

Original BMW Parts and Accessories. Installation Instructions.



M Performance Exterior Components Retrofit Kit.

BMW X3 (G45)

BMW X3 long version (G48)

Retrofit kit number

Number	Component designation	Installation time (h)	Installation as described in ISTA/AIR (h)**
51 11 5A8F9F3	Black high-gloss front attachment, left	0.25*	-
51 11 5A8F9F4	Black high-gloss front attachment, right	0.25*	-
51 11 5A8F9F5	Black high-gloss front attachment, centre	0.25*	-
51 13 5B47E05	Black high-gloss front ornamental grille, left	-	0.25
51 13 5B47E06	Black high-gloss front ornamental grille, right	-	
51 16 7883949	Exterior mirror cover, CFRP	-	
51 16 7883950	Exterior mirror cover, CFRP	-	
51 16 7883951	Exterior mirror cover, CFRP	-	
51 16 7883952	Exterior mirror cover, CFRP	-	
51 16 8083557	M exterior mirror cover, CFRP	-	
51 16 8083558	M exterior mirror cover, CFRP	-	
51 16 8083559	M exterior mirror cover, CFRP	-	
51 16 8083560	M exterior mirror cover, CFRP	-	
51 47 5A6CBC3	Carbon sill trim	-	
65 20 5A59AB9	Aramid antenna cover	-	
82 14 5B3E1E0	Side panel foil wrap	-	
51 12 5B4D659	Black high-gloss rear diffuser, centre	0.25	
51 12 5B4D662	Aramid rear diffuser	0.25	
51 62 5B4D6D2	Roof edge spoiler	0.75	
51 12 5B8AF54	MPA rear finisher	0.25	
51 12 5B8AF41	MSP rear finisher	0.25	

* Excluding the time required for the shape cutting of the absorber – plus 0.50 hours for the shape cutting of the absorber (excluding the time required for disassembly in accordance with ISTA/AIR)

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

Installation time

Installation time, see table. This may vary depending on the condition of the vehicle, the equipment in it and the type of retrofit.

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

If you experience installation or functional problems, restrict troubleshooting to approx. 0.5 hours for mechanical work and 1.0 hour 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/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 primer/adhesive to dry fully. 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 cars; proceed in the same way on RHD cars.
- To prevent damage to the component surfaces during transport and installation, protective films have been applied to the surfaces of the front attachment parts. Only remove these protective films after the installation if possible.

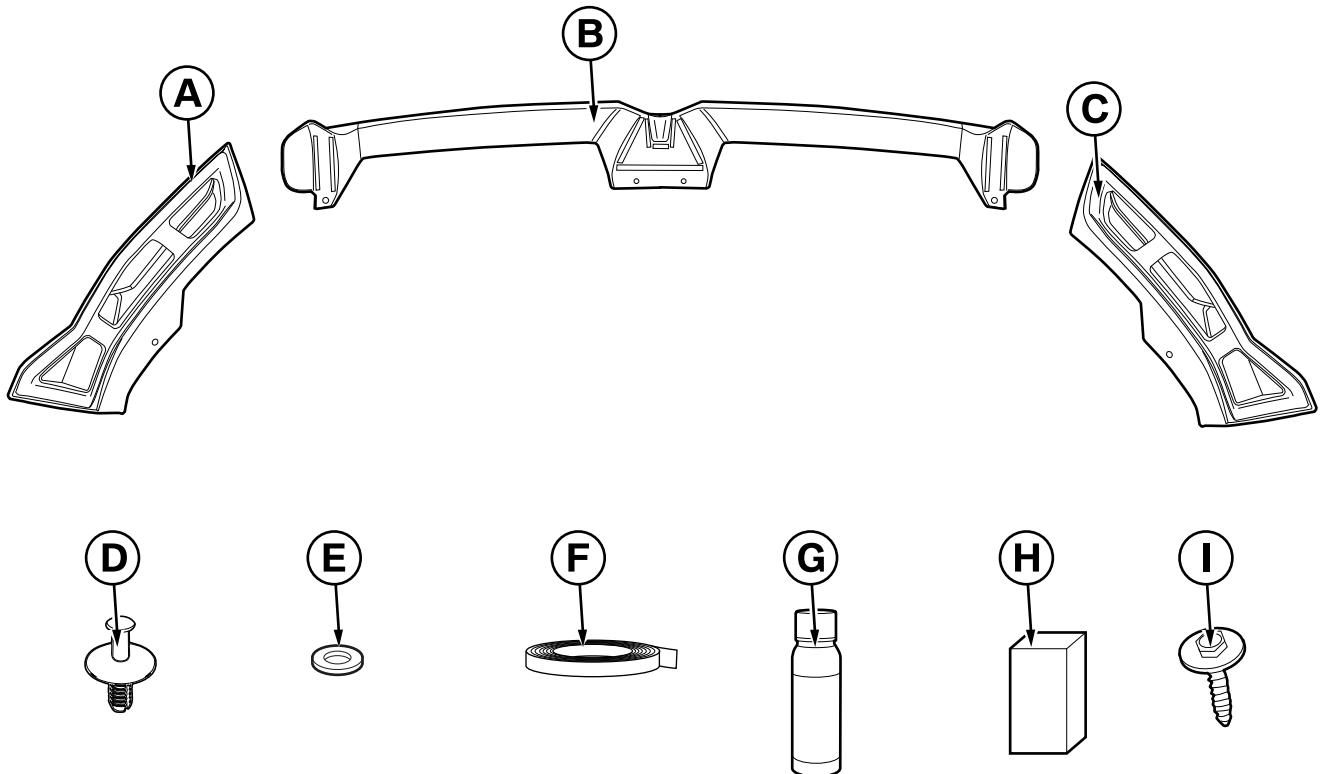
Special tools required

- None

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1. Front attachment parts list

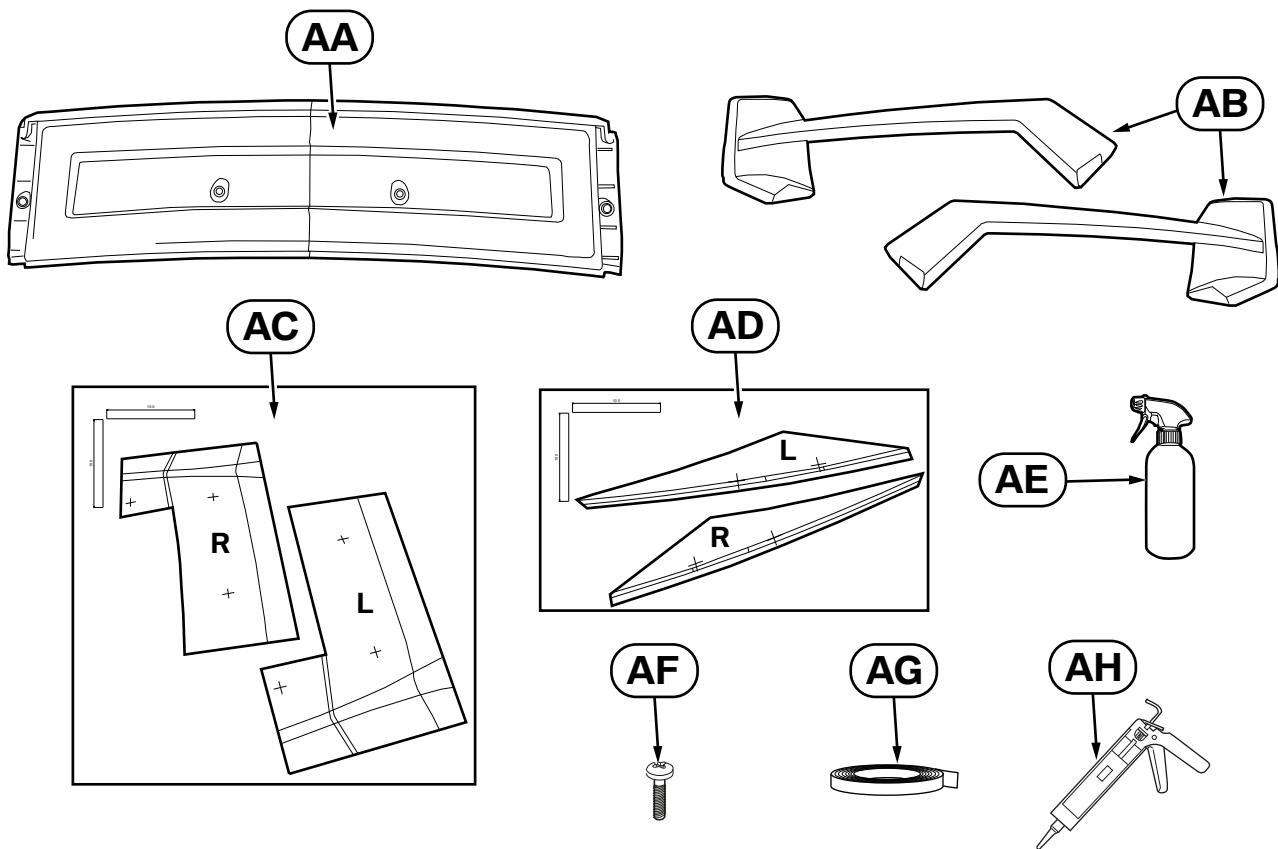


G45 0000 V

Legend

- A** Black high-gloss front attachment, left
- B** Black high-gloss front attachment, centre
- C** Black high-gloss front attachment, right
- D** Expanding rivet (4 x, part no. 8174185, not included in parts kit, see EPC for details)
- E** Shim (2 x)
- F** Adhesive tape roll (not included in parts kit, see EPC for details and part number)
- G** Cleaner (not included in parts kit, see EPC for details and part number)
- H** Liquid adhesive (not included in parts kit, see EPC for details and part number)
- I** Screw (2 x, not included in parts kit, see EPC for details and part number)

