

Original BMW Parts and Accessories. Installation Instructions.



M Performance Exterior Components Retrofit Kit. BMW 1 Series (F40)

Retrofit kit number

51 11 2 468 204	Aero Flick, right
51 11 2 468 205	Aero Flick, left
51 19 2 467 256	Carbon rear diffuser MSP
51 19 2 467 258	Carbon rear diffuser MPA
51 19 2 462 318	Black high gloss front attachment
51 19 2 471 101	Black high gloss roof edge spoiler MPA
51 19 2 462 543	Black high gloss roof edge spoiler MSP (including primed boot lid spoiler Part No. 51 62 7 490 371)
51 19 2 462 601	High gloss black side skirt insert, left
51 19 2 462 600	High gloss black side skirt insert, right

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).

Retrofit kit	Hours
Aero Flick, left/right	0.25 per side
Rear diffuser	0.50
Front attachment	0.50
Rear spoiler MPA	0.25
Rear spoiler MSP (including roof edge spoiler)	0.50
Black high gloss side skirt insert left/right	0.30 per side

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/cm² and 50 N/cm².
- Take care not to damage the parts when opening the packaging.
- Check that all the parts fit accurately on the car before fitting them.
- All the components and their bonding surfaces must be at room temperature for installation. The ideal relative humidity is 50%. Different values will change the specified times.
- After completing the bonding and installation work, the car must remain stationary at room temperature for at least 12 hours.
- If adhesives are used, the car may be driven after 24 hours, and may be taken through a car wash after 48 hours. The car may only be driven at a speed of $v_{max} < 100$ km/h for a period of 24 to 48 hours.
- The installed parts may become loose and fly off the car if you fail to wait for the full reaction time of the primer/adhesive. Danger of accidents!
- Some of the installation steps are shown only on one side of the car. Proceed in the same way on the other side of the car.
- All illustrations show LHD (left-hand drive) cars; proceed similarly on RHD (right-hand drive) cars.



Print the template **S1** in the annex **without** scaling on DIN A4 paper. To do this, in printer settings go to **“Actual size”**. The printer setting must not be set to “Fit”.

