

# Original BMW Parts and Accessories. Installation Instructions.



## M Performance Carbon Exterior Components Retrofit Kit.

BMW 5 Series Saloon (G60)

BMW 5 Series Touring (G61)

### Retrofit kit number

| Number        | Component designation                                                                  | Install-<br>ation time (h) | Installation<br>as described<br>in ISTA/AIR* |
|---------------|----------------------------------------------------------------------------------------|----------------------------|----------------------------------------------|
| 51 11 5A6FE86 | Carbon centre right front attachment                                                   | 0.20                       | -                                            |
| 51 11 5A6FE85 | Carbon centre left front attachment                                                    | 0.20                       | -                                            |
| 51 11 5A6FE82 | Carbon right front attachment                                                          | 0.20                       | -                                            |
| 51 11 5A6FE81 | Carbon left front attachment                                                           | 0.20                       | -                                            |
| 51 11 5A8F939 | Left primed PUR front attachment**                                                     | 0.50                       | -                                            |
| 51 11 5A8F940 | Right primed PUR front attachment**                                                    | 0.50                       | -                                            |
| 51 19 5A56352 | Carbon right side skirt attachment                                                     | 0.50                       | -                                            |
| 51 19 5A56353 | Carbon left side skirt attachment                                                      | 0.50                       | -                                            |
| 51 12 5A7F3C5 | Centre rear diffuser                                                                   | 0.20                       | -                                            |
| 51 12 5A7F3C3 | Right rear diffuser                                                                    | 0.25                       | -                                            |
| 51 12 5A7F3C0 | Left rear diffuser                                                                     | 0.25                       | -                                            |
| 51 62 5A79E68 | Carbon Pro rear spoiler                                                                | 0.50                       | -                                            |
| 51 12 5A852A0 | Right carbon tail fin (G61 only)                                                       | 0.20                       | -                                            |
| 51 12 5A85299 | Left carbon tail fin (G61 only)                                                        | 0.20                       | -                                            |
| 51 62 5B3E1A8 | Black high gloss roof edge spoiler (G61 only)                                          | 0.30                       | -                                            |
| 65 20 5A59AD9 | Aramid antenna cover<br><b>(see EBA 01 29 5 A5C 9E3 for installation instructions)</b> | 0.50                       | -                                            |
| 01 29 5B34093 | Universal sill strip<br><b>(see EBA 01 29 5 A95 648 for installation instructions)</b> | 0.10                       | -                                            |

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

\*\* Only for cars without SA8TF (active pedestrian protection).

### 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.

**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/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 cars; proceed in the same way on RHD cars.
- The primed PUR front attachment can only be installed on cars without SA8TF (active pedestrian protection).

## **Painting instructions**

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

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

Follow the BMW painting instructions.

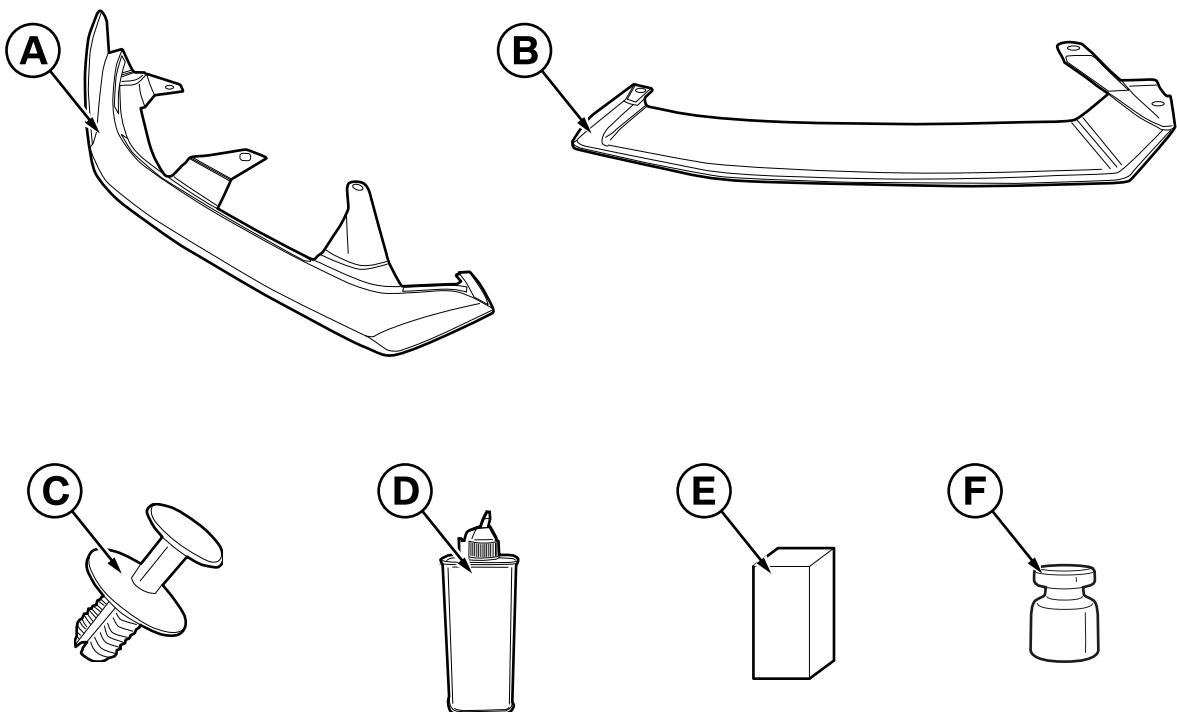
## **Special tools required**

- None

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## 1. Carbon front attachment parts list

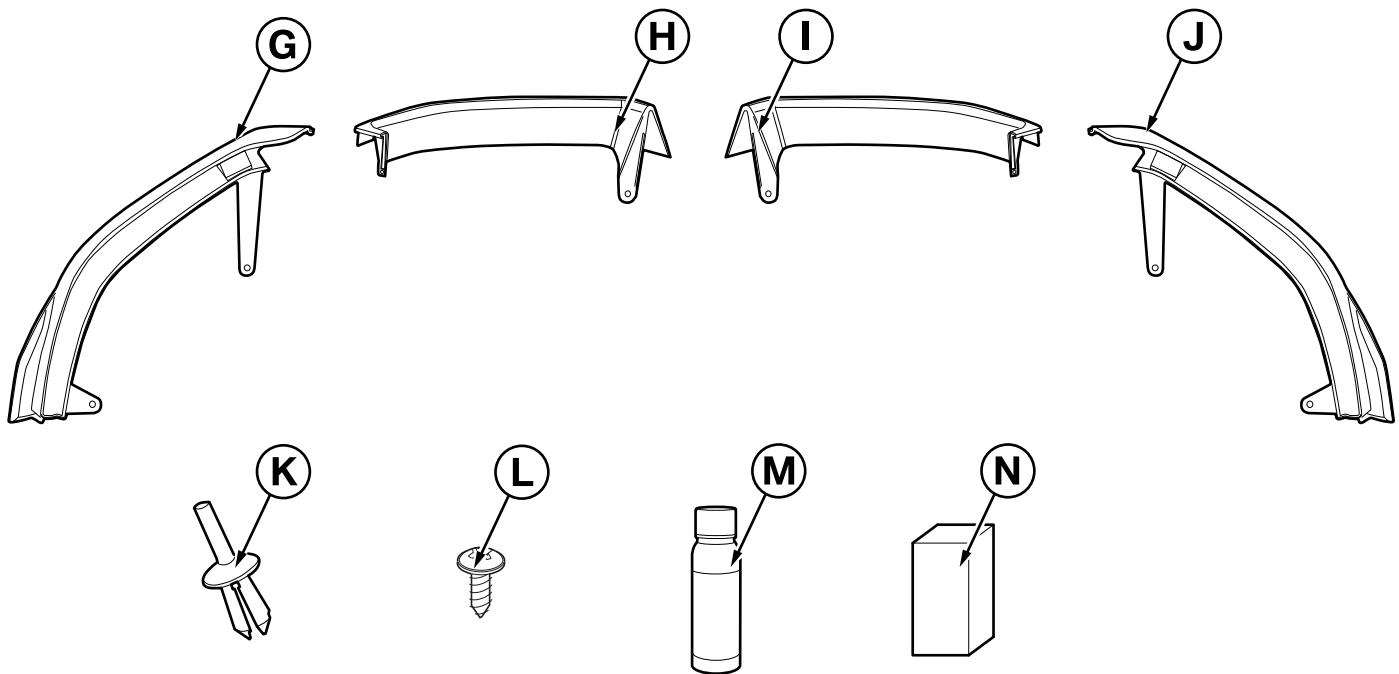


G60 0020 V

### Legend

- A** Carbon front left/right attachment (right side shown)
- B** Carbon centre front left/right attachment (right side shown)
- C** Expanding rivet (4 x, not included in the parts kit, Part number 51 47 1 911 992)
- D** Cleaner (not included in kit, see EPC for details)
- E** Liquid adhesive (not included in kit, see EPC for details)
- F** Primer (not included in kit, see EPC for details)

## 2. PUR front attachment parts list

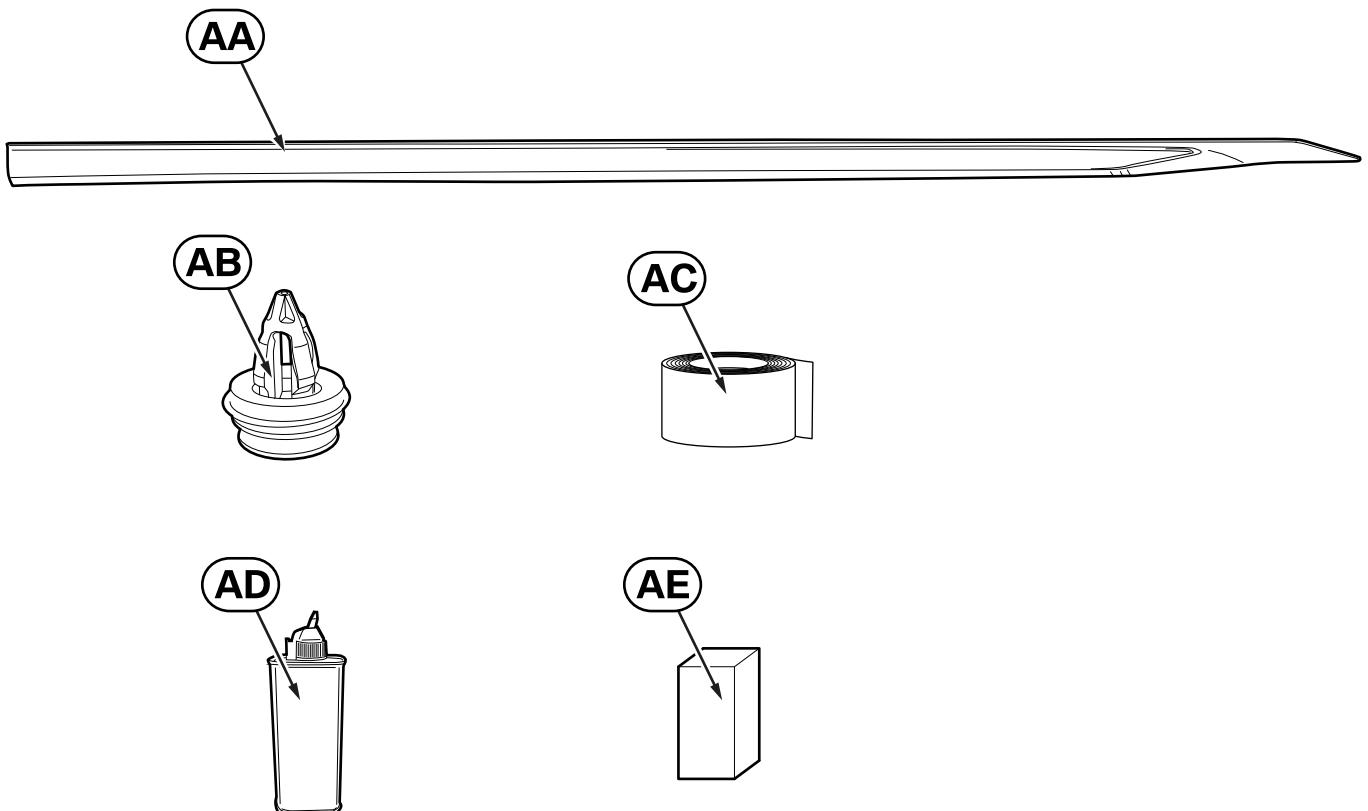


G60 0110 V

### Legend

- G** Outer left primed PUR front attachment
- H** Inner left primed PUR front attachment
- I** Inner right primed PUR front attachment
- J** Outer right primed PUR front attachment
- K** Expanding rivet (4x, not included in the parts kit, part number 51 46 7 002 606)
- L** Self-tapping screw (4x, not included in the parts kit, see EPC for details and part number)
- M** Cleaner (not included in parts kit, see EPC for details and part number)
- N** Liquid adhesive (not included in parts kit, see EPC for details and part number)

### 3. Carbon side skirt attachment parts list

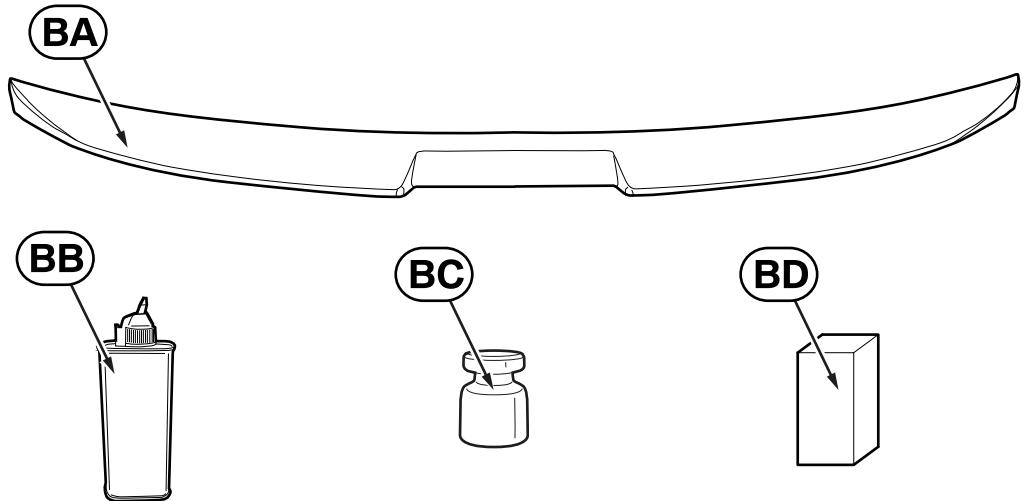


G60 0001 V

#### Legend

- AA** Carbon left/right side skirt attachment (right side shown)
- AB** Clip (4 x)
- AC** Template left/right (used for both sides)
- AD** Cleaner (not included in kit, see EPC for details)
- AE** Liquid adhesive (not included in kit, see EPC for details)

