

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 5A270F2	Carbon right side skirt attachment	0.30	-
51 19 5A270F3	Carbon left side skirt attachment	0.30	-
51 19 5A34857	Carbon left front attachment	0.20	-
51 19 5A34858	Carbon right front attachment	0.20	-
51 19 5A34859	Carbon centre front attachment	0.20	-
51 19 5A51348	Carbon rear spoiler US	0.75/1.00**	-
51 19 5A36893	Carbon rear diffuser (for MSP***/MPA**** only)	0.30	-
65 20 5A59AB5	Aramid antenna cover (see EBA 01 29 5A5C9E3 for installation instructions)	0.50	-
65 20 5A59AB7	Aramid antenna cover (built before 07/2022)	0.50	-
65 20 5A59AD9	Aramid antenna cover (built from 07/2022 onwards)	0.50	-
51 62 5A63C67	Black high gloss roof edge spoiler	0.25	-
51 62 5A63C65	Carbon throughflow rear spoiler	2.00	-
51 62 5B33F50	Carbon throughflow rear spoiler	2.00	-
51 71 9627307	Carbon front ornamental grille	-	x
51 47 2472521	Sill trim, left/right	-	x
51 16 2462824	Carbon exterior mirror covers (for MSP*** only) LHD right	-	x
51 16 2462825	Carbon exterior mirror covers (for MSP*** only) LHD left	-	x
51 16 2462826	Carbon exterior mirror covers (for MSP*** only) RHD right	-	x
51 16 2462827	Carbon exterior mirror covers (for MSP*** only) RHD left	-	x
51 16 8075063	Left carbon cover cap	-	x
51 16 8075064	Right carbon cover cap	-	x
51 16 8075065	Left carbon cover cap	-	x
51 16 8075066	Right carbon cover cap	-	x
16 11 2472988	Carbon filler cap	-	x
51 14 5A4B373	Black high gloss M side logo	-	x
51 14 2472854	Black painted lettering	-	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

**** MPA = M Performance Automobiles

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 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

- Templates **DB** and **DC** can be found in the appendix of these installation instructions. **Print them without scaling. Check the dimensions on the printout with a ruler.**
- 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. Do not touch the bonding surfaces after this time.
- If you use adhesive tape, it must be applied using a contact pressure of between 10 N/cm² and 50 N/cm². (A forceful press of your thumb will reach around 35 N/cm².) It is not how long you apply this pressure, but the force with which it is applied that counts. Press the component into place over the entire bonding area. Removing the adhesive tape after pressing the component into place will destroy the bond.
- 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.

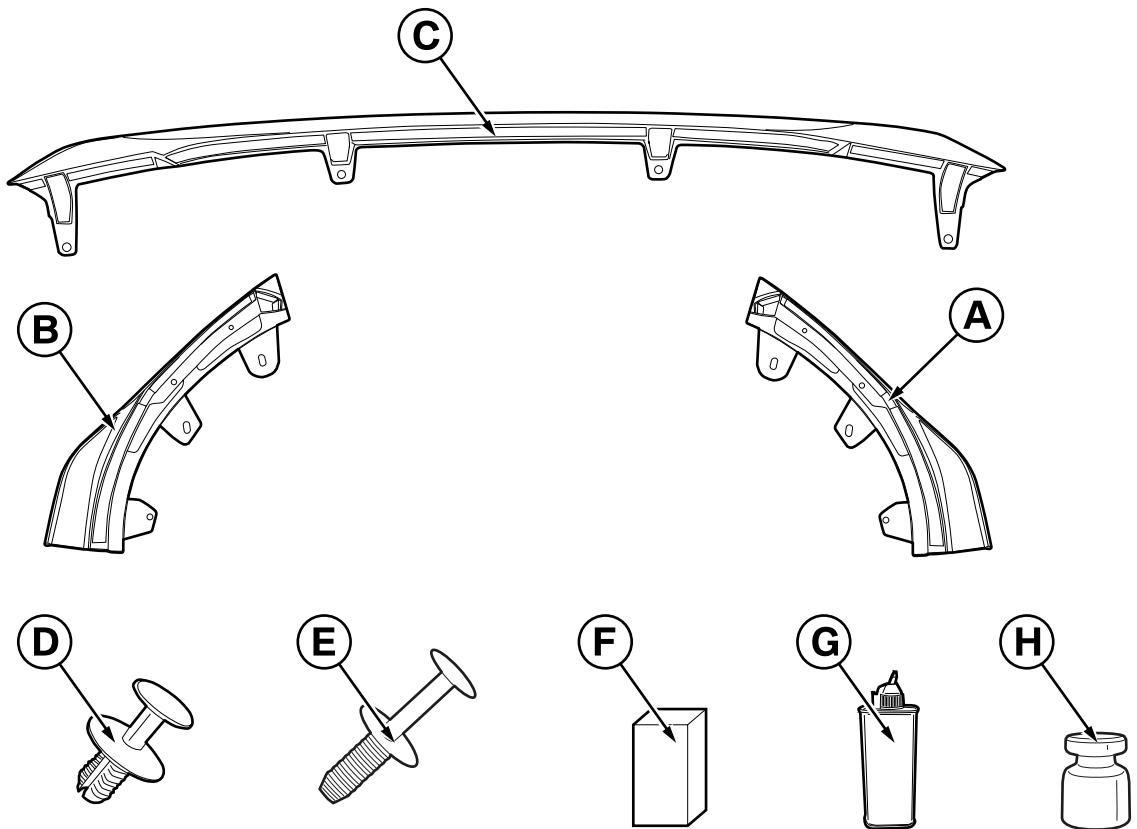
Special tools required

- None

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1. Carbon front attachment parts list