Check the reference dimension on the print-out using a ruler. ◀

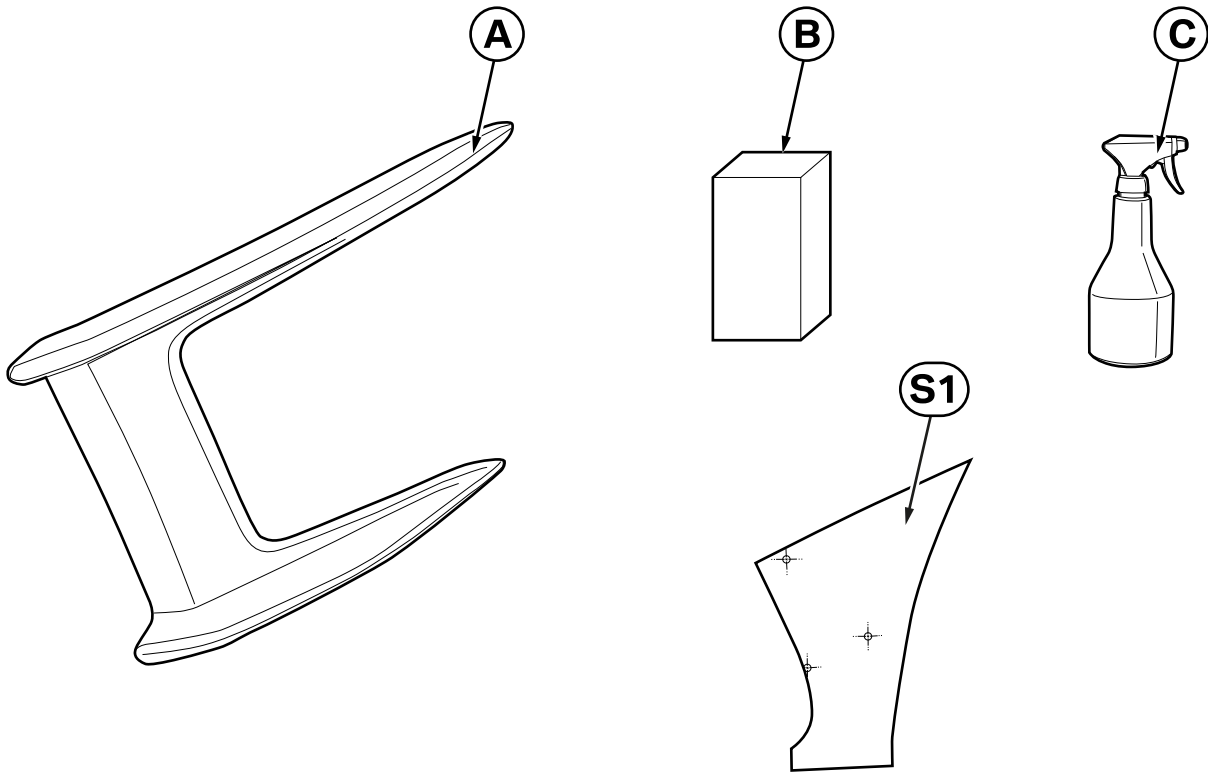
Special tools required

None

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1. Aero Flick parts list

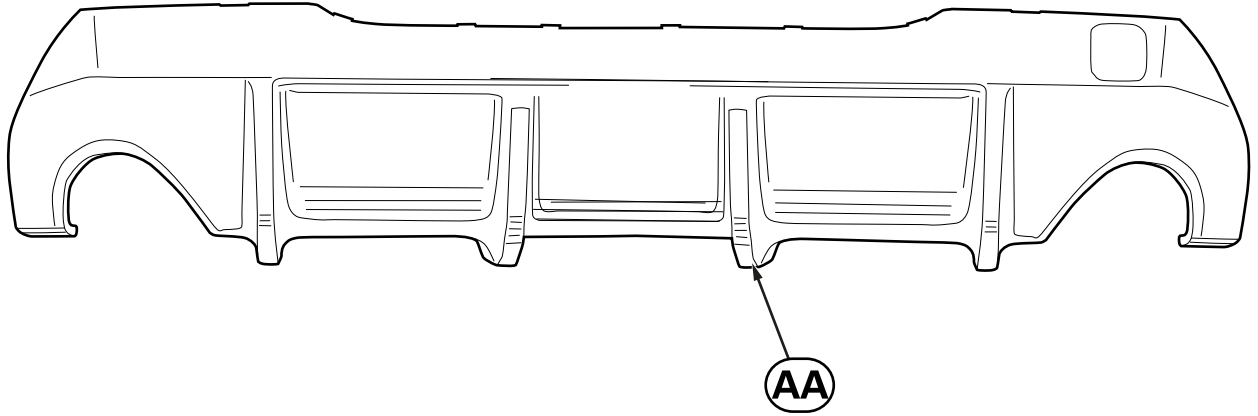


F40 0024 V

Legend

- A** Aero Flick carbon front side panel, left/right (left side shown)
- B** Liquid adhesive (not included in parts kit, see EPC for details and part number)
- C** Cleaner (not included in parts kit, see EPC for details and part number)
- S1** Template (in the annex of these installation instructions)
Print **without** scaling on DIN A4 paper. To do this, in printer settings go to **“Actual size”**. The printer setting must not be set to **“Fit”**. Check the reference dimension on the print-out using a ruler.