#### 4. Carbon rear spoiler parts list

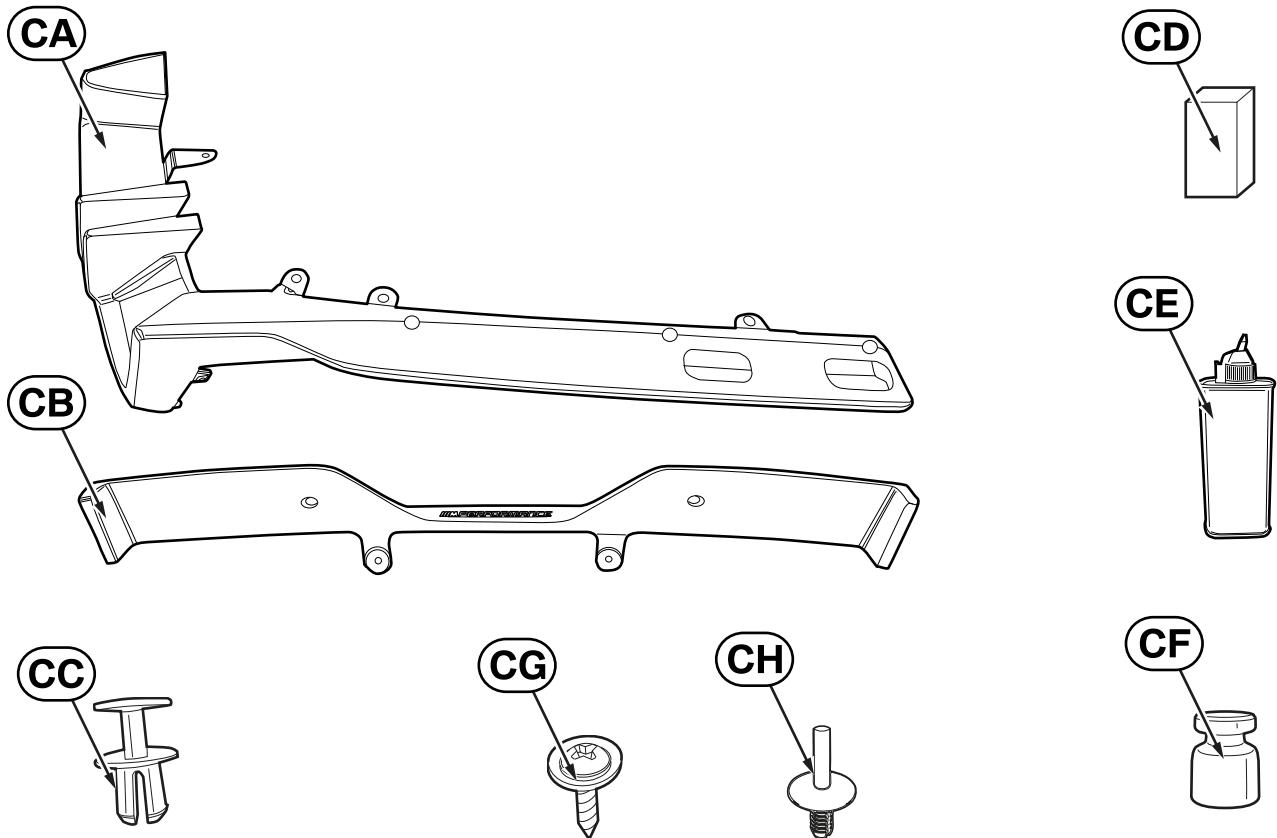


G60 0040 V

#### Legend

- BA** Carbon rear spoiler
- BB** Cleaner (not included in kit, see EPC for details)
- BC** Primer (not included in kit, see EPC for details)
- BD** Liquid adhesive (not included in kit, see EPC for details)

## 5. Carbon rear diffuser parts list

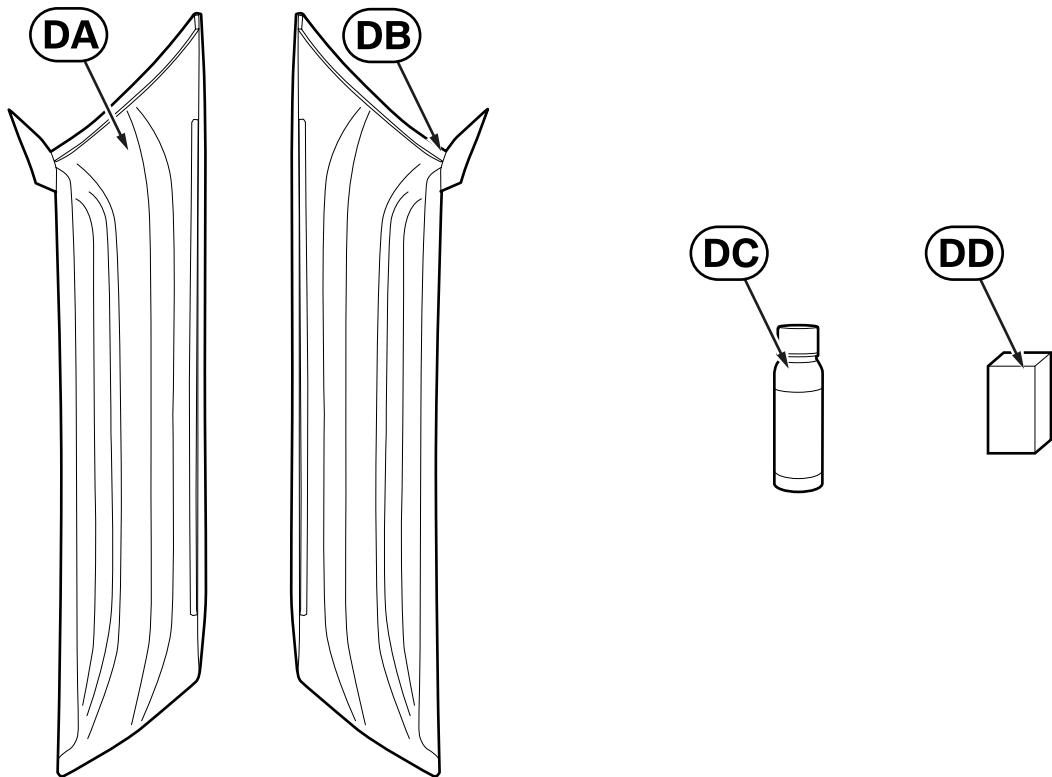


G60 0050 V

### Legend

- CA** Carbon left/right rear diffuser (right side shown)
- CB** Carbon centre rear diffuser
- CC** Expanding rivet Ø 8 mm (6 x, not included in the parts kit, see EPC for details)
- CD** Liquid adhesive (not included in kit, see EPC for details)
- CE** Cleaner (not included in kit, see EPC for details)
- CF** Primer (not included in kit, see EPC for details)
- CG** Fillister head screw (10 x, not included in the parts kit, see EPC for details)
- CH** Expanding rivet Ø 6 mm (2 x, not included in the parts kit, see EPC for details)

## 6. Carbon tail fin parts list

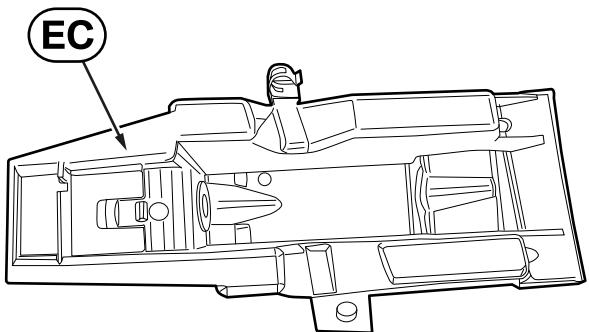
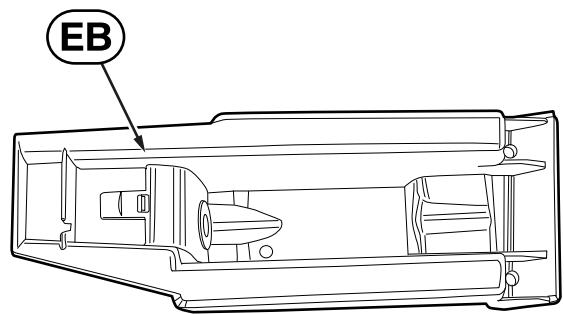
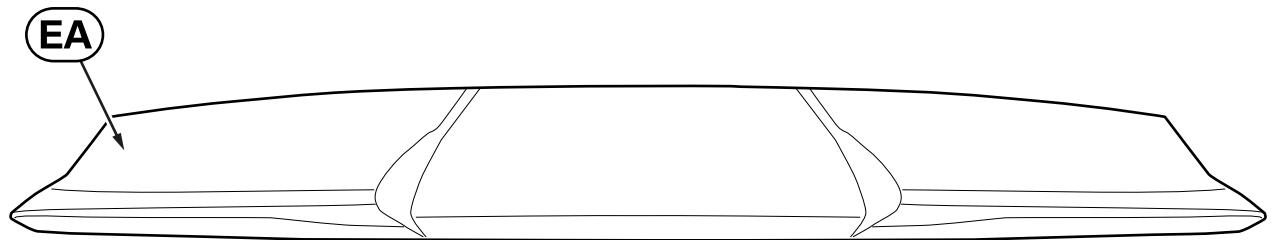


G61 0000 V

### Legend

- DA** Carbon tail fin, left
- DB** Carbon tail fin, right
- DC** Cleaner (not included in kit, see EPC for details)
- DD** Liquid adhesive (not included in kit, see EPC for details)

## 7. Black high gloss roof edge spoiler parts list



G61 0010 V

### Legend

**EA** Black high gloss roof edge spoiler

**EB** Adapter, left

**EC** Adapter, right

## 8. Preparations

ISTA/AIR No.

**The following components must be removed first of all**

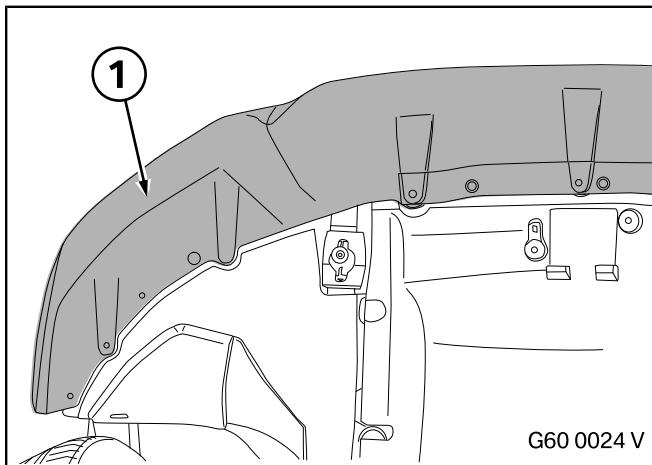
**For installing the M Performance CRP boot lid rear spoiler only**

- Standard gurney

**For installing the black high gloss roof edge spoiler only**

- Standard roof edge spoiler

## 9. Installing the carbon front attachment

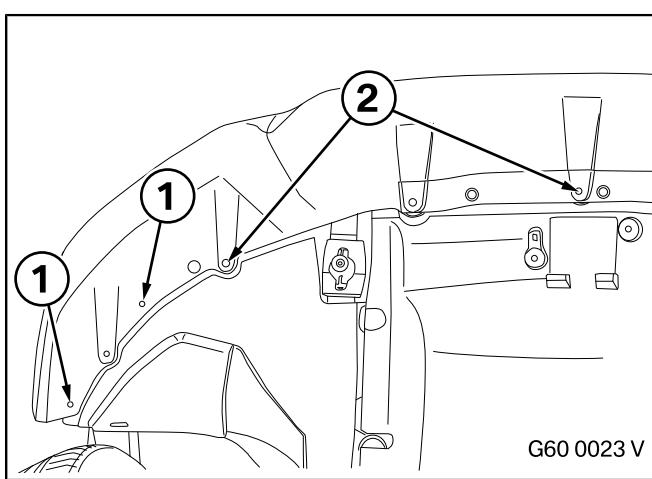


### Carbon left/right front attachment installation

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

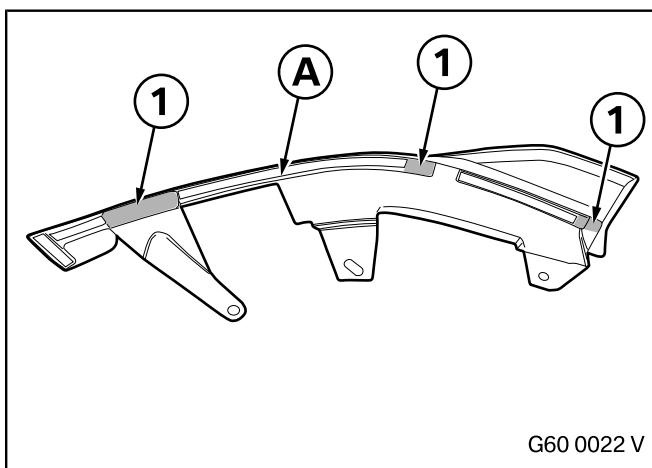
Wait until the cleaner is fully dry. ◀

Clean the bottom and outside surfaces (1) of the front trim with cleaner **D**.



Remove the expanding rivets (1), they will be reused later.

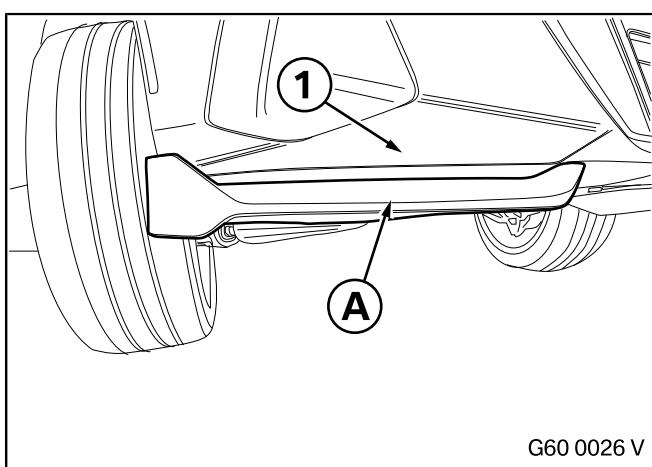
Remove the screws (2), they will be reused later.



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

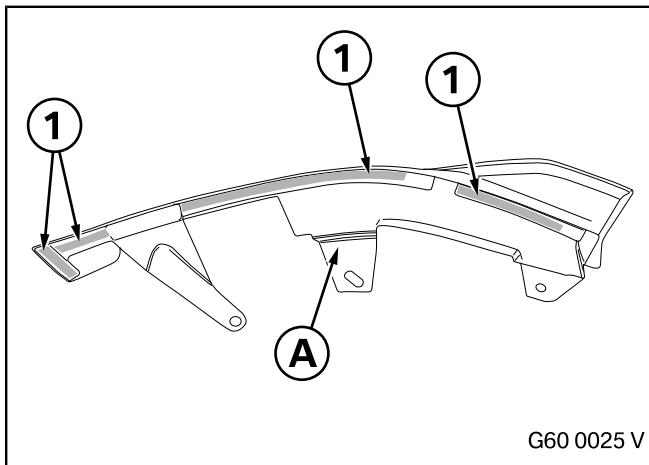
Wait until the cleaner is fully dry. ◀

Abrade the bonding surfaces (1) on the inside of the carbon left/right front attachment **A** using suitable tools and then clean them with cleaner **D**.