2. Parts list for rear spoiler

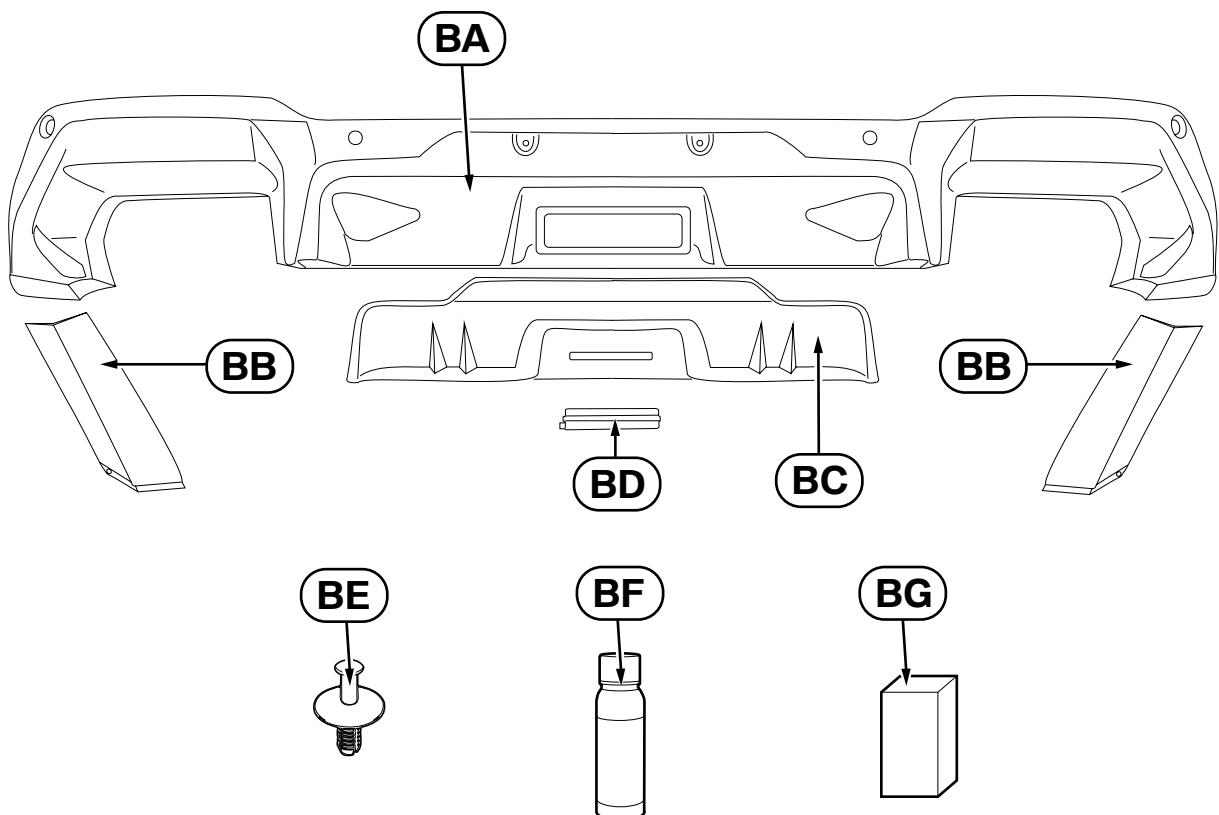


G45 0035 V

Legend

- AA** Roof edge spoiler, centre
- AB** Roof edge spoiler, right/left
- AC** Left/right inner rear spoiler template
(in the appendix of these installation instructions, **print without scaling**)
- AD** Left/right outer rear spoiler template
(in the appendix of these installation instructions, **print without scaling**)
- AE** Cleaner (see EPC for details and part number)
- AF** Screw (**10 x**)
- AG** Double-sided adhesive tape (not included in parts kit, see EPC for details and part number)
- AH** Applicator for beads of adhesive (not included in parts kit, see EPC for details and part number)

3. Rear finisher and diffuser parts list



G45 0023 E

Legend

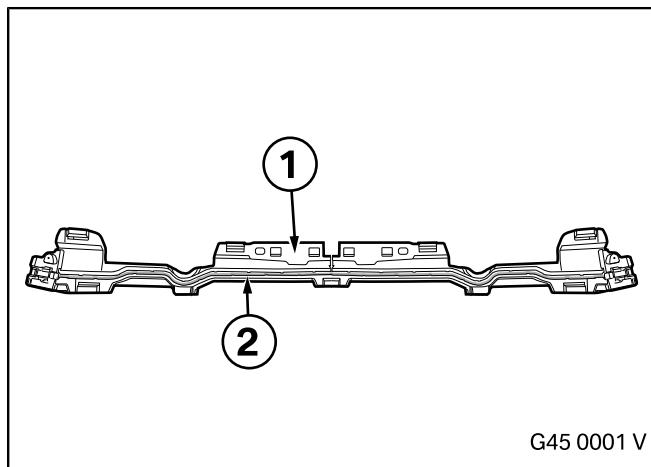
- BA** Rear finisher
- BB** Rear finisher side sections
- BC** Aramid or black high-gloss diffuser
- BD** Centre light (not included in parts kit, see EPC for details and part number)
- BE** Expanding rivet (4 x, not included in parts kit, see EPC for details)
- BF** Cleaner (not included in parts kit, see EPC for details and part number)
- BG** Liquid adhesive (not included in parts kit, see EPC for details and part number)

4. Preparations

	ISTA/AIR No.
The following components must be removed first of all	
For the front attachment (only relevant for cars with SA8TF – active pedestrian protection)	---
<ul style="list-style-type: none">Remove the shock absorber and cut it as described in Section Shape cutting of the shock absorber <p>Relevant for MPA cars: If only the front attachment is installed on the car but not the MPP black high-gloss roof edge spoiler (part no. 51 62 5B4D6D2), the standard air guide (part no. 51 11 5A53590) must be removed</p>	
For installing the roof edge spoiler only	- 51 71 407
For installing the rear diffuser only	---
<ul style="list-style-type: none">Standard roof edge spoiler	
<ul style="list-style-type: none">Removal of the bumper panel	

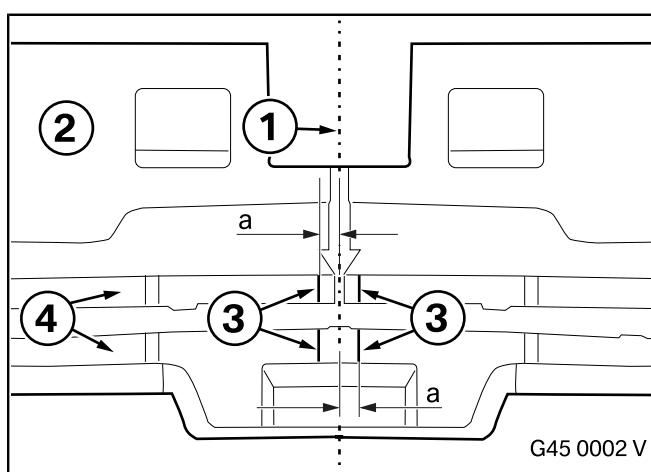
5. Shape cutting of the shock absorber

 This section is only relevant if the car is equipped with SA8TF (active pedestrian protection). 

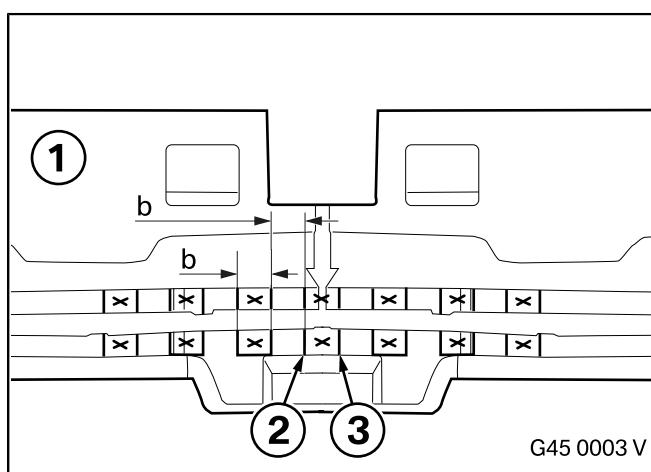


 Remove the shock absorber (1) as described in ISTA/AIR.

Remove the pressure sensor hose (2) from the shock absorber (1) as described in ISTA/AIR. 



Starting from the centre (1) of the shock absorber (2), measure dimension **a = 7.5 mm** to the left and also to the right and draw a mark (3) on both webs (4).

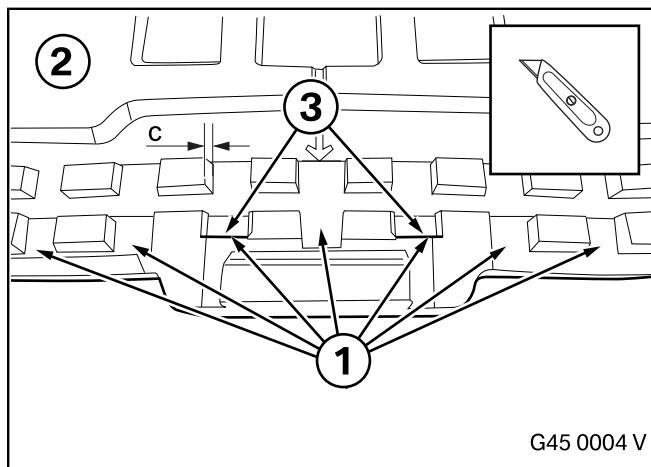


On both webs of the shock absorber (1) and with a distance of **b = 15 mm** each, draw six marks to the left starting from the left centre mark (2) and six marks to the right starting from the right centre mark (3).

Starting from the centre, mark the surface with an X. Then mark every second surface on the left and on the right with an X on both webs.

Finally, the centre must be marked as shown.

5. Shape cutting of the shock absorber

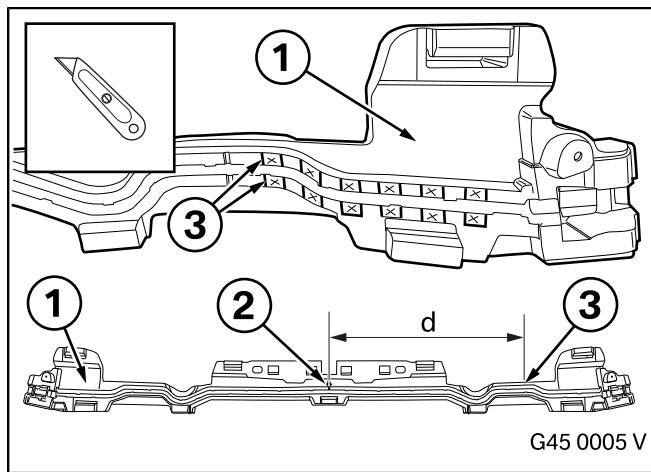


G45 0004 V

► Use a sharp knife (e.g. a Stanley knife). We recommend using a new blade. ◀

Using a suitable sharp knife, cut out the surfaces (1) with the marks on both webs of the shock absorber (2). Cutting depth **c** should be equal to the height of both webs.

For the surfaces (3), do not completely cut the web but remain in line with the other surfaces.



G45 0005 V

► Use a flexible ruler for measuring. ◀

Starting from the centre (2) of the shock absorber (1) and using a flexible ruler, measure the distance **d = 550 mm** and draw a line (3) on both webs.

On both webs of the shock absorber (1), draw eleven marks towards the outer side, each with a distance of **b = 15 mm**.

Mark the outer field with an X and then continue to mark every second field with an X. Finally, both webs must be marked as shown.

