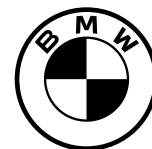


Original BMW Parts and Accessories. Installation Instructions.



M Performance Carbon Exterior Components Retrofit Kit. BMW M2 (G87)

Retrofit kit number

Number	Component designation	Installation time (h)	Installation as described in ISTA/AIR*
51 11 5A5F445	Carbon centre front attachment	0.20	-
51 11 5A5F481	Carbon left front attachment	0.40	-
51 11 5A5F482	Carbon right front attachment	0.40	-
51 11 5A44F42	Carbon right brake air inlet trim	0.25	-
51 11 5A44F43	Carbon left brake air inlet trim	0.25	-
51 13 5A649E3	Front left side panel finisher	0.25	-
51 13 5A649E4	Front right side panel finisher	0.25	-
51 19 5A44DE2	Carbon right-side skirt attachment	0.37	-
51 19 5A44DE7	Carbon left-side skirt attachment	0.37	-
51 13 5A64A11	Rear left side panel finisher	0.25	-
51 13 5A64A12	Rear right side panel finisher	0.25	-
65 20 5A59AD9	Aramid antenna cover (see EBA 01 29 5A5C9E3 for installation instructions)	0.50	-
51 62 5A63C67	Black high gloss roof edge spoiler	0.25	-
51 19 5A51348	Carbon rear spoiler US (see EBA 01 29 5A42518 for installation instructions)	0.75/1.00**	-
51 62 5A63C65	Carbon throughflow rear spoiler (Clubsport)	2.00**	-
51 62 5B33F50	Carbon throughflow rear spoiler (Clubsport)	2.00**	-
51 12 5A66161	Carbon left rear attachment	0.25	-
51 12 5A66162	Carbon right rear attachment	0.25	-
51 12 5A46B54	Carbon rear diffuser (MPP exhaust system) (see EBA 01 29 5A0DB45 for installation instructions)	-	-
51 12 5A46B51	Carbon rear diffuser	-	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.

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 (electronic parts catalogue).

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 and 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 cars; proceed in the same way on RHD cars.

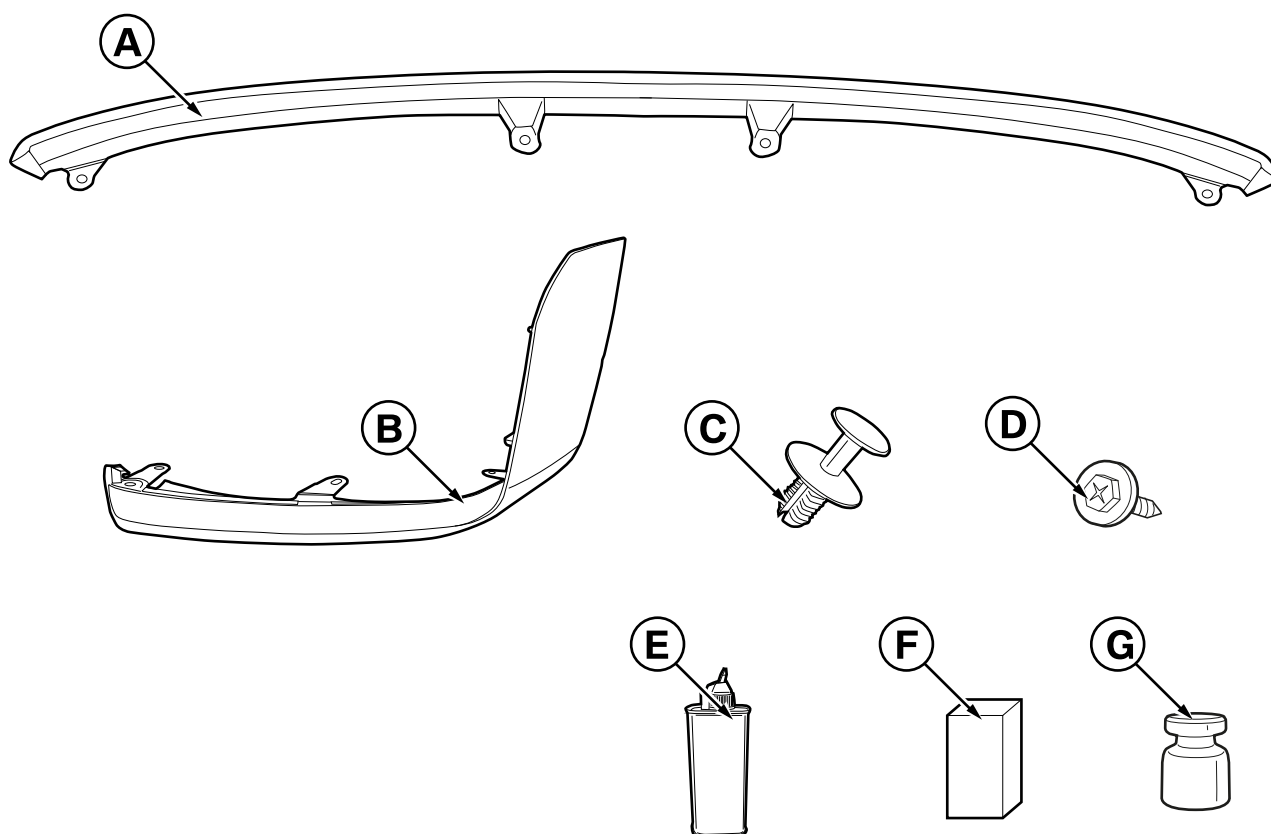
Special tools required

- None

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1. Carbon front attachment parts list

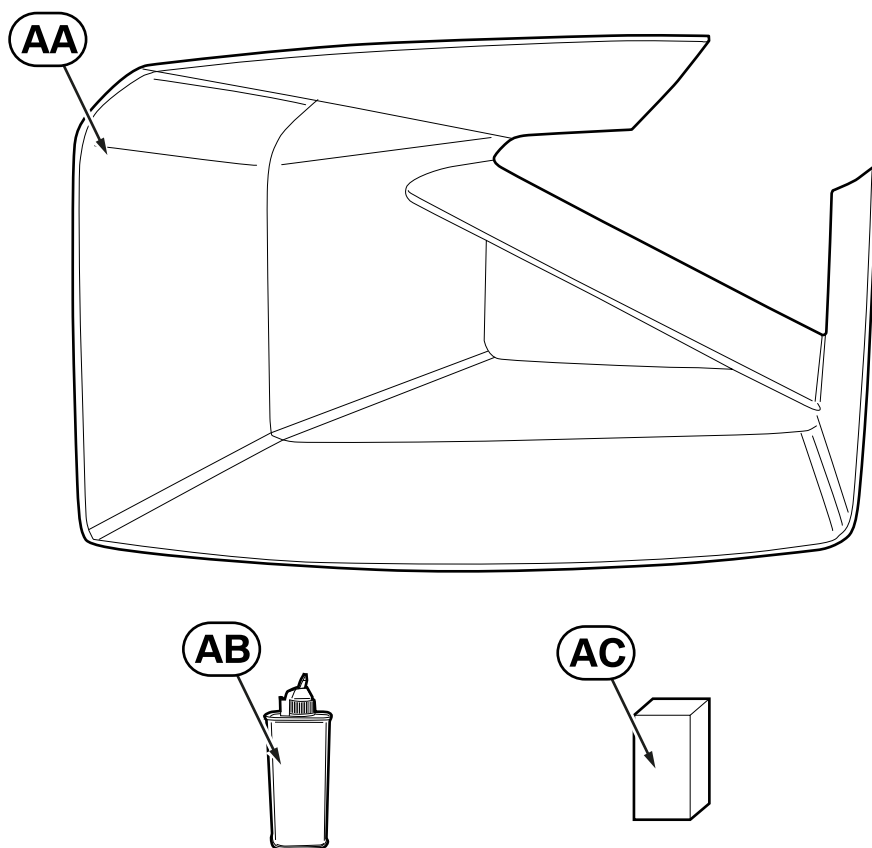


G87 0040 V

Legend

- A** Carbon centre front attachment
- B** Carbon front attachment, left/right (left side shown)
- C** Expanding rivet (1 x, part number 51 47 1 911 992)
- D** Screw (2 x)
- E** Cleaner (not included in kit, see EPC for details)
- F** Liquid adhesive (not included in kit, see EPC for details)
- G** Primer (not included in kit, see EPC for details)

2. Carbon brake air inlet trim parts list

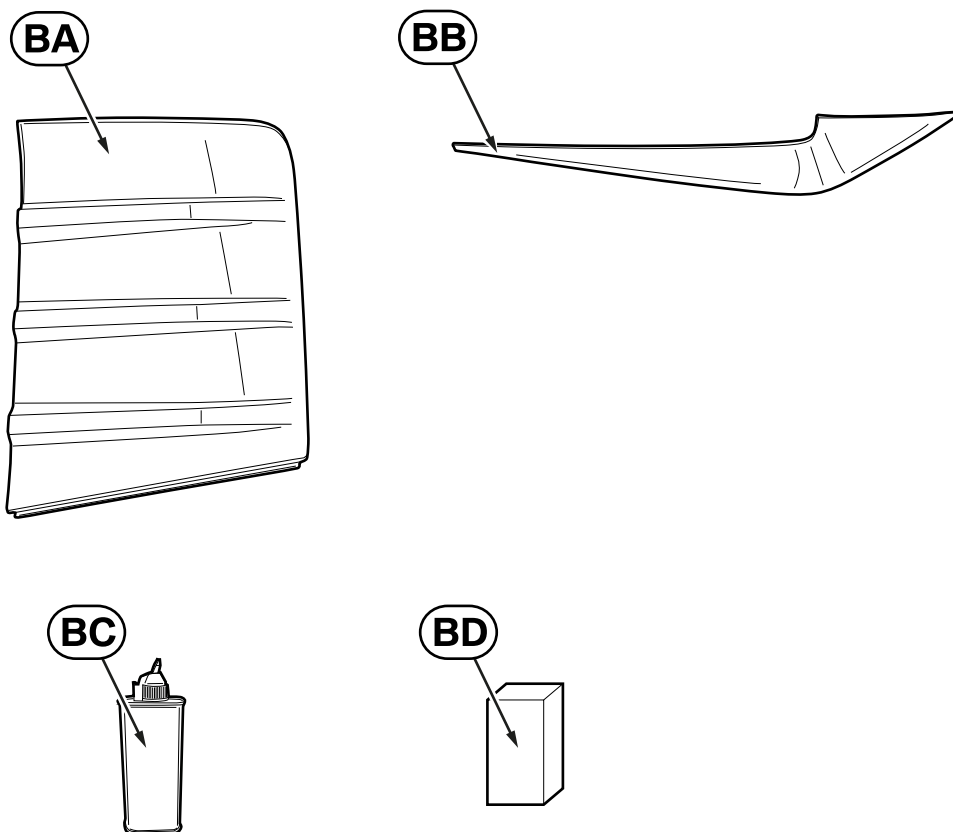


G87 0060 V

Legend

- AA** Carbon brake air inlet trim, left/right (left side shown)
- AB** Cleaner (not included in kit, see EPC for details)
- AC** Liquid adhesive (not included in kit, see EPC for details)

3. Carbon rear attachment parts list

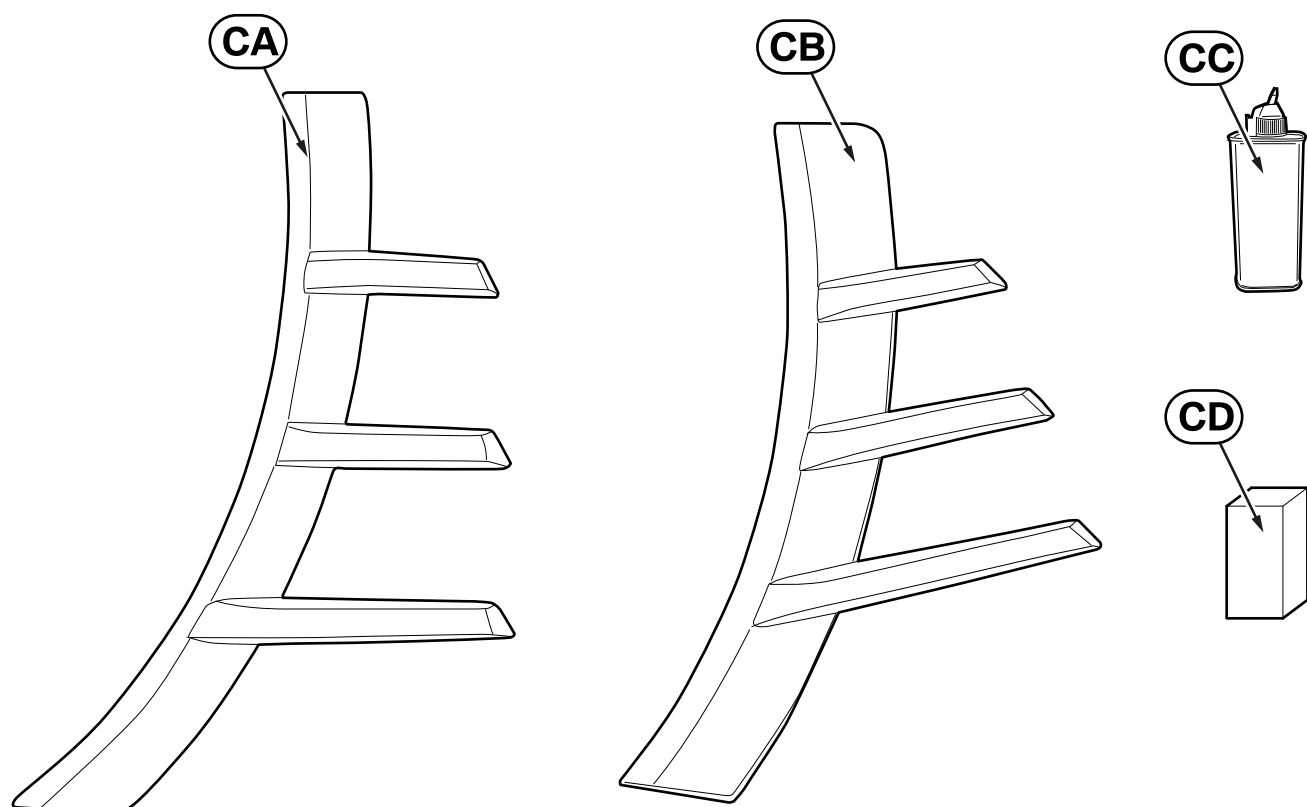


G87 0020 V

Legend

- BA** Carbon top rear attachment, left/right (left side shown)
- BB** Carbon bottom rear attachment, left/right (left side shown)
- BC** Cleaner (not included in kit, see EPC for details)
- BD** Liquid adhesive (not included in kit, see EPC for details)