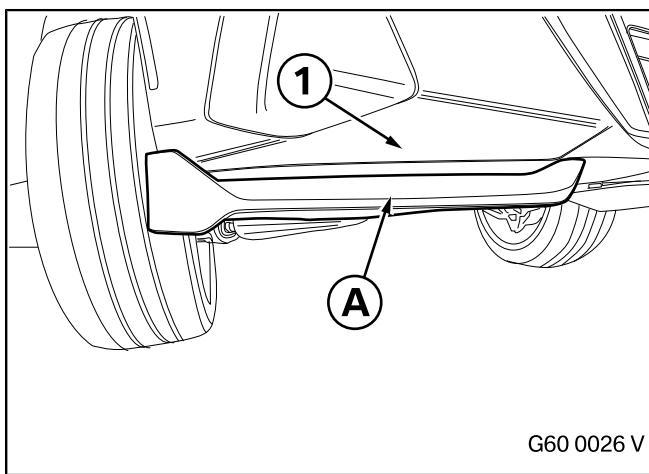


Hold the carbon left/right front attachment **A** in the installation position and check that it fits properly, then remove it again.

## 9. Installing the carbon front attachment



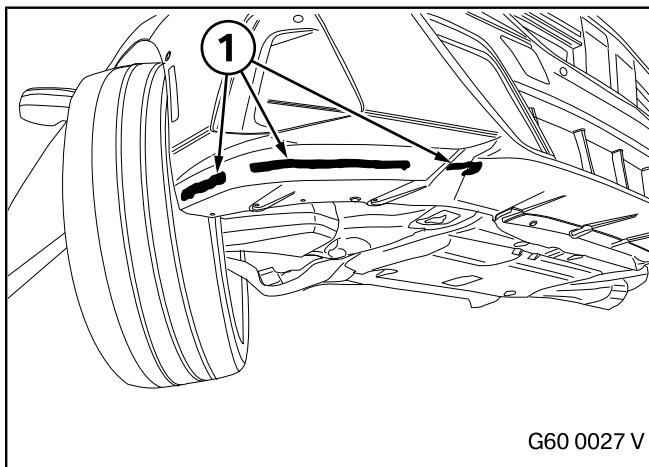
Apply the primer **F** to the backing foil (1) on the adhesive tapes.



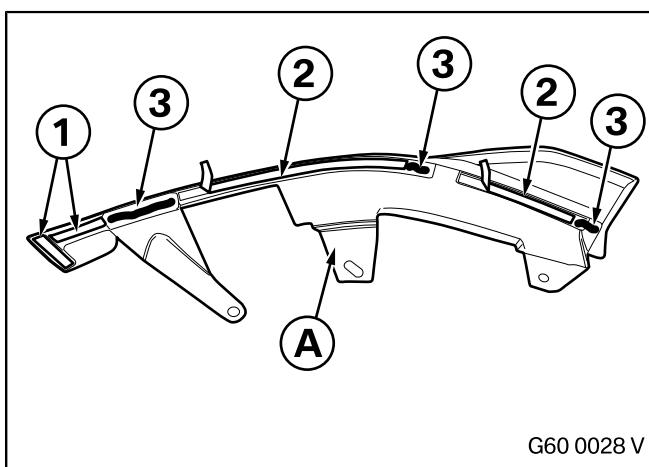
Work precisely to prevent unnecessary contact by the primer with the car's trim parts. ◀

Place the carbon left/right front attachment **A** in its installation position on the front trim and press it firmly so that the primer can be transferred to the trim.

Then remove the carbon left/right front attachment **A**.



Draw round the marks (1) on the car's trim with primer **F**.



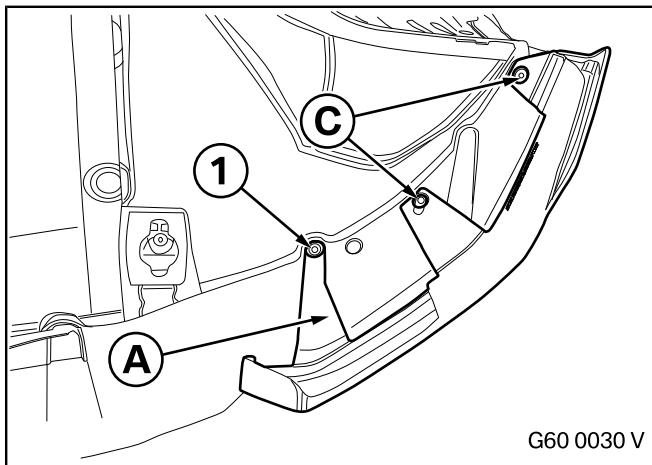
Remove the remaining primer from the backing foils. ◀

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

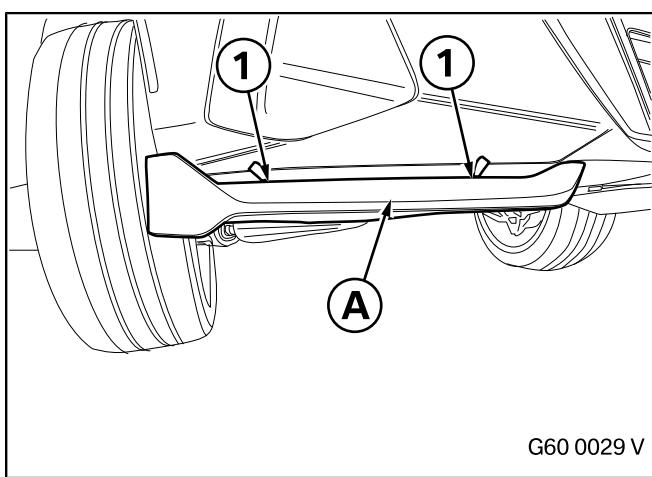
Bend the ends of the backing foils (2) outwards.

Apply beads of liquid adhesive **E** to the abraded surfaces (3).

## 9. Installing the carbon front attachment



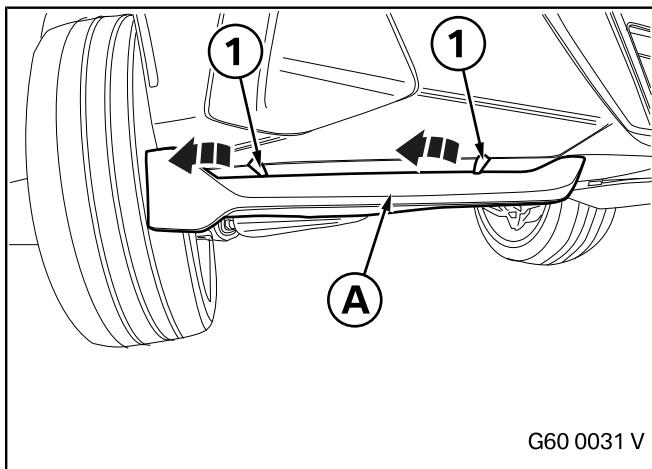
Press in the expanding rivets **C** on the underside and tighten the existing screw (1).



► The ends of the backing foils (1) must be bent outwards so that they are visible. ◀

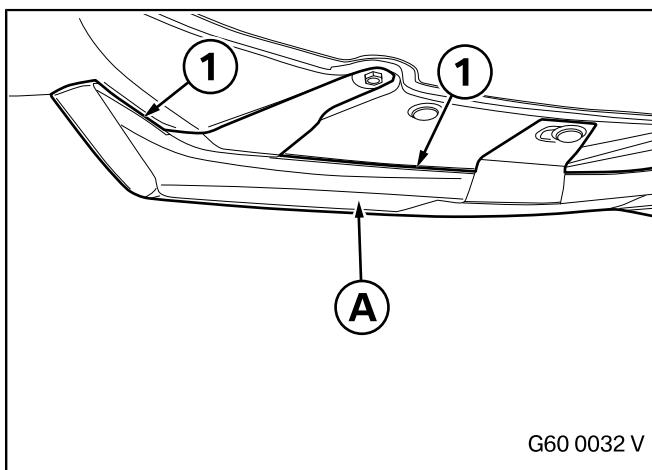
Place the carbon left/right front attachment **A** in its installation position on the front trim.

The ends of the backing films (1) must be visible.



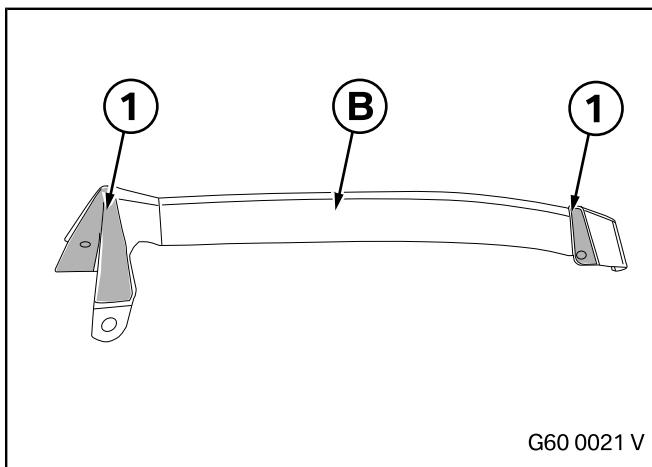
► Remove any excess liquid adhesive immediately using suitable tools. ◀

Pull the ends of the backing films (1) out to the side and press the carbon left/right front attachment **A** into position several times.



Check the gap (1) between the front trim and the carbon left/right front attachment **A** from the bottom and, if necessary, press it multiple times downwards onto the car's trim until the adhesive tape bonds and no gap can be seen.

## 9. Installing the carbon front attachment

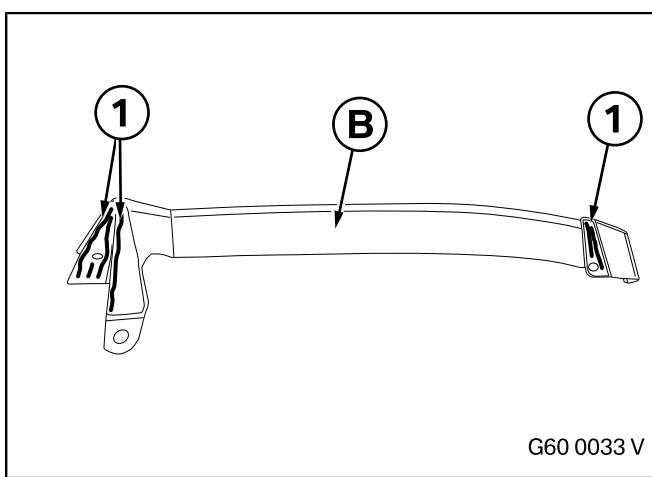


G60 0021 V

### Installing the carbon centre left/right front attachment

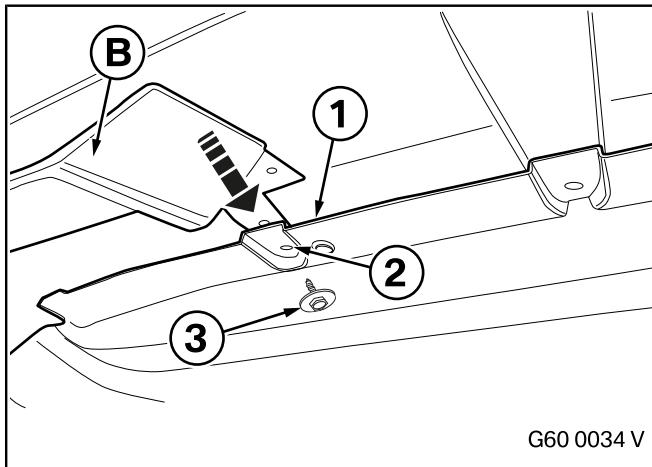
Abrade the surfaces (1) on the carbon centre left/right front attachment **B** using suitable tools and clean it with cleaner **D**.

► Wait until the cleaner is fully dry. ◀



G60 0033 V

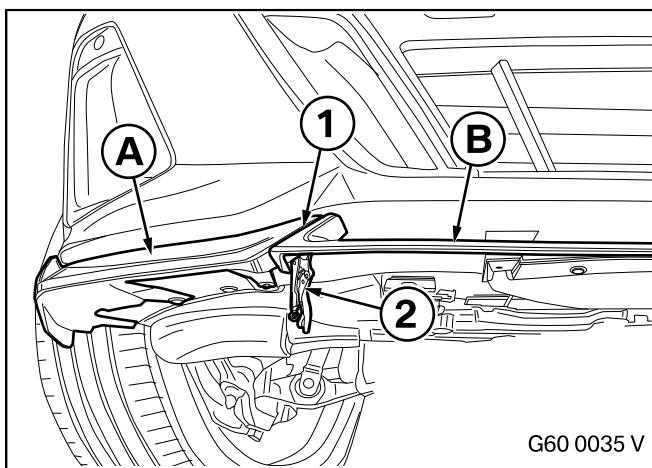
Apply a bead of liquid adhesive **E** to the surfaces (1) you cleaned earlier.



G60 0034 V

► Complete this step with a second person so that the liquid adhesive does not come into contact with the car's trim prematurely. ◀

Push the lug on the carbon centre left/right front attachment **B** under the edge (1) of the air guide (if there is one) until the hole (2) lines up with the hole in the carbon centre left/right front attachment **B** and secure it with the existing screw (3).

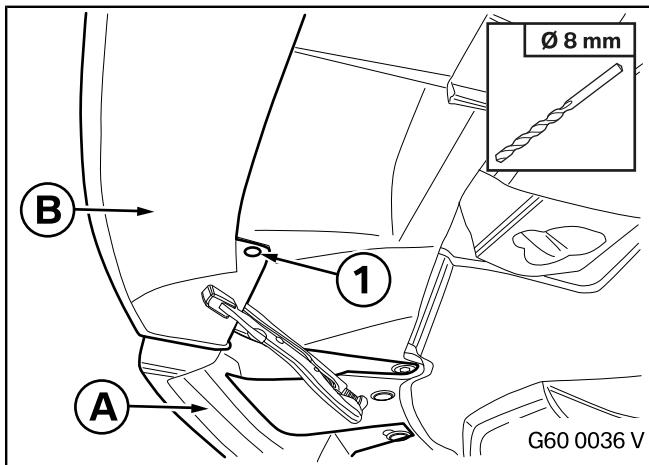


G60 0035 V

► Wait until the cleaner is fully dry. ◀

Adjust the transition (1) of the centre left/right front attachment **B** with the left/right front attachment **A**, check it and then secure it with suitable equipment (2).

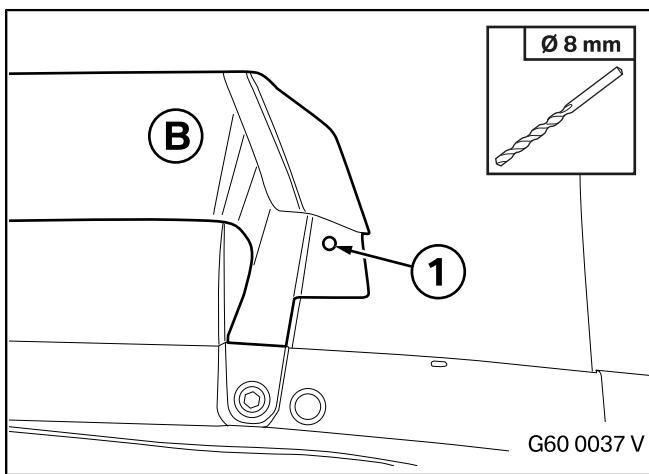
## 9. Installing the carbon front attachment



► Do not exceed the drilling depth. ◀

Drill an **8 mm** hole through the hole (1) in the carbon centre left/right front attachment **B**.