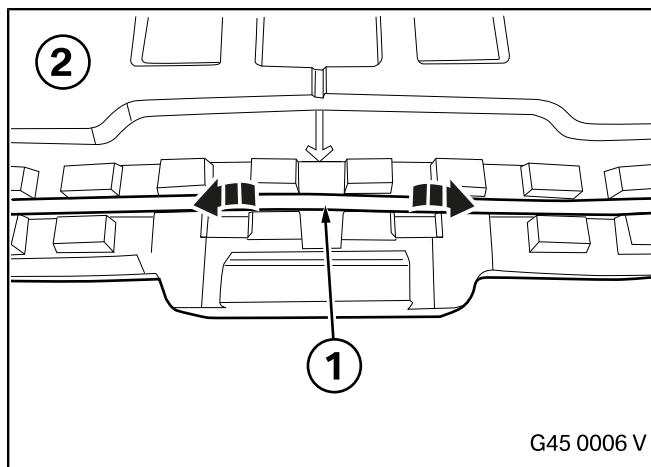
Using a suitable sharp knife, cut out the surfaces marked with X on both webs of the shock absorber (1). The cutting depth should be equal to the height of both webs.

Repeat these steps accordingly on the opposite side of the shock absorber (1).

► Check for any scraps and remove them if applicable. ◀

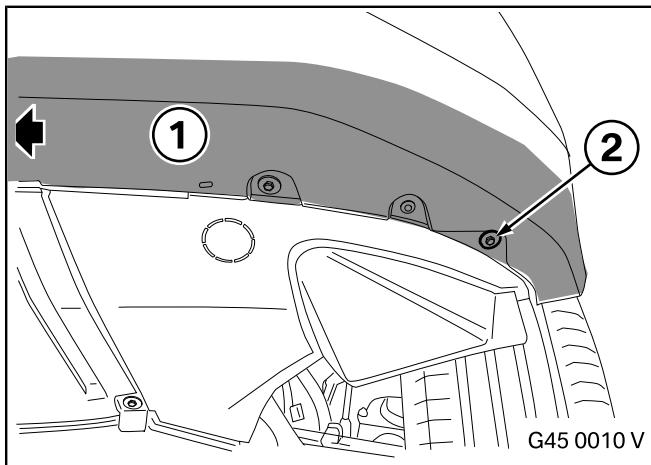
Install the pressure sensor hose (1) on the shock absorber (2), starting from the centre of the shock absorber (2) towards the left and right without any tension or pressure as described in **ISTA/AIR**.

Install the shock absorber (2) on the car as described in **ISTA/AIR**.



G45 0006 V

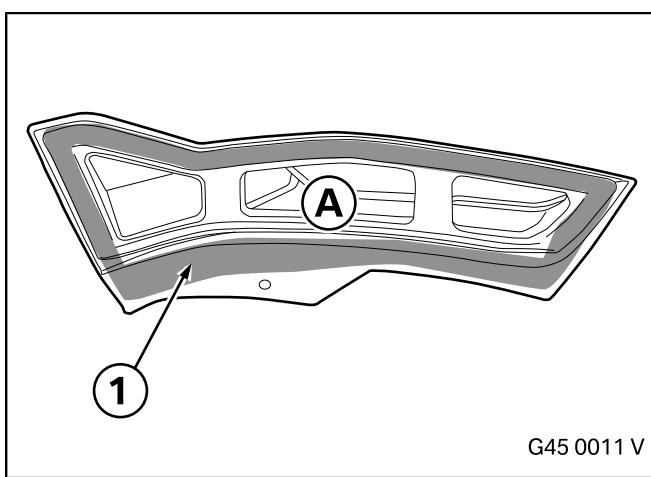
6. Installing the front attachment



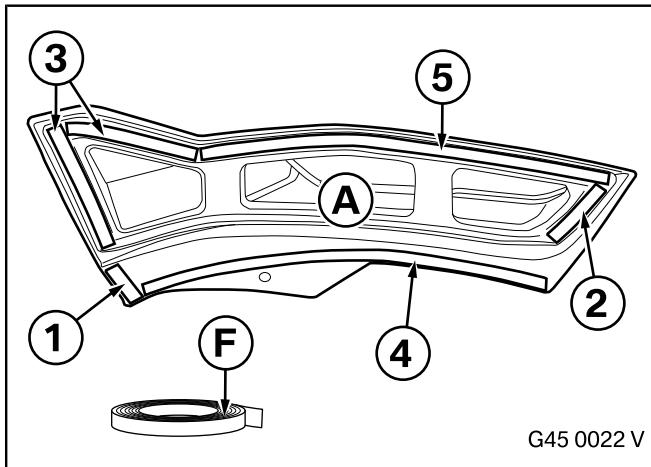
► The bonding surfaces must be completely dry, clean, and free of wax or grease. ◀

Clean the bonding surface (1) on the car with cleaner **G**. Completely clean the surface all the way to the opposite side of the car.

Remove the screw (2), it will not be reused.



Clean the surfaces (1) on the rear side of left front attachment **A** using cleaner **G** as shown.



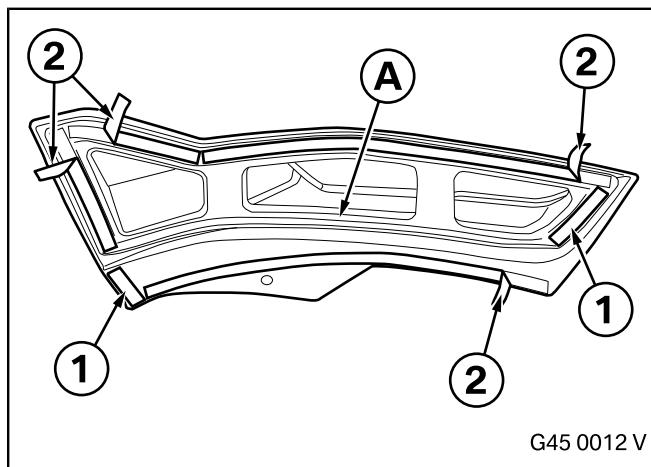
Cut adhesive tape **F** as specified in the table below:

Press the adhesive tapes firmly into place in the specified positions on left front attachment **A**.

► Press the adhesive tapes into position 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. ◀

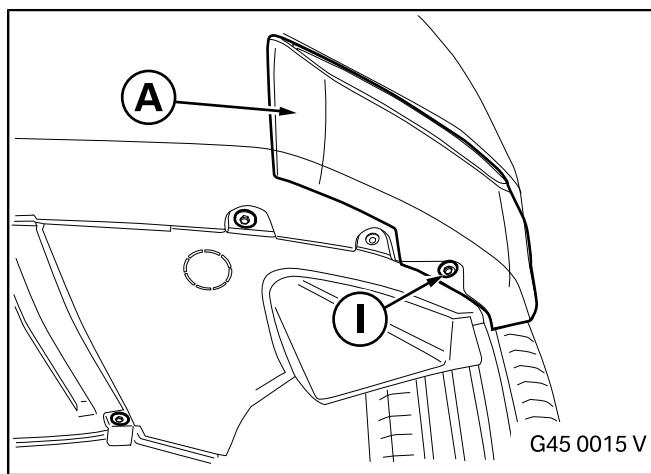
Position	Length in mm
(1)	40
(2)	60
2 x (3)	100
(4)	320
(5)	360

6. Installing the front attachment

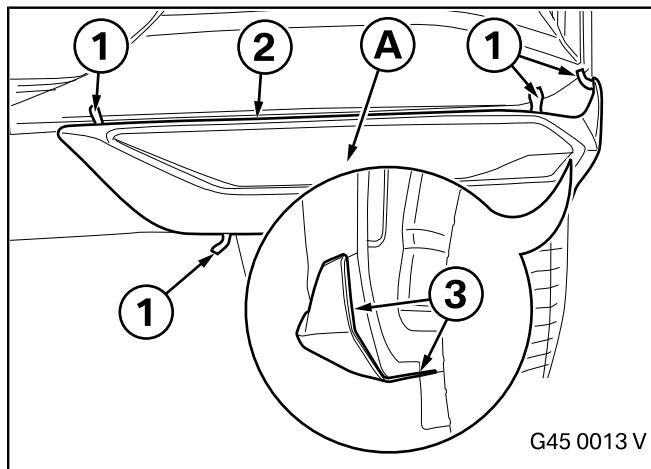


Completely remove the protective film from the short adhesive strips (1).

For the long adhesive tapes, bend the ends of the backing films (2) to the outside.



Insert screw I into left front attachment A. On the rear side, place washer E between the front attachment and the bumper trim.



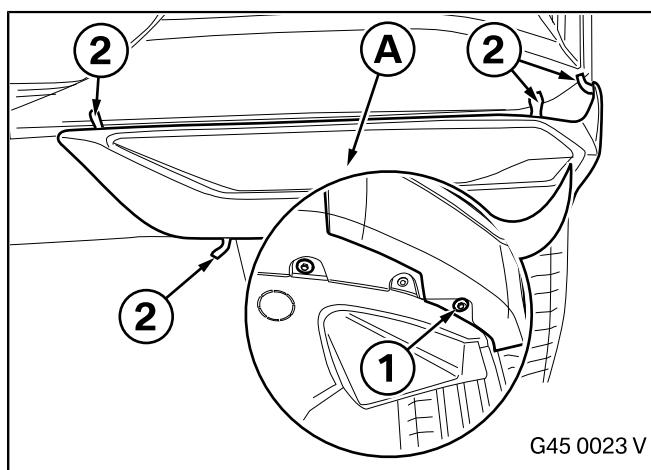
► The backing films (1) of the adhesive tapes must be visible. ◀

Press left front attachment A against the car from the front.

Lightly tighten the screw with the washer.

Ensure that the edge (2) is flush with the component edge.

Ensure that the edge (3) is flush with the component edge.



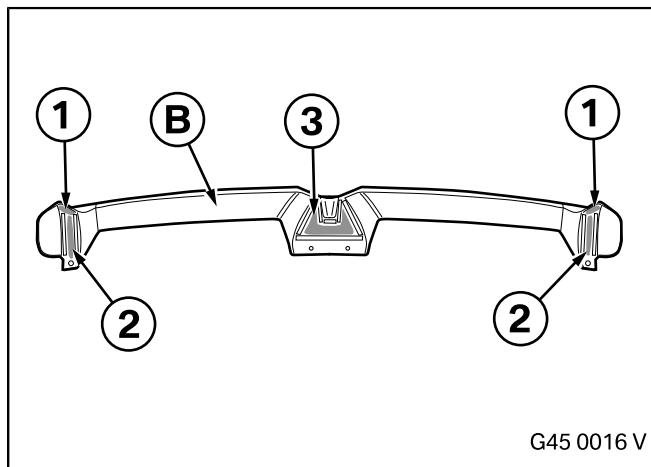
Tighten the screw (1).