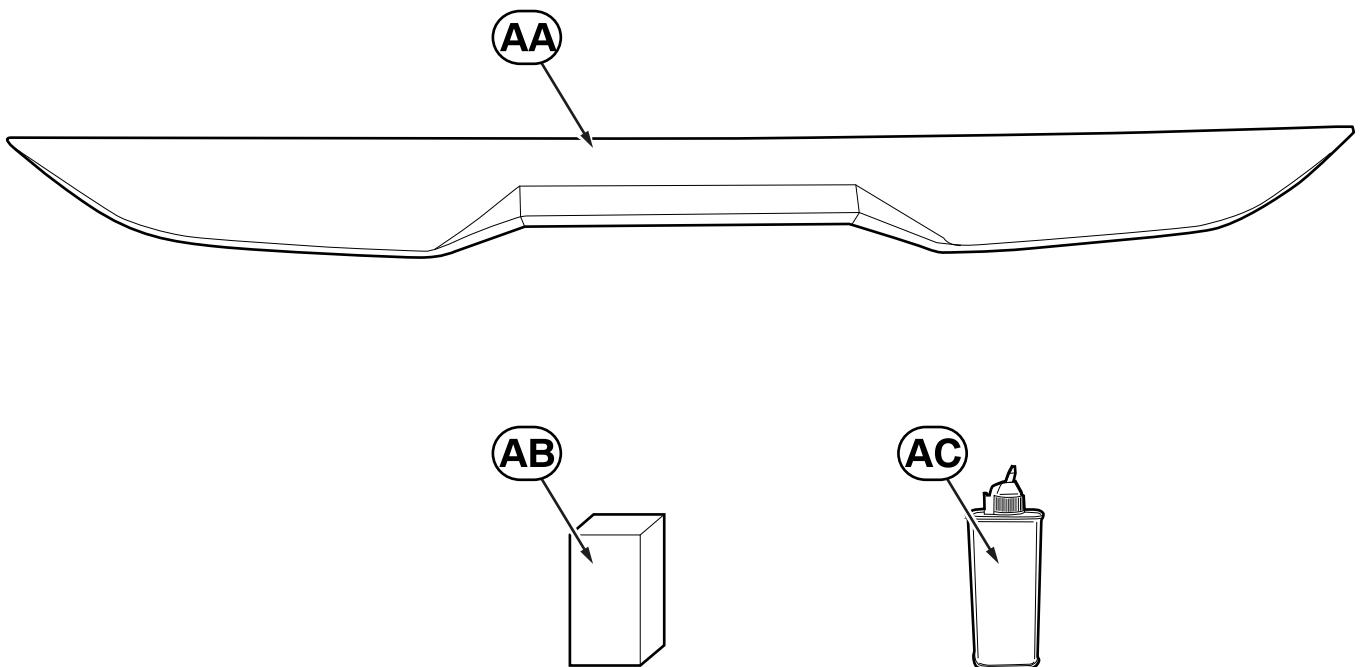


G42 0016 V

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

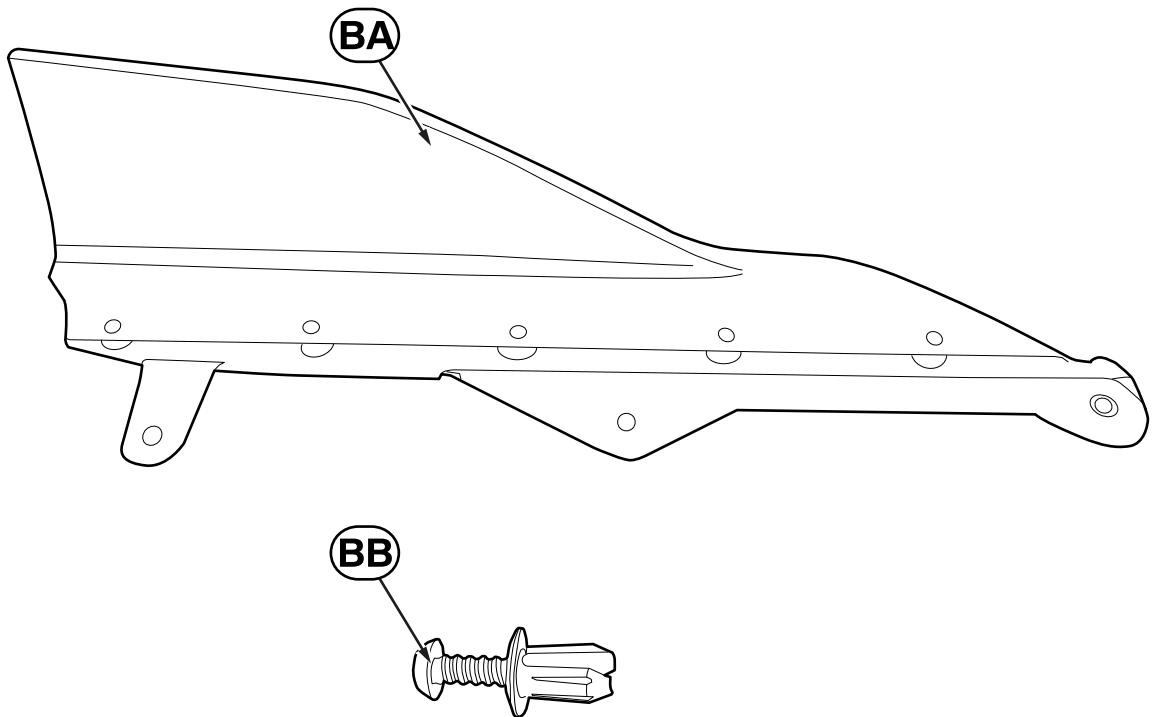


G42 0008 V

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



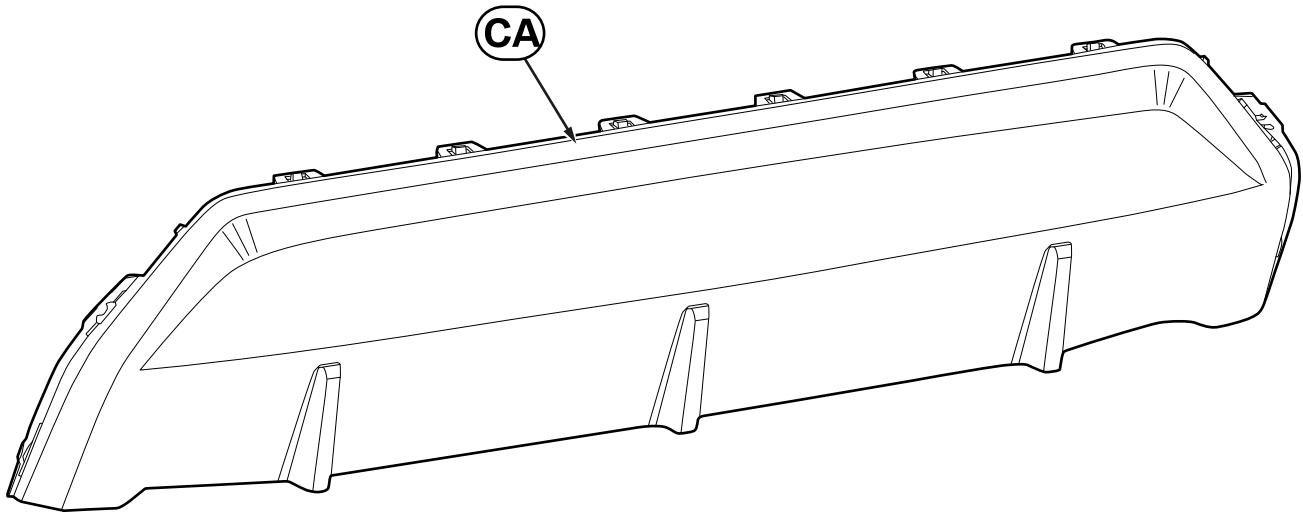
G42 0001 V

Legend

BA Carbon side skirt attachment, left/right (left side shown)

BB Expanding rivet (5 x, Part No. 07 14 9 193 301)

4. Carbon rear diffuser parts list

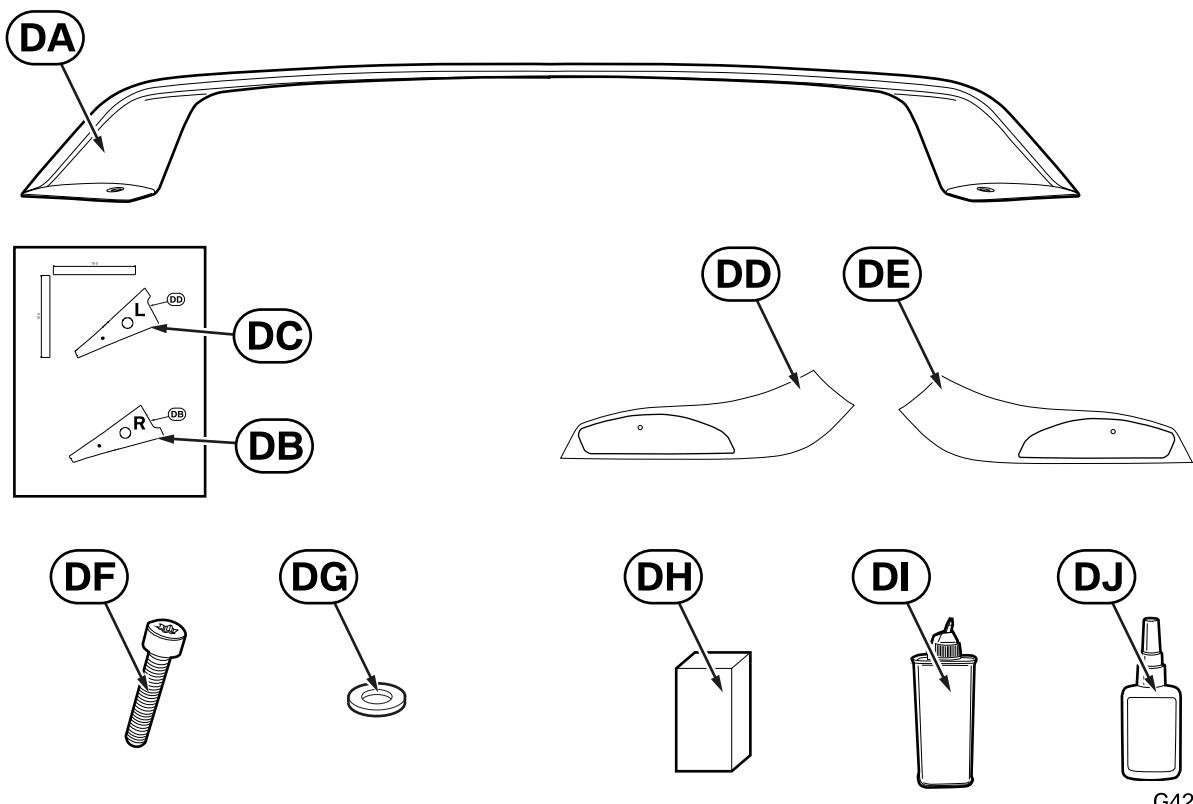


G42 0057 V

Legend

CA Carbon rear diffuser

5. Carbon throughflow rear spoiler (Clubsport) parts list

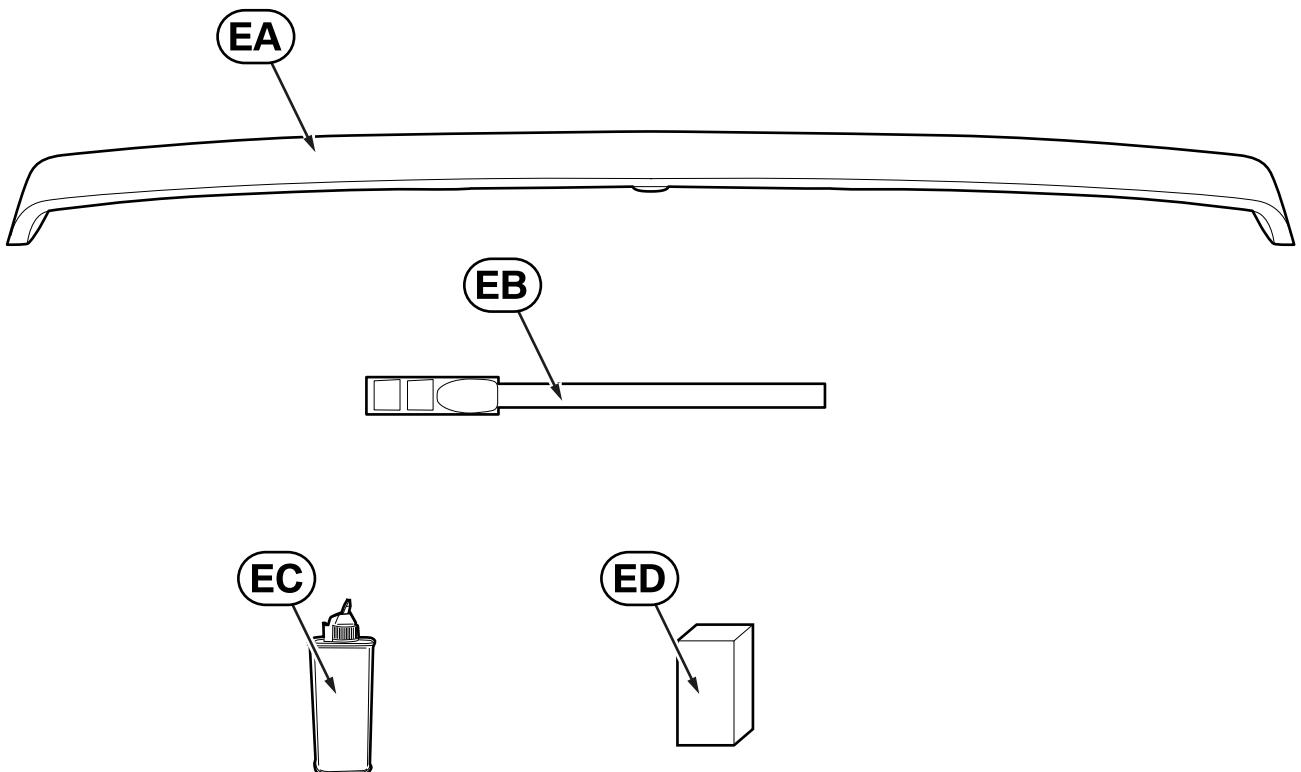


G42 0076 V

Legend

- DA** Carbon throughflow rear spoiler
- DB** Right inner template
(in the appendix of these installation instructions, **print without scaling**)
- DC** Left inner template
(in the appendix of these installation instructions, **print without scaling**)
- DD** Right outer template
- DE** Left outer template
- DF** Screw (2 x)
- DG** Washer (2 x)
- DH** Liquid adhesive (not included in kit, see EPC for details)
- DI** Cleaner (not included in kit, see EPC for details)
- DJ** Liquid screw lock (not included in kit, see EPC for details)

6. Black high gloss roof edge spoiler parts list



G42 0090 V

Legend

- EA** Black high gloss roof edge spoiler
- EB** Backing film with adhesive pads
- EC** Cleaner (not included in kit, see EPC for details)
- ED** Liquid adhesive (not included in kit, see EPC for details)