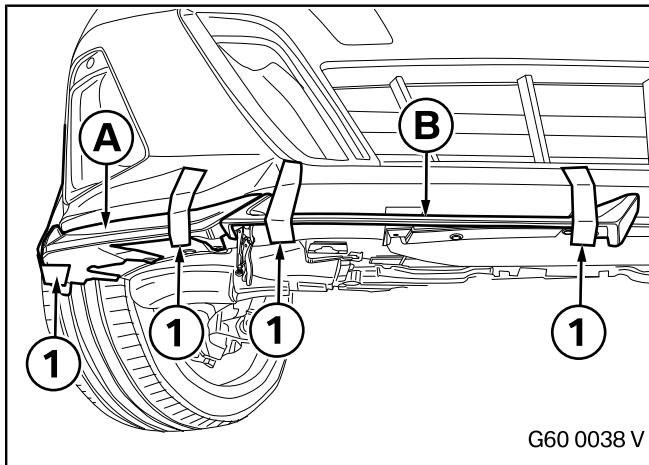
Insert an expanding rivet **C**.



► Do not exceed the drilling depth. ◀

Drill an **8 mm** hole through the hole (1) in the carbon centre left/right front attachment **B**.

Insert an expanding rivet **C**.



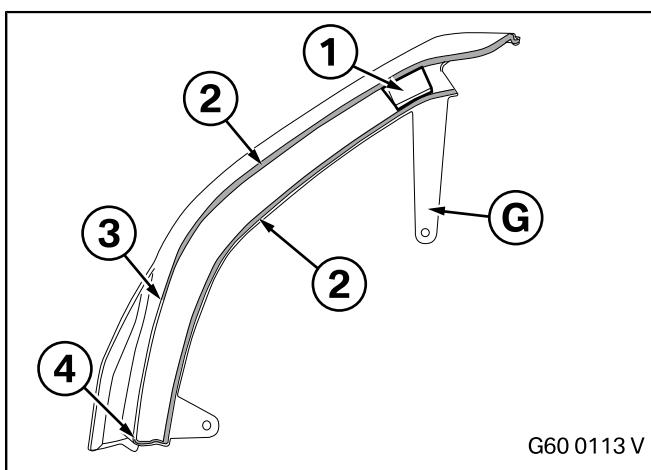
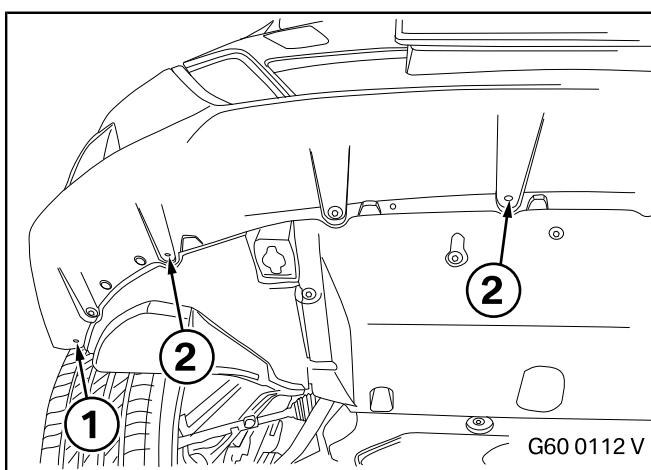
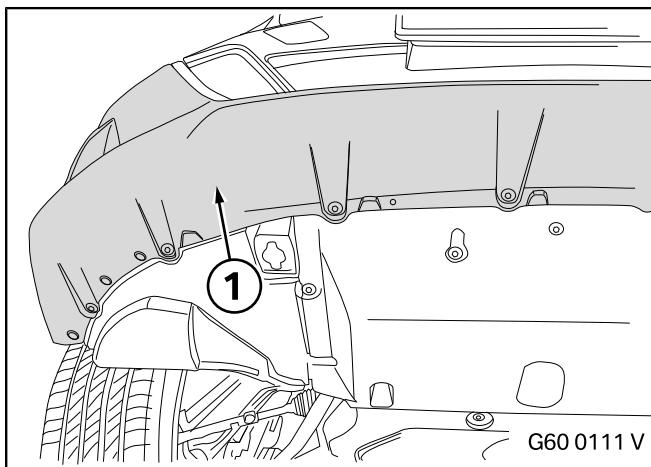
Secure the carbon left/right front attachment **A** and the carbon centre left/right front attachment **B** using suitable adhesive tapes (1).

Repeat the whole of the installation procedure on the other side of the car.

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

## 10. Installing the PUR front attachment

► Refer to the painting instructions on page 3 before installation. ◀



### Installing the outer left/right primed PUR front attachment

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

Wait until the cleaner is fully dry. ◀

Clean the bottom and outside surfaces (1) of the front trim with cleaner **M**.

Remove the expanding rivet (1), it will be reused later.

Remove the screws (2), they will be reused later.

► Do not remove the foam wedge (1). It forms a barrier to prevent the ingress of dirt, such as sand or small stones.

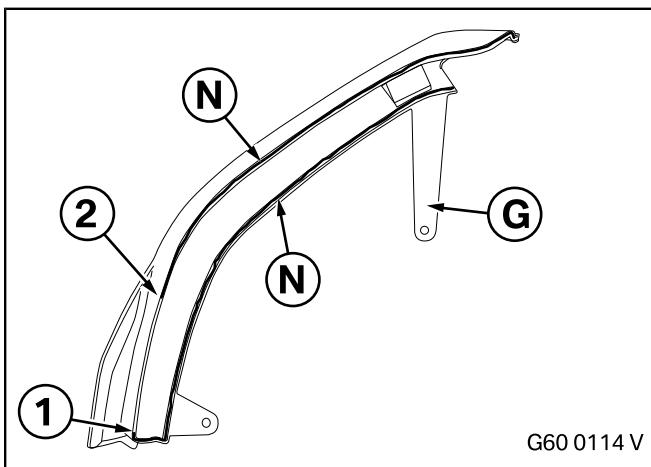
The bonding surfaces (2) must be completely dry, clean and free of wax or grease.

No abrading is required in the area between (3) and (4) around the winglet.

Wait until the cleaner is fully dry. ◀

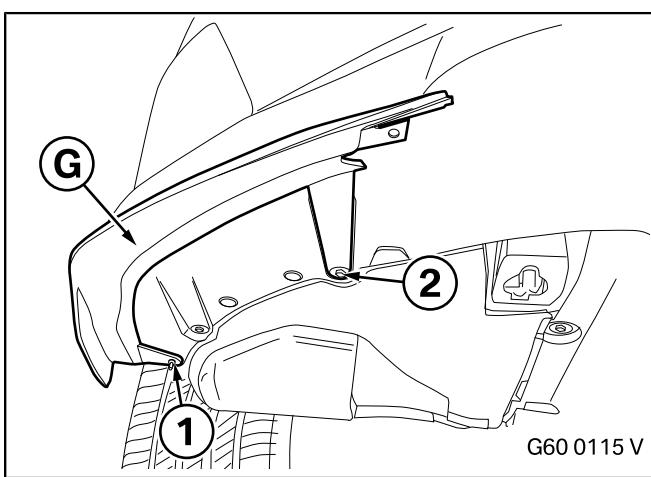
Abrade the bonding surfaces (2) on the inside of the outer left primed PUR front attachment **G** using suitable tools and then clean them with cleaner **M**.

## 10. Installing the PUR front attachment



Do not apply any liquid adhesive **N** in the area between (1) and (2) as this area cannot be cleaned later on. ◀

Apply a bead of liquid adhesive **N** to the prepared surfaces of the outer left primed PUR front attachment **G**.

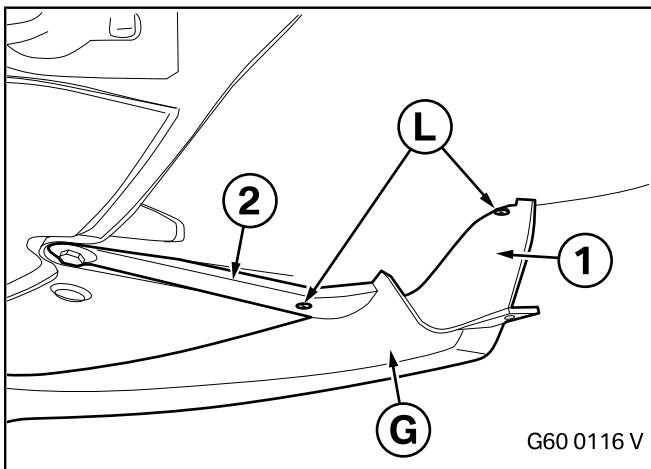


Complete this step with a second person so that the liquid adhesive does not come into contact with the car's trim prematurely. ◀

Place the outer left primed PUR front attachment **G** against the outside of the car in its installation position and secure it with the existing expanding rivet (1). Do not press the expanding rivet (1) in fully.

Then tighten the existing screw (2).

Only then should the expanding rivet (1) be pressed in fully.



Secure the outer left primed PUR front attachment **G** using self-tapping screws **L**.

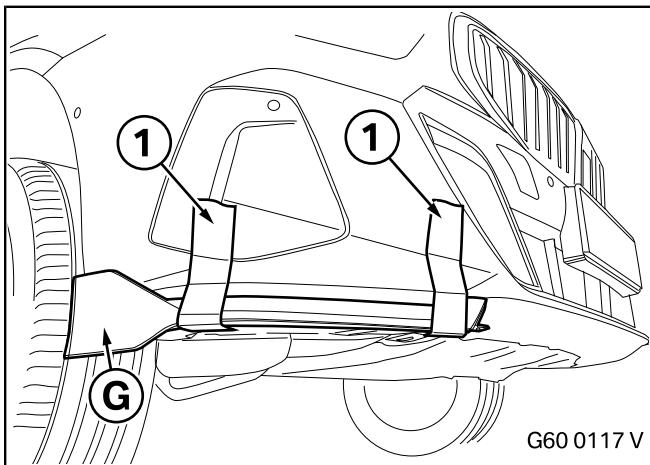
Following the contour of the bumper trim, push the surface (1) slightly towards the front. Then temporarily screw in self-tapping screws **L** to secure it.

Ensure that self-tapping screws **L** do **not** penetrate the outer left primed PUR front attachment **G** but provide support only. ◀

Screw in the first screw **L** on the inner section of the outer left primed PUR front attachment **G** in such a way that the screw secures the outer left primed PUR front attachment **G**, but does not penetrate it.

Insert the second screw **L** into the lug (2) on the outer left primed PUR front attachment **G** in such a way that the lug (2) is pressed against the front trim.

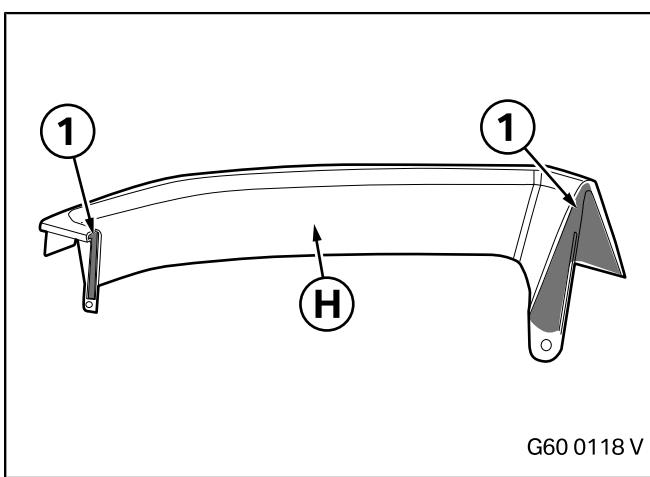
## 10. Installing the PUR front attachment



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

Secure the outer left primed PUR front attachment **G** to the front trim using suitable adhesive tape (1).

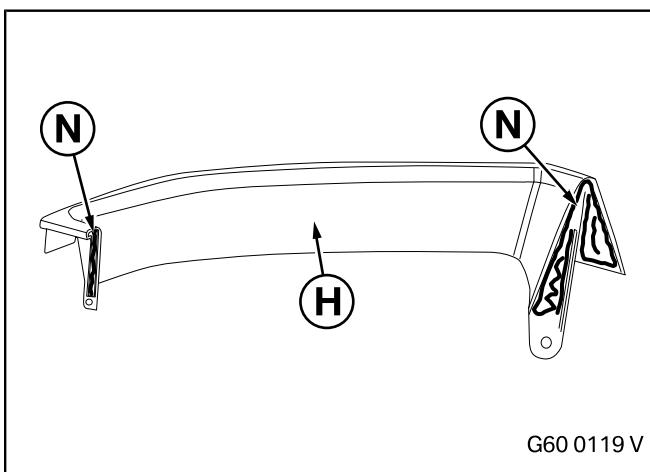
Repeat the above installation work for the outer right primed PUR front attachment **J**.



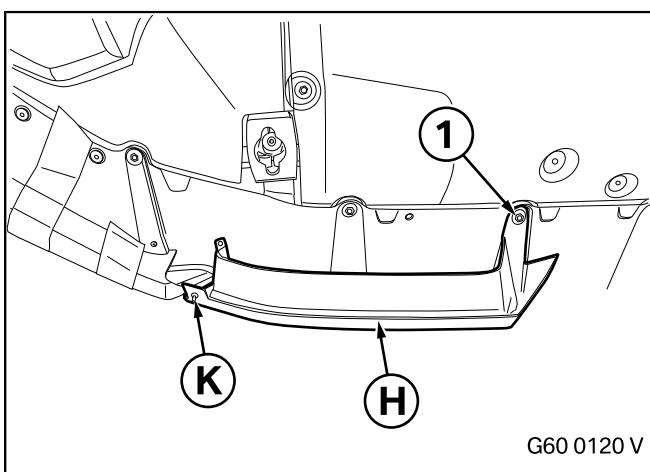
### Inner left/right primed PUR front attachment

Abrade the surfaces (1) on the inner front primed PUR front attachment **H** using suitable tools and clean them with cleaner **M**.

► Wait until the cleaner is fully dry. ◀



Apply a bead of liquid adhesive **N** to the previously cleaned surfaces of the inner left primed PUR front attachment **H** as shown.

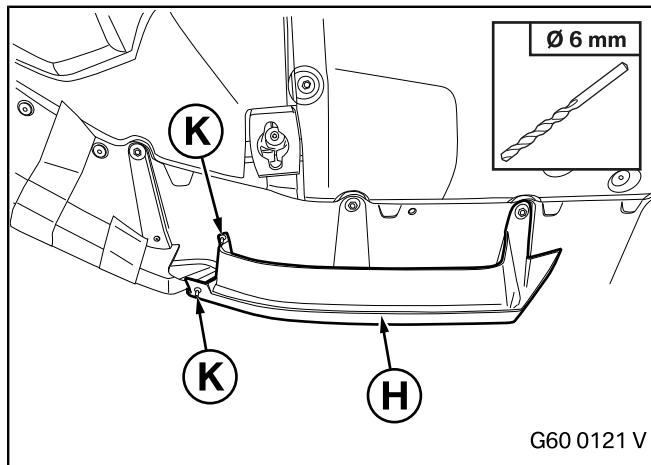


► Complete this step with a second person so that the liquid adhesive does not come into contact with the car's trim prematurely. ◀

Place the left inner primed PUR front attachment **H** in its installation position and secure it with the existing screw (1).

Secure the inner left primed PUR front attachment **H** with expanding rivet **K**. Do not press the expanding rivet **K** in fully.