Pull the backing films (2) out to the side and press left front attachment A firmly into position.

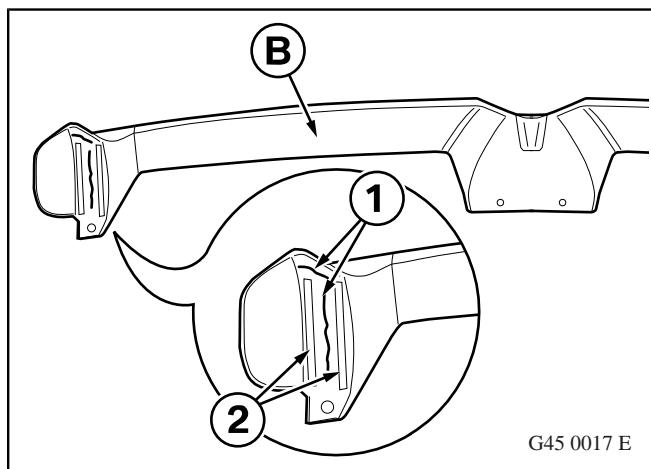
► Press the adhesive tapes into position using a contact pressure of between 10 N/cm² and 50 N/cm². (A forceful press of your thumb will reach around 35 N/cm².) It is not how long you apply this pressure, but the force with which it is applied that counts. Press the component into place over the entire bonding area. Removing the adhesive tape after pressing the component into place will destroy the bond. ◀

6. Installing the front attachment

Repeat the steps accordingly for right front attachment **C**.

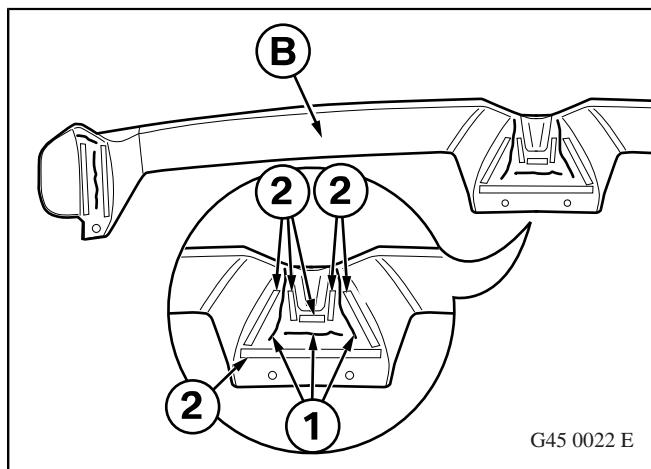


Abrade the surfaces (1), (2) and (3) of centre front attachment **B** using suitable tools and then clean them with cleaner **G**.



► For greater clarity, centre front attachment **B** is only partially shown. ◀

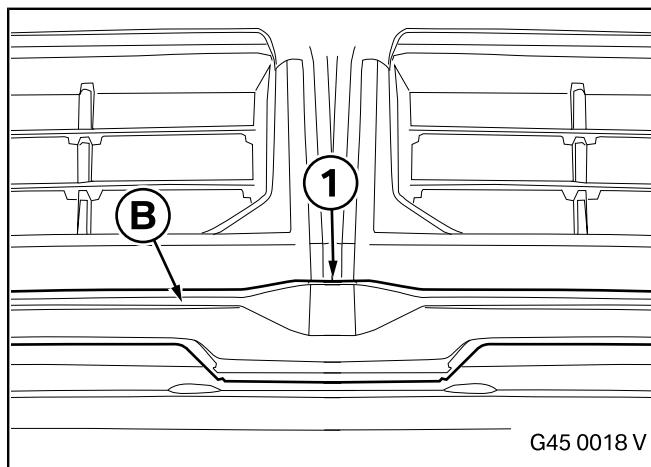
Apply a thin bead of liquid adhesive **H** to each surface (1) that you cleaned earlier.



Apply liquid adhesive **H** in the centre of the surface all the way to the tips.

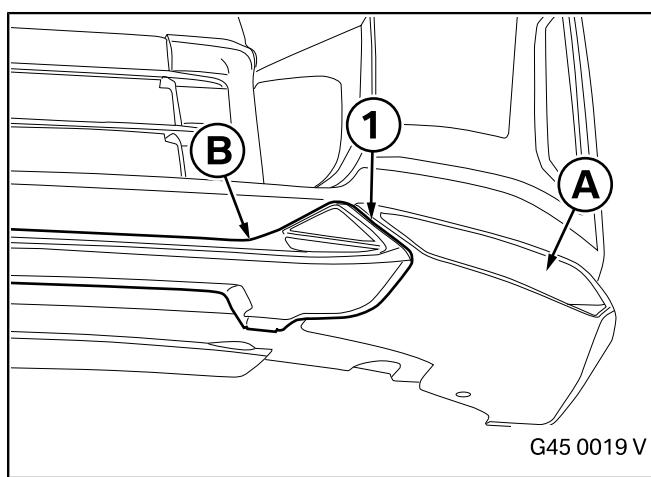
Completely remove the backing films (2) of adhesive tapes **F**.

6. Installing the front attachment



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

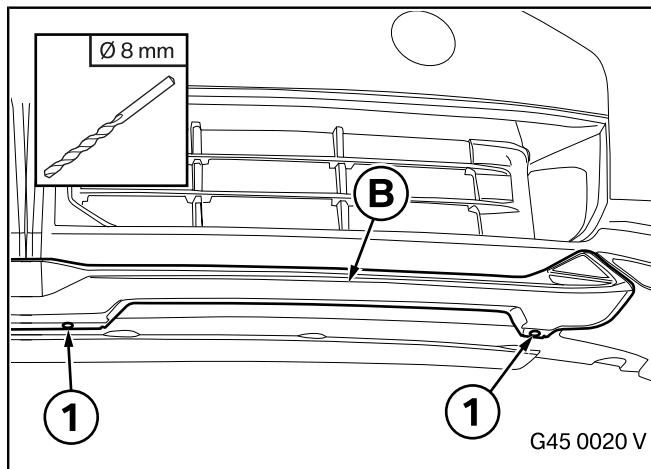
Place centre front attachment **B** in the centre (1) of the car and align it.



► Ensure exact alignment with the bumper edge and that the side sections are at the same height, so that there is no offset between left front attachment **A** and centre front attachment **B**. ◀

Check the gap (1) between left front attachment **A**, right front attachment **C** and centre front attachment **B** on both sides and adjust it if required.

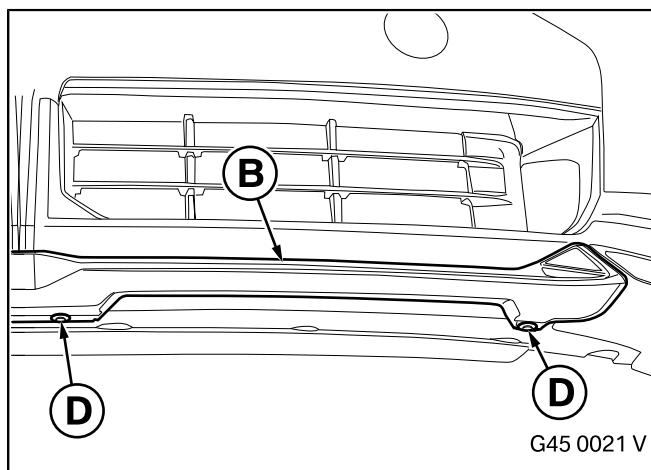
Then press centre front attachment **B** firmly against the car. In particular, press firmly against the left, right and centre sections.



► Note the drilling depth and the package space behind. ◀

► For greater clarity, only one side of the installation is shown. ◀

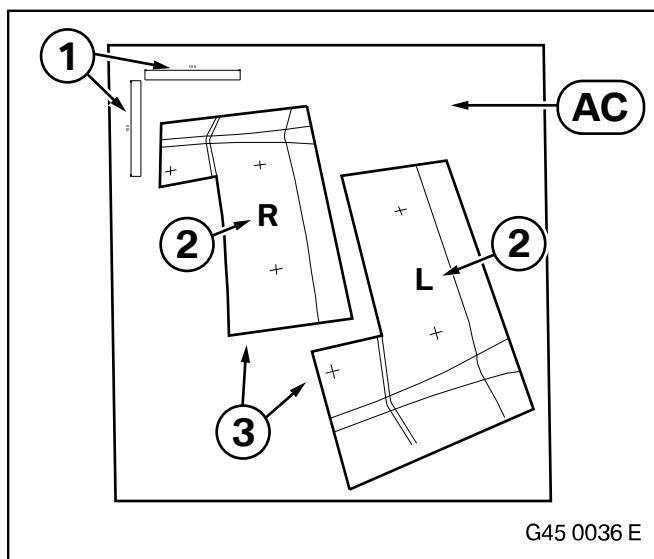
Drill an **8 mm** hole into the front apron through each of the four holes (1) in centre front attachment **B**.



Press the four expanding rivets **D** into centre front attachment **B**.

► Refer to the installation instructions on **page 2**. ◀

7. Installing the roof edge spoiler

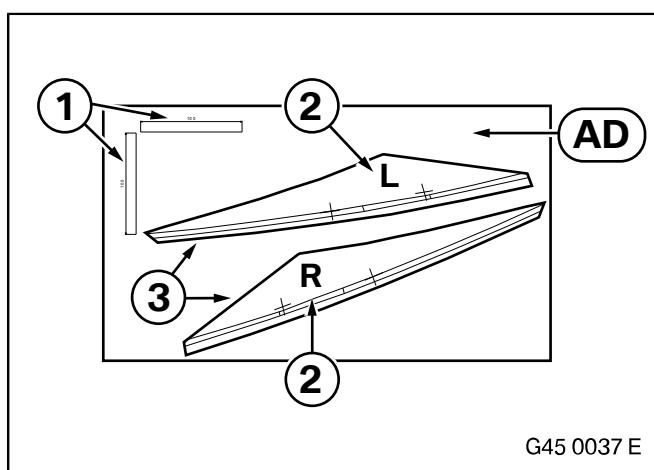


► **Print inner** rear spoiler template **AC** **without scaling** from these installation instructions.

Check the scale (1) of the printout.

The templates are labelled (2). There is one template for the left side of the vehicle (L) and one template for the right side of the vehicle (R).

