer service word for carbon right/left front attachment retrofit kit **A, B** and carbon front attachment **C**: 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