## 10. Installing the PUR front attachment

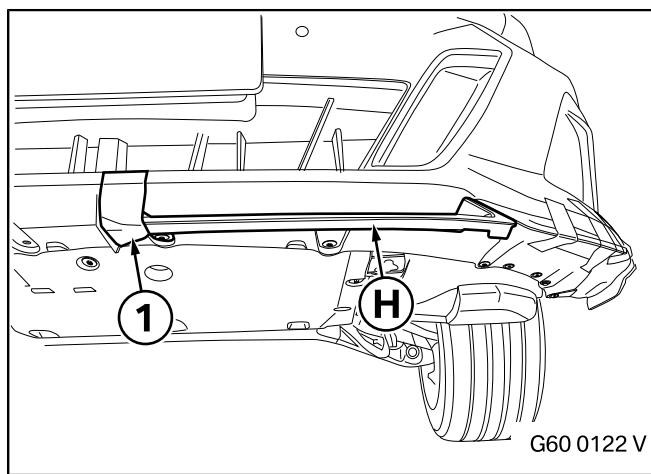


► Do not exceed the drilling depth. ◀

Drill a **6 mm** hole through the hole (1) in the inner left primed PUR front attachment **H**.

Insert and secure an expanding rivet **K**.

Then insert the second expanding rivet **K** fully.



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

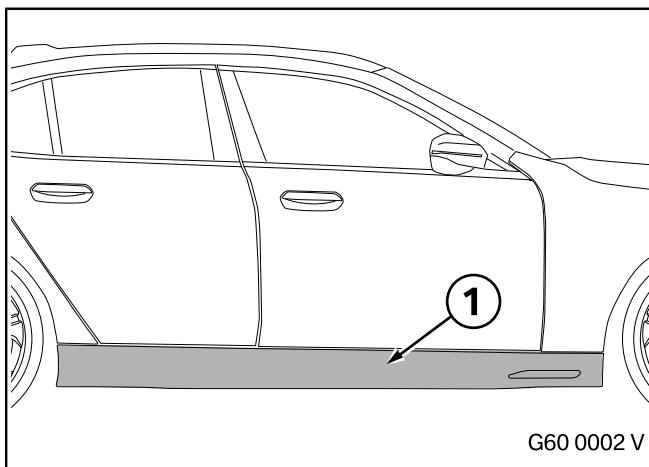
Secure the inner left primed PUR front attachment **H** using suitable adhesive tape (1) as shown.

Repeat the above installation work for the inner right primed PUR front attachment **I**.

► Leave the car to stand for **24 hours** before removing the adhesive tape and self-tapping screws. Refer to the installation instructions on **page 2**. ◀

## 11. Installing the carbon side skirt attachment

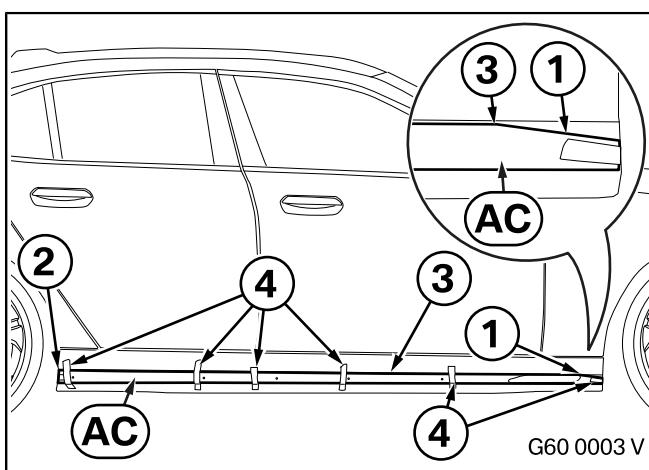
 The installation of the carbon side skirt attachment is shown on a BEV model.  
The installation work on an ICE model is identical. ◀



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

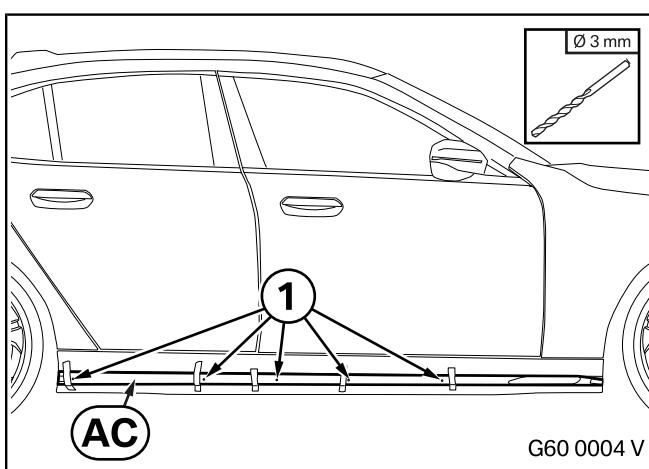
Wait until the cleaner is fully dry. ◀

Clean the bonding surface (1) on the car with cleaner **AD**.



 The template **AC** is not self-adhesive. It must be used for both sides. The angled side (1) of the template ends at the front wheel arch from the refractory edge pointing downwards. ◀

Starting at the rear wheel arch (2), align the template **AC** along the refractory edge (3) towards the front. Secure the template **AC** to the car using suitable adhesive tape (4).

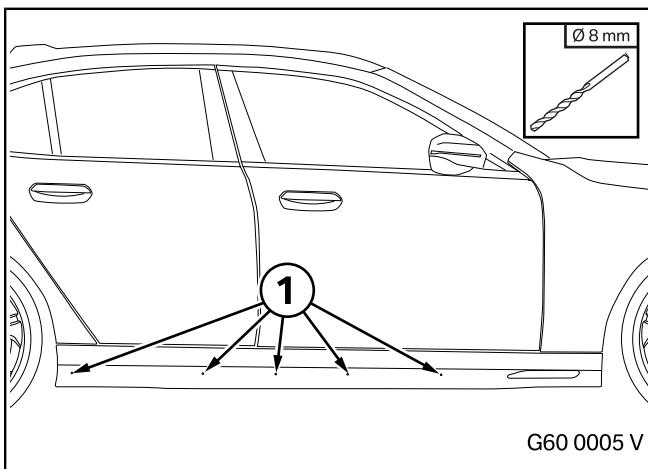


 Do not exceed the maximum drilling depth of **10 mm!** ◀

Drill the five holes on the template **AC** using a **3 mm** drill bit, ensuring that you do not exceed the drilling depth.

Then carefully remove the template **AC**, which must also be used for the other side.

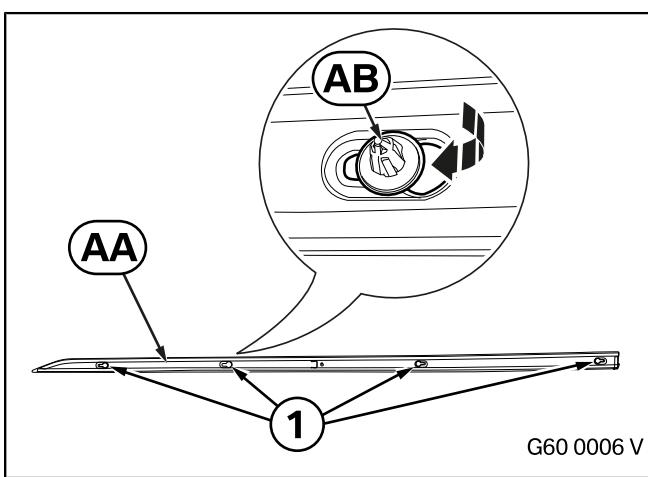
## 11. Installing the carbon side skirt attachment



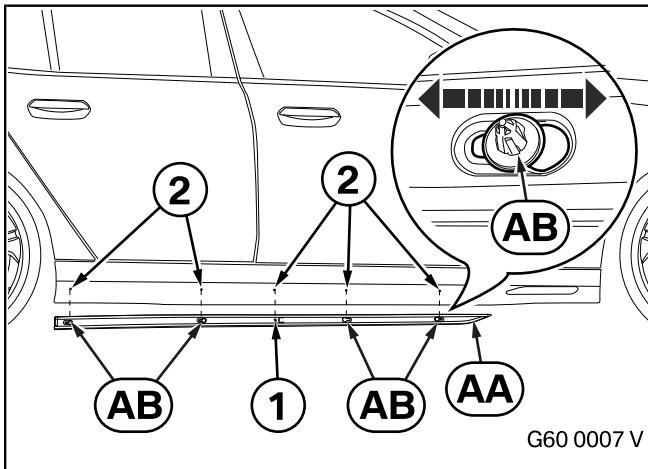
► Do not exceed the maximum drilling depth of **10 mm!** ◀

Enlarge the holes (1) to **8 mm**, ensuring that you do not exceed the drilling depth.

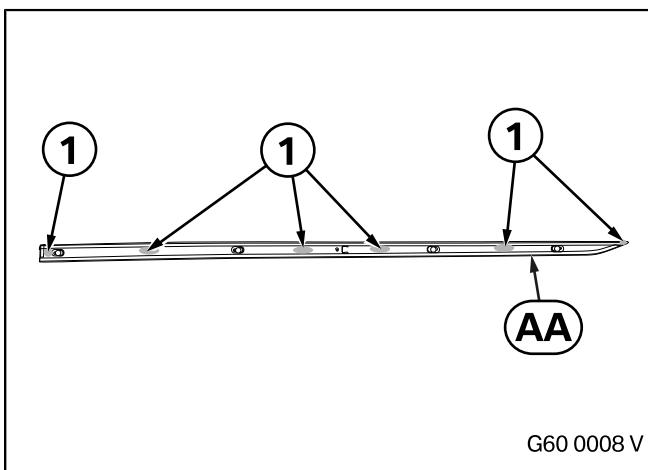
Deburr the holes (1) with suitable equipment.



Insert the clips **AB** on the rear of the carbon side skirt attachment **AA** into the oval holes (1) at the side and position them in the centre as shown.



Hold the carbon side skirt attachment **AA** on the car. Whilst holding it in position, use the pin (1) on the carbon side skirt attachment **AA** as a reference and check the position of the clips **AB**, moving them to the left or right if necessary until all the clips **AB** and the pin (1) are lined up with the holes (2).

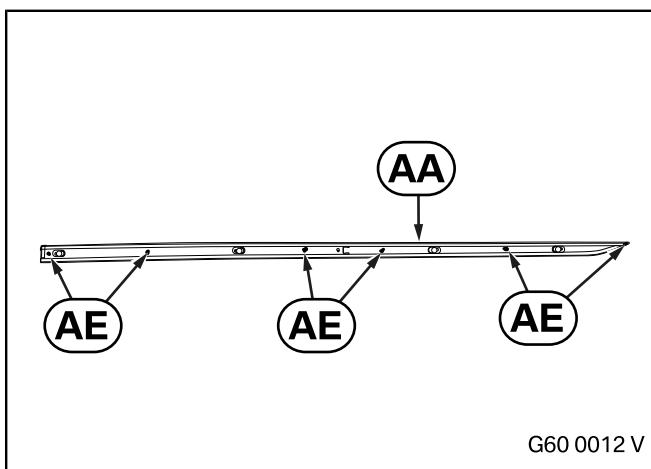


► The bonding surface (1) must be completely clean, dry and free from wax or grease.

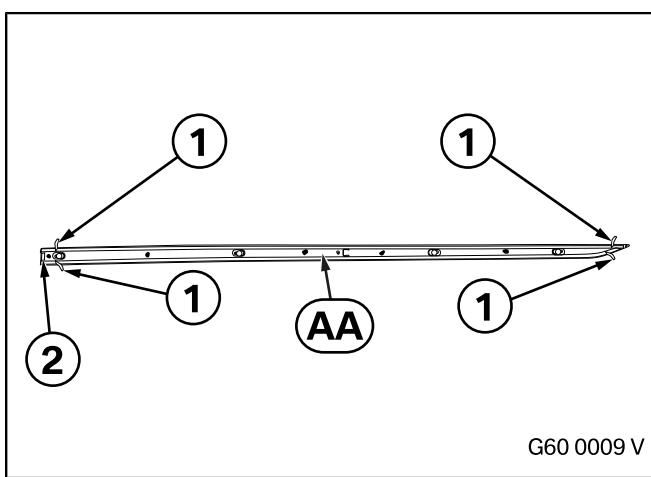
Wait until the cleaner **AD** is fully dry. ◀

Abrade the surfaces (1) on the rear of the carbon side skirt attachment **AA** using suitable equipment. Then clean them using cleaner **AD**.

## 11. Installing the carbon side skirt attachment

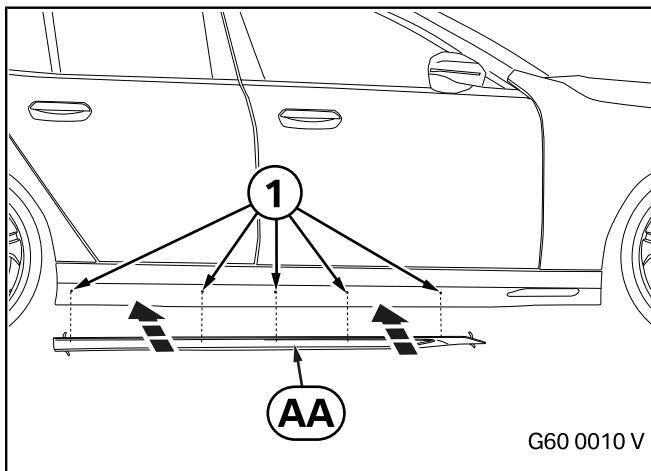


Apply the liquid adhesive **AE** in dots on the surfaces on the rear of the carbon side skirt attachment **AA** you cleaned earlier.

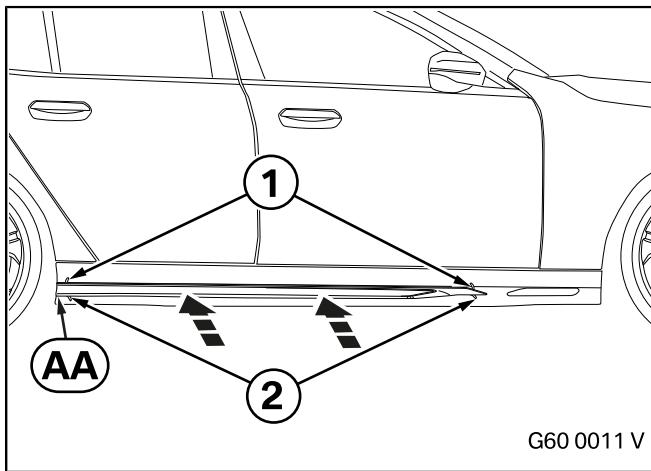


Release the four ends (1) of the backing film and bend them towards the outside.

Remove the backing film (2) from the small strip of adhesive tape in full.



Insert the carbon side skirt attachment **AA** into the holes (1) from the outside and press it onto the car.

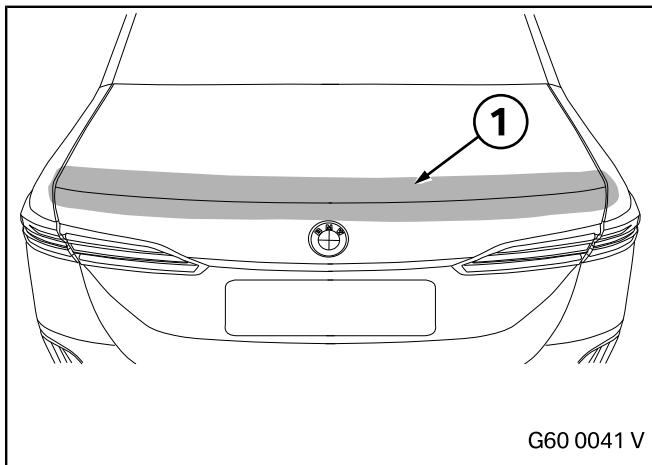


Pull the top ends of the films (1) and the bottom ends of the films (2) from the carbon side skirt attachment **AA** from the outside towards the centre.