7. Preparatory work

ISTA/AIR No. ---

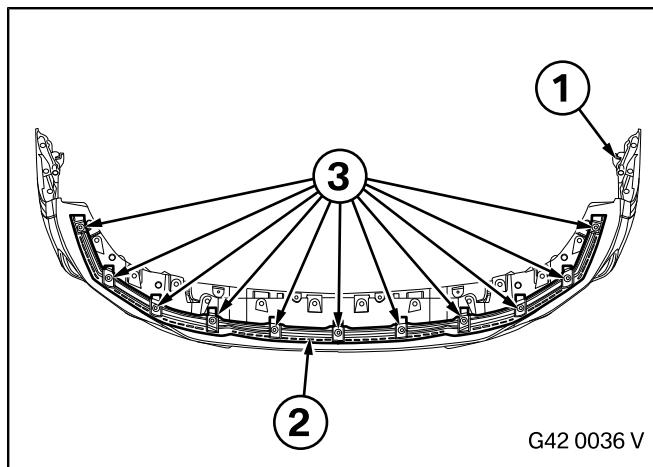
The following components must be removed first of all

For installing the rear spoiler only

The standard rear spoiler may already be installed

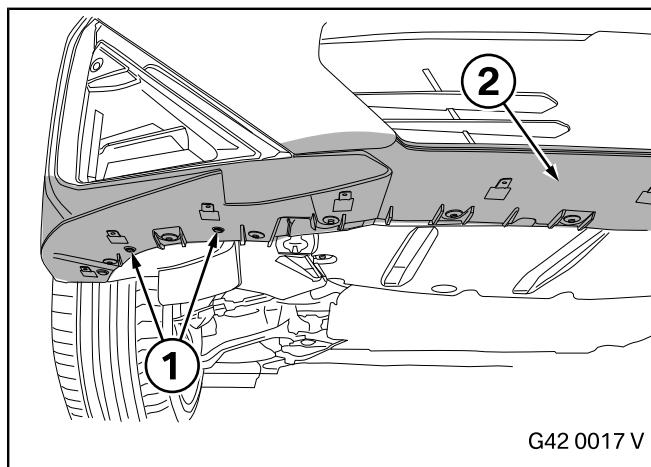
For installing the front attachment only

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 eleven screws (3) on the front attachment lip (2).

8. Carbon front attachment installation

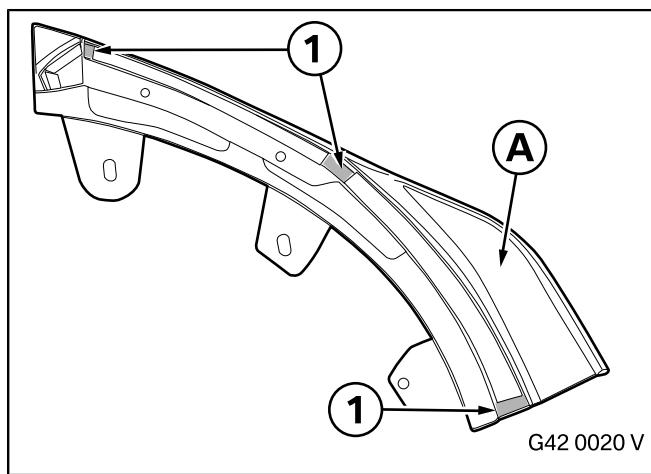


G42 0017 V

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

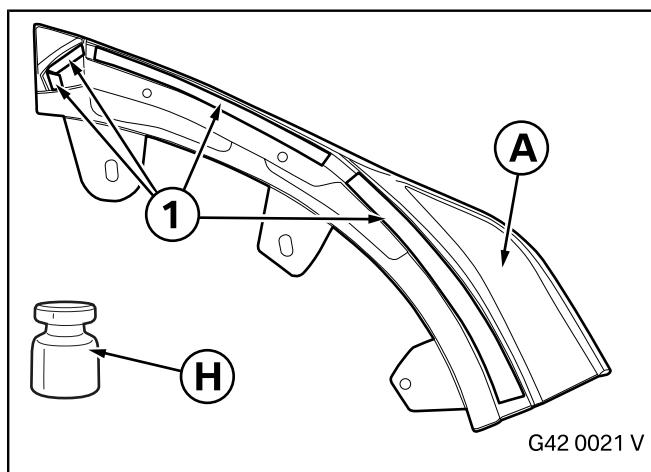
Remove the four expanding rivets (1) on both sides.

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



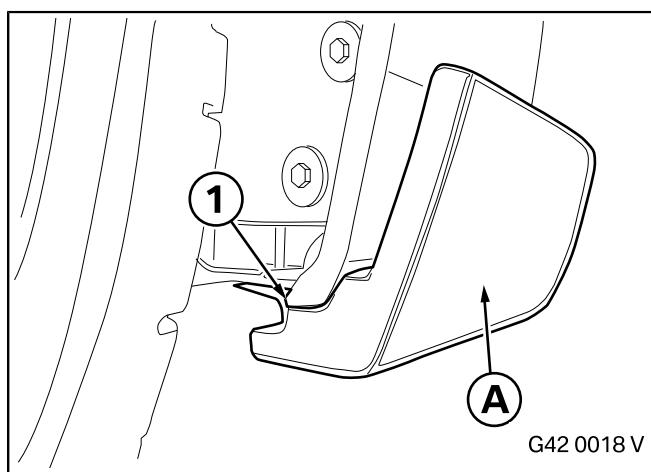
G42 0020 V

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**.



G42 0021 V

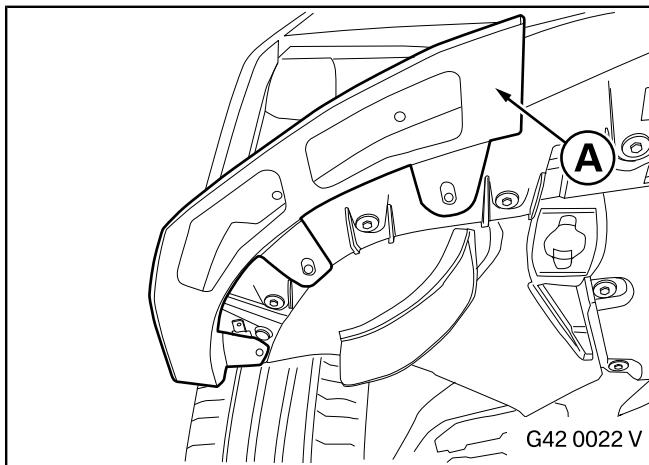
Apply the primer **H** to the backing foils on the adhesive tape (1) with suitable tools.



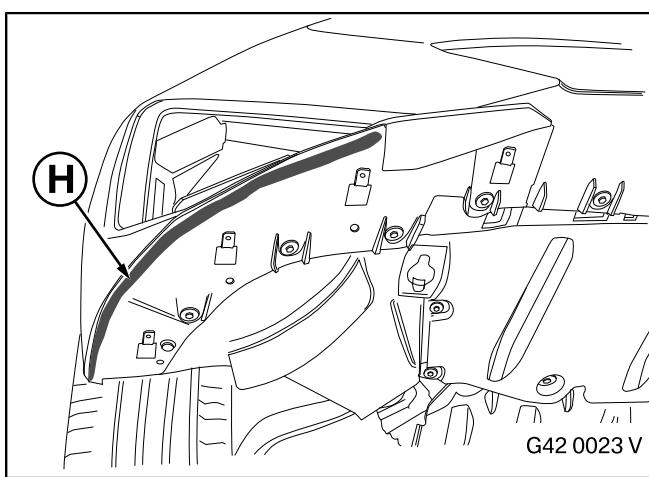
G42 0018 V

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

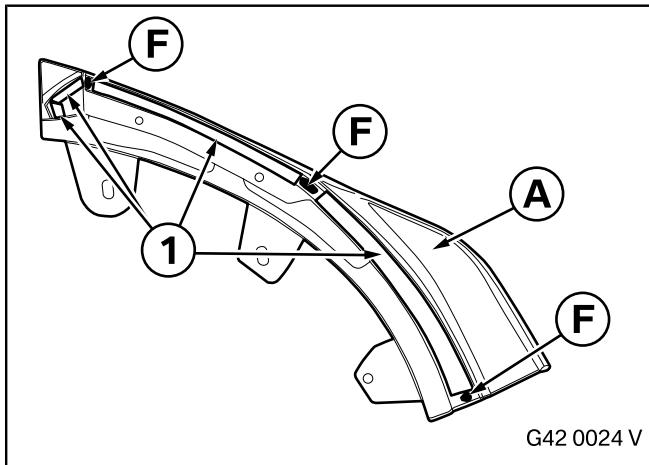
8. Carbon front attachment installation



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.

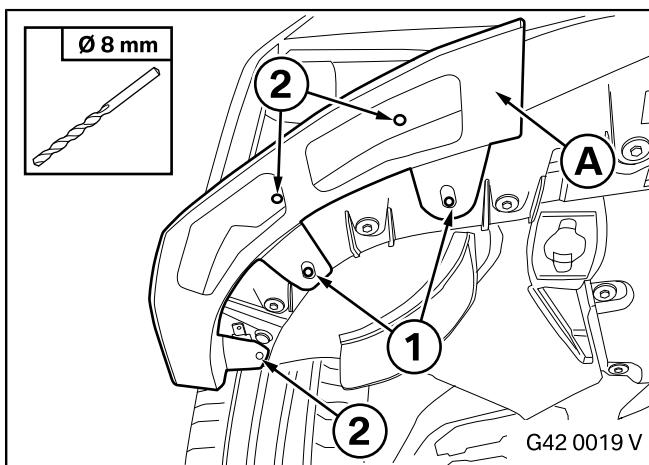


Apply primer **H** to the impression on the front apron as shown.



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

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

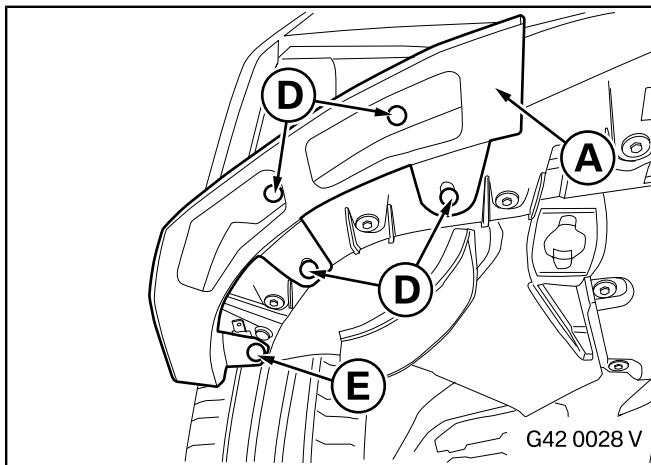


► Position the two holes (1) as far to the rear end of the oval hole as possible. ◀

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

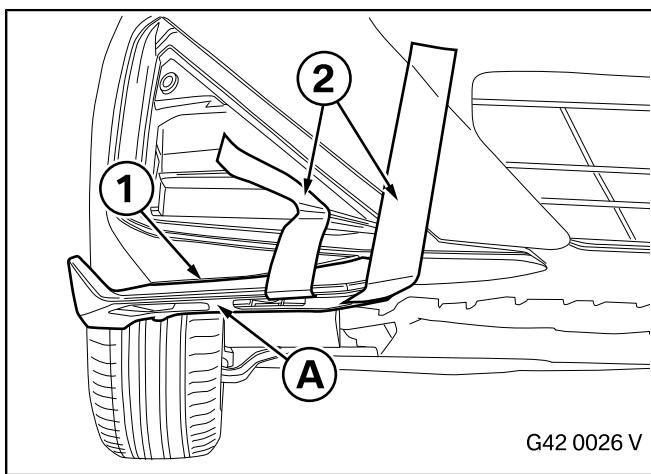
Use the two holes (1) as a guide and drill three holes (2) with an **8 mm** drill bit.