4. Front/rear side panel finisher parts list

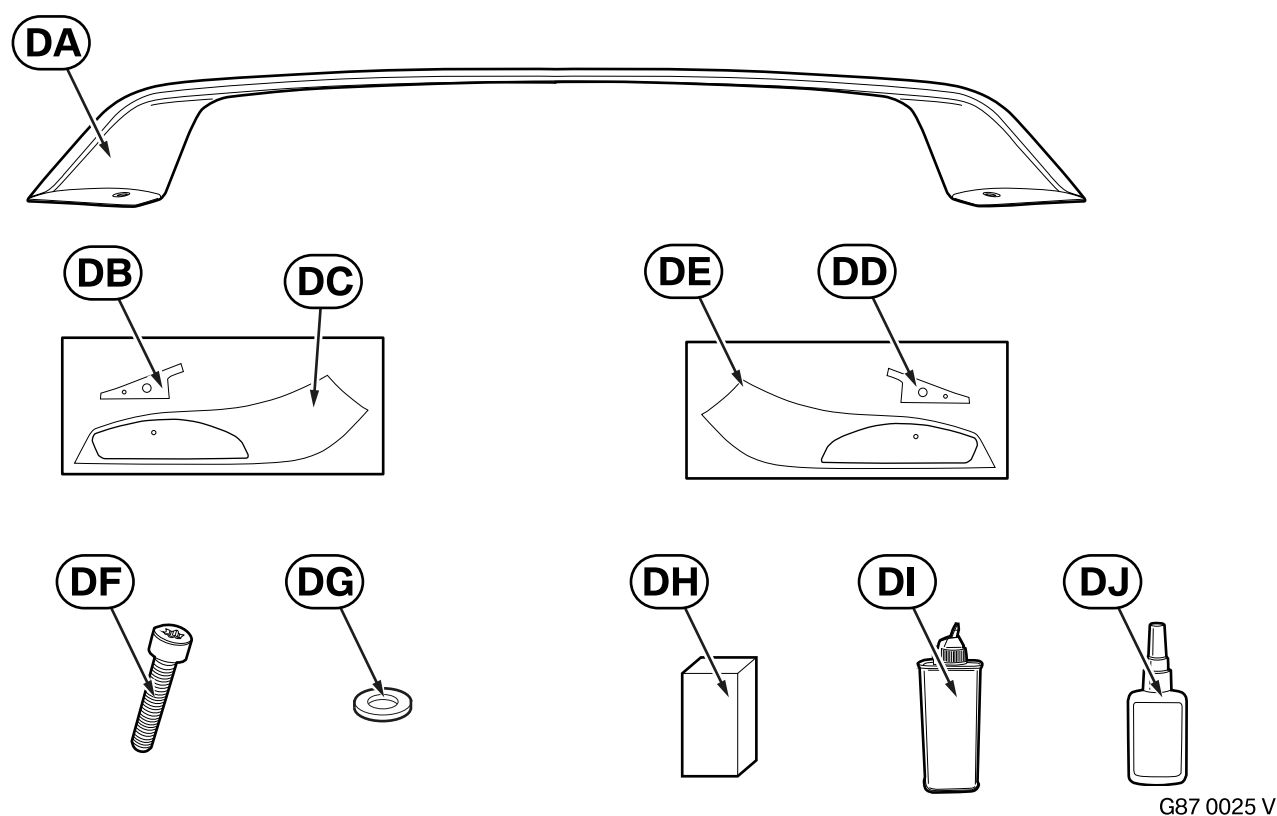


G87 0001 V

Legend

- CA** Front side panel finisher, left/right (left side shown)
- CB** Rear side panel finisher, left/right (left side shown)
- CC** Cleaner (not included in kit, see EPC for details)
- CD** Liquid adhesive (not included in kit, see EPC for details)

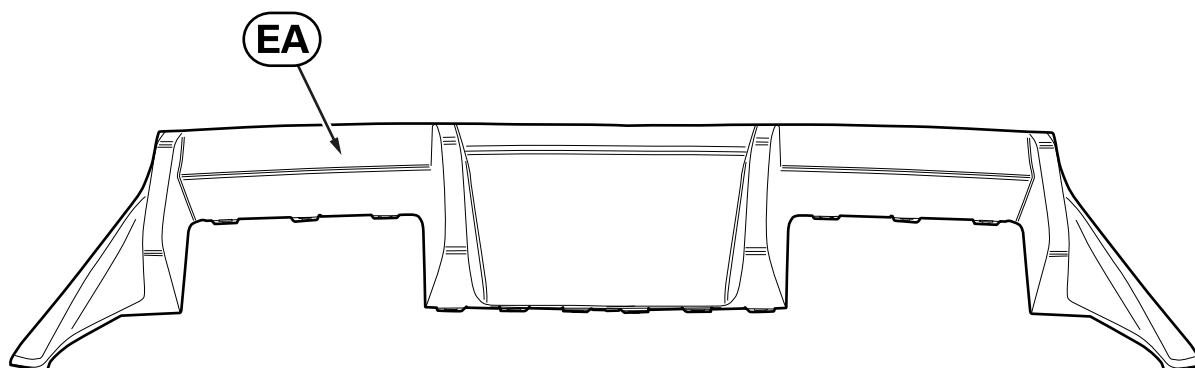
5. Carbon throughflow rear spoiler (Clubsport) parts list



Legend

- DA** Carbon throughflow rear spoiler
- DB** Right inner template
- DC** Right outer template
- DD** Left inner 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. Carbon rear diffuser parts list

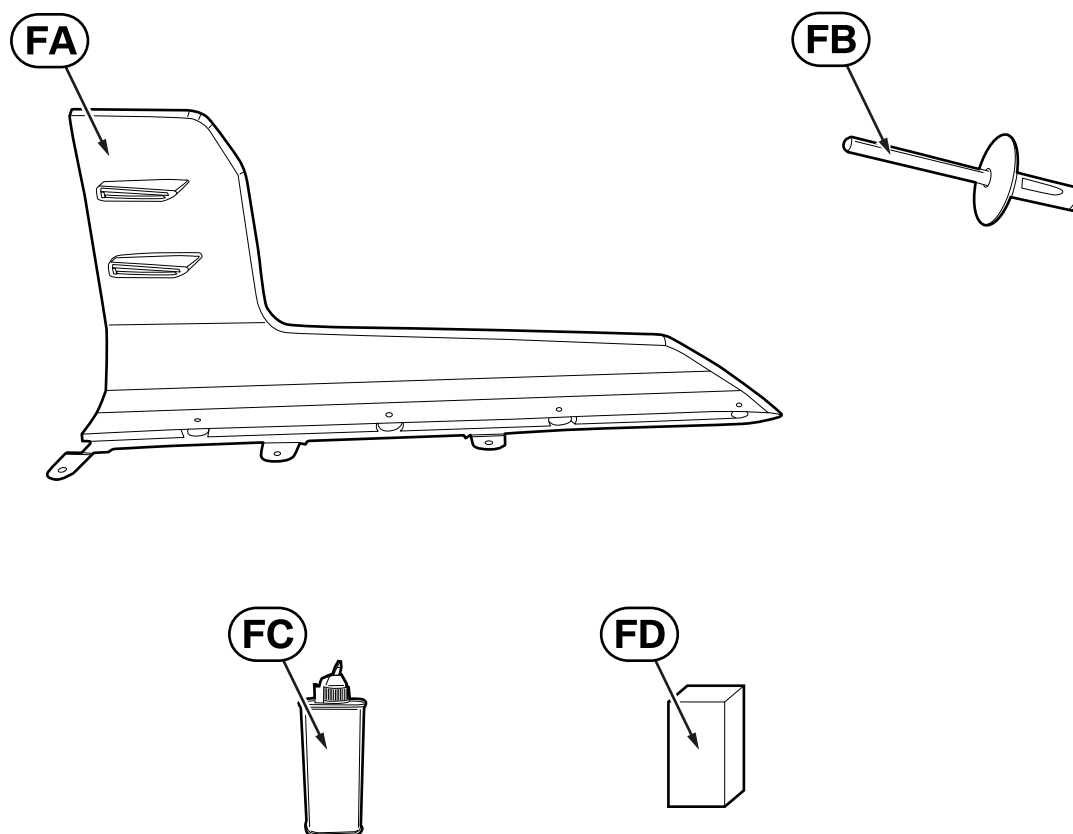


G87 0010 V

Legend

EA Carbon rear diffuser

7. Carbon side skirt attachment parts list

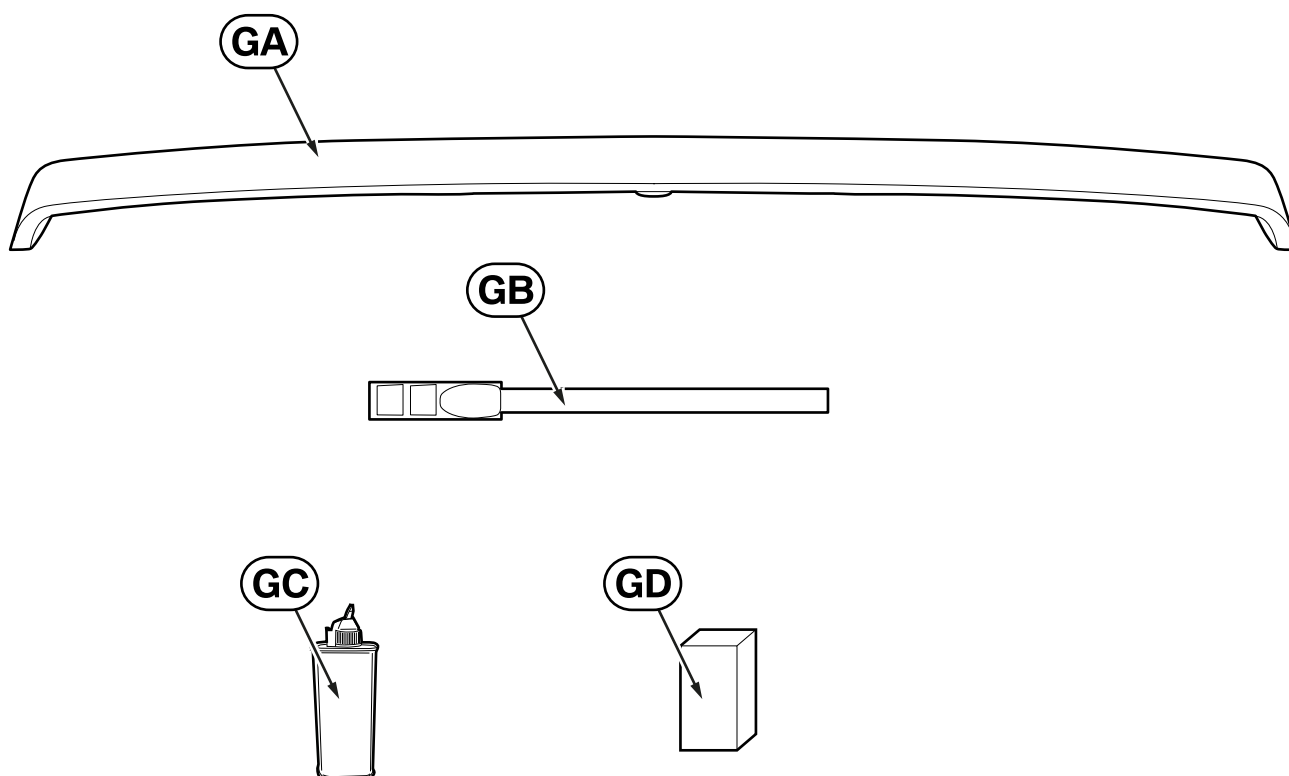


G87 0070 V

Legend

- FA** Carbon side skirt attachment, left/right (left side shown)
- FB** Expanding rivet (4 x, Part No. 51 77 7 171 004)
- FC** Cleaner (not included in kit, see EPC for details)
- FD** Liquid adhesive (not included in kit, see EPC for details)