Press the carbon side skirt attachment **AA** multiple times forcefully onto the car, checking the gap between the carbon side skirt attachment **AA** and the car as you do so, and correct it if necessary.

► If necessary, remove any excess liquid adhesive immediately using suitable tools. ◀

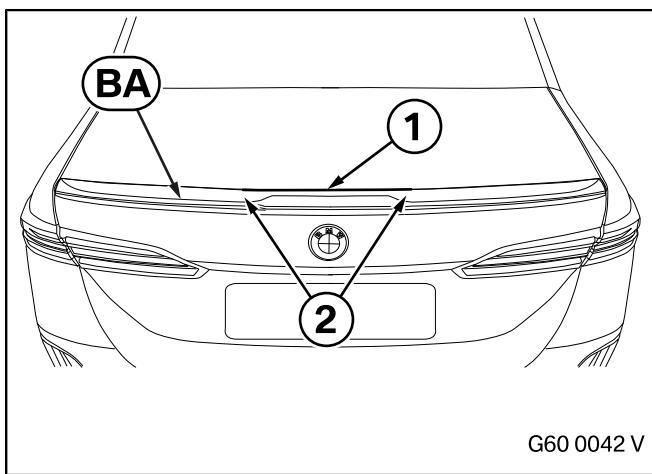
## 12. Installing the carbon rear spoiler



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

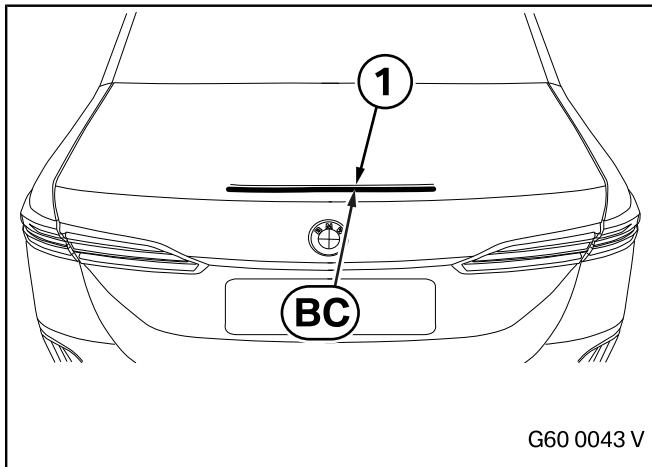
Clean the bonding surface (1) with cleaner **BB**.

► Wait until the drying time has elapsed. ◀



► Use a water-soluble pen. ◀

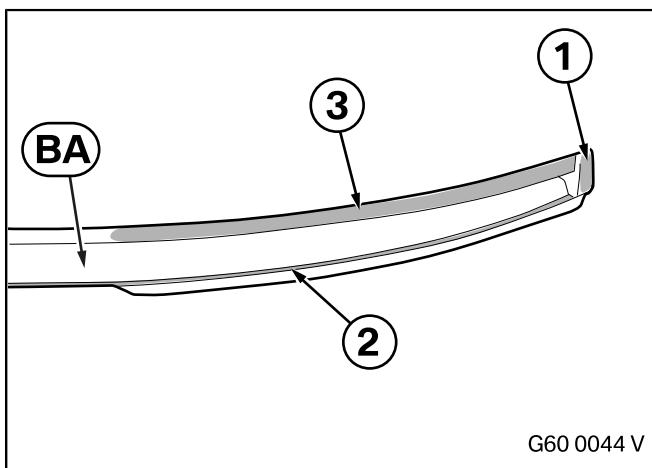
Press the carbon rear spoiler **BA** into position on the boot lid and draw round the contours (1) in the area (2) between the rear lights on the boot lid using a water-soluble pen. Then remove the carbon rear spoiler **BA**.



Apply a full strip of primer **BC** on the boot lid inside the contours (1) using suitable equipment.

► Wait for the flash-off time of the primer. ◀

After the flash-off time of the primer has elapsed, remove the contours (1) with cleaner **BB**.

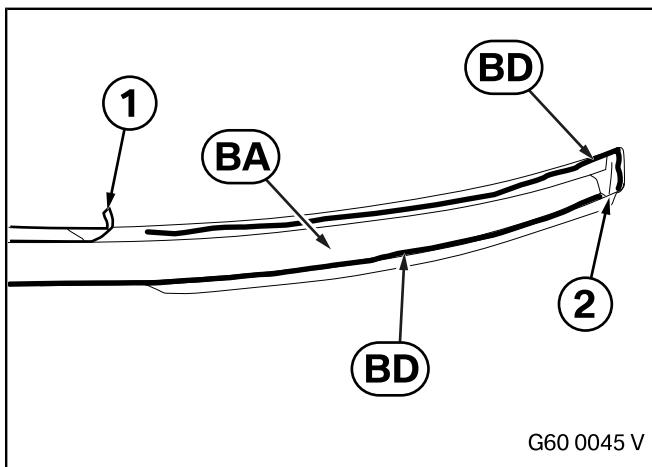


► The bonding surfaces (1), (2) and (3) must be completely clean, dry and free from wax or grease. ◀

Abrade the surfaces (1) on the sides, the surfaces (2) in the groove and the surfaces (3) on the inside of the carbon rear spoiler **BA** using suitable equipment and then clean them with cleaner **BB**.

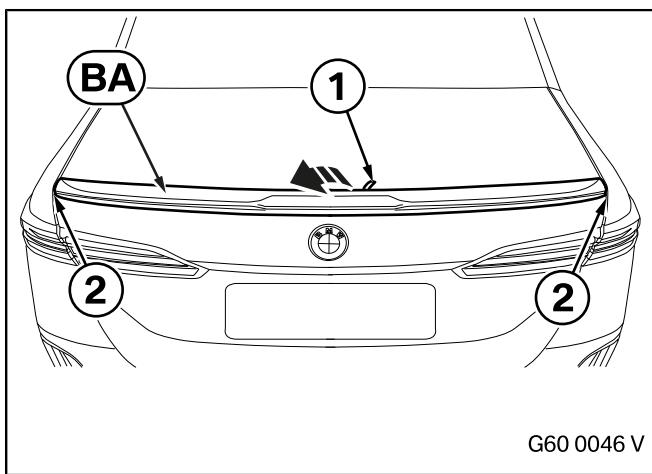
► Wait until the cleaner is fully dry. ◀

## 12. Installing the carbon rear spoiler



Partly pull off the end (1) of the backing film and bend it outwards so that it can easily be gripped later during the installation work.

Apply a bead of liquid adhesive **BD** to the cleaned surfaces. Do not apply any liquid adhesive **BD** to the corner (2), so that any water that gets in later can escape if necessary.



► It must be possible to grip the end (1) of the backing film after the component has been positioned. ◀

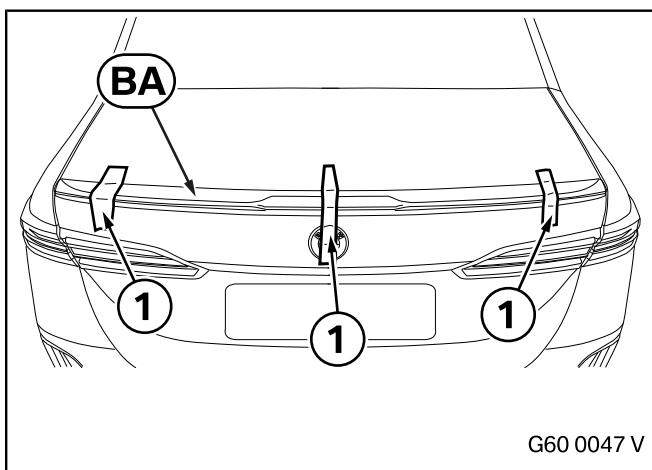
Align the carbon rear spoiler **BA** in the centre between the edges (2) of the boot lid and place it in the installation position.

Pull out the end of the backing film (1) to the side and press the carbon rear spoiler **BA** multiple times forcefully on to the boot lid until it bonds to the boot lid.

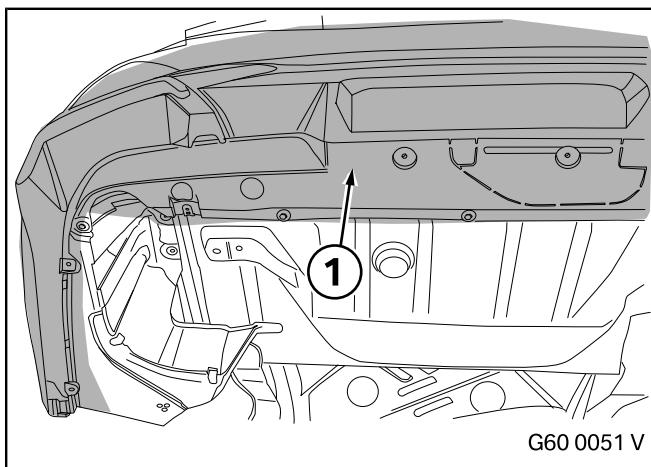
► Remove any excess liquid adhesive **BD** immediately using suitable tools. ◀

Secure the carbon rear spoiler **BA** using suitable adhesive tape (1) in multiple places.

► Leave the car to stand for **24 hours** before removing the adhesive tape and refer to the installation instructions on **page 2**. ◀



## 13. Carbon rear diffuser installation

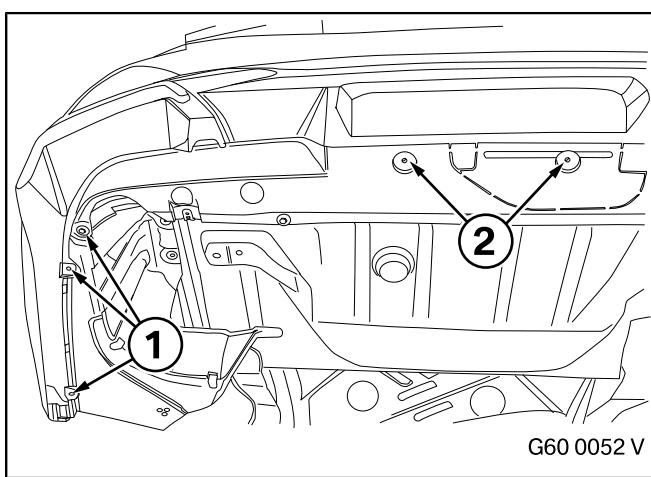


### Installing the carbon left/right rear diffuser

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

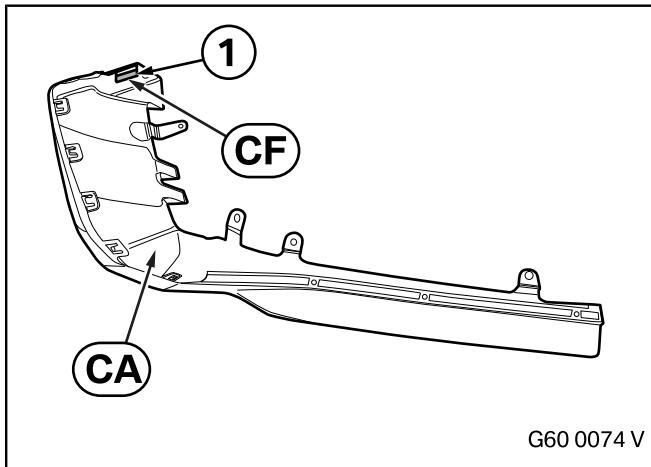
Wait until the cleaner is fully dry. ◀

Clean the top and outside surface (1) of the rear trim with cleaner **CE**.



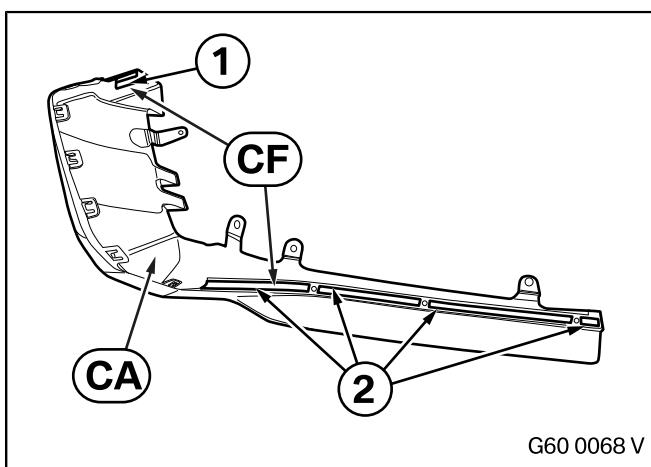
Remove the screws (1) on the left and right of the car, they will be reused.

Remove the screws (2) in the centre of the car, they will be reused.



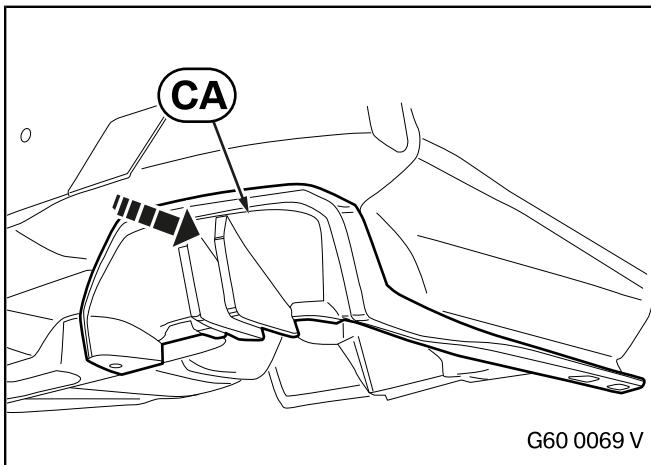
Abrade and clean the surface (1) near the adhesive tape using suitable equipment. Then prime it using primer **CF**.

► Wait for the flash-off time of the primer **CF**. ◀



Apply primer **CF** to the backing films (1) and (2) of the adhesive tapes using suitable equipment.

### 13. Carbon rear diffuser installation

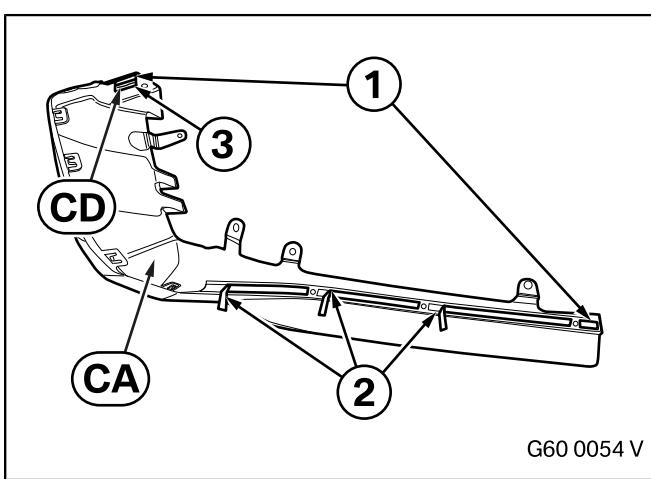


► The primer must not come into contact with the rear trim during installation until it is in its installation position. ◀

Hold the carbon left/right rear diffuser **CA** from behind in the installation position on the rear trim and press the areas (1) of the primer so that the primer **CF** is transferred to the rear trim.