8. Carbon front attachment installation



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

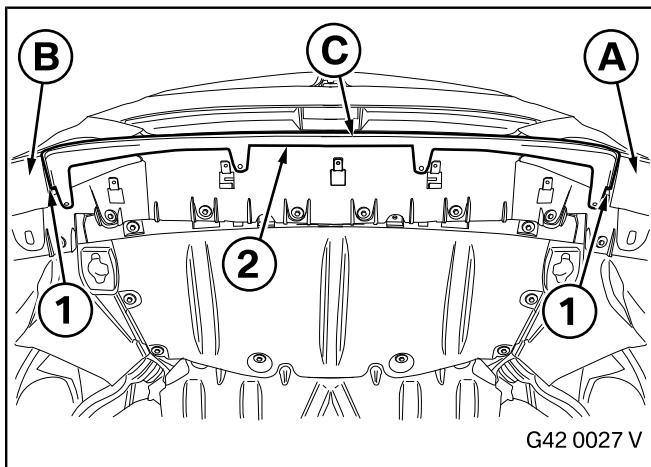
Push in the four expanding rivets **D**.



► 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).

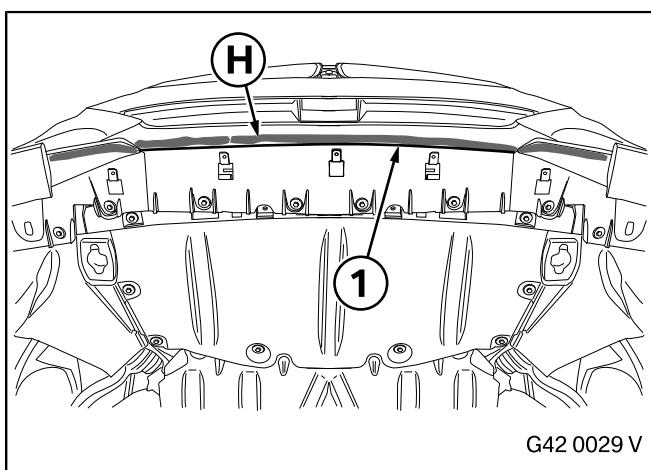
► Repeat the whole installation procedure for the carbon left front attachment **B**. ◀



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.

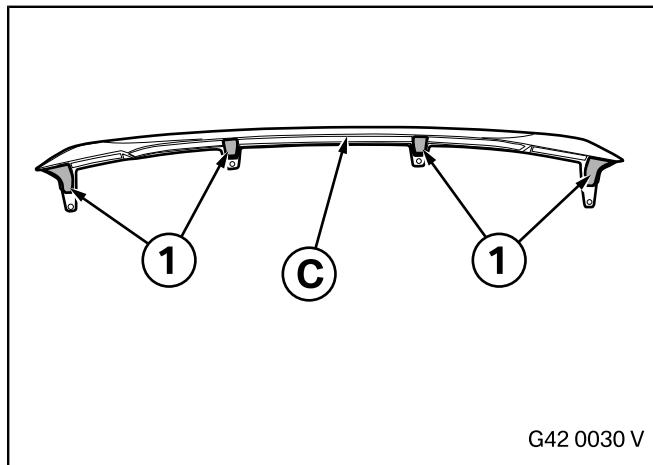
Mark the contour (2) (the internal edge) on the front apron using suitable tools.

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

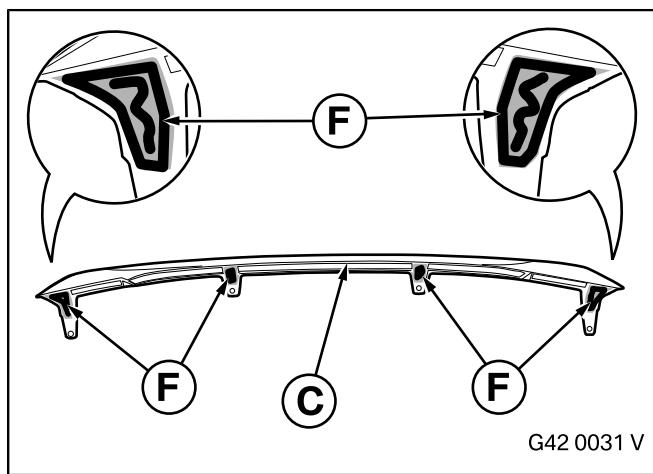


Apply the primer **H** to the surface within the contour (1) you marked earlier using suitable tools only where the surfaces contain adhesive tape, as shown.

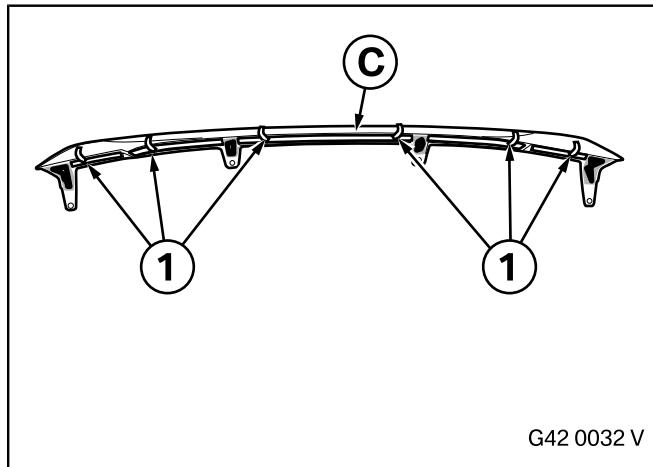
8. Carbon front attachment installation



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

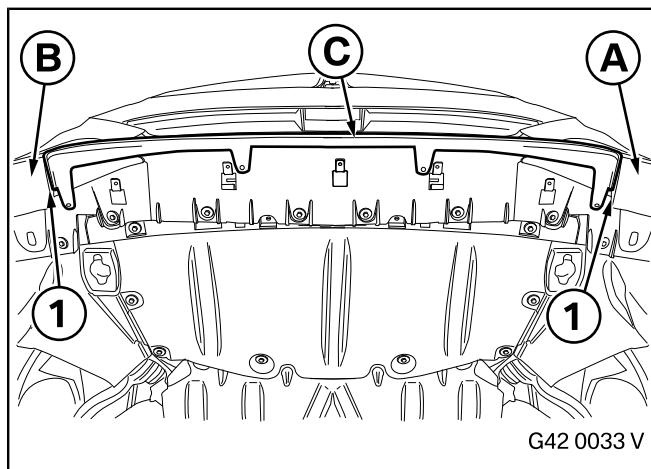


Apply liquid adhesive **F** to the abraded surfaces, on the two outer surfaces, also right up to the left and right edges.



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

8. Carbon front attachment installation



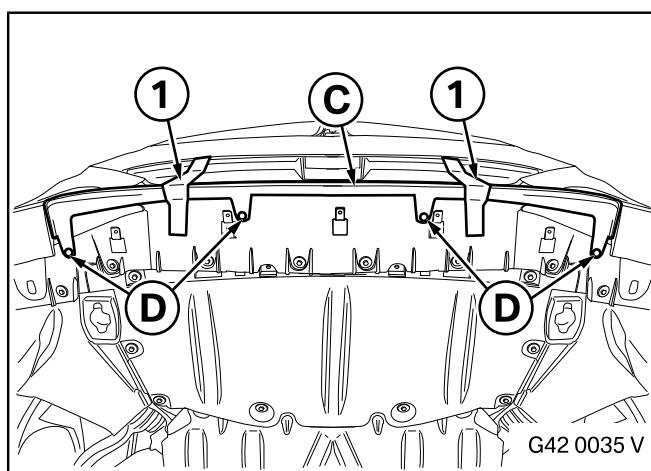
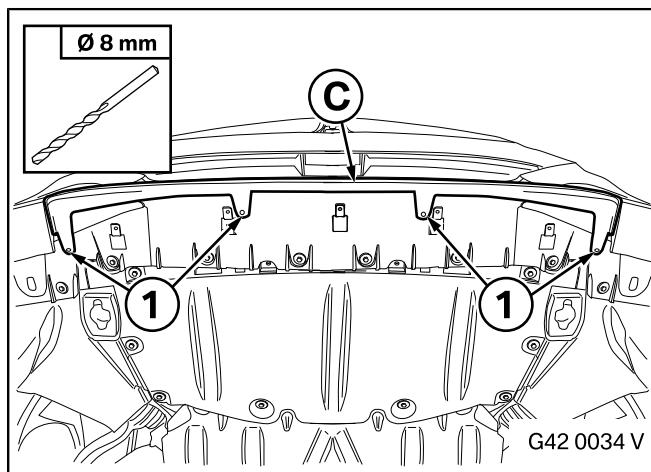
► Carefully insert the front attachment between the two side sections. Ensure that no liquid adhesive is left on the front apron. Positioning: Position the carbon centre front attachment **C** in the centre between the two side sections. Ensure it is flush with the front edge. The ends of the backing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



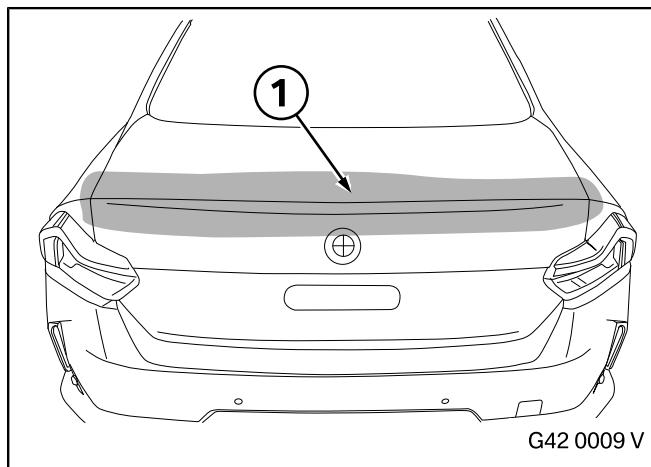
Push in the expanding rivets **D**. Secure the carbon centre front attachment **C** in the centre with adhesive tape (1).