Cut out both templates (3). ◀

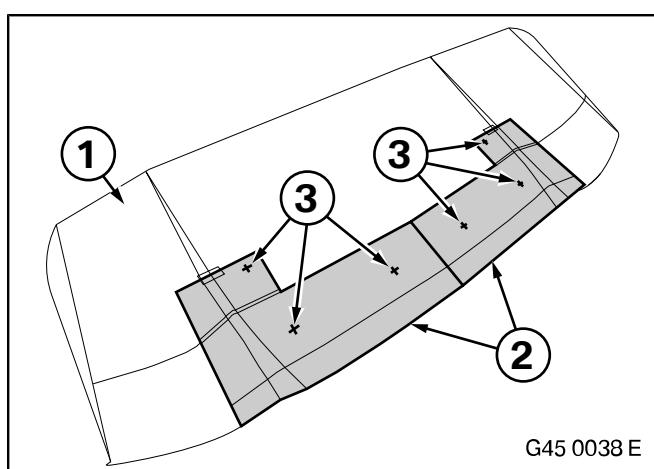


► **Print outer** rear spoiler template **AD** **without scaling** from these installation instructions.

Check the scale (1) of the printout.

The templates are labelled (2). There is one template for the left side of the vehicle (L) and one template for the right side of the vehicle (R).

Cut out both templates (3). ◀



Use the contour (2) of the roof edge spoiler (1) to align the right and left templates **AC**.

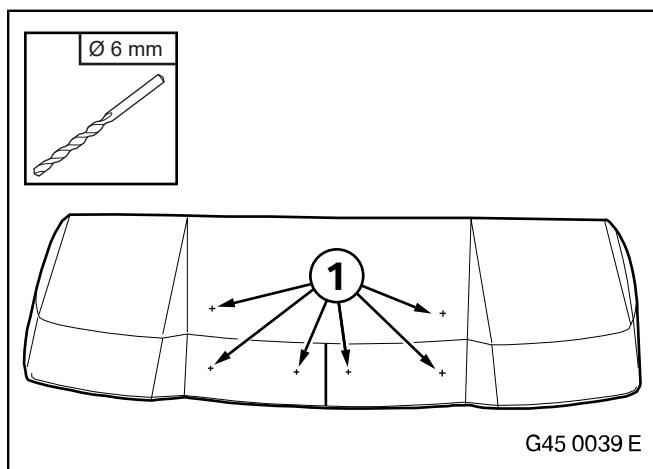
► Do not overlap the templates but place them edge to edge. ◀

► Place the templates at the refractory edges (2). ◀

Secure templates **AC** with adhesive tape.

Using suitable equipment, transfer the drill holes (3) to the surface of the roof edge spoiler (1) and remove templates **AC**.

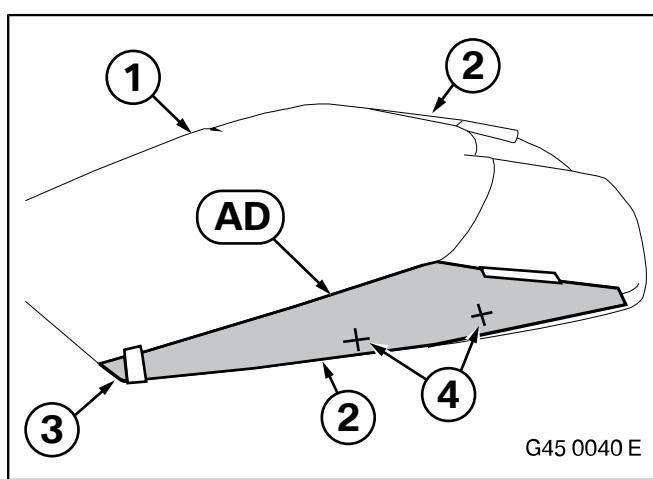
7. Installing the roof edge spoiler



When drilling, ensure the correct drilling angle.

The drilling angle must be 90°. ◀

Pre-drill the six marks (1) with a **3.0 mm drill bit**. Then enlarge the holes using a **6.0 mm** drill bit and deburr them.



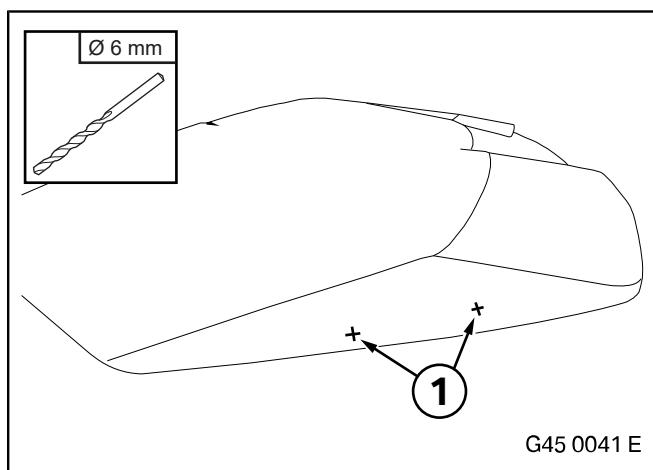
The two templates **AD** are for the two outer surfaces (2) on the outside of the roof edge spoiler (1). The corner (3) of template **AD** must be flush with the corner of the lug.

Place the templates at the refractory edges. ◀

Use the contour (2) of the roof edge spoiler (1) to align template **AD**.

Secure templates **AD** with adhesive tape.

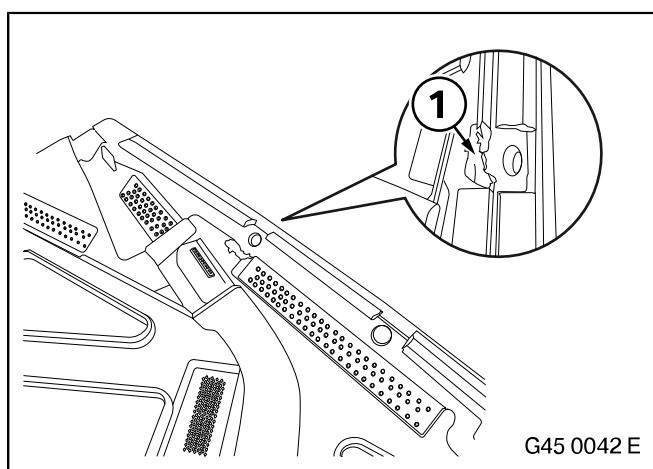
Using suitable equipment, transfer the drill holes (4) to the surface of the roof edge spoiler and remove templates **AD**.



When drilling, ensure the correct drilling angle.

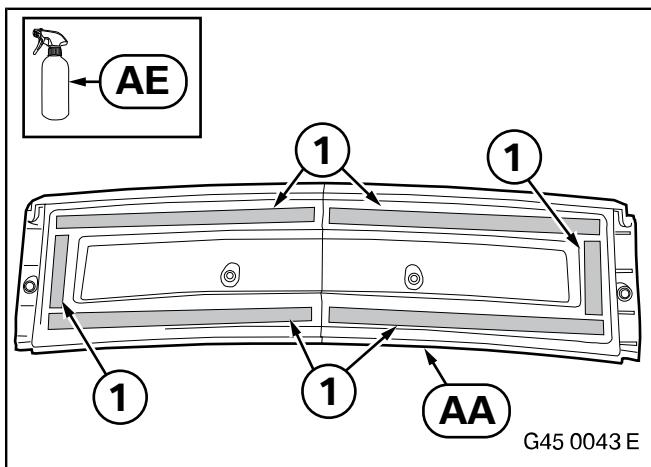
The drilling angle must be 90°. ◀

Pre-drill the two holes on the right and left (1) on both sides of the roof edge spoiler using a **3.0 mm** drill bit. Then enlarge the holes using a **6.0 mm** drill bit and deburr them.



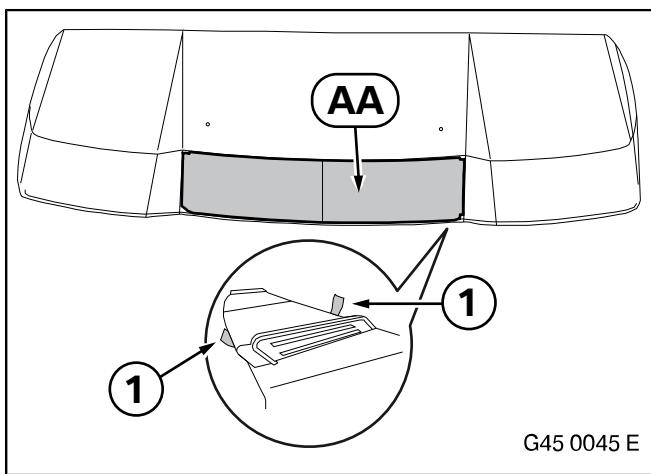
At the edges (1) on the underside of the roof edge spoiler, create an even surface for screws (to ensure optimal contact of the screw head) using a suitable tool.

7. Installing the roof edge spoiler



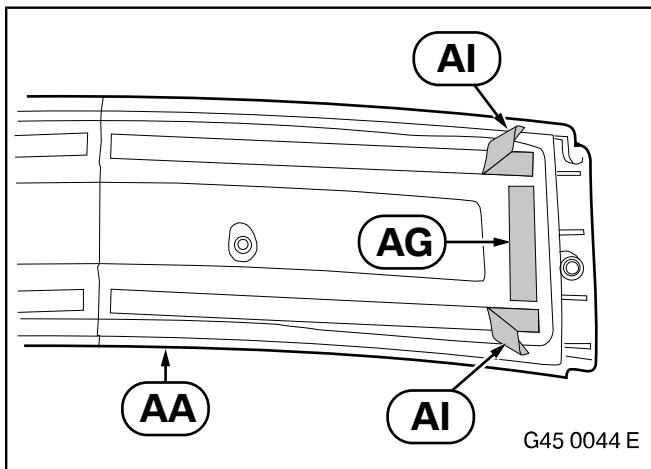
► The bonding surfaces must be completely dry, clean, and free of wax or grease. ◀

Clean the surface (1) on the underside of roof edge spoiler **AA** on both sides with cleaner **AE**.



Position roof edge spoiler **AA** on the standard roof edge spoiler and ensure that the holes are positioned correctly.

Abrade and clean the left and right bonding surfaces (1).



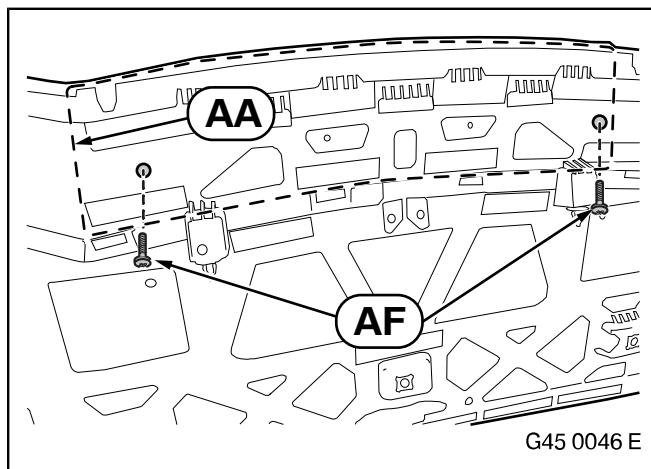
Affix double-sided adhesive tape **AG**.