8. Black high gloss roof edge spoiler parts list



G87 0055 V

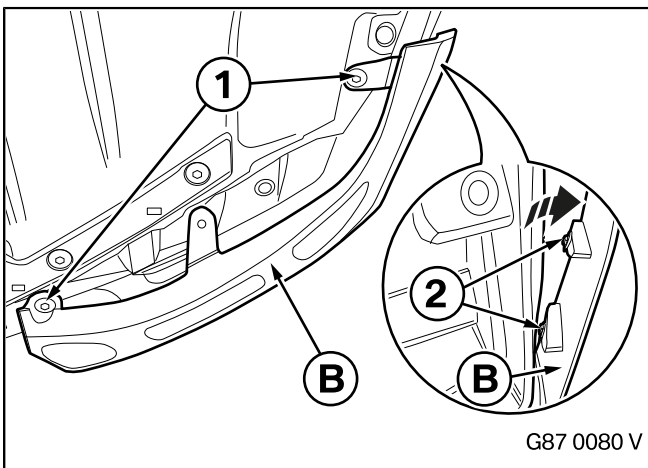
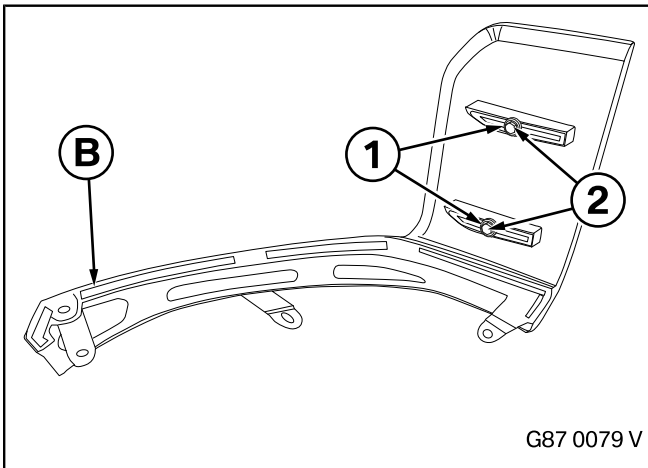
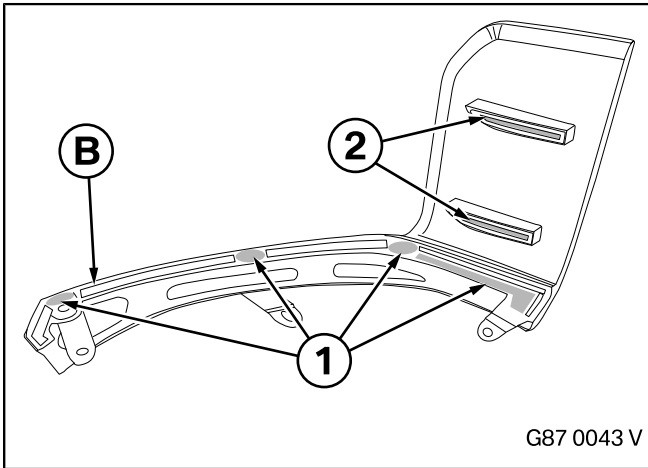
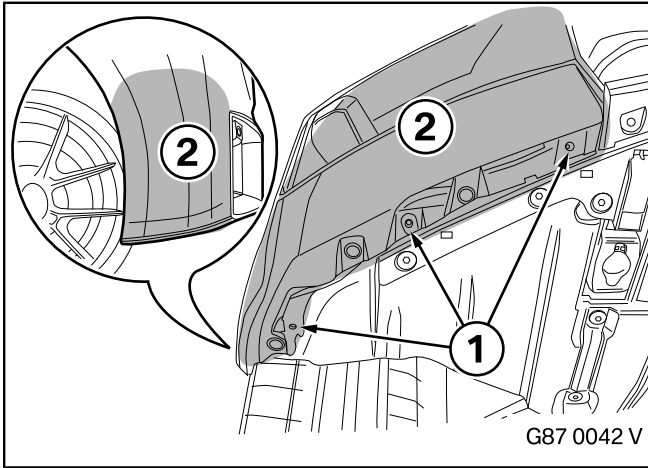
Legend

- GA** Black high gloss roof edge spoiler
- GB** Backing film with adhesive pads
- GC** Cleaner (not included in kit, see EPC for details)
- GD** Liquid adhesive (not included in kit, see EPC for details)

9. Preparations

	ISTA/AIR No.
The following components must be removed/replaced first of all	
For installing the carbon throughflow rear spoiler only	
<ul style="list-style-type: none">– Remove the standard gurney– Remove the standard tailgate gas pressure springs and replace them with the tailgate gas springs (Part No. 41 00 9 641 758, see EPC for details).	

10. Carbon front attachment installation



Carbon left/right front attachment installation

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

Wait for the drying time of the cleaner.

The screws will be reused. ◀

Remove the three screws (1).

Clean the top and outside surfaces (2) of the front trim with cleaner **E**.

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

Wait for the drying time of the cleaner. ◀

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

Also abrade the bonding surfaces (2) within the adhesive tape using suitable tools and then clean them with cleaner **E**.

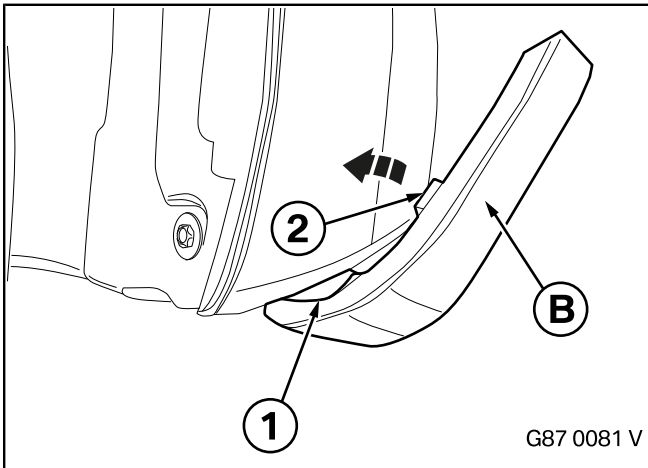
Fully insert two suitable expanding rivets (2) into the holes (1).

Mark the heads of the expanding rivets (2) using suitable means (e.g. touch-up stick) so that the markings can then be applied to the front in the next step in order to indicate the positions of the holes to be made.

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

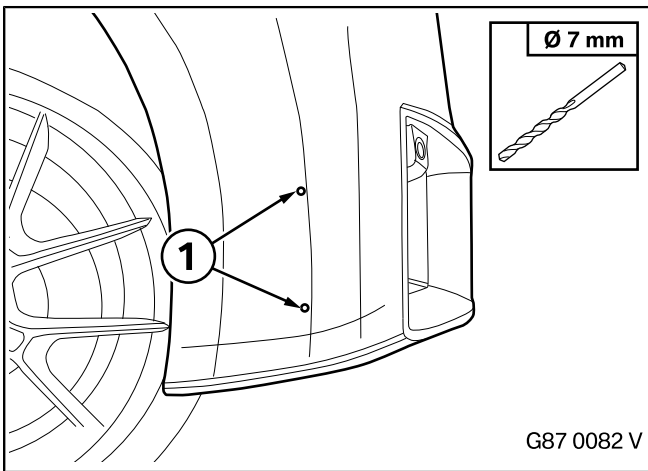
Put in place the carbon left/right front attachment **B** from underneath and secure it with two screws (1). At the same time, the second person holds the carbon left/right front attachment **B** to the side, away from the front trim, so that the heads of the expanding rivets (2) with the touch-up stick do not touch the front trim prematurely.

10. Carbon front attachment installation



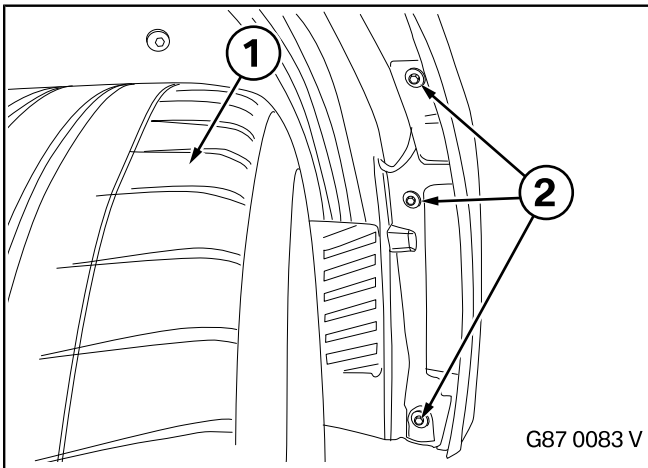
Check the contour line (1) between the carbon left/right front attachment **B** and the front trim and press the carbon left/right front attachment **B** onto the car surface so that the paint (2) is transferred to the positions of the holes to be drilled.

Then remove the carbon left/right front attachment **B** from the front trim and remove the two expanding rivets.

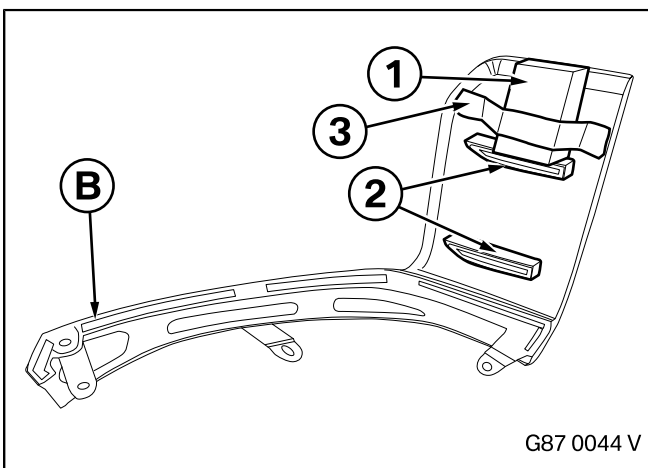


▶ When drilling, note the drilling depth. ◀

Pre-drill the two markings (1) on the front trim using a **3 mm diameter** drill bit and then enlarge them using a **7 mm diameter** drill bit.



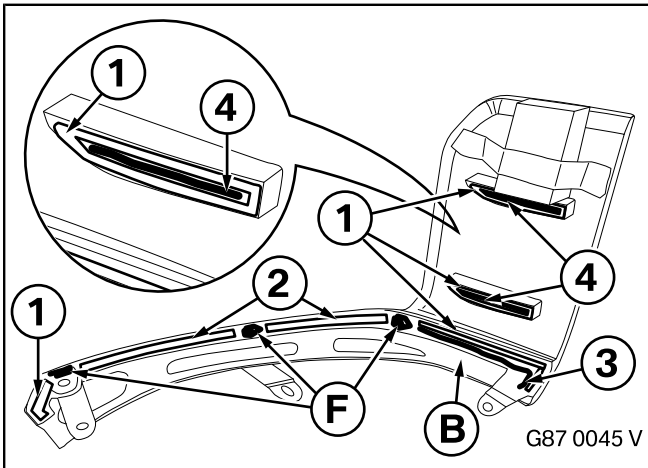
Turn the wheel (1) inwards. Remove the three screws (2) from the wheel arch liner.



Place a suitable object (1) above the mount (2) and secure it in place with a suitable adhesive tape (3).

▶ The object (1) must be thicker than the mounts (2) of the carbon left/right front attachment **B**, so that the adhesive tape does not immediately stick during installation. ◀

10. Carbon front attachment installation

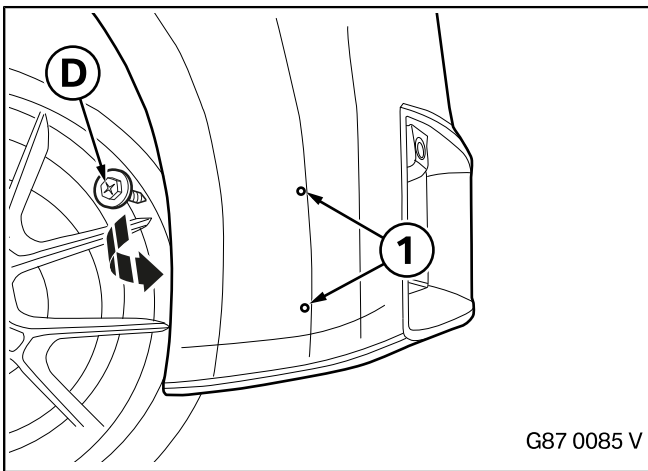


Remove the backing foils (1) from the adhesive tapes in full.

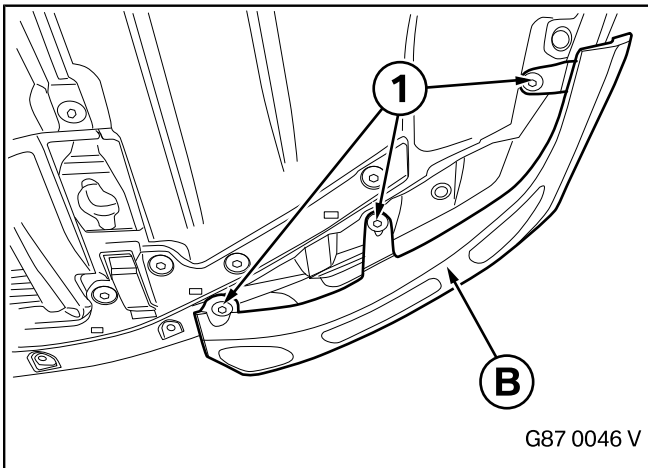
Fold the ends of the backing film (2) of the adhesive tape.

Apply the liquid adhesive **F** to the previously abraded surfaces in a thin line.

⚠ Do not apply too much liquid adhesive to prevent it from coming out. ◀



Insert the two screws **D** from behind through the wheel arch and position them in the holes (1).

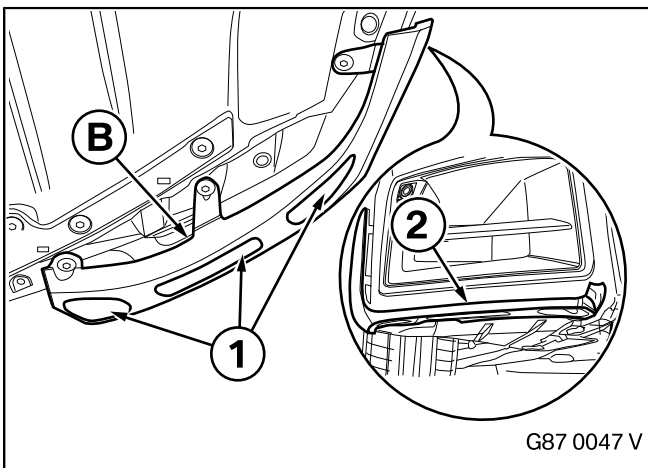


⚠ Carry out this work step with a second person. ◀

Hold the carbon left/right front attachment **B** on the car in the installation position. The second person screws the three screws (1) tight from underneath.

Remove the object attached previously as a spacer.

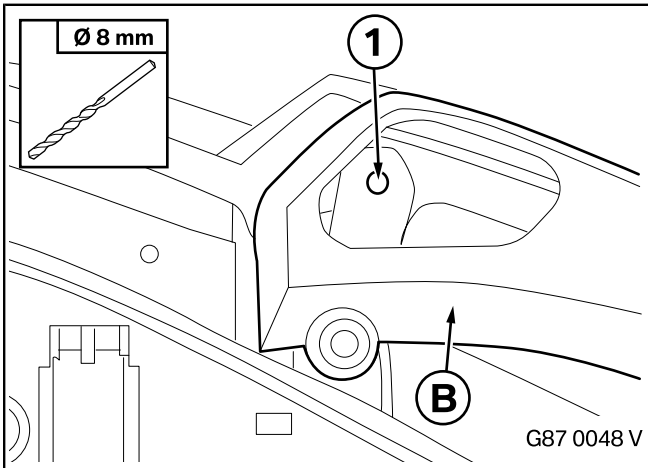
Screw the two screws **D** hand-tight into the holes of the carbon left/right front attachment **B** from the inside using a suitable tool until the gap with the front trim closes.