► 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. ◀

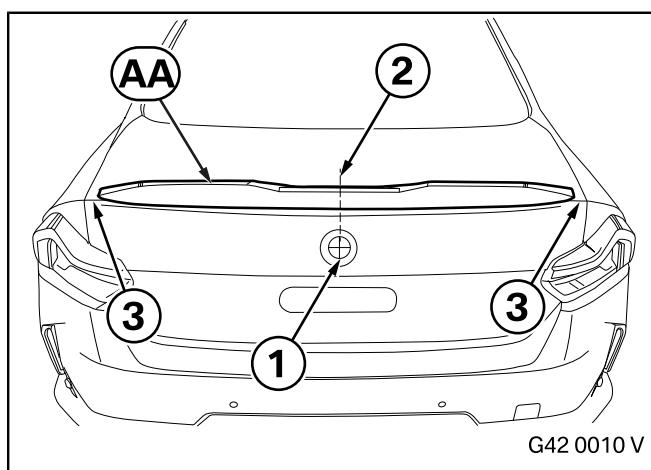
9. Installing the carbon rear spoiler

► 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.

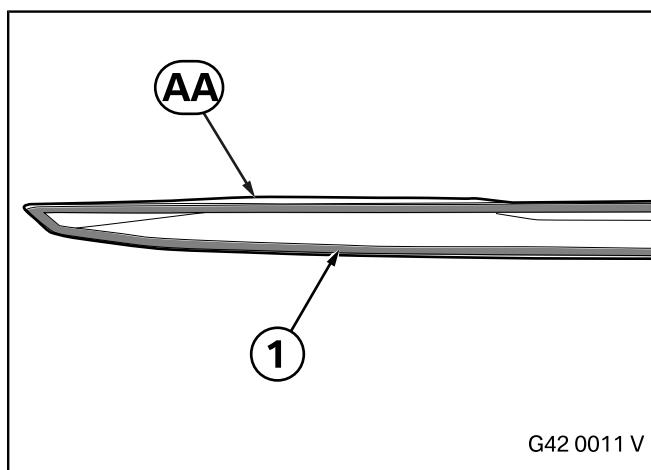
Measure the centre of the carbon rear spoiler **AA** and mark it using a water-soluble pen. Place the carbon rear spoiler **AA** on the edge of the boot lid and adjust it so that it is central using the centre of the boot lid (2) the centre mark you made earlier. Check that the spacing (3) is identical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

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

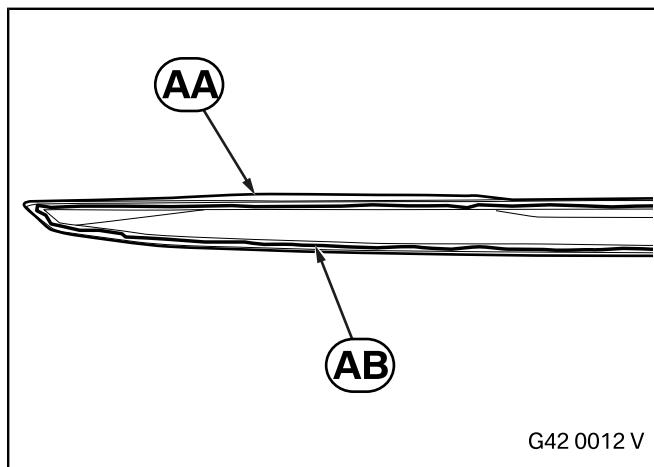
Remove the carbon rear spoiler **AA**.

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

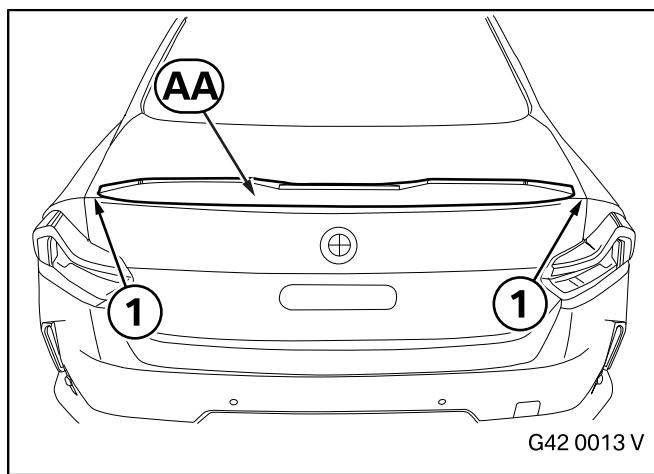
Then clean the surface (1) with cleaner **AC**.



9. Installing the carbon rear spoiler



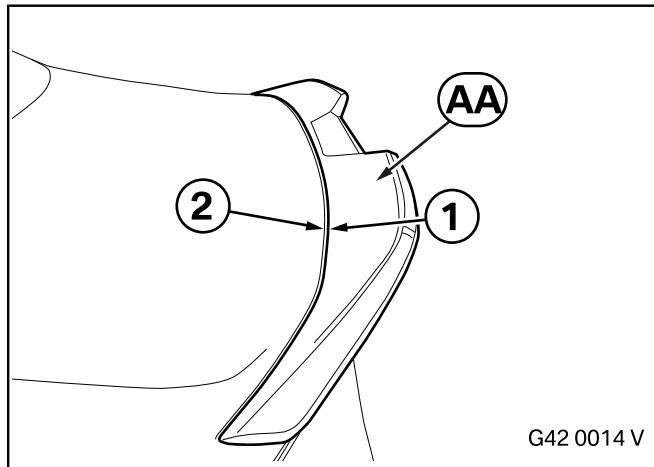
Apply a bead of liquid adhesive **AB** to the abraded surface of the carbon rear spoiler **AA**.



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

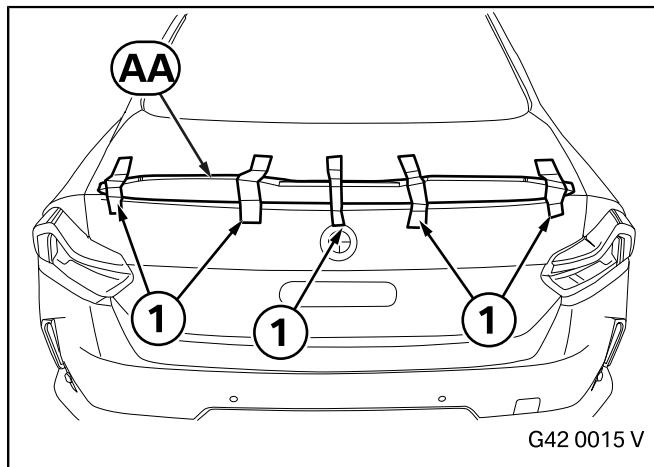
Recheck the position of the carbon rear spoiler **AA** at the left and right (1).

► 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.** ◀

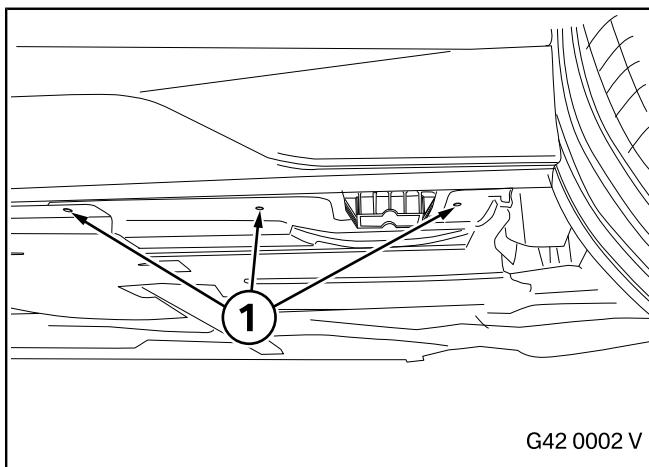


Secure the carbon rear spoiler **AA** in at least five places using suitable adhesive tapes (1).

► 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. ◀

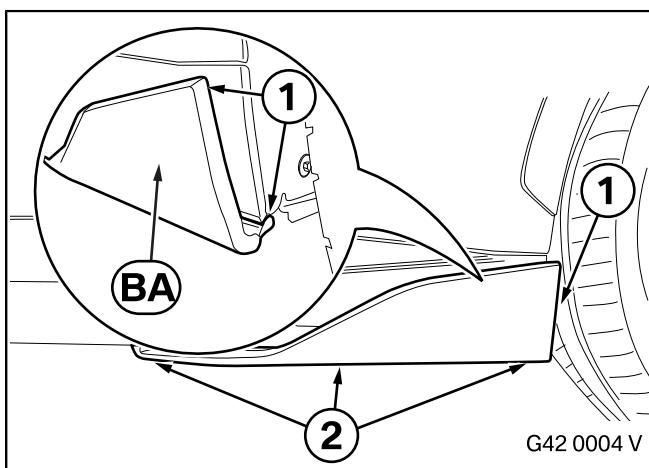
10. Installing the carbon side skirt attachment

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



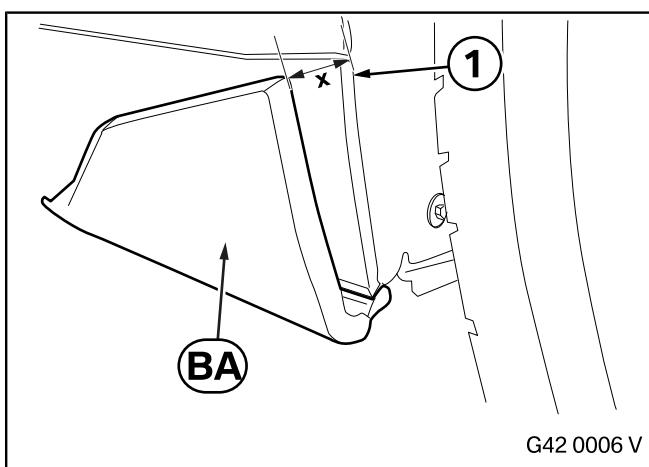
Remove the three fastening screws (1) and keep them safe. They will be reused later.