► Press the adhesive tapes into position 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. ◀

Completely remove the backing film of adhesive tape **AG** on roof edge spoiler **AA** on both sides. Partly pull off the end of backing film **AI** and bend it outwards so that it can easily be gripped later during the installation work.

► It must be possible to grip the end of backing film **AI** after the component has been positioned. ◀

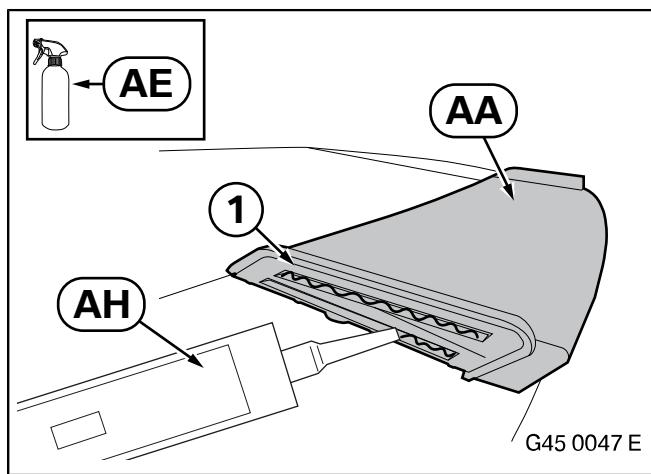
7. Installing the roof edge spoiler



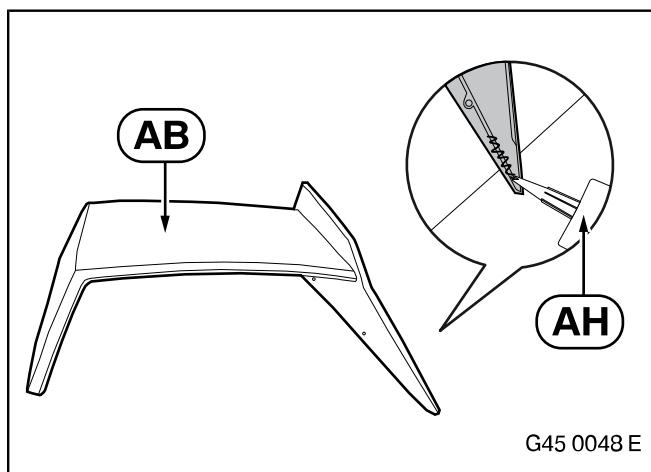
Position roof edge spoiler **AA** from the underside with all screws **AF**.

► Do not yet tighten the screws. ◀

Pull out the backing films **AI** of adhesive tapes **AG**. Press the centre section firmly into place and tighten screws **AF**.

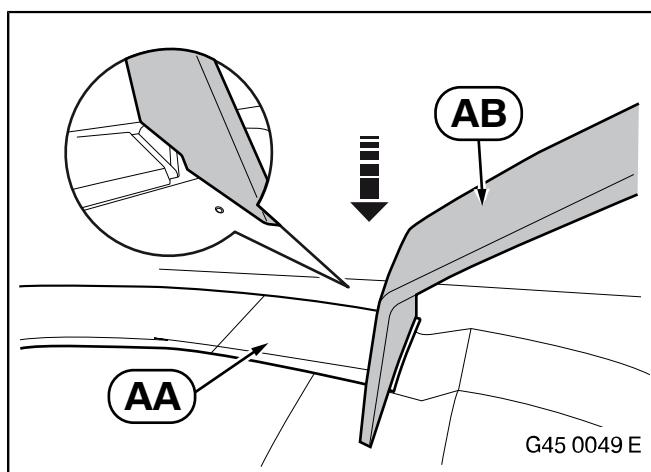


Apply beads of adhesive **AH** to both sides of roof edge spoiler centre section **AA**.



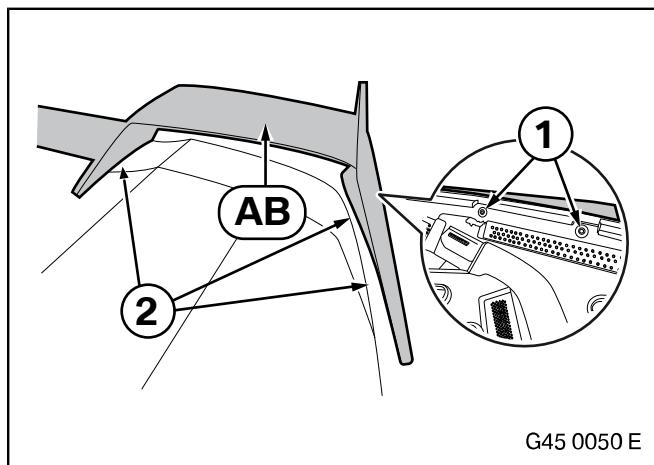
Degrease and abrade the bonding surfaces.

Apply a small bead of adhesive **AH** to the end tips of side sections **AB** (on both sides).

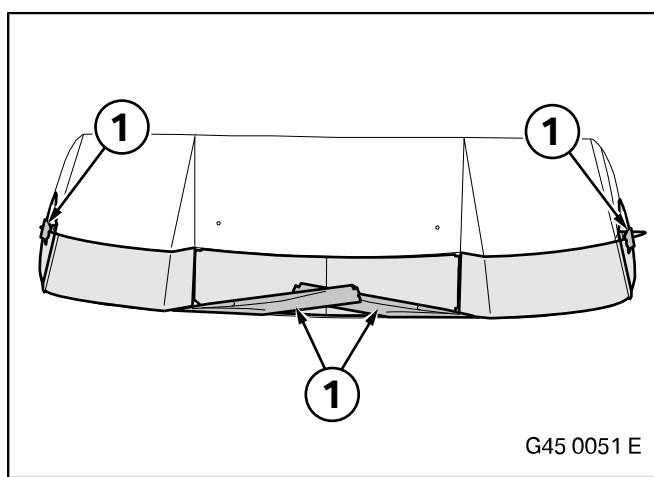


Insert the roof edge spoiler side sections **AB** from above.

7. Installing the roof edge spoiler



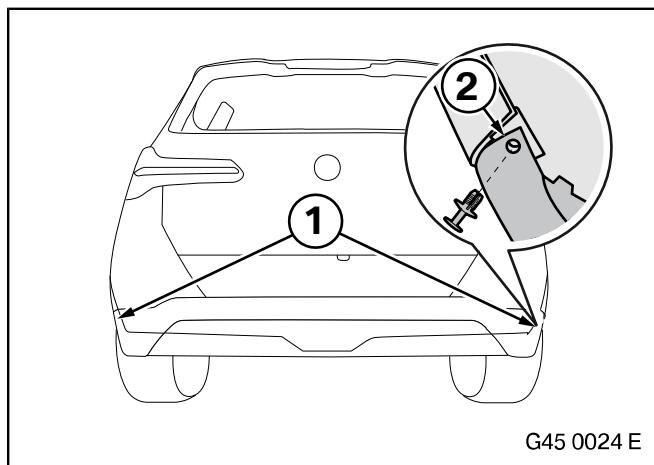
Position side sections **AB**, align them with the drill holes (1), ensure correct position again and then tighten all three screws (2).



Secure the bonding edges (1) using suitable adhesive tape and tightened all screws **AF** to the required torque.

► Observe the curing time ◀

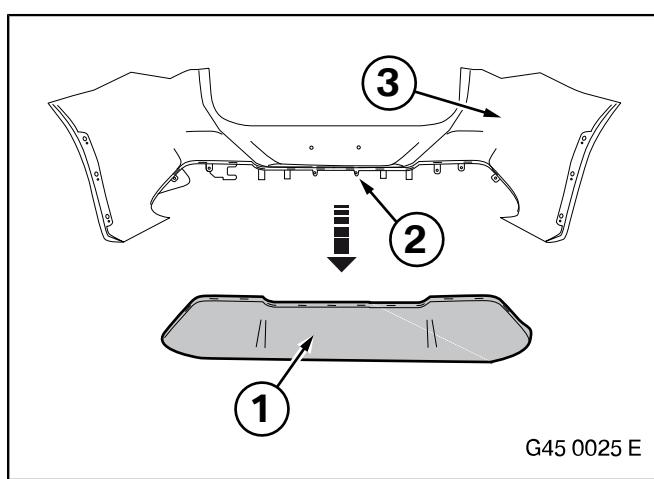
8. Installing the rear finisher and diffuser



► Remove the standard bumper panel as described in **ISTA/AIR**. ◀

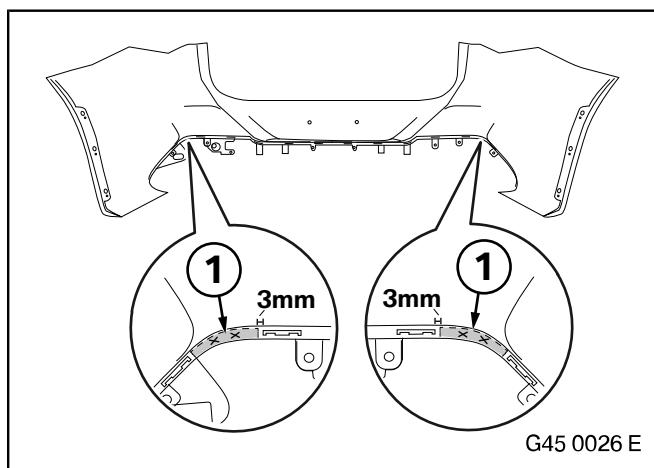
► **Keep** the expanding rivets **BE**; they will be reused later. ◀

Remove (2) the two expanding rivets **BE** on the left and right (1).



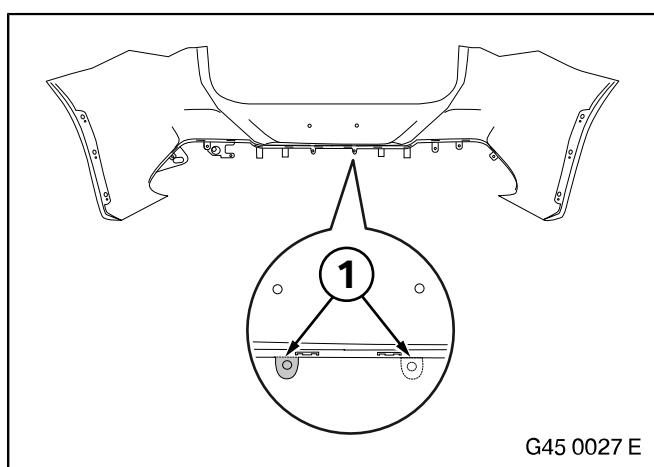
Unclip the **original diffuser** (1) and remove it.