At the position of the adhesive tape (1), press the carbon left/right front attachment **B** firmly onto the front trim from underneath several times; there must be no light gap (2) visible from the outside.

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

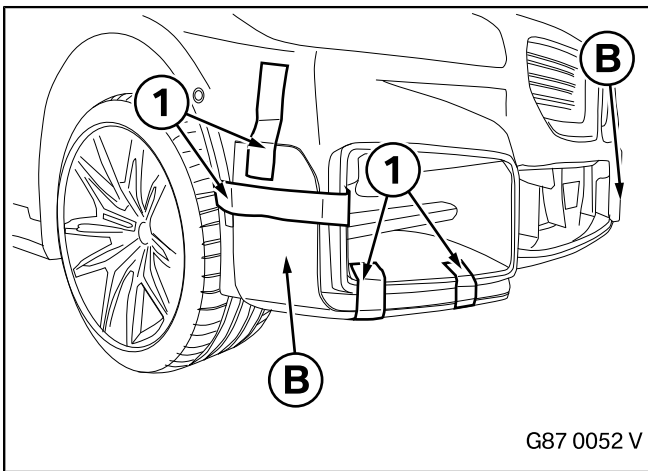
10. Carbon front attachment installation



▶ When drilling, observe the drilling depth. ◀

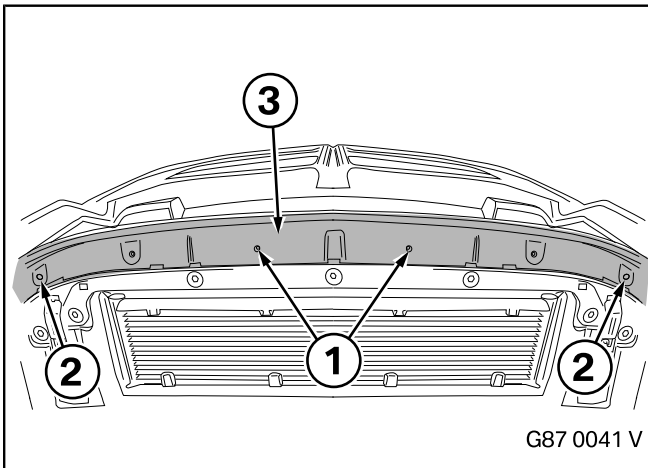
Drill a hole (1) with a **diameter of 8 mm** into the front trim. Press the expanding rivet **C** into the drill hole (1) of the carbon left/right front attachment **B**.

Screw the three screws back into the wheel arch liner again.



Fix in place the carbon left/right front attachment **B** using suitable adhesive strips (1).

Repeat the process in the same way on the other side.



Carbon centre front attachment installation

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

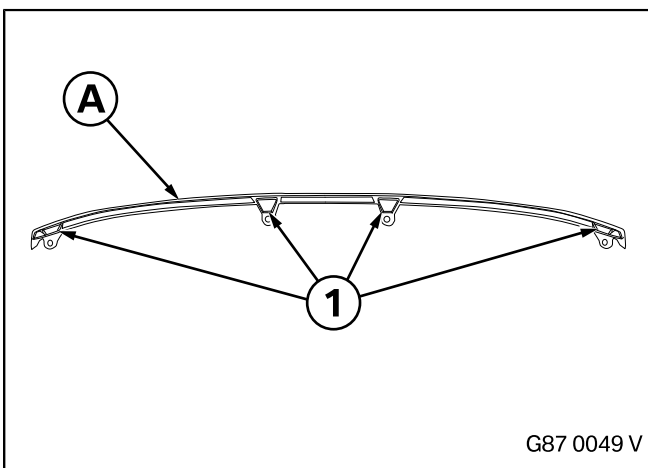
Wait for the drying time of the cleaner.

The screws and expanding rivets will be reused. ◀

Remove the two screws (1).

Remove the two expanding rivets (2).

Clean the surface (3) of the front trim with cleaner **E**.

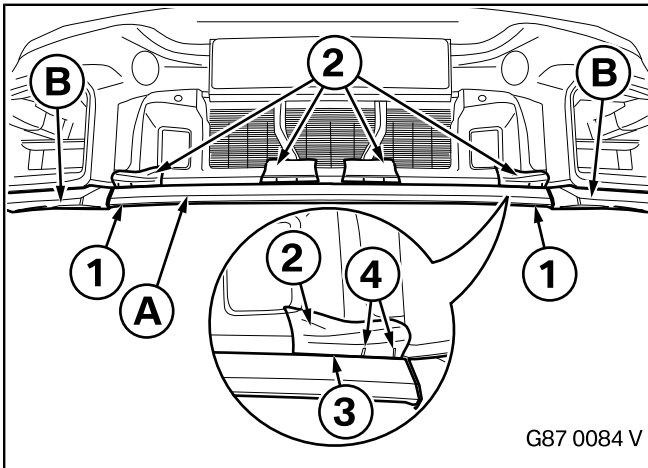


▶ The bonding surfaces (1) must be completely dry, clean and free from wax or grease.

Wait for the drying time of the cleaner. ◀

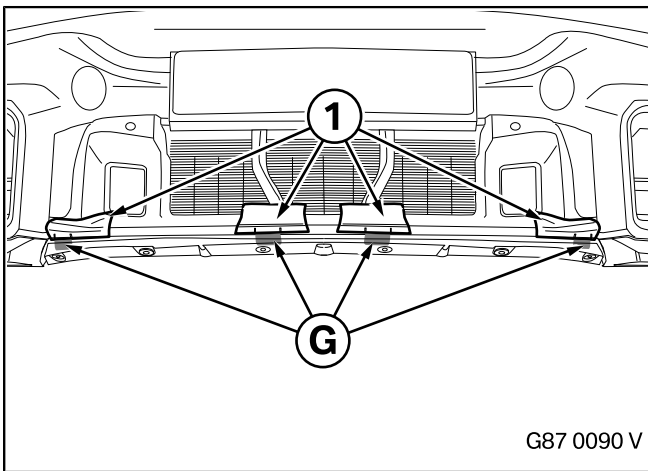
Abrade the bonding surfaces (1) on the carbon centre front attachment **A** using suitable tools and then clean them with cleaner **E**.

10. Carbon front attachment installation



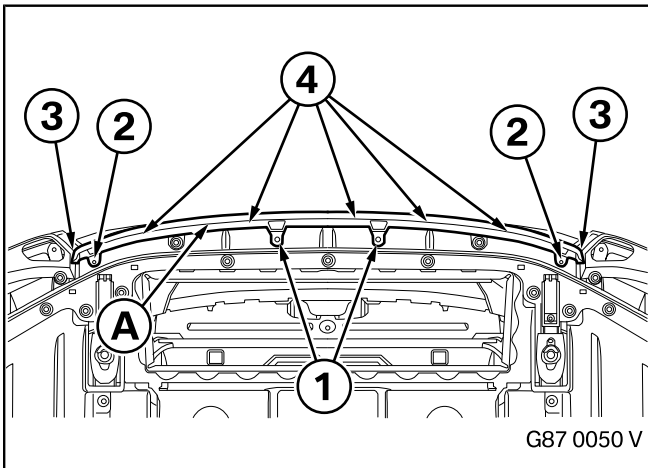
Position the carbon centre front attachment **A** between the carbon left/right front attachments **B** and press in the two expanding rivets (1). Affix the adhesive tape (2) above the carbon centre front attachment **A** so that the edge (3) is flush with the carbon centre front attachment **A**. Add markings (4) to the adhesive tape for the area to be primed.

Pull out the two expanding rivets (1) and remove the carbon centre front attachment **A**.



Prime the front trim underneath the adhesive tape (1) in the areas between the markings using primer **G**.

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



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

Hold the carbon centre front attachment **A** on the car in the installation position. The second person screws the two screws (1) only hand-tight and sets the two expanding rivets (2).

Check the gaps (3) on both sides; they must be identical. If necessary, reposition the carbon centre front attachment **A** by pushing it.

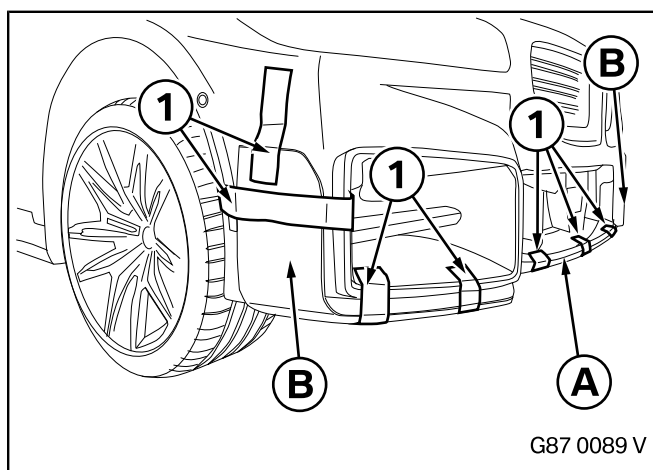
Screw the two screws (1) tight.

Then remove the backing film from the adhesive tape.

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

Press the adhesive tape of the carbon centre front attachment **A** firmly onto the front trim from below several times at position (4).

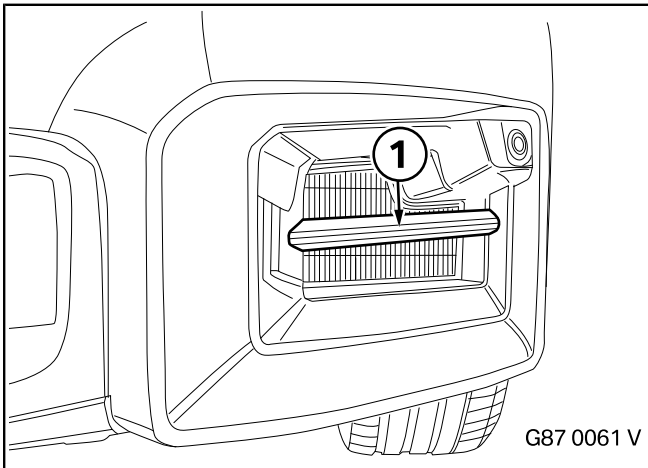
10. Carbon front attachment installation



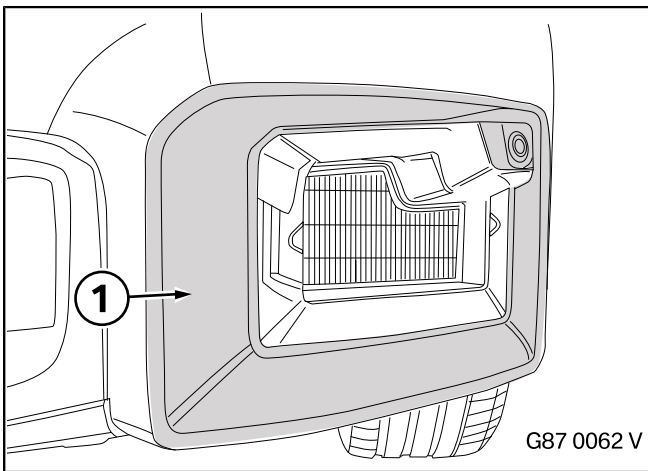
Secure the carbon centre front attachment **A** using suitable adhesive tape (1).

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

11. Carbon brake air inlet trim installation



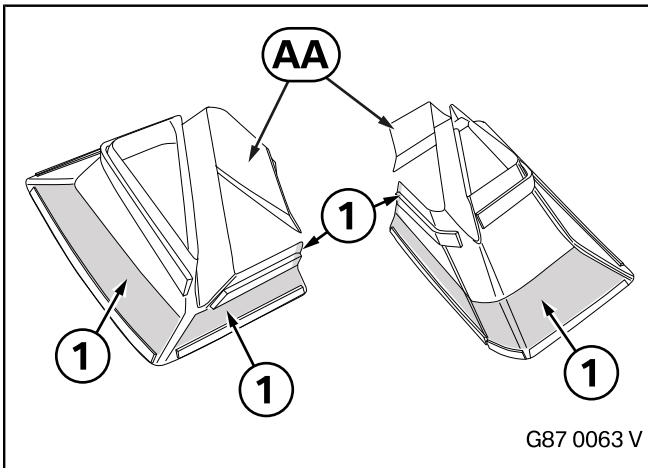
Completely remove and deburr the horizontal web (1) on both sides using a suitable tool (e.g. oscillating saw).



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

Wait for the drying time of the cleaner. ◀

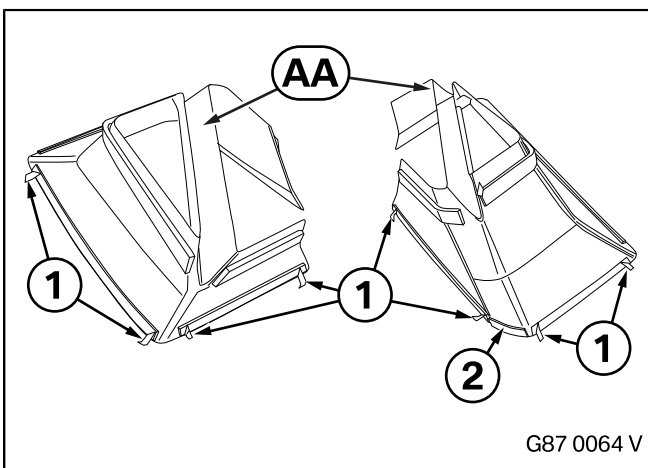
Clean the bonding surface (1) with cleaner **AB**.