► Clean the installation position with suitable products. ◀



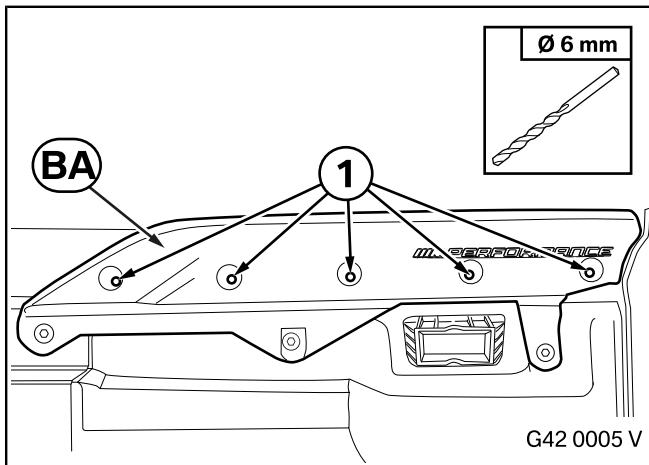
► When positioning the component, ensure that the end (1) of the carbon side skirt attachment **BA** is flush with the side skirt. ◀

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. ◀

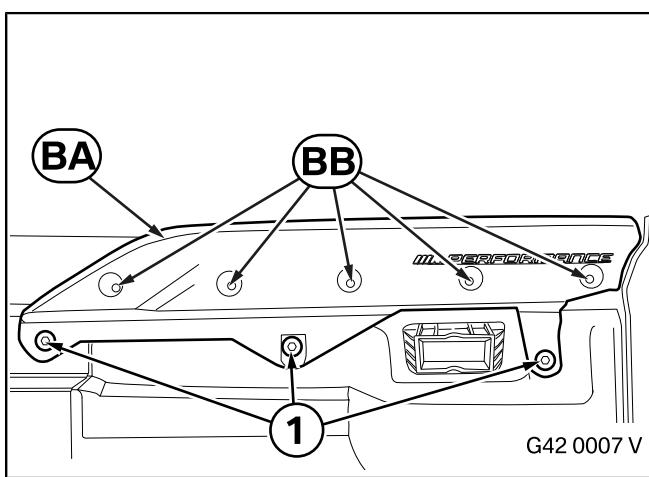
10. Installing the carbon side skirt attachment



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

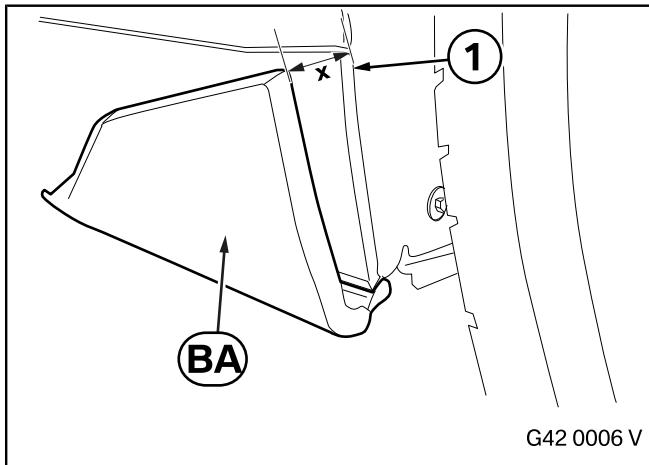
Use a **5 mm** drill stop so as not to damage the part below. ◀

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



Fully tighten the three existing fastening screws (1).

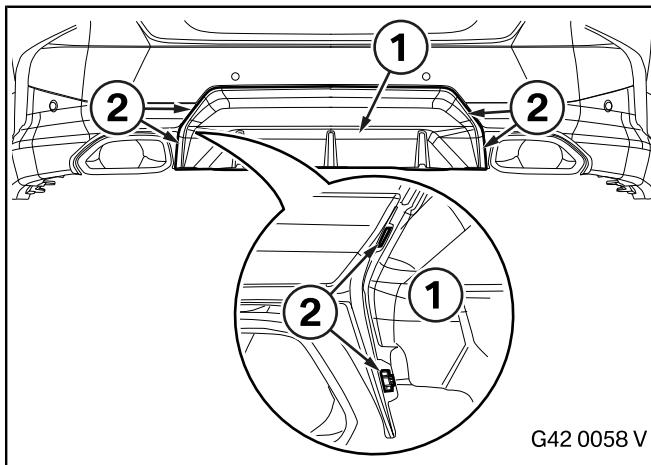
Push in the five expanding rivets BB.



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

11. Install the carbon rear diffuser

 **The carbon rear diffuser CA is only clipped into position. It may only be installed on MSP/MPA derivatives.** ◀



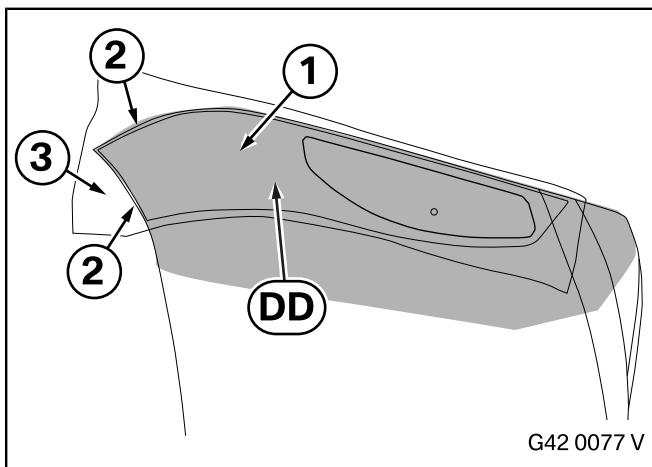
To ensure that the standard diffuser (1) can be removed, the parts of the bumper to the left and right, between the exhaust pipe and standard diffuser (1), must be unclipped. (The magnified view is shown from the rear.)

The standard diffuser (1) can then be unclipped.

 When installing the carbon rear diffuser **CA**, ensure that the lower row of clips (near the ground) is pushed in before the remaining clips engage.

The carbon rear diffuser **CA** must be installed following the procedure to remove the standard diffuser in reverse. ◀

12. Carbon throughflow rear spoiler installation



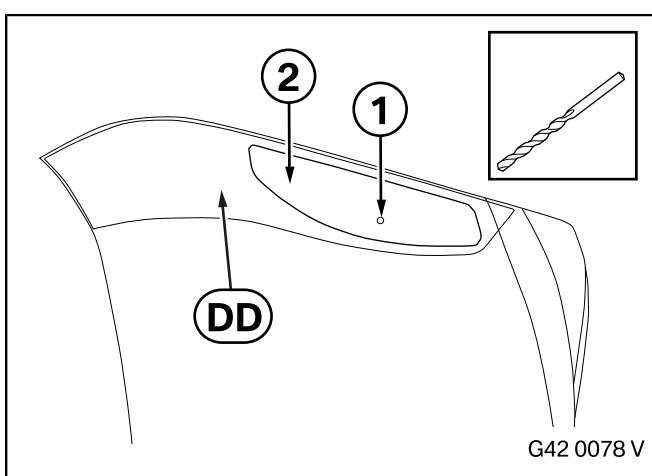
► The left and right bonding surfaces (1) must be completely clean, dry and free from wax or grease.

Store the carbon throughflow rear spoiler **DA** at room temperature before installation. ◀

Clean the bonding surfaces (1) on the left and right edge of the tailgate with cleaner **DI**.

Place the right outer template **DD** and left outer template **DE** on the refractory edge (2) of the tailgate and press on.

Remove the backing film (3).



► Vacuum the swarf produced during the drilling process using a vacuum cleaner. ◀

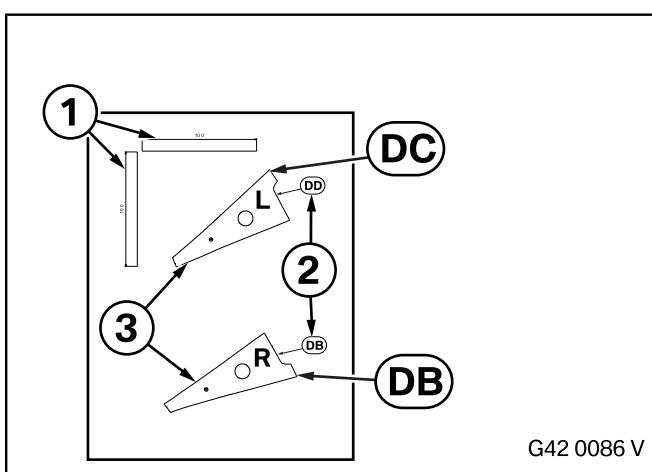
Centre-punch hole positions (1).

Pre-drill the holes (1) with a **3 mm diameter** drill bit.

Then enlarge the holes (1) to a **diameter of 8 mm**.

Remove the interior part (2) from the right outer template **DD** and the left outer template **DE**. Deburr the holes (1), clean with cleaner **DI** and treat the edges with conventional anti-corrosive agents.

► Observe the drying time. ◀



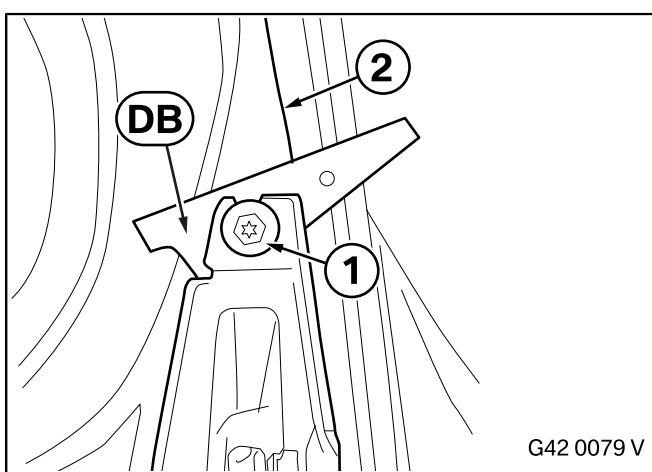
► If templates **DB** and **DC** are not enclosed in the package, please use the templates at the end of these installation instructions. ◀

Print templates **DB** and **DC** **without scaling** from these installation instructions.

Check the scale (1) of the printout.

The templates are labelled (2). There is one template for the left side of the car (**DC**) and one template for the right side of the car (**DB**).

Cut out both templates (3).