Unclip the **wiring harness** from the fastening lugs (2) on the bumper panel (3) and remove the **PDC sensors** from the original diffuser (1).



Make marks (1) on the bumper panel at a distance of **3 mm** to the mounting groove and **cut out** the **area** using suitable equipment.

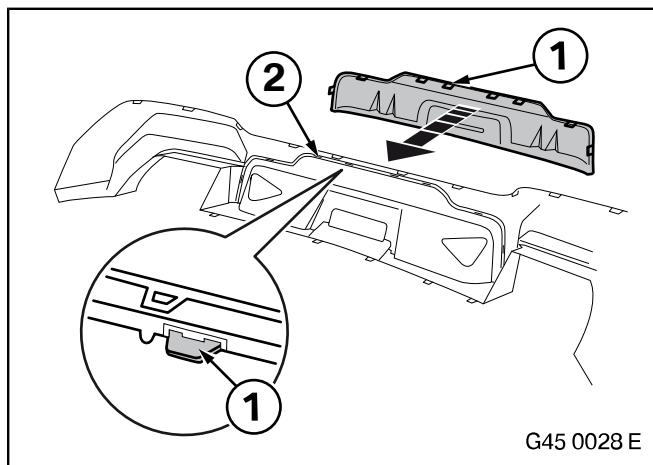
Deburr the cut surfaces.



Using suitable equipment, remove the centre **fastening lugs** (1) for the wiring harness.

Deburr the cut surfaces.

8. Installing the rear finisher and diffuser

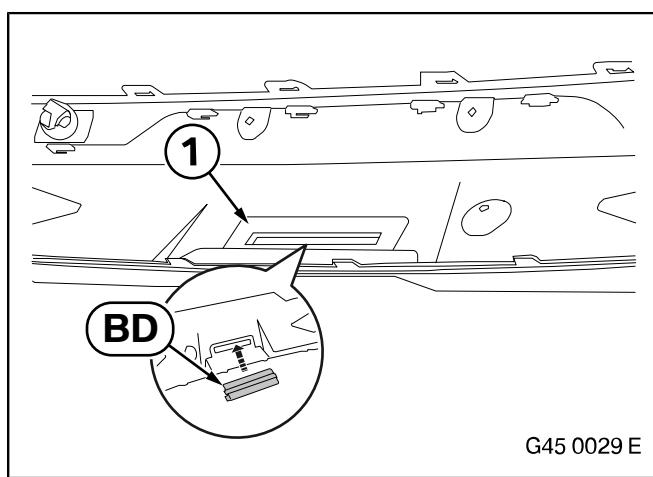


G45 0028 E

Remove the protective film from rear finisher **BA**.

Install diffuser **BC** from the inside by inserting the eight fastening lugs into the mounting grooves (1). Install the 4 expanding rivets **BE** from below and complete the 2-piece rear finisher.

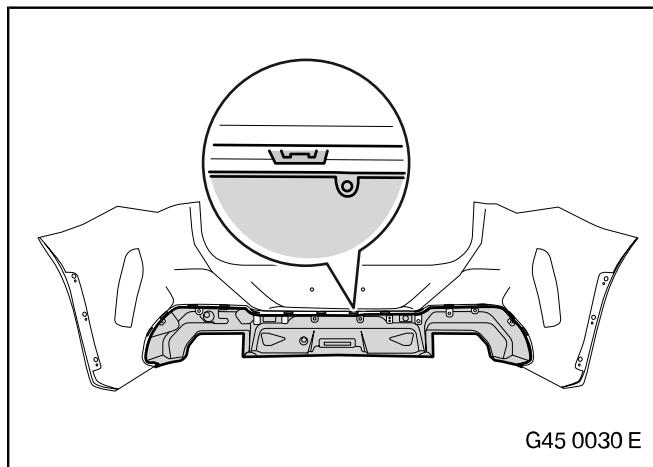
► Ensure correct fit when fastening. ◀



G45 0029 E

Degrease the bonding surfaces (1) and clean them with cleaner **BF**.

Install centre light **BD**.

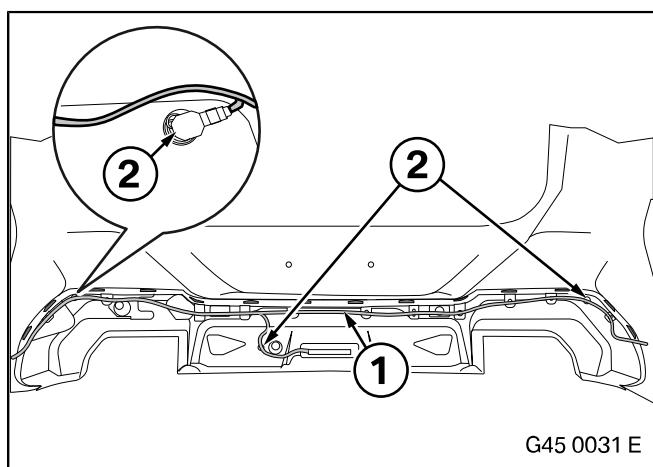


G45 0030 E

► Rear finisher **BA** is to be positioned **below the bumper panel**. ◀

Position rear finisher **BA** and clip it in.

► Ensure that it is correctly locked in place. ◀

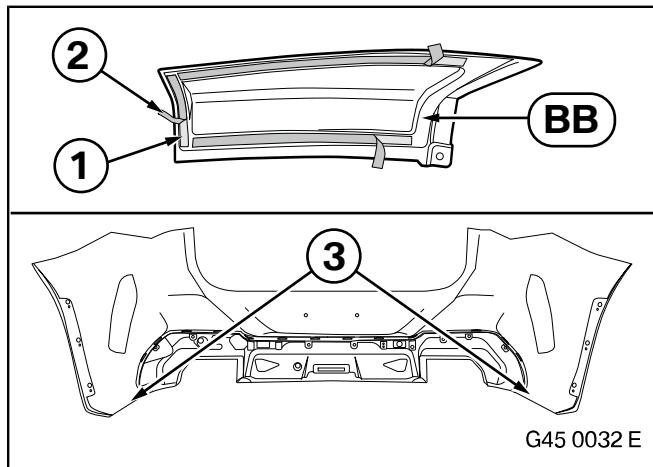


G45 0031 E

Install the **wiring harness** (1) correctly.

Install the **PDC sensors** (2).

8. Installing the rear finisher and diffuser



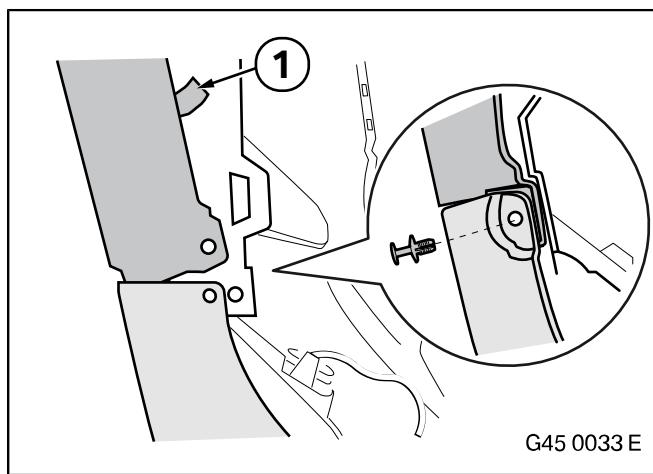
Installing the rear finisher side sections

Remove the film from the adhesive tape (1) and **bend the ends outwards (2)**.

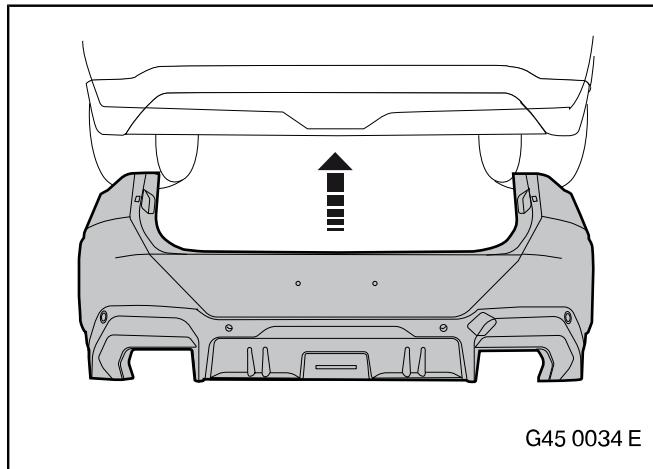
Remove the **outer protective film** of the side sections.

Position rear finisher side sections **BB** on the left and right (3).

► Do not yet fully bond them. ◀



Fasten the side sections with the **two** expanding rivets **BE** that you set aside earlier.



Install the **completed rear trim panel** (consisting of rear finisher **BA**, diffuser **BC** and the bumper panel) along the upper edge as described in **ISTA/AIR**.

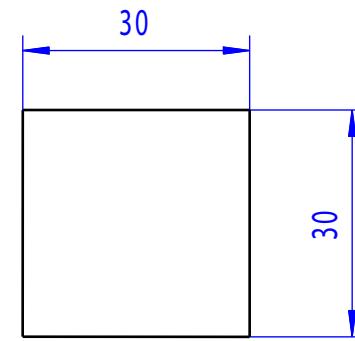
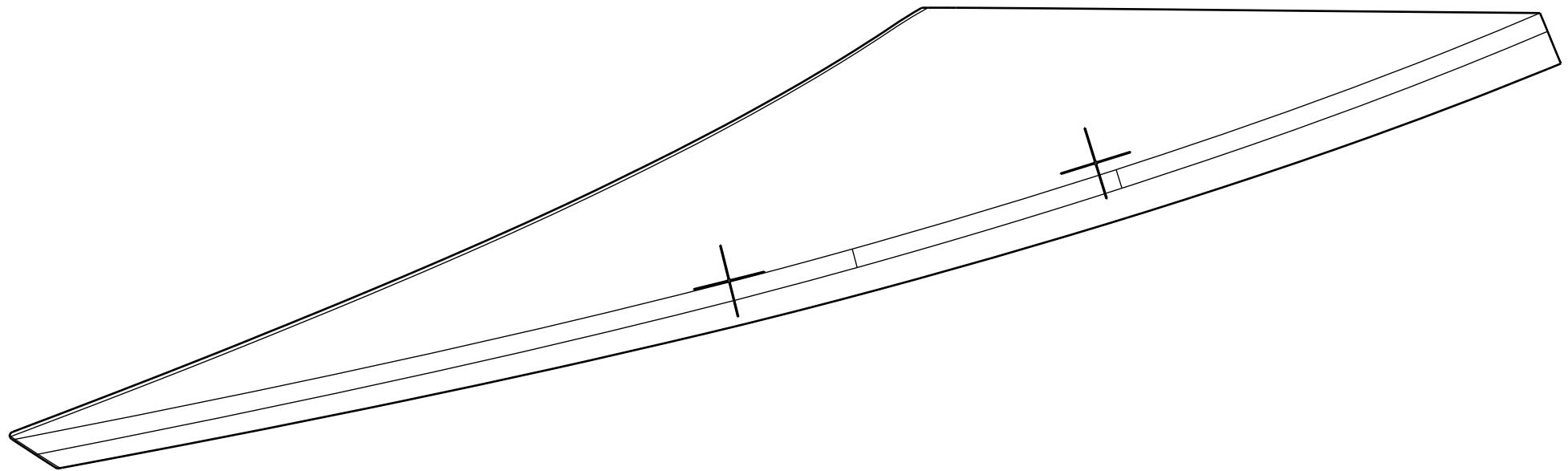
Once the rear trim panel has been fitted correctly, **adjust the side sections**.