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

Wait for the drying time of the cleaner. ◀

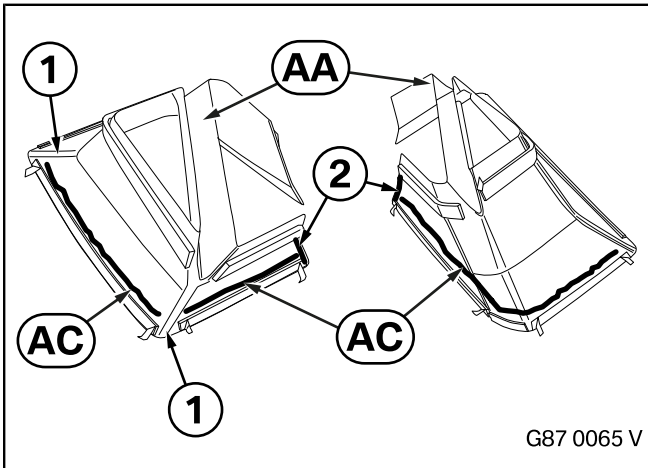
Abrade the entire area (1) around the carbon brake air inlet trim **AA** with suitable tools and clean with cleaner **AB**.



Fold the ends of the backing films (1) outwards.

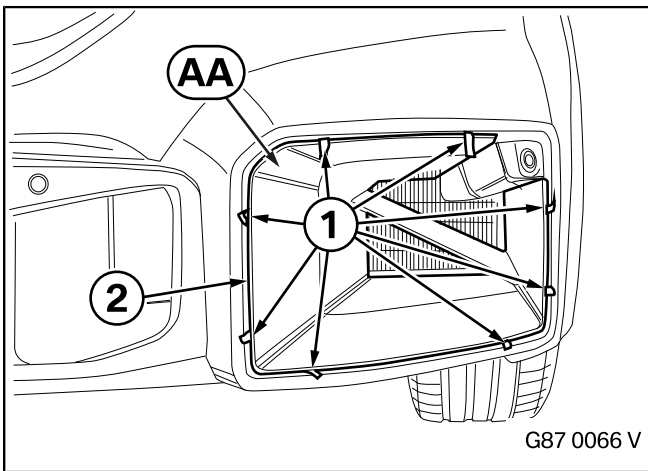
Remove the backing film (2) from the small strip of adhesive tape in full.

11. Carbon brake air inlet trim installation



- ▢ Do not apply liquid adhesive **AC** at the edges (1) in order to allow liquid that has penetrated inside to flow out at this point if necessary. ◀

Apply a bead of liquid adhesive **AC** around the sides while leaving the edges (1) free of adhesive. Also apply liquid adhesive **AC** to the two edges (2) from the outside up to the adhesive tape.



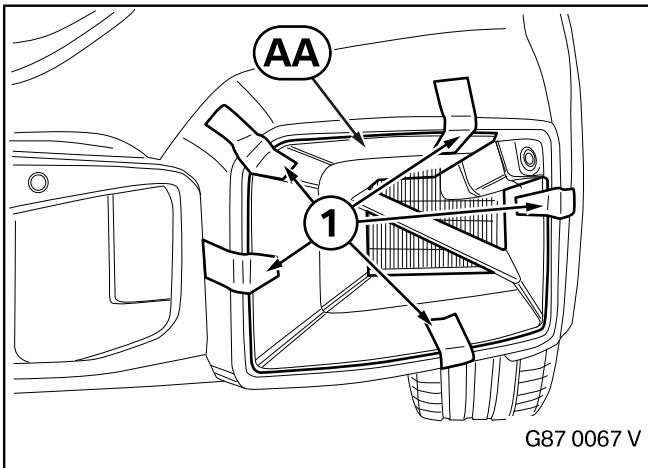
- ▢ Ensure that all ends of the protective film (1) are folded outwards and visible. ◀

Push the carbon brake air inlet trim **AA** into the opening directly from the front and press it firmly into place.

Ensure the contour line (2) is uniform.

Pull off the ends of the protective film (1) to the sides. Press the carbon brake air intake trim **AA** firmly in place several times.

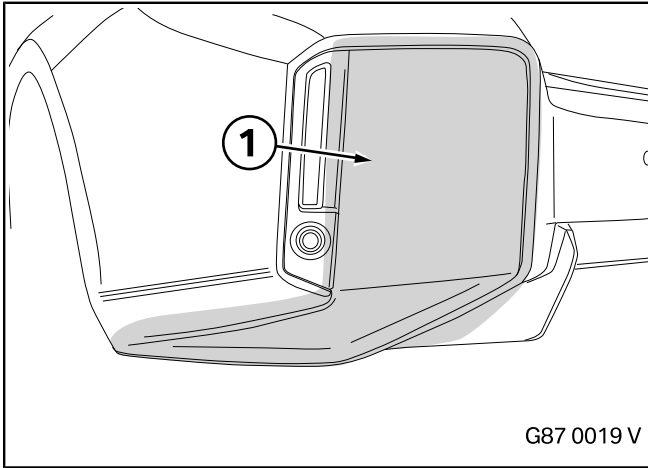
- ▢ Remove any excess liquid adhesive immediately using suitable tools. ◀



Secure the carbon brake air inlet trim **AA** at several points using suitable adhesive tape (1).

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

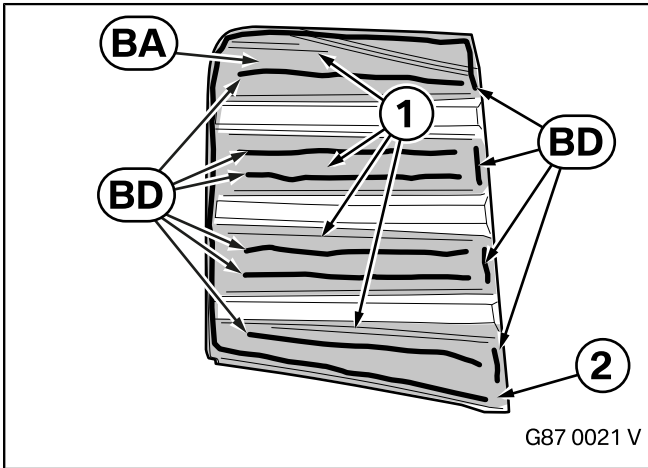
12. Carbon rear attachment installation



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

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

☐ Wait until the drying time has elapsed. ◀



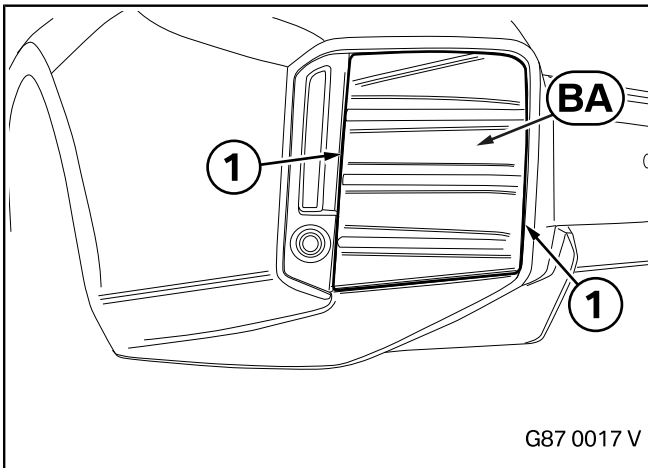
☐ The bonding surfaces (1) must be completely clean, dry and free from wax or grease. ◀

Abrade the bonding surfaces (1) on the inside of the carbon top rear attachment **BA** using suitable tools and clean it with cleaner **BC**.

☐ Wait until the drying time has elapsed.

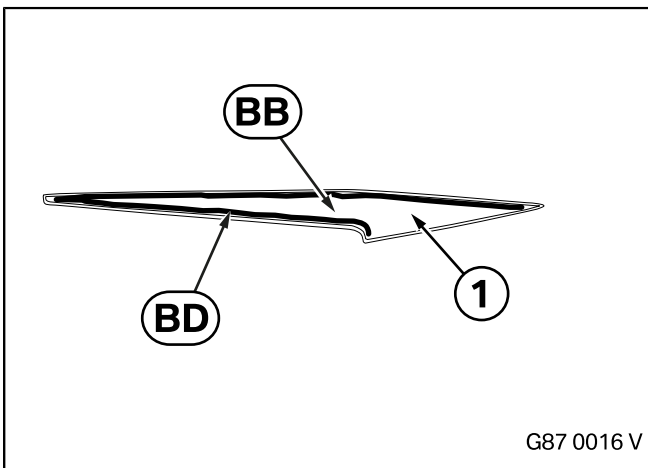
Do **not** apply any liquid adhesive **BD** to the edge (2), so that water that has penetrated inside can escape if necessary. ◀

Apply beads of liquid adhesive **BD** as shown.



Align the carbon top rear attachment **BA** within the contour (1) and put it in place. Then press it firmly in place.

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



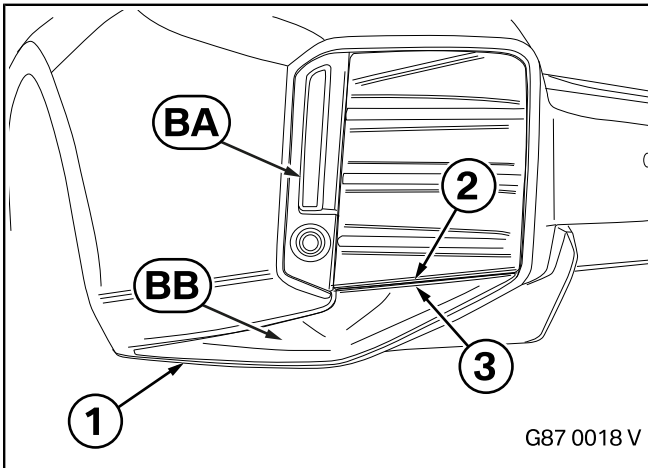
☐ The bonding surface (1) must be completely clean, dry and free from wax or grease. ◀

Abrade the bonding surface (1) of the carbon bottom rear attachment **BB** using suitable tools and clean it with cleaner **BC**.

☐ Wait until the drying time has elapsed. ◀

Apply a bead of liquid adhesive **BD** along the contour as shown.

12. Carbon rear attachment installation



- Take into account of the fibre orientation of the carbon structure of the carbon top rear attachment **BA** and the carbon bottom rear attachment **BB**. There is a narrow gap between the two components. The fibre orientation can be adjusted by moving the carbon bottom rear attachment to the left or right. ◀

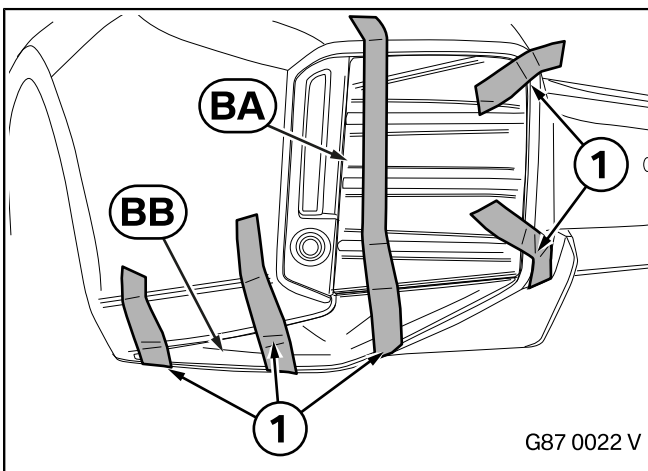
Align the carbon bottom rear attachment **BB** within the contour (1) and put it in place. In doing so, observe the fibre orientation of the carbon structure between the edge (2) of carbon top rear attachment **BA** and the edge (3) of the carbon bottom rear attachment **BB**. Then press it firmly in place.

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

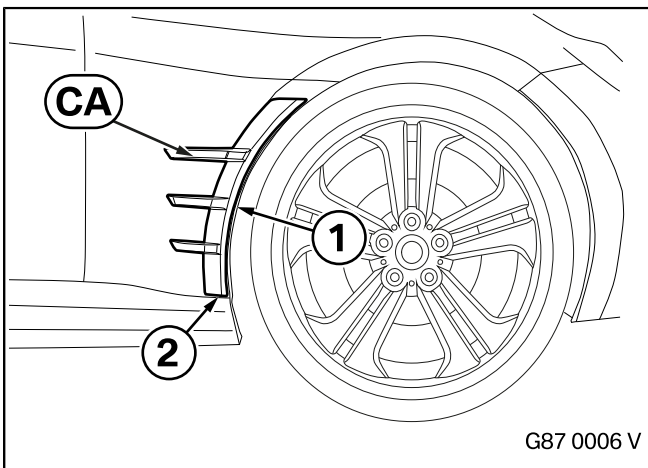
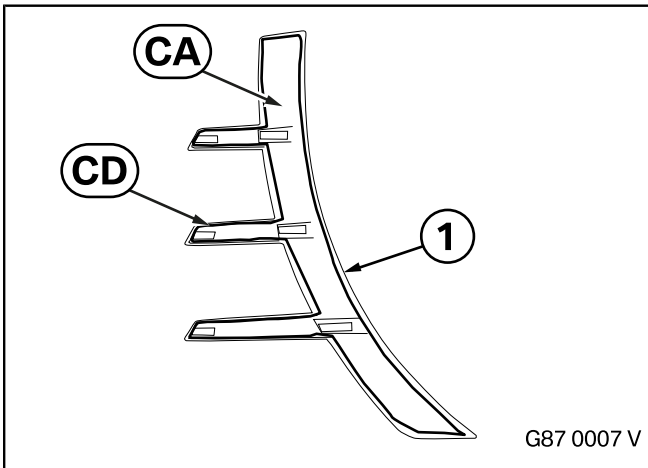
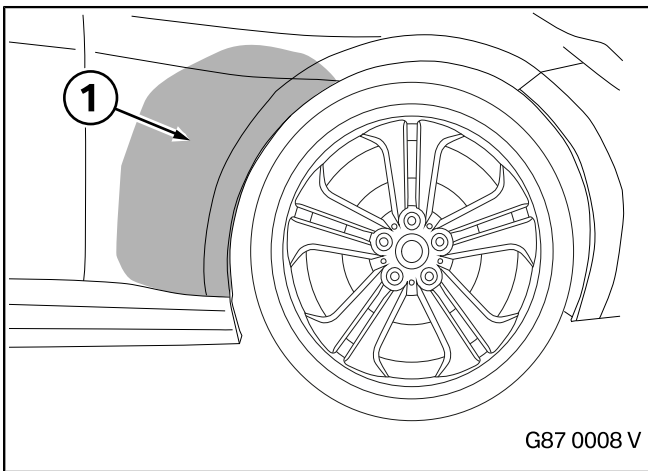
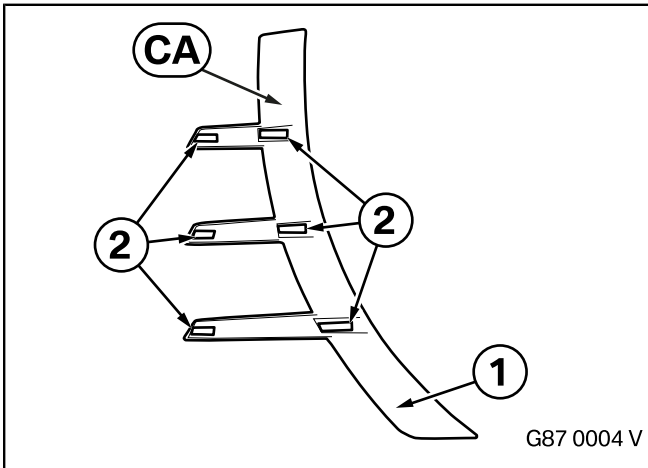
Fix in place the carbon bottom rear attachment **BB** and the carbon top rear attachment **BA** using suitable adhesive tape (1) at suitable points.