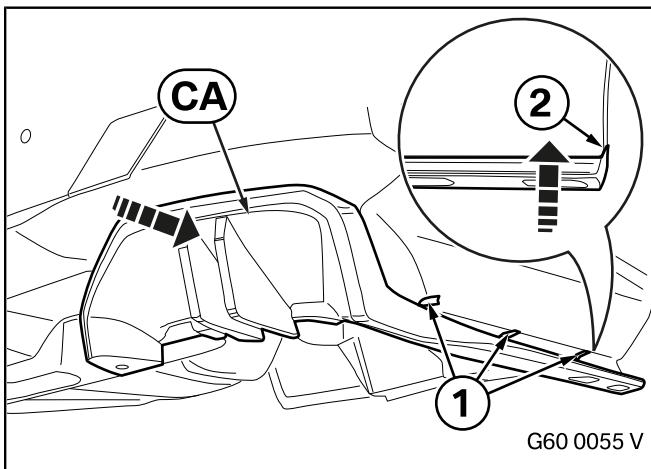
Then remove the carbon left/right rear diffuser **CA**.

Draw round the contours on the rear trim with primer **CF** using suitable equipment.



Completely remove the adhesive tape backing film (1) from the carbon left/right rear diffuser **CA**. Bend one end of the backing films (2) towards the outside as shown.

Apply a line of liquid adhesive **CD** to the surface (3).

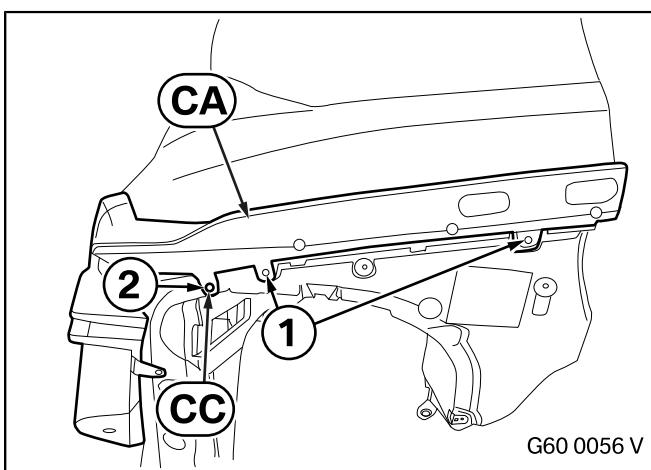


► During the installation, ensure that the ends of the backing files (1) are bent outwards and visible. ◀

Slide the carbon left/right rear diffuser **CA** from the rear into the installation position, pushing the narrow end (2) away with the adhesive tape so that it is not in contact with the rear trim.

Check the edge (2), it must finish flush with the wheel arch edge. Then push the end upwards.

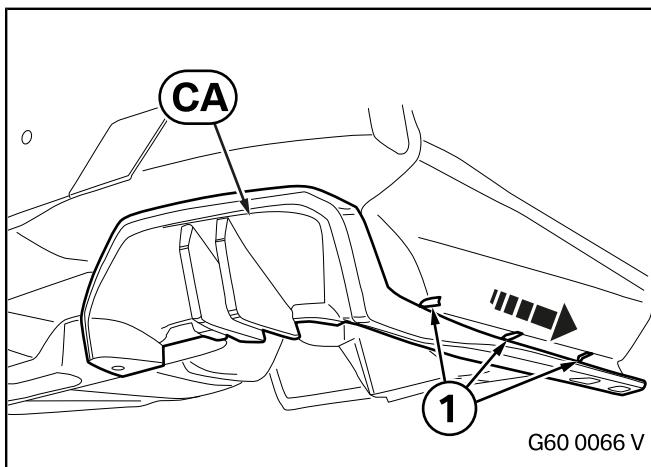
► Remove any excess liquid adhesive immediately using suitable tools. ◀



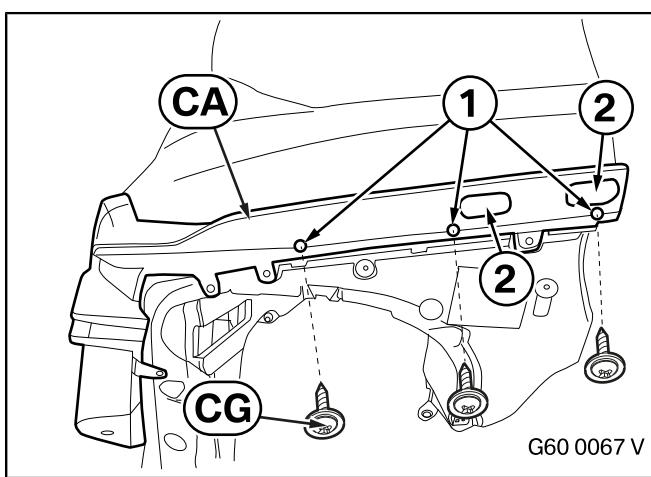
Secure the carbon rear diffuser **CA** using the existing screws (1).

Use the expanding rivet **CC** for the hole (2).

## 13. Carbon rear diffuser installation

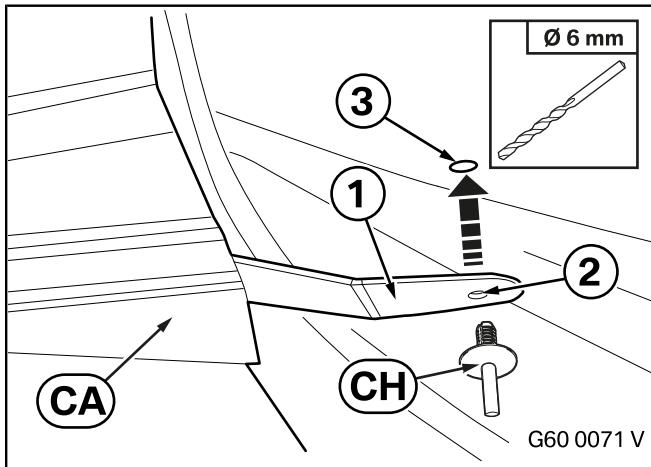


Pull out the ends of the backing films (1) and press the carbon left/right rear diffuser **CA** onto the rear trim until the carbon left/right rear diffuser **CA** bonds flush on the rear trim.



Screw the three fillister head screws **CG** from below through the holes (1) into the rear trim.

Press the carbon left/right rear diffuser **CA** onto the car trim through the openings (2) using suitable equipment until no gap can be seen between the carbon left/right rear diffuser **CA** and the car trim.



### For BEVs

The lug (1) must be pressed towards the rear trim.

### For ICE cars

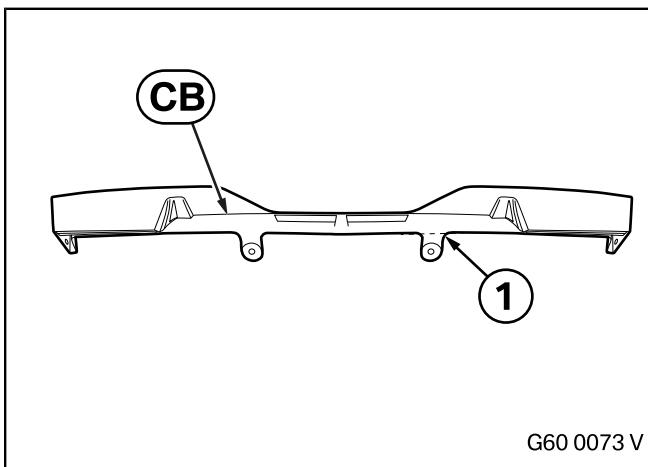
The lug (1) should be on the rear trim.

### For all cars

Drill a **6 mm** hole (3) in the rear trim through the hole (2) in the lug (1).

Insert the expanding rivet **CH** through the hole (2) in the lug (1) on the carbon left/right rear diffuser **CA** from beneath into the hole (3) and press it into place to secure it.

## 13. Carbon rear diffuser installation

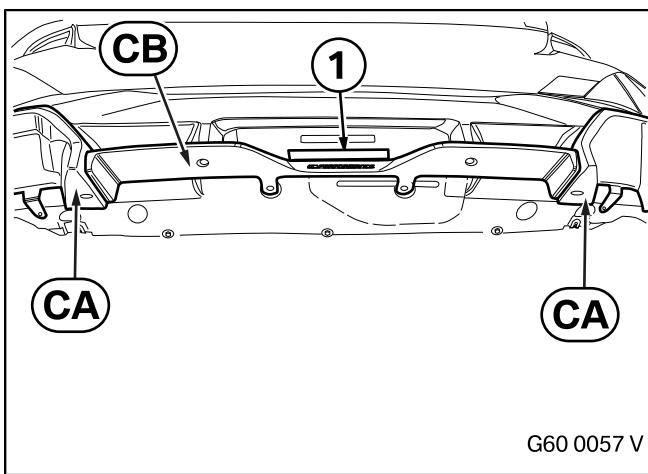


### Installing the carbon centre rear diffuser (for all cars)

► The lug (1) must be removed if a trailer tow hitch is installed. ◀

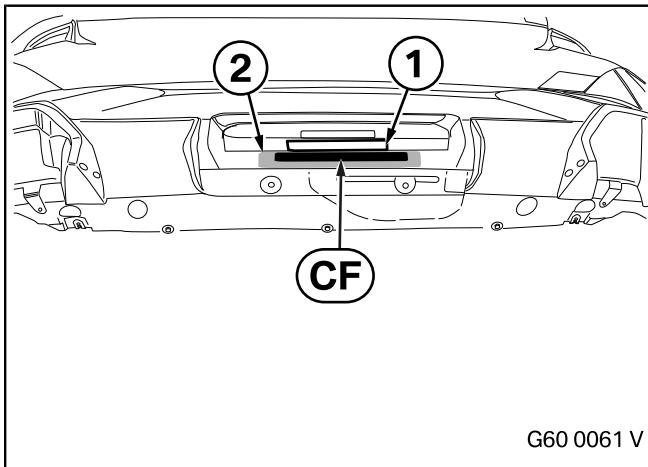
Cut the lug (1) off the carbon centre rear diffuser **CB** flush using suitable equipment.

Treat the cut area with clearcoat.



Hold the carbon centre rear diffuser **CB** between the two carbon rear diffusers left/right **CA** in the installation position on the rear trim and secure adhesive tape (1) to the top edge of the carbon centre rear diffuser **CB** on the rear trim.

Then remove the carbon centre rear diffuser **CB** again.

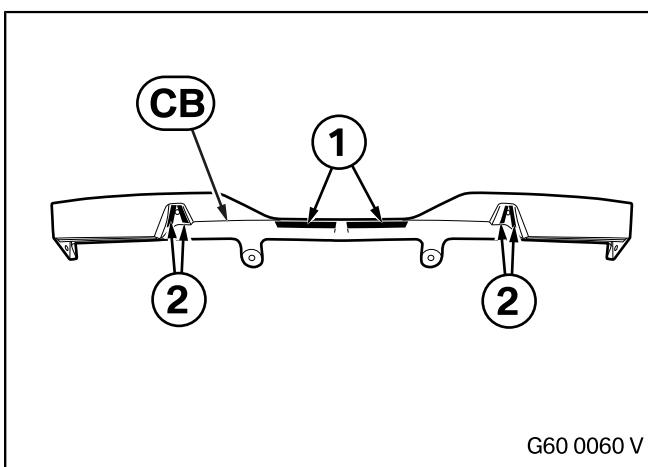


► Only apply primer underneath the adhesive tape (1).

Wait for the flash-off time of the primer **CF**. ◀

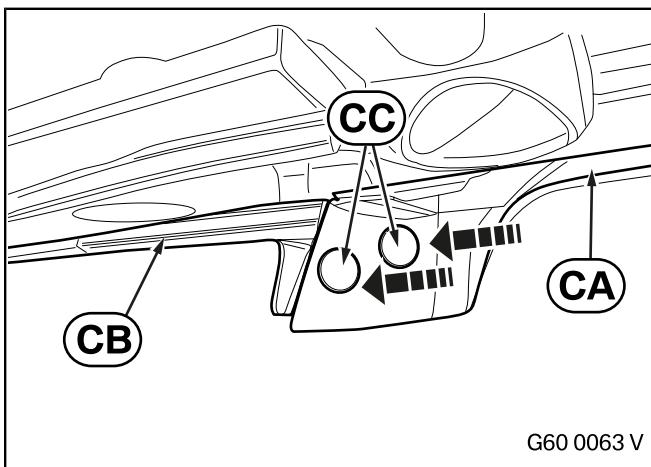
Prime the surface (2) of the carbon centre rear diffuser **CB** below the adhesive tape (1) using primer **CF**.

Remove the adhesive tape (1) after the flash-off time has elapsed.

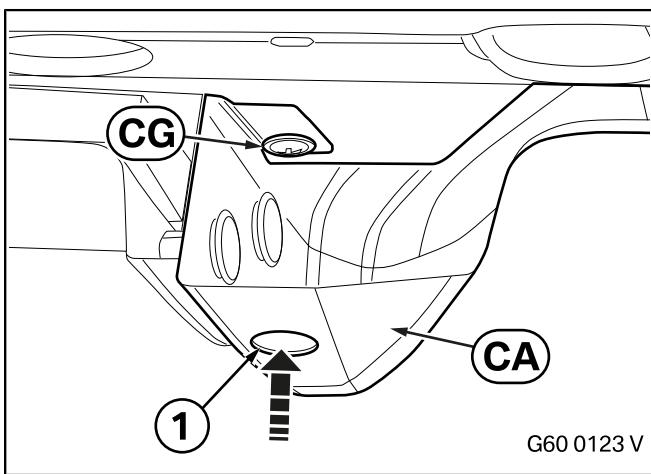


Completely remove the adhesive tape backing films (1) and (2) from the carbon centre rear diffuser **CB**.

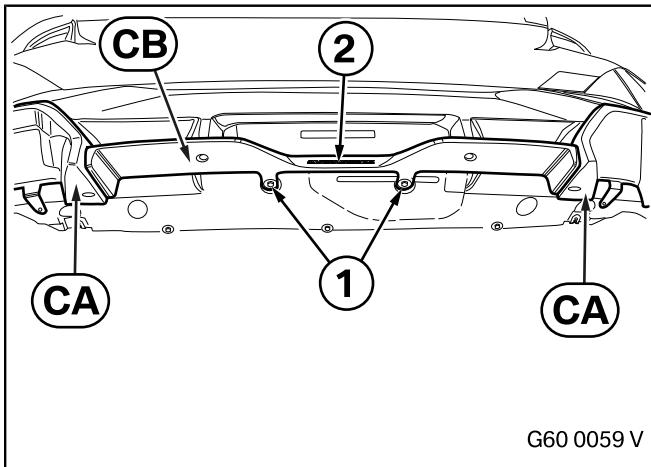
### 13. Carbon rear diffuser installation



Insert the two expanding rivets **CC** through the holes in the carbon left/right rear diffuser **CA** and secure the carbon centre rear diffuser **CB** to the carbon left/right rear diffuser **CA**.