Remove the backing films from side sections **BB**.

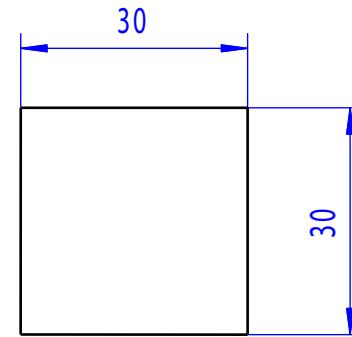
► Press against the bonding areas with a force of at least 10 kg. ◀

9. Concluding work and coding

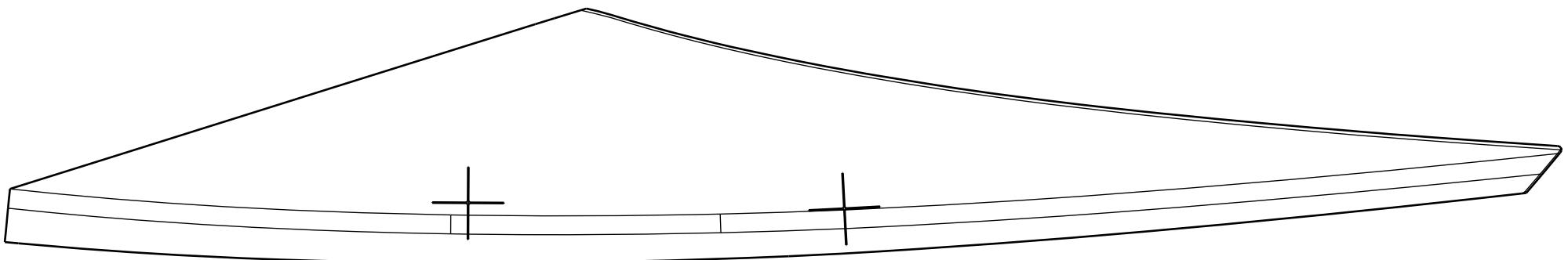
The retrofit system does not require programming/coding.

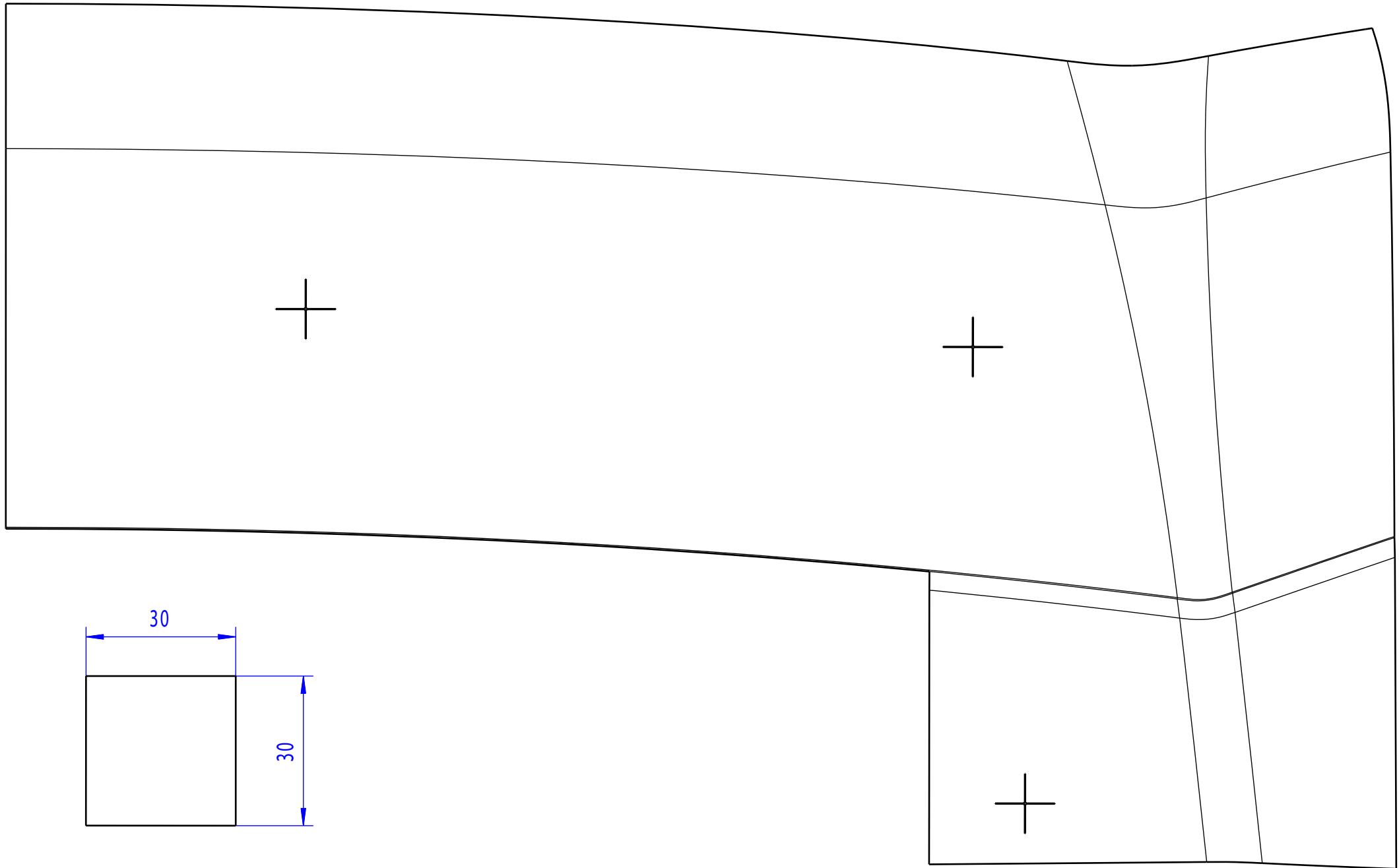


G45 roof edge spoiler outside left

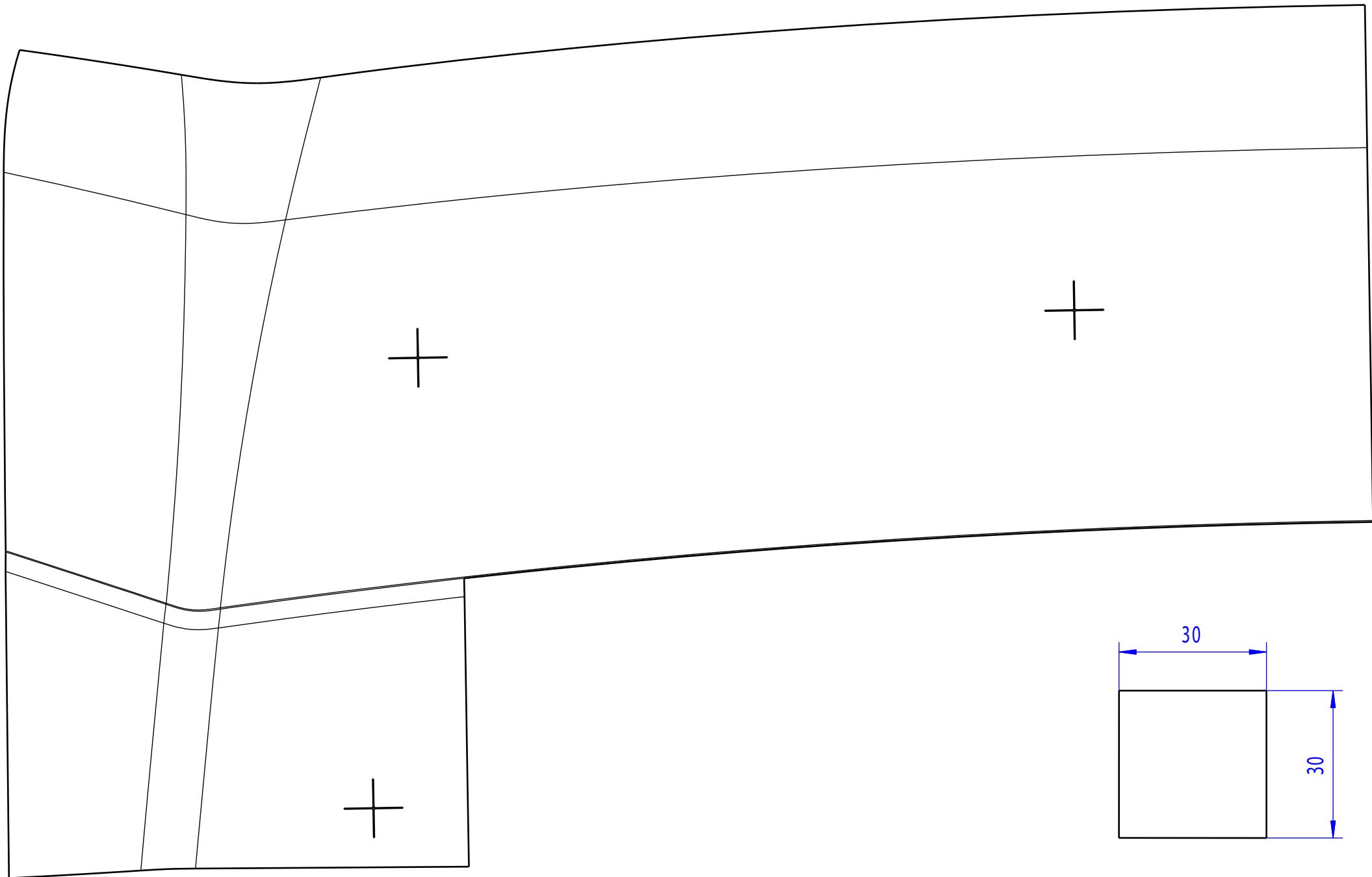


G45 roof edge spoiler outside right





G45 roof edge spoiler center left



G45 roof edge spoiler center right