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

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



13. Front/rear side panel finisher installation



Front side panel finisher installation

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

Abrade the bonding surface (1) on front side panel finisher **CA** using suitable tools and then clean it with cleaner **CC**.

▶ Wait until the drying time has elapsed. ◀

Remove the backing foils (2) from the adhesive tapes in full.

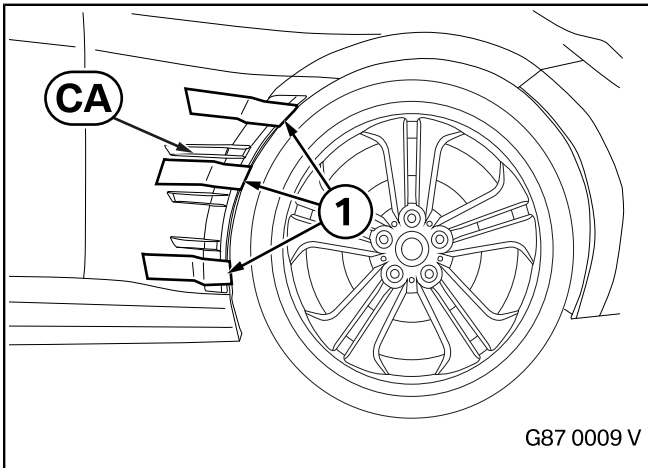
▶ The bonding surface (1) must be completely clean, dry and free from wax or grease. ◀

Clean the bonding surface (1) on the front wheel arch with cleaner **CC**.

Along the contour (1) of the front side panel finisher **CA**, apply a bead of liquid adhesive **CD**.

Align the front side panel finisher **CA** along the wheel arch contour (1) and at the bottom, use the refractory edge (2) for alignment purposes and press into place.

13. Front/rear side panel finisher installation

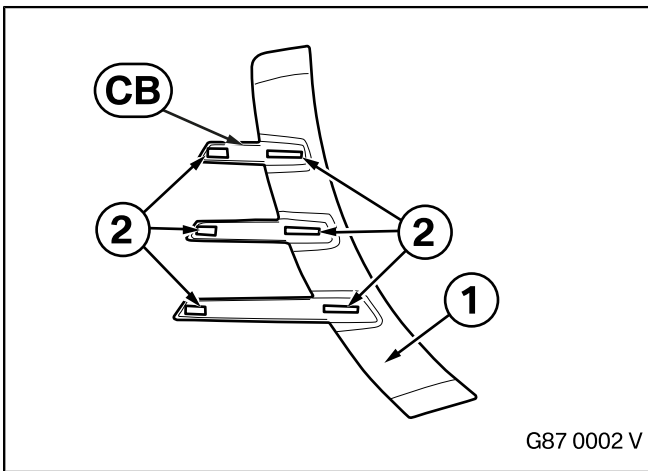


Secure it using suitable adhesive tape (1).

- Remove any excess liquid adhesive immediately using suitable tools.

Particular attention must be paid that the upper and lower edge are correctly fixed in place.

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



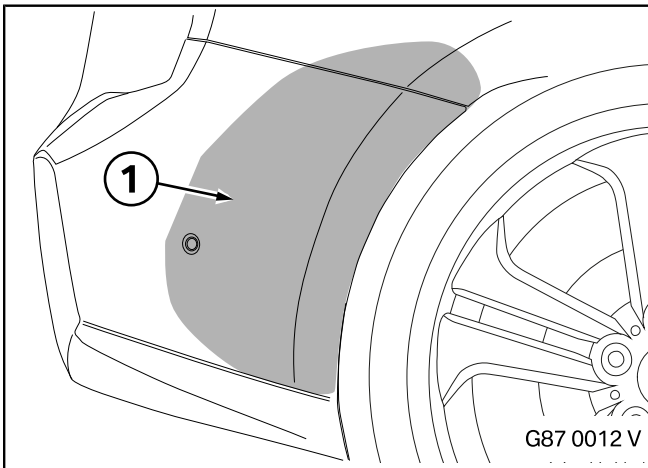
Rear side panel finisher installation

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

Abrade the bonding surface (1) on rear side panel finisher **CB** using suitable tools and then clean it with cleaner **CC**.

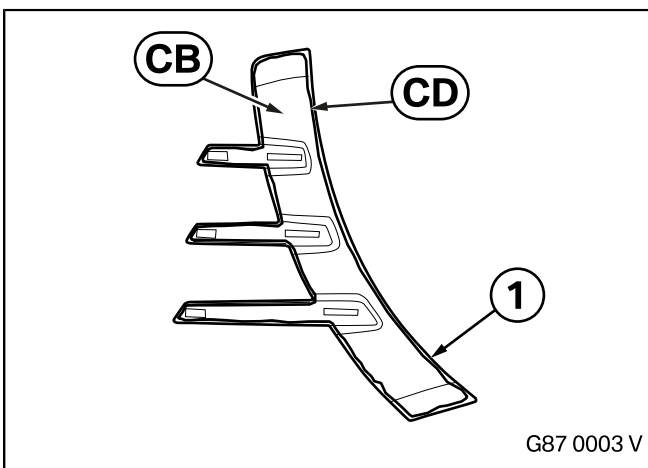
- Wait until the drying time has elapsed. ◀

Remove the backing foils (2) from the adhesive tapes in full.



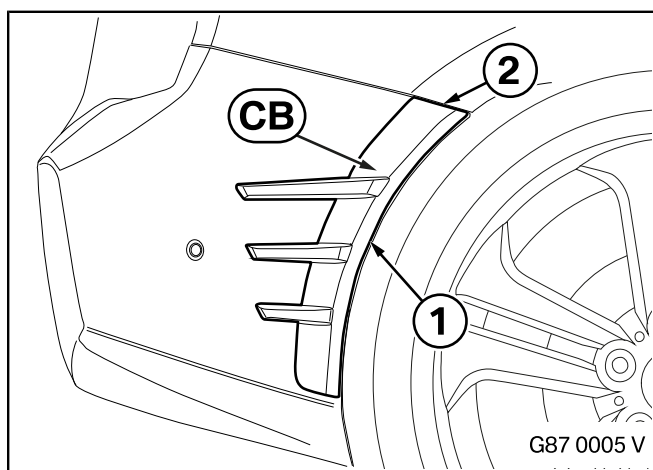
- The bonding surface (1) must be completely clean, dry and free from wax or grease. ◀

Clean the bonding surface (1) on the rear wheel arch with cleaner **CC**.

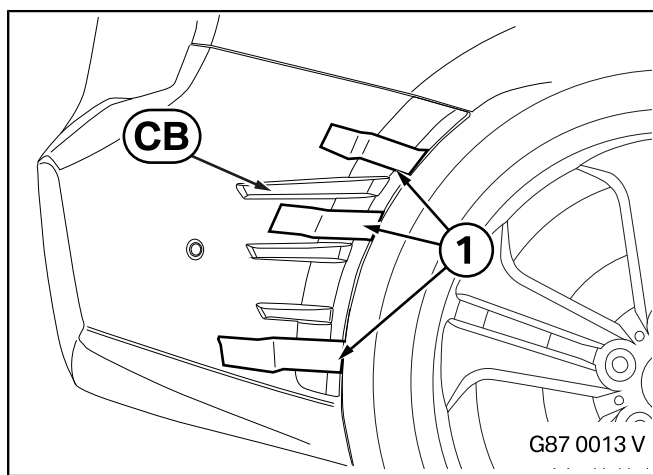


Along the contour (1) of the rear side panel finisher **CB**, apply a bead of liquid adhesive **CD**.


13. Front/rear side panel finisher installation



Align the rear side panel finisher **CB** along the wheel arch contour (1) and at the top, use the refractory edge (2) for alignment purposes and press into place.



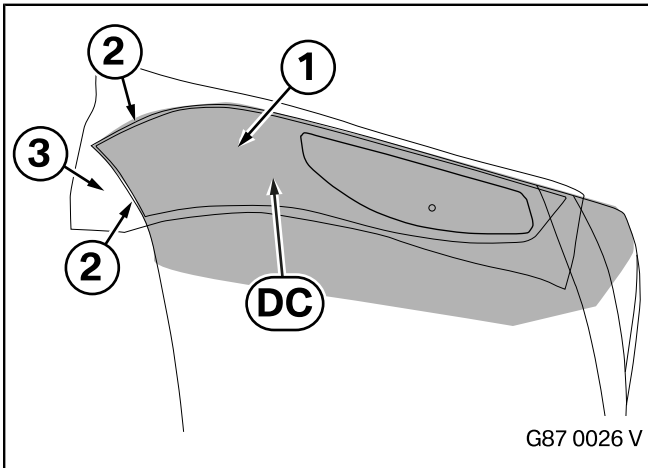
Secure it using suitable adhesive tape (1).

 Remove any excess liquid adhesive immediately using suitable tools.

Particular attention must be paid that the upper and lower edge are correctly fixed in place.

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

14. Carbon throughflow rear spoiler installation



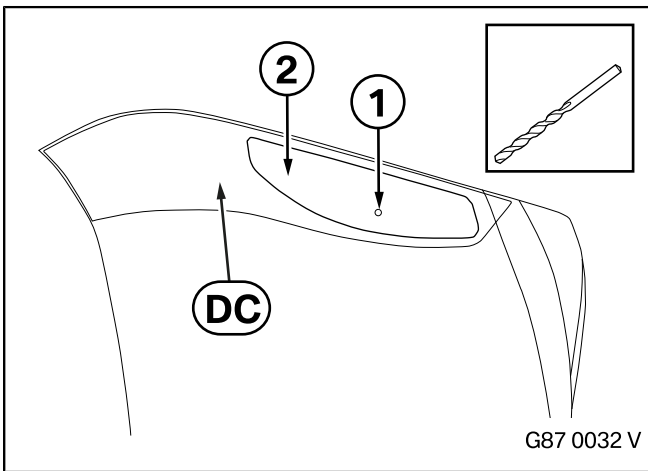
- ☐ The left and right bonding surfaces (1) must be completely clean, dry and free from wax or grease.

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 **DC** 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. ◀

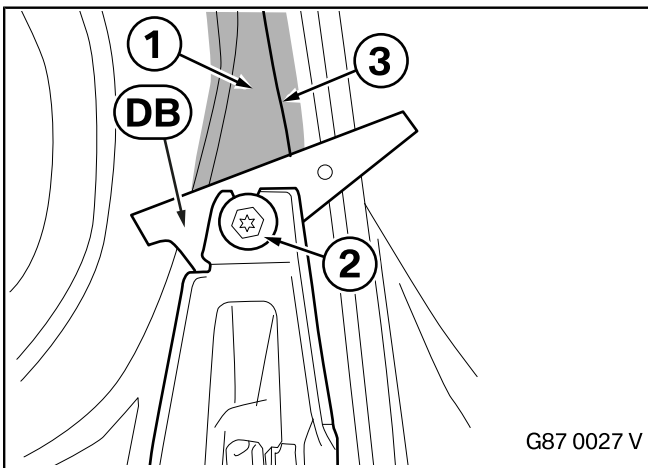
Centre-punch hole positions (1).

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 **DC** 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. ◀



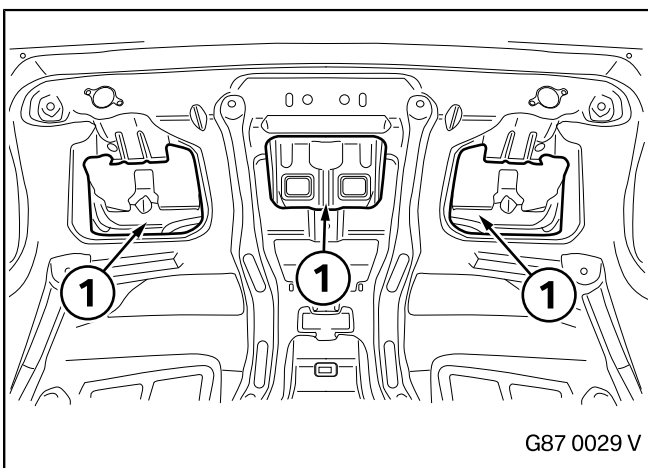
- ☐ The left and right bonding surfaces (1) must be completely clean, dry and free from wax or grease.

Open the tailgate. ◀

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

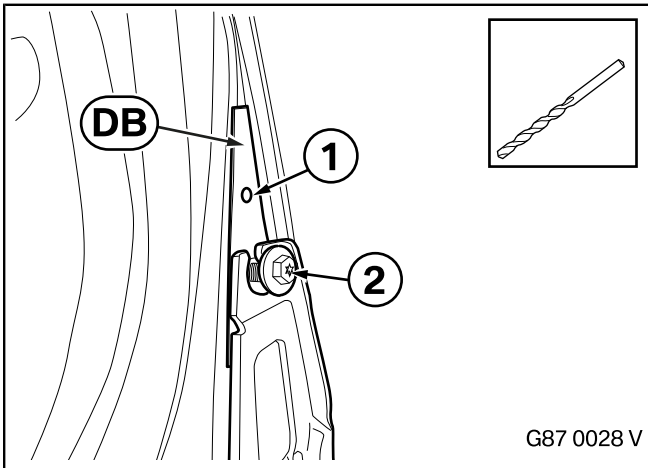
Loosen the screws (2) and unscrew them.