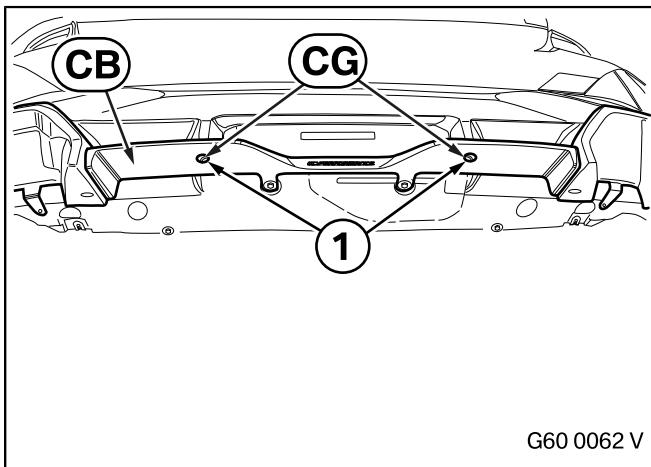


Insert an oval-head screw **CG** through the hole (1) in the carbon left/right rear diffuser **CA** and tighten it.



Move the carbon centre rear diffuser **CB** into position between the two carbon rear diffusers left/right **CA** and secure it with the two existing screws (1).

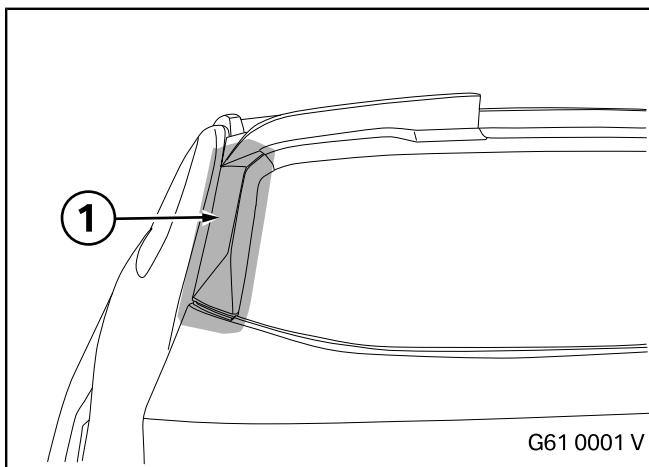
Press on area (2) multiple times to bond the adhesive tape to the rear trim.



Screw the two fillister head screws **CG** from below through the holes (1) in the carbon centre rear diffuser **CB** into the rear trim.

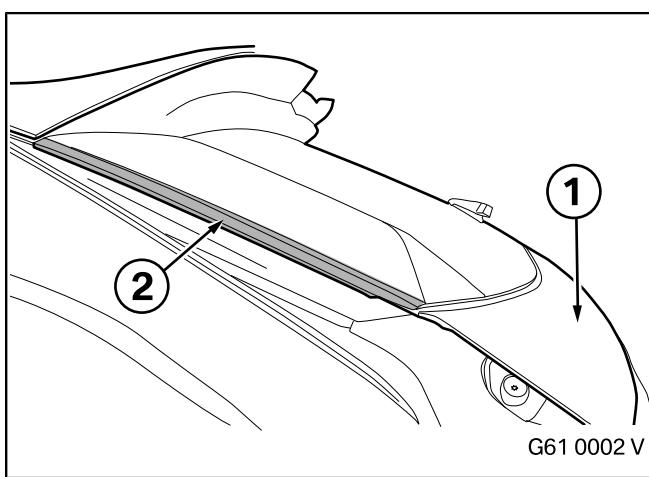
Leave the car to stand for **24 hours** and refer to the installation instructions on **page 2**. ▲

## 14. Carbon tail fin installation



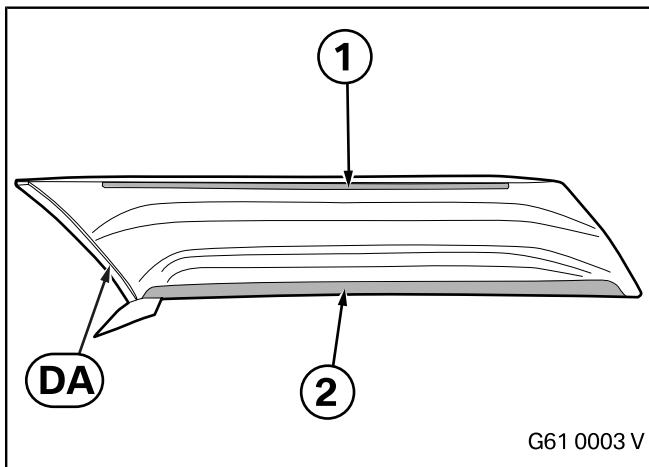
► The bonding surfaces (1) must be completely dry, clean and free of wax or grease. ◀

Clean the surface (1) of the standard tail fin with cleaner **DC**.



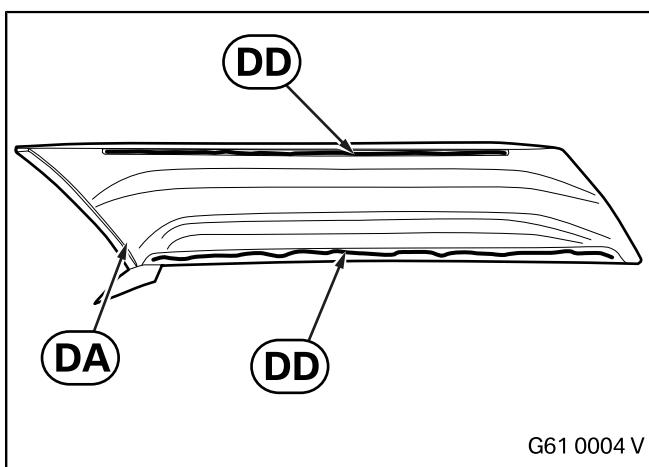
Open the tailgate (1) a little and also clean the concealed side area (2) of the standard tail fin with cleaner **DC**.

► Wait until the cleaner **DC** is fully dry. ◀



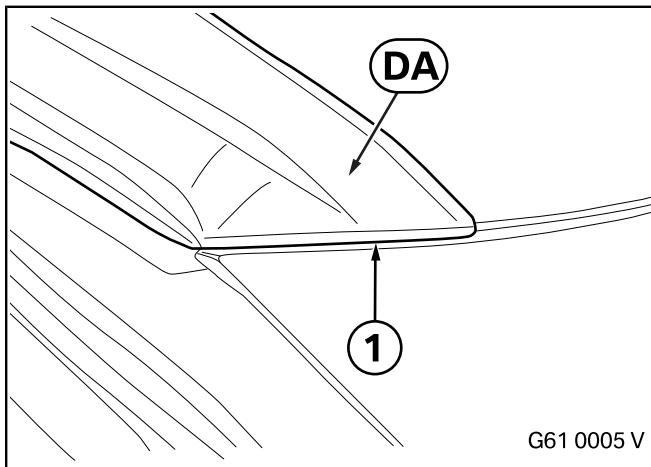
Abrade the two surfaces (1) and (2) on the inside of the left carbon tail fin **DA** using suitable tools and clean them with cleaner **DC**.

► Wait until the cleaner **DC** is fully dry. ◀

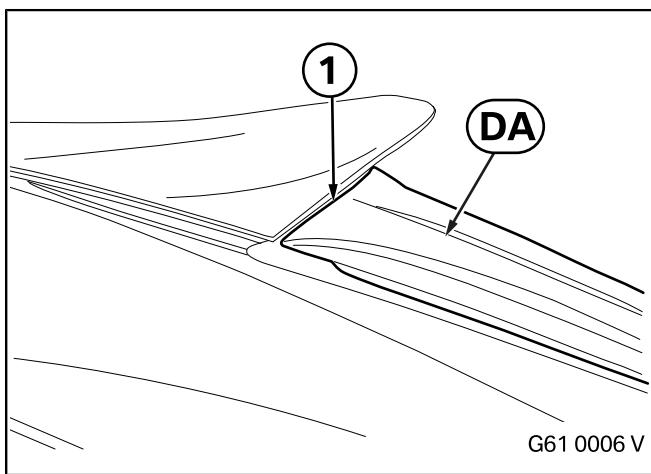


Apply a bead of liquid adhesive **DD** to the surfaces you have just cleaned.

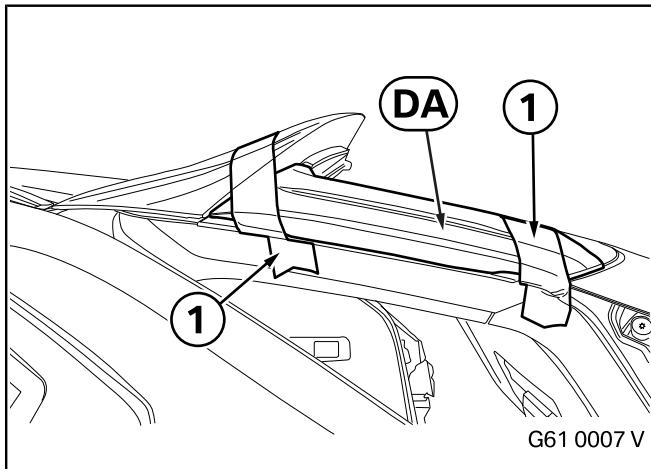
## 14. Carbon tail fin installation



Position the left carbon tail fin **DA** flush on the standard tail fin, starting from the bottom edge (1).



Check the position of the left carbon tail fin **DA** at the top end (1) and correct it if necessary.

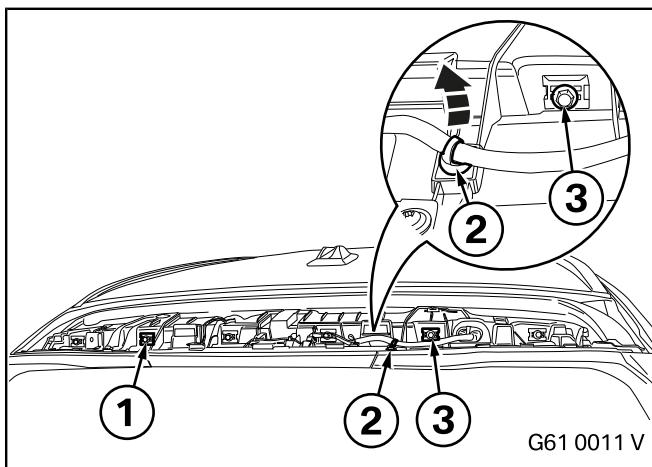


Secure the left carbon tail fin **DA** at the top and bottom using suitable adhesive tape (1).

► Remove any excess liquid adhesive immediately using suitable tools.

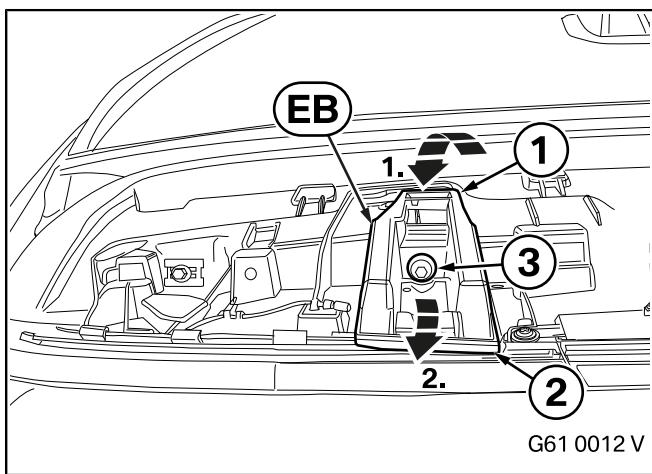
Leave the car to stand for **24 hours** before removing the adhesive tapes. Refer to the installation instructions on **page 2**. ▲

## 15. Black high gloss roof edge spoiler installation

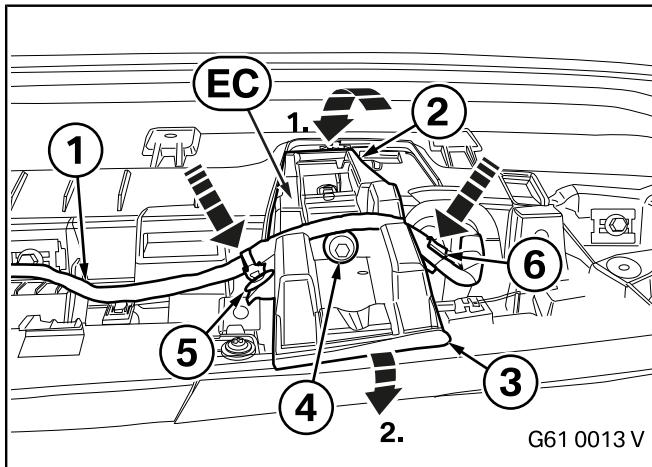


Remove screw (1) on the left side of the car and keep it safe. Screw (1) will be reused.

Remove cable holder (2) on the right side of the car using suitable equipment. Remove screw (3) on the right side of the car and keep it safe. Screw (3) will be reused.



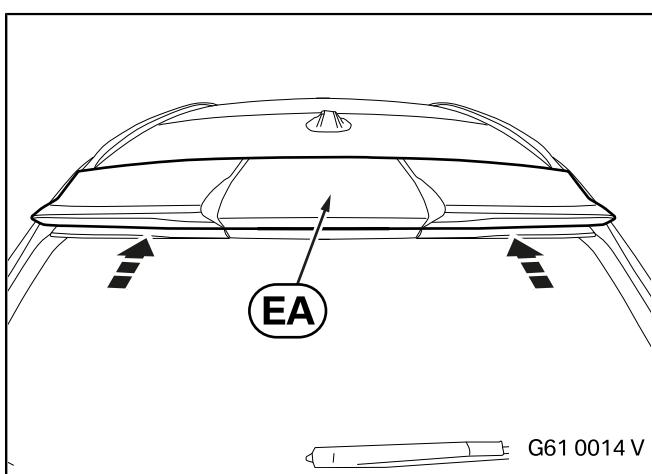
On the left side of the car, position the left adapter **EB** first on edge (1) and then on edge (2). Then secure it using existing screw (3).



► Bend cable (1) to the side during the installation. ◀

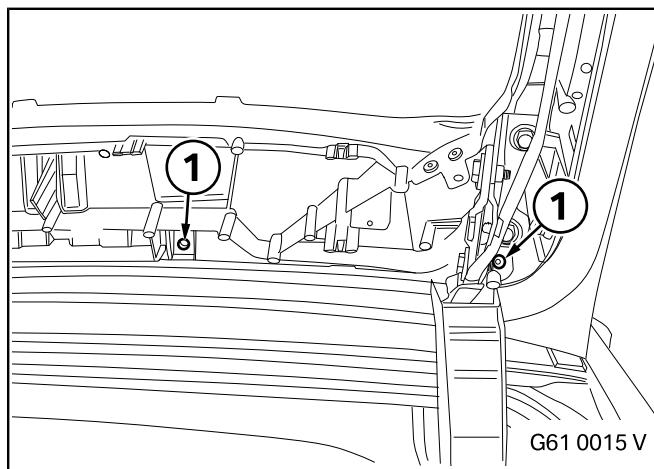
On the right side of the car, position the right adapter **EC** first on edge (2) and then on edge (3). Then secure it using existing screw (4).

Allow cable holder (5) to engage with the matching opening on the right adapter **EC**. Clip cable (1) into holder (6).



Slide black high gloss roof edge spoiler **EA** onto the car from the rear.

## 15. Black high gloss roof edge spoiler installation



► For greater clarity, only the right side of the car is shown. Proceed accordingly on the left side of the car.◀

Secure roof edge spoiler **EA** on the inside of the tailgate using the **four** existing screws (1).

Then install the tailgate trim as described in **ISTA/AIR**.

## 16. Concluding work and coding

The retrofit system does not require programming/coding.