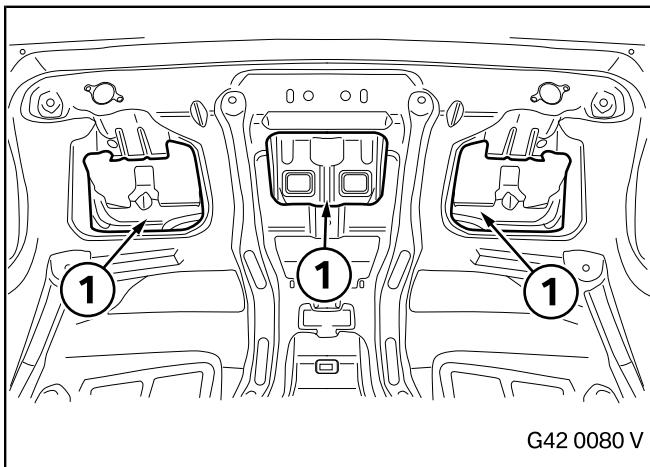


► Open the tailgate. ◀

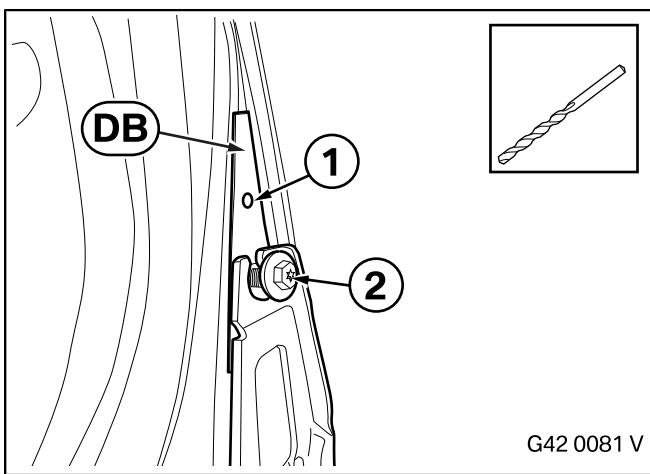
Loosen the screws (1) and unscrew them.

In order to correctly position the right inner template **DB** and the left inner template **DC**, insert the screws (1) into the perforated hole and align each of the templates with the refractory edge (2).

12. Carbon throughflow rear spoiler installation



► Vacuum the swarf produced during the drilling process using a vacuum cleaner. Use the openings (1) for this purpose. All the swarf must be vacuumed up. Work thoroughly. Any swarf that is not vacuumed out may cause noise during driving. ◀



Centre-punch hole positions (1) and pre-drill them with a **3 mm diameter** drill bit.

Then enlarge the holes (1) to a **diameter of 8 mm**.

Remove the right inner template **DB** and the left inner template **DC**. Deburr the holes (1) and treat them with conventional anti-corrosive agents.

Tighten the screws (2) with a torque of **28 Nm**.

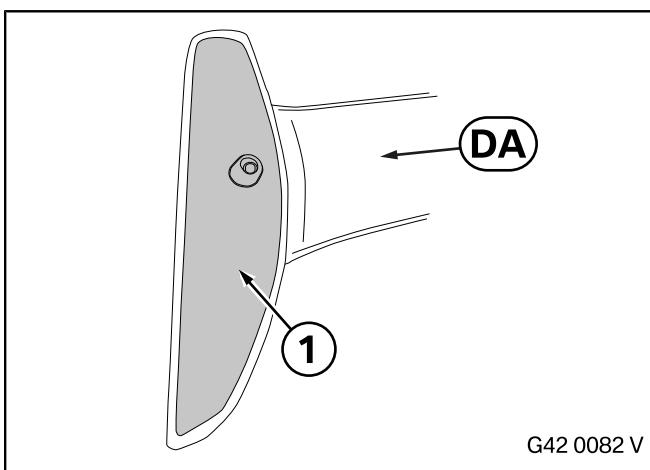
Remove the sawdust from the interior of the tailgate.

Spray cavity sealing (wax spray) into the side interior of the tailgate in order to fix in place any potentially remaining swarf.

► Completely remove any sticker residue before cleaning. ◀

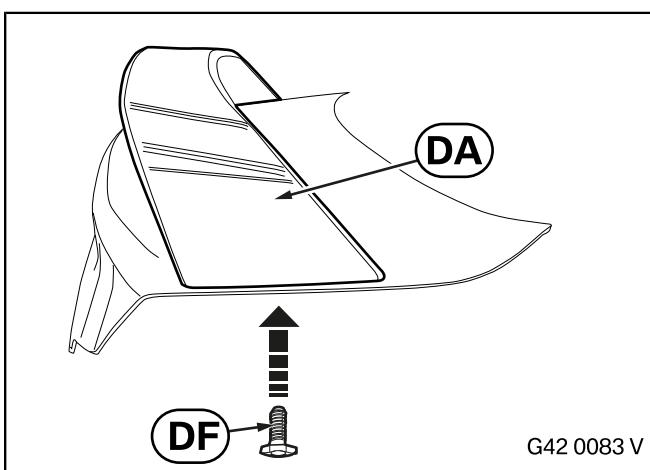
Abrade the underside of the two leg supports of the carbon throughflow rear spoiler **DA** in the areas (1) and clean with cleaner **DI**.

► Wait until the drying time has elapsed. ◀

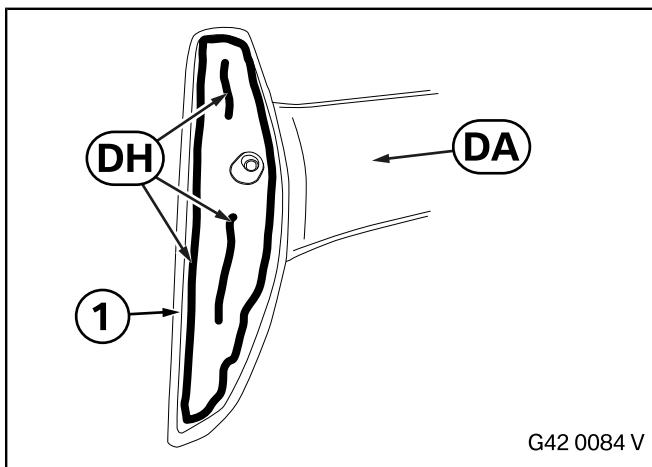


► To check that the carbon throughflow rear spoiler **DA** is fitted correctly, put in place the carbon throughflow rear spoiler **DA** with two people, insert the screws **DF**, tighten them slightly and adjust the drill holes if necessary.

Unscrew the carbon throughflow rear spoiler **DA** again and remove it from the tailgate. ◀

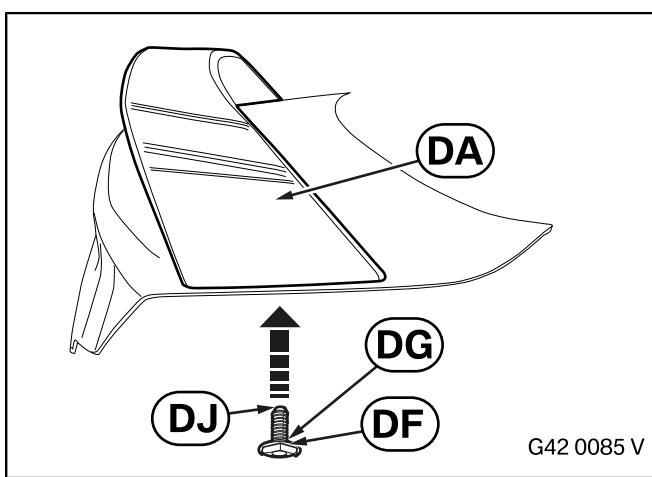


12. Carbon throughflow rear spoiler installation



Along the edge (1) of the leg support **DA**, apply a bead of liquid adhesive **DH**. Apply two lines of liquid adhesive **DH** as shown.

► A continuous adhesive bead prevents water ingress later on. ◀



► Two people must place the carbon throughflow rear spoiler **DA** in position.

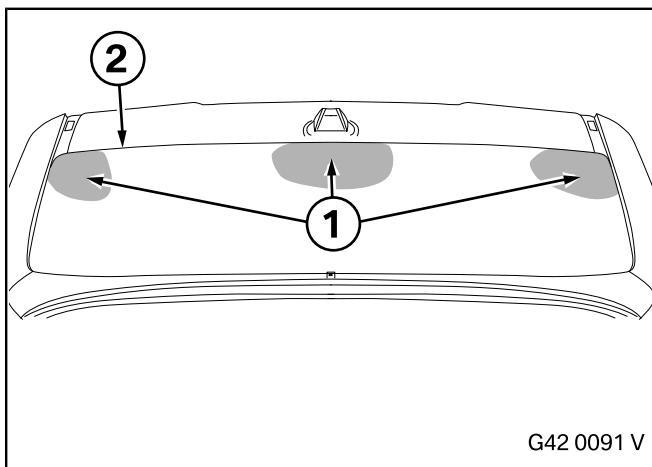
Wet the threads of the screws **DF** with liquid screw lock **DJ**. ◀

Place the carbon throughflow rear spoiler **DA** onto the two holes from above. Insert the screws **DF** and washers **DG** from below and tighten them to using a torque of **3 Nm**.

► Remove any excess liquid adhesive **DH** immediately using suitable tools.

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

13. Black high gloss roof edge spoiler installation

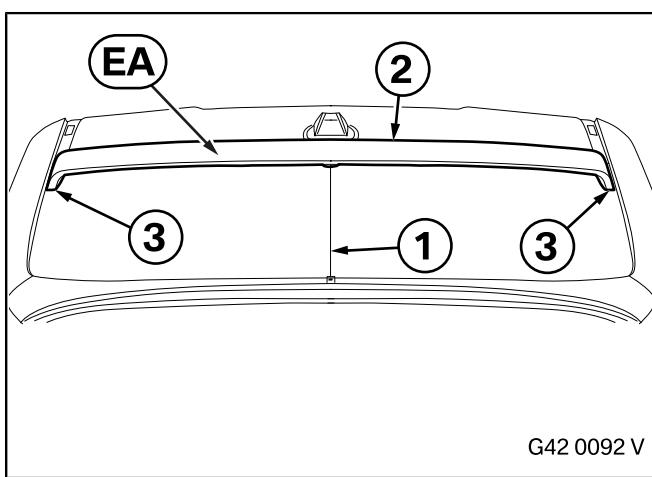


► The bonding surfaces (1) must be completely clean, dry and free from wax or grease.

The bonding surfaces (1) extend up to the top edge (2) of the window glass.

Wait until the cleaner **EC** is completely dry. ◀

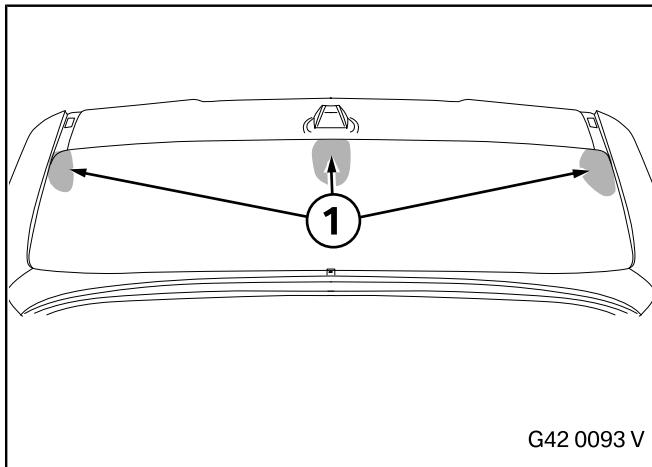
Clean the bonding surfaces (1) with cleaner **EC**.