In order to correctly position the right inner template **DB** and the left inner template **DD**, insert the screws (2) into the perforated hole, align each of the templates with the refractory edge (3) and affix them in place.



- ☐ 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. ◀

14. Carbon throughflow rear spoiler installation



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 **DD**. Deburr the holes (1) and treat them with conventional anti-corrosive agents.

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

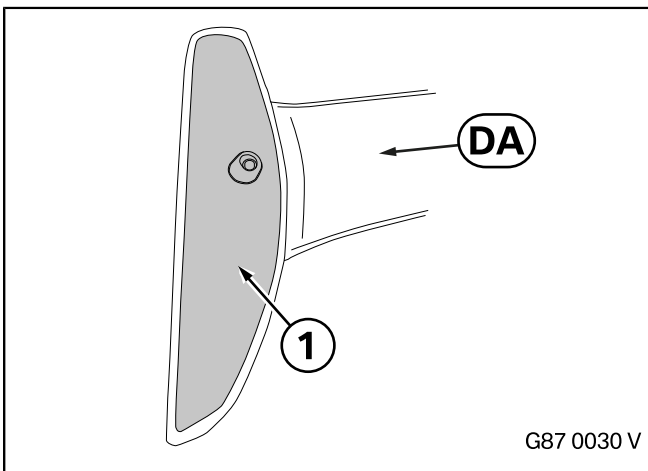
Remove the sawdust from the interior of the tailgate.

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

☐ There is a sticker in this area (1). It must be completely removed before cleaning. ◀

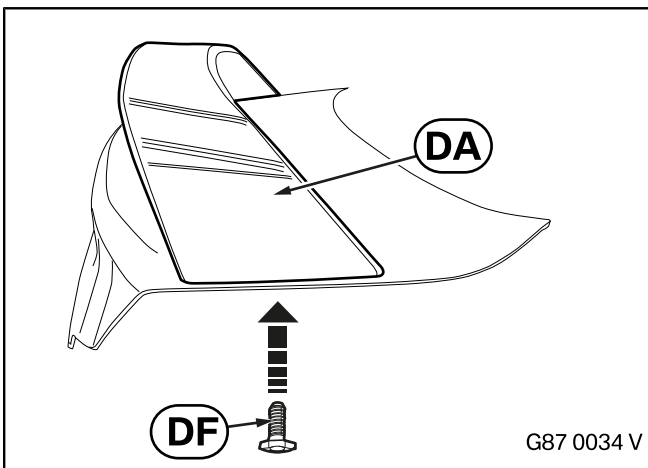
Abrade the underside of the two leg supports of the carbon throughflow rear spoiler **DA** in the areas (1) and clean with cleaner **DI**.

☐ Wait until the drying time has elapsed. ◀



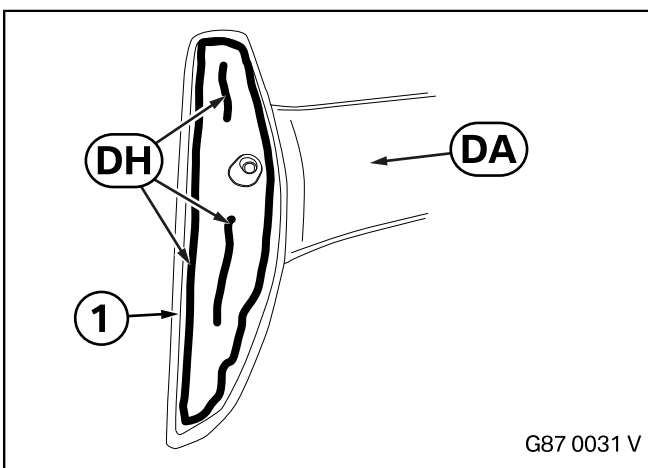
☐ To check that the carbon throughflow rear spoiler **DA** is fitted correctly, put in place the carbon throughflow rear spoiler **DA** with two people, insert the screws **DF**, tighten them slightly and adjust the drill holes if necessary.

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

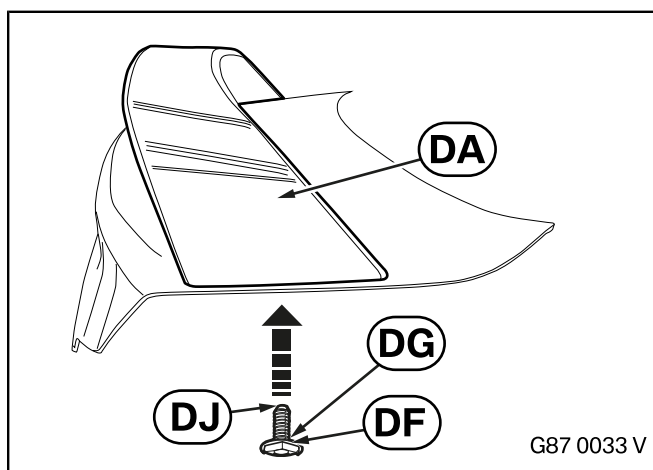


Along the edge (1) of the leg support **DA**, apply a bead of liquid adhesive **DH**. Apply two lines of liquid adhesive **DH** as shown.

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



14. Carbon throughflow rear spoiler installation



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

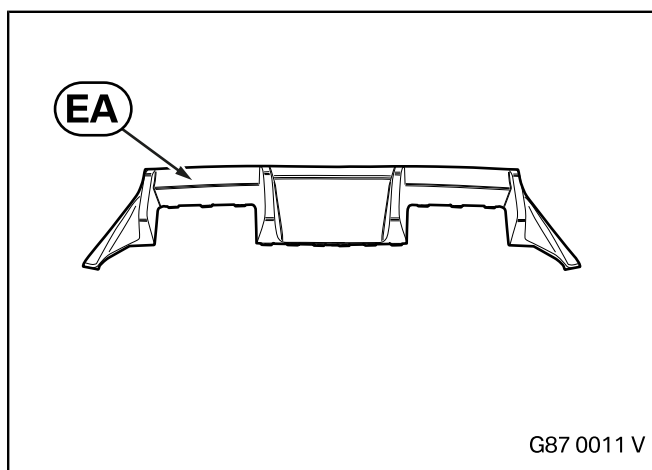
Wet the threads of the screws **DF** with liquid screw lock **DJ**. ◀

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**. ◀

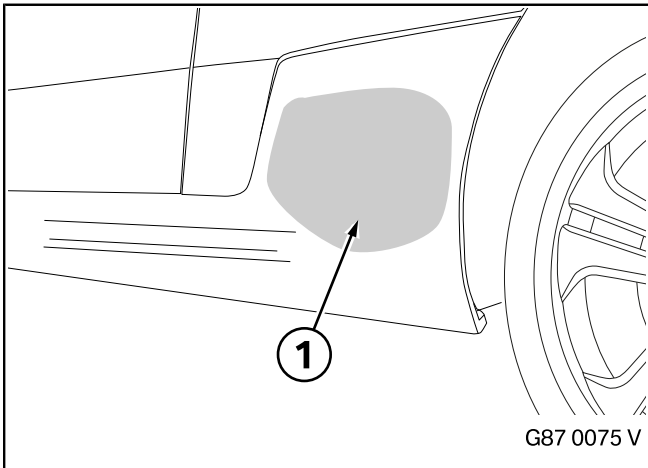
15. Carbon rear diffuser installation



- ▶ The carbon rear diffuser **EA** is installed according to ISTA/AIR. ◀
- ▶ The installation of the carbon rear diffuser (MPP exhaust system) part number 51 12 5 A46 B54 is described in installation instructions 01 29 5 A0D B45. ◀

16. Installing the carbon side skirt attachment

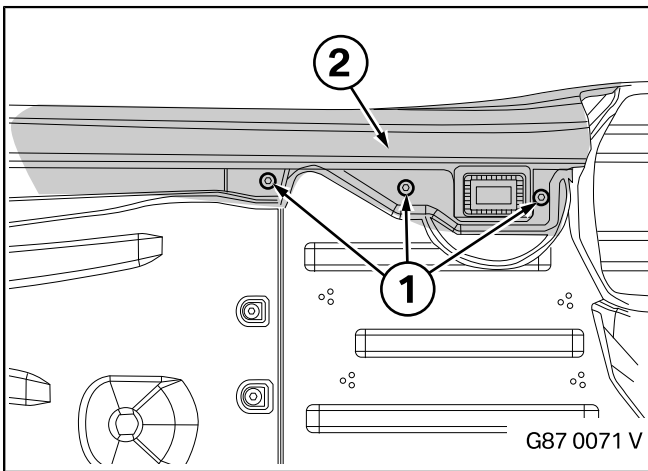
► Use a suitable lifting platform or suitable action to provide good access to the installation position. ◀



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

Wait for the drying time of the cleaner. ◀

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

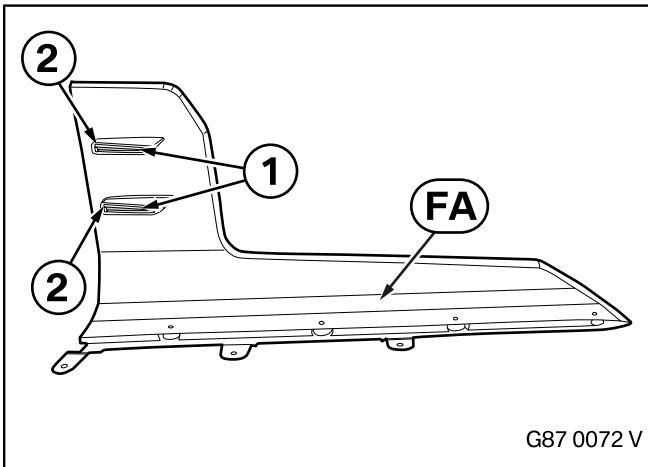


► The installation surface must be completely clean, dry and free from wax or grease.

Wait for the drying time of the cleaner. ◀

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

Clean the installation surface (2) with cleaner **FC**.

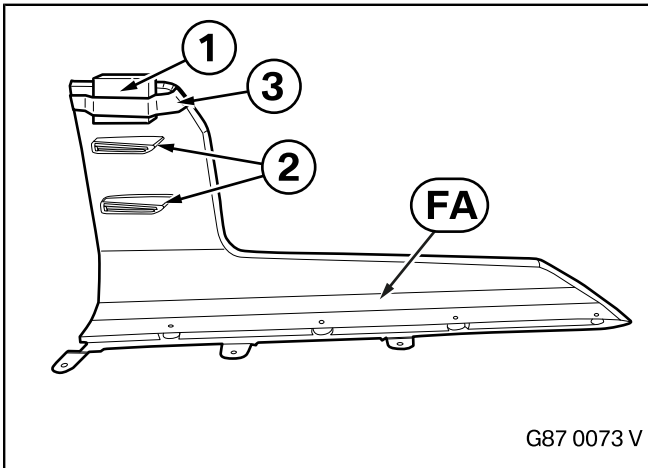


► The bonding surfaces (1) must be completely dry, clean and free from wax or grease.

Wait for the drying time of the cleaner. ◀

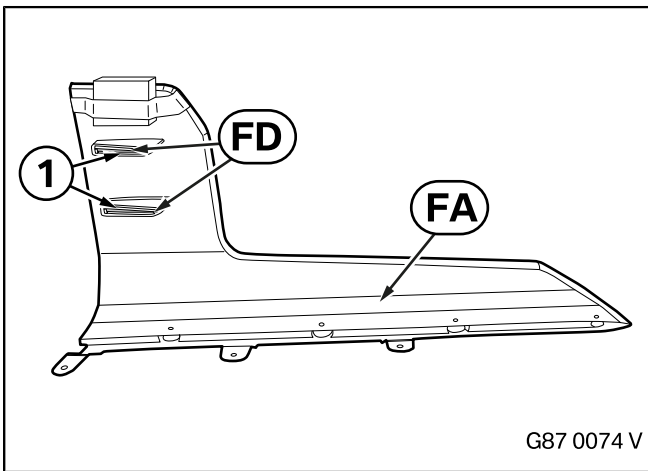
Abrade the bonding surfaces (1) within the adhesive tapes (2) on the inside of carbon side skirt attachment **FA** using suitable materials and then clean them with the cleaner **FC**.

16. Installing the carbon side skirt attachment

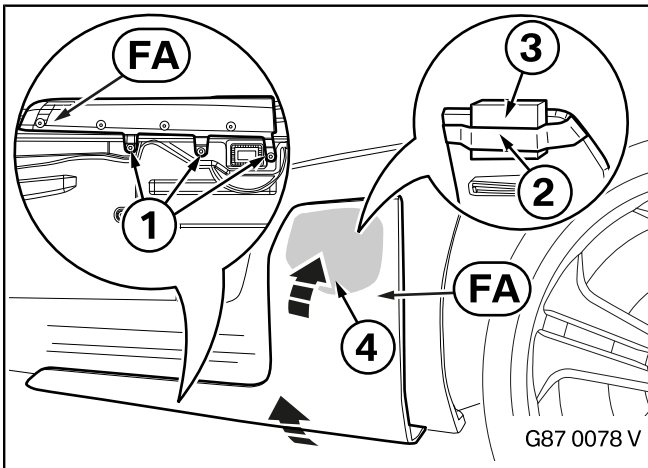


Place a suitable object (1) above the mounts (2) and secure it in place with a suitable adhesive tape (3).