► Carry out this work step with a second person. ◀

Place the black, high-gloss roof edge spoiler **EA** on the glass pane, centre it on the wire (1) of the rear window heating and place it flush with the upper edge (2) of the glass pane.

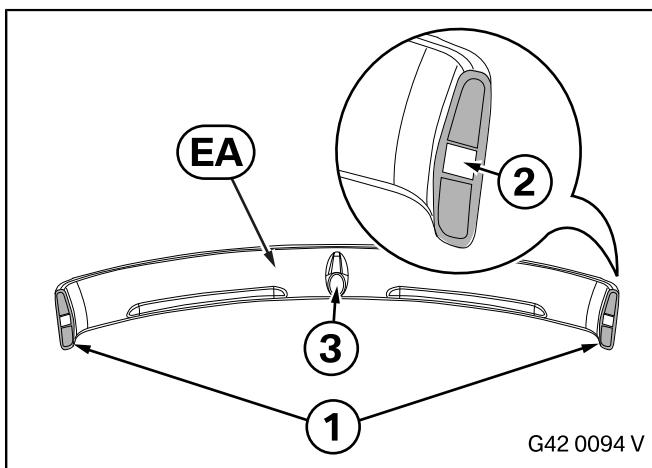
Trace the outline (3) of the support feet on the window glass using suitable equipment (for example a water-soluble pen).



► The bonding surfaces (1) must be completely clean, dry and free from wax or grease.

Wait until the cleaner **EC** is completely dry. ◀

Clean the bonding surfaces (1) again with cleaner **EC**.



► The bonding surfaces (1), (2) and (3) must be completely clean, dry and free from wax or grease. ◀

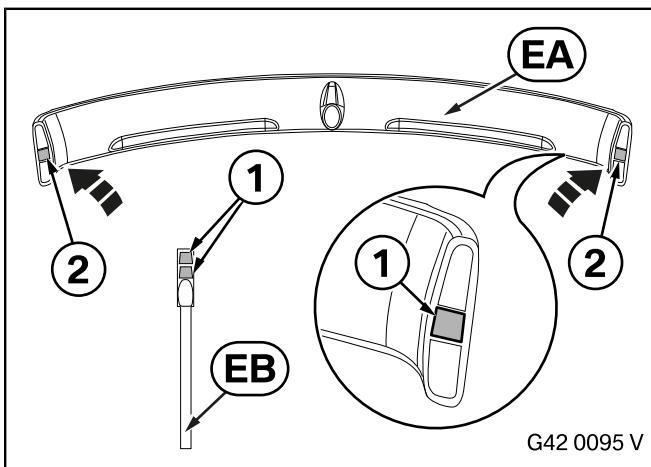
Abrade the surfaces (1) on the underside of the black, high gloss roof edge spoiler **EA** using suitable equipment.

Do **not** abrade bonding surfaces (2) and (3).

Then clean the bonding surfaces (1), (2) and (3) with cleaner **EC**.

► Wait until the cleaner **EC** is completely dry. ◀

13. Black high gloss roof edge spoiler installation

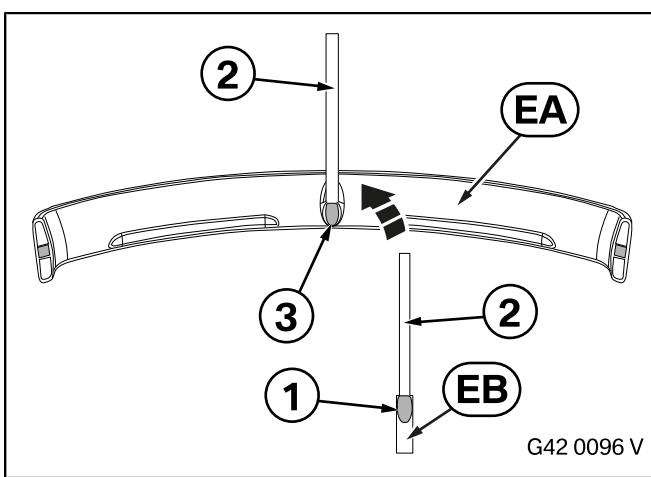


► The adhesive pads (1) are cut in a trapezoidal shape and fit precisely into the recess (2) in the black high gloss roof edge spoiler EA.

Avoid soiling the bonding surface of the adhesive pad (1). ◀

Remove the two trapezoidal adhesive pads (1) from the backing foil with adhesive pads EB and affix them precisely into each of the recesses (2) of the black, high gloss roof edge spoiler EA, pressing them into position.

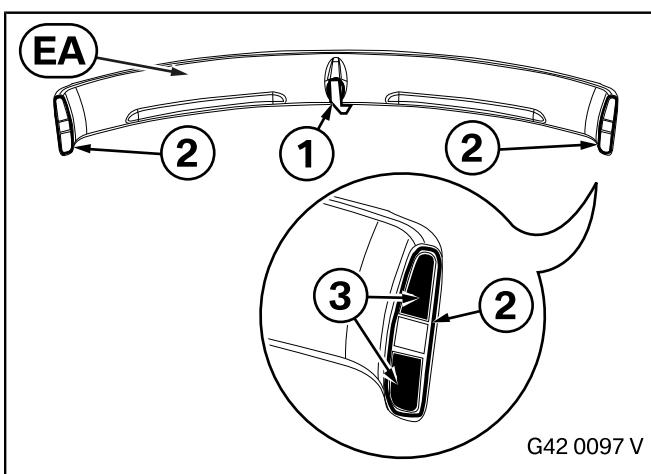
Remove the backing foil from the two adhesive pads in full.



► The adhesive pad (1) is cut precisely to fit the recess (3) in the black high gloss roof edge spoiler EA.

Avoid soiling the bonding surface of the adhesive pad (1). ◀

Remove the adhesive pad (1) with the pull-off strip (2) together from the adhesive pad EB and affix it onto the centre recess (3) of the black high gloss roof edge spoiler EA so that the pull-off strip (2) points upwards as shown.

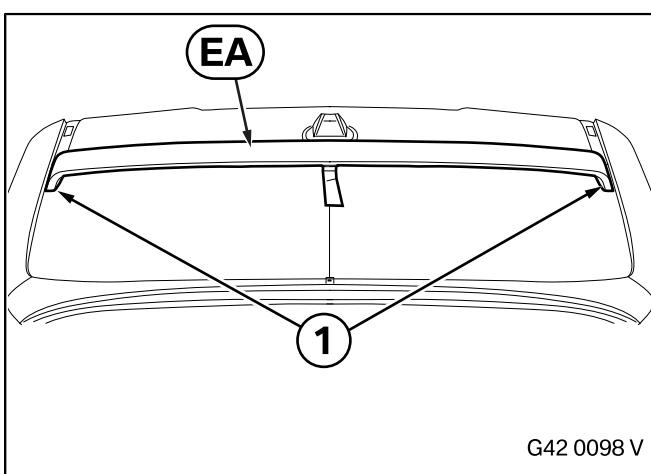


► Do **not** remove the pull-off strip (1) in the centre. ◀

Wrap the pull-off strip (1) in the centre around the black high gloss roof edge spoiler EA.

Apply the liquid adhesive ED in a line (2) around the full contour of the support foot. Spread a suitable amount of liquid adhesive ED in the areas (3) over the full surface using suitable equipment (for example a spatula).

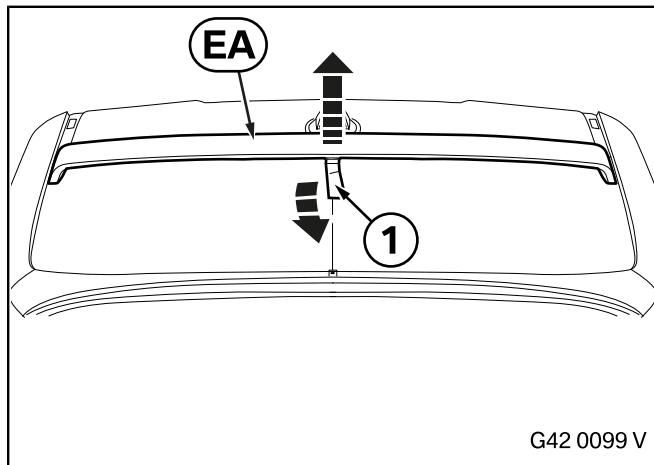
► Ensure that you do not exceed the pot time of the liquid adhesive ED. ◀



► Carry out this work step with a second person. ◀

Place the black, high-gloss roof edge spoiler EA on the centre of the glass pane, position it using the markings (1), and do not yet press it tight in the centre.

13. Black high gloss roof edge spoiler installation



► Carry out this work step with a second person. ◀

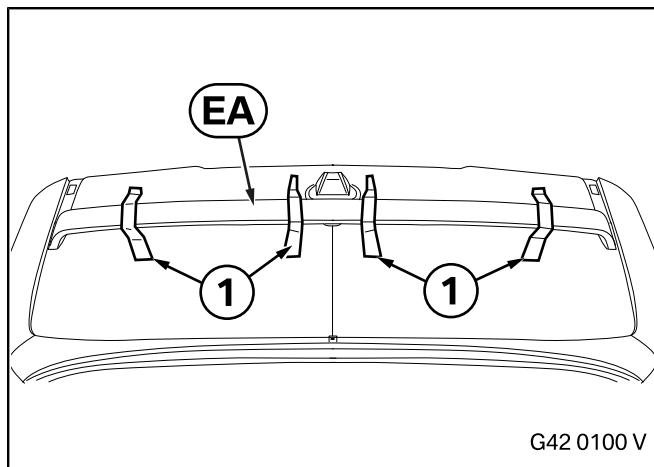
Raise the black high gloss roof edge spoiler **EA** in the centre a little without raising the two outer adhesion points, pull the pull-off strip (1) under the black high gloss roof edge spoiler **EA**, removing the backing foil from the adhesive pad. Now press the black high gloss roof edge spoiler **EA** into position in the centre and on the outer feet.

► Press the component into place over the entire bonding area. Minimum pressure $\geq 15 \text{ N/cm}^2$. A forceful press of your thumb will reach around 35 N/cm^2 . If necessary, use equipment (for example something to stand on) to achieve a higher pressure. ◀

Fix in place the black high-gloss roof edge spoiler **EA** using suitable adhesive tape (1).

► Remove any excess liquid adhesive immediately using suitable tools.

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



14. Concluding work and coding

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 right/left front attachment retrofit kit **A**, **B** and carbon front attachment **C**: Select MI 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