▢ The object (1) must be thicker than the mounts (2) for the carbon side skirt attachment **FA** so that the adhesive tape does not bond immediately during installation. ◀



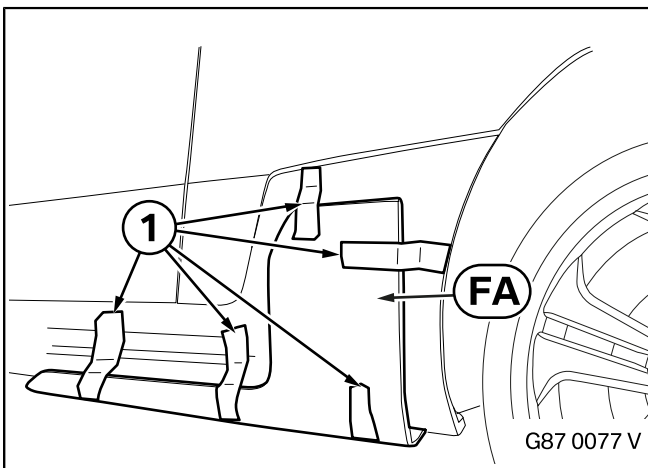
Completely remove the adhesive tape backing films (1) from the carbon side skirt attachment **FA**. Apply a thin layer of liquid adhesive **FD** to the previously abraded surfaces.



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

Hold the carbon side skirt attachment **FA** in the installation position from below. The second person screws the three fastening screws (1) completely tight.

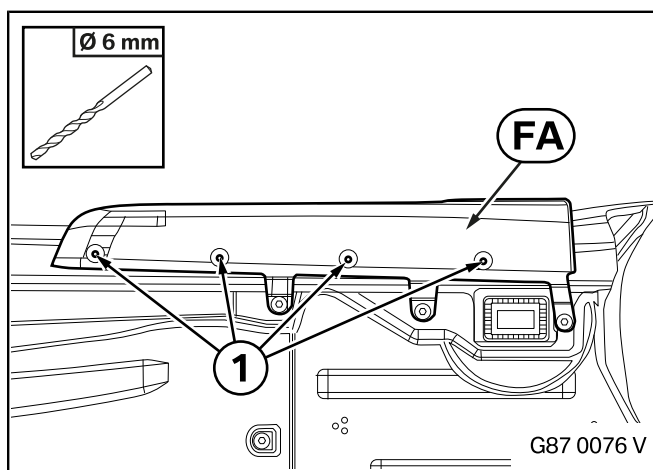
Remove the adhesive tape (2) and the object (3), while holding the part by the top edge and moving it to position (4) by lifting it slightly. Press the carbon side skirt attachment **FA** onto the car.



Secure carbon side skirt **FA** in place from the outside using suitable adhesive tape (1).

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

16. Installing the carbon side skirt attachment



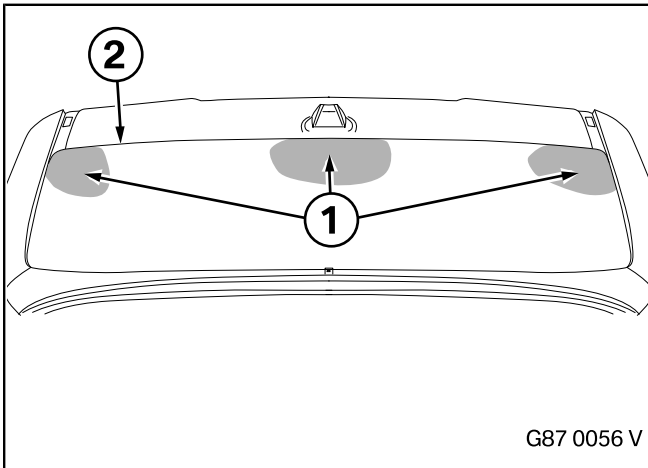
- ▶ Use a **5 mm diameter** drill stop so as not to damage the part below. ◀

Drill four holes (1) with a **diameter of 6 mm**.

Then press in the four expanding rivets **FB**.

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

17. Black high gloss edge spoiler section installation

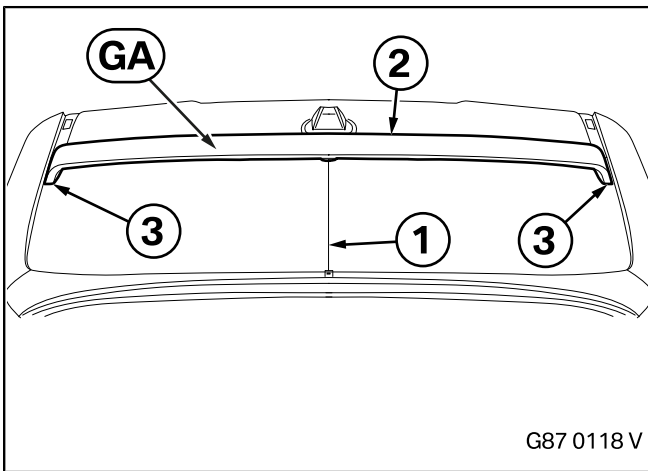


▶ The bonding surfaces (1) must be completely clean, dry and free from wax or grease.

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

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

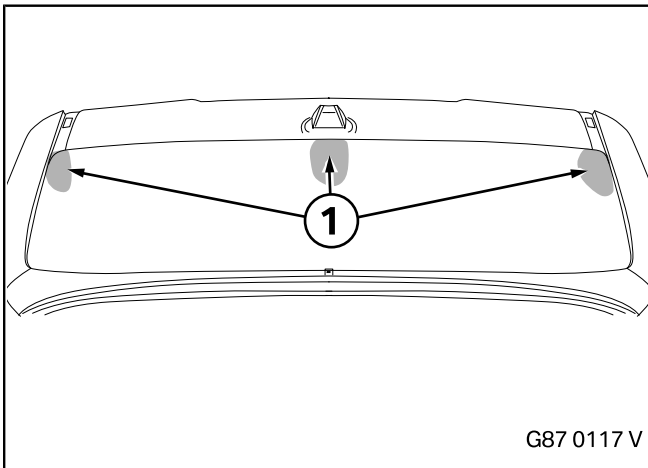
Clean the bonding surfaces (1) with cleaner **GC**.



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

Place the black, high-gloss roof edge spoiler **GA** 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.

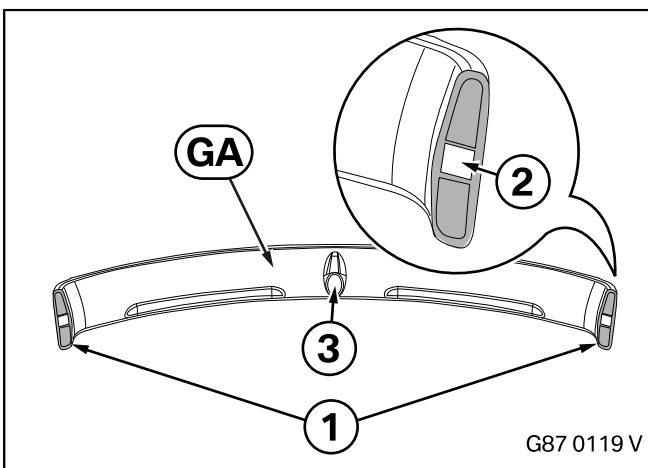
Trace the outline (3) of the support feet on the window glass using suitable equipment (for example a water-soluble pen).



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

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

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



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

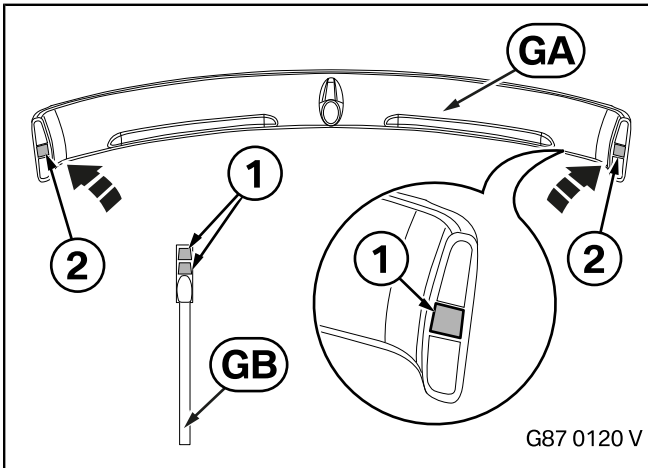
Abrade the surfaces (1) on the underside of the black, high gloss roof edge spoiler **GA** using suitable equipment.

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

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

▶ Wait until the cleaner **GC** is completely dry. ◀

17. Black high gloss edge spoiler section installation

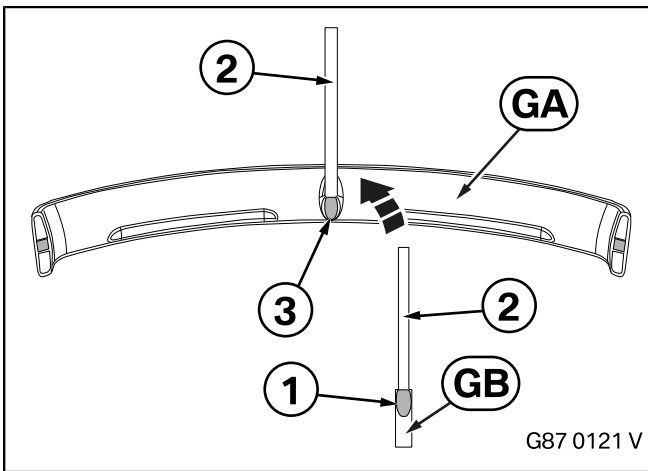


- ▶ The adhesive pads (1) are cut in a trapezoidal shape and fit precisely into the recess (2) in the black high gloss roof edge spoiler **GA**.

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

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

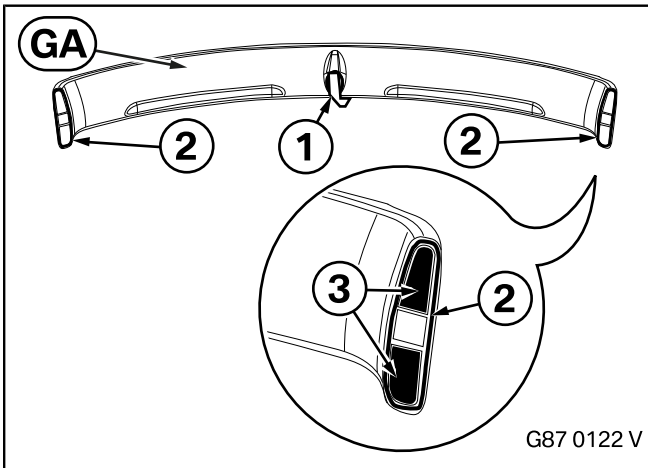
Remove the backing foil from the two adhesive pads in full.



- ▶ The adhesive pad (1) is cut precisely to fit the recess (3) in the black high gloss roof edge spoiler **GA**.

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 **GB** and affix it onto the centre recess (3) of the black high gloss roof edge spoiler **GA** so that the pull-off strip (2) points upwards as shown.

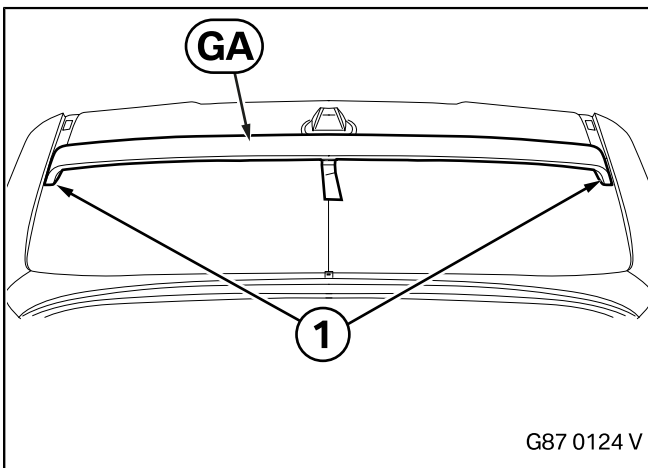


- ▶ Do **not** remove the pull-off strip (1) in the centre. ◀

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

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

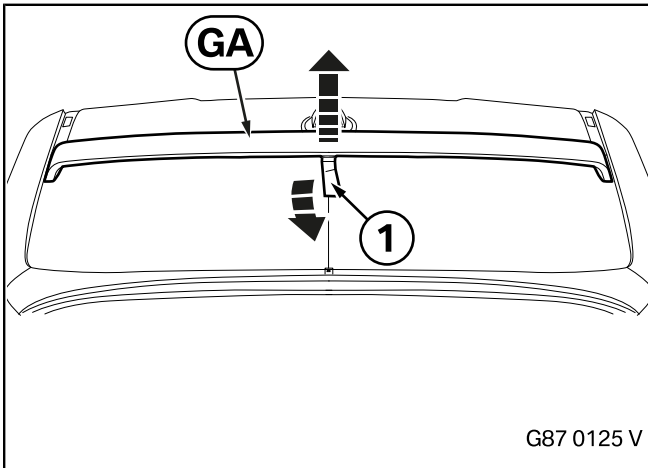
- ▶ Ensure that you do not exceed the pot time of the liquid adhesive **GD**. ◀



- ▶ Carry out this work step with a second person. ◀

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

17. Black high gloss edge spoiler section installation



- ▶ Carry out this work step with a second person. ◀

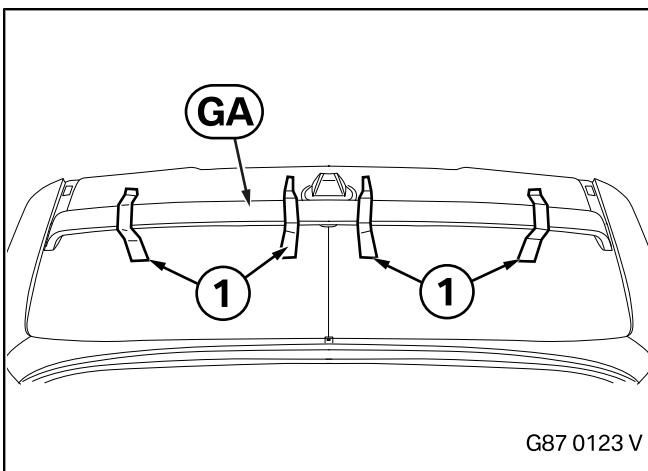
Raise the black high gloss roof edge spoiler **GA** in the centre a little without raising the two outer adhesion points, pull the pull-off strip (1) under the black high gloss roof edge spoiler **GA**, removing the backing foil from the adhesive pad. Now press the black high gloss roof edge spoiler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



18. Concluding work and coding

- None

The retrofit system does NOT require programming/coding.