2. Carbon rear diffuser parts list

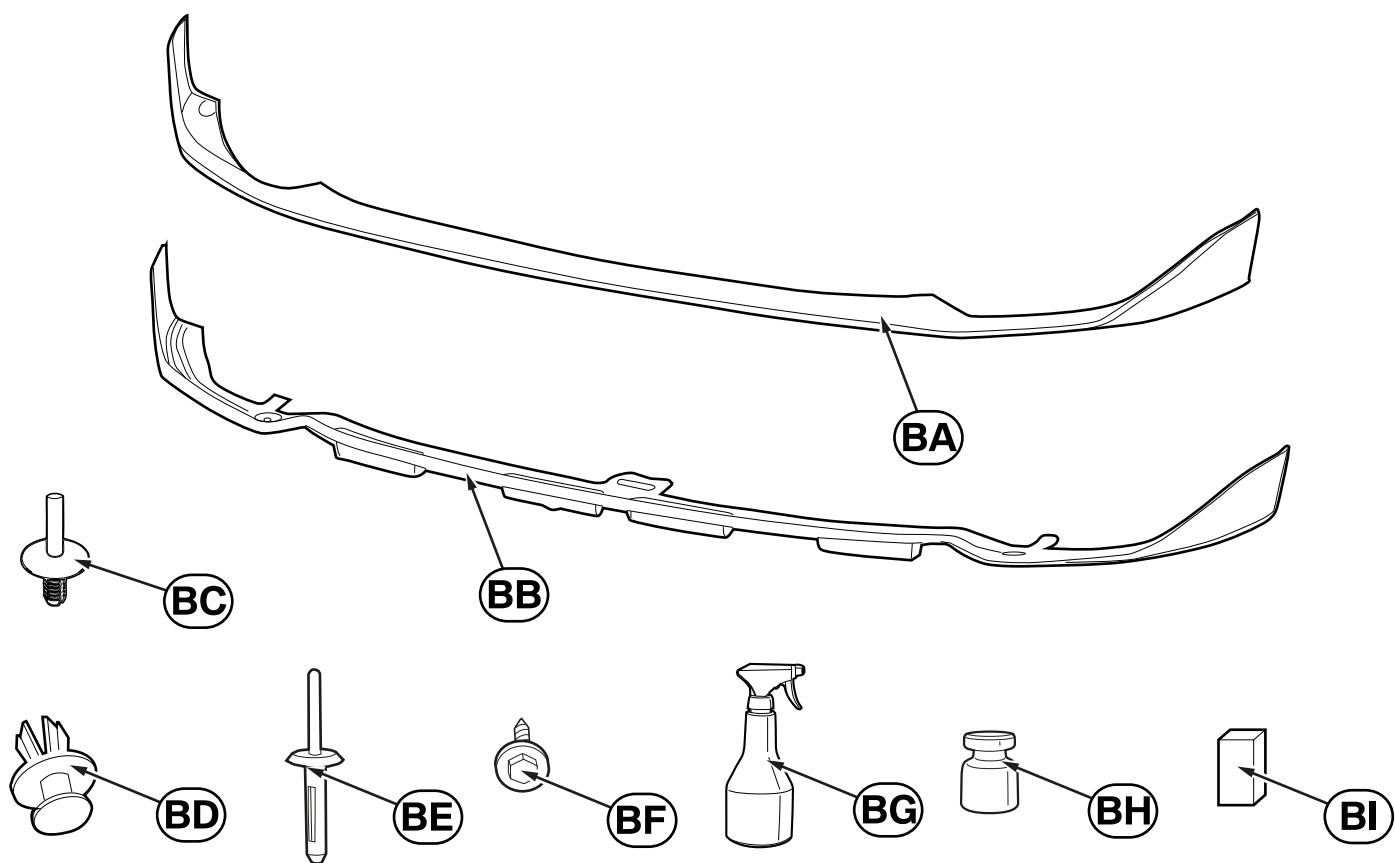


F40 0030 V

Legend

AA Carbon rear diffuser MSP (the carbon rear diffuser MPA is identical but has large cut-outs for the tailpipes)

3. Black high gloss front attachment parts list

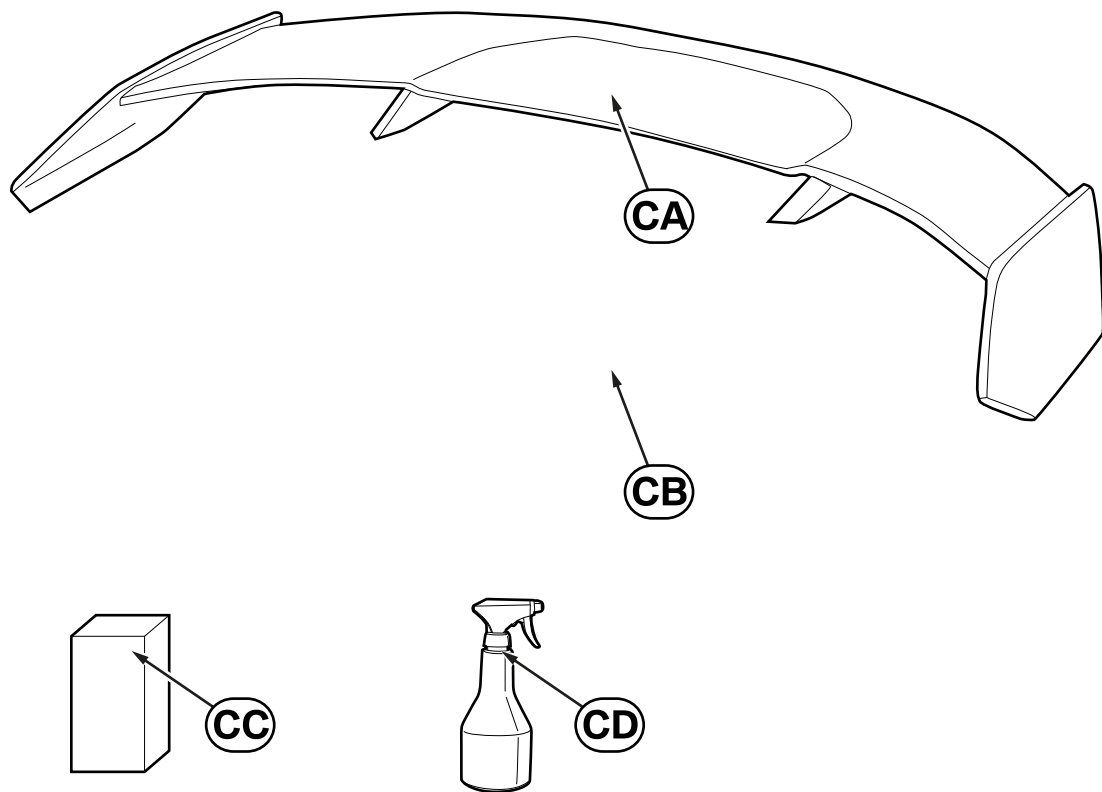


F40 0067 V

Legend

- BA** Front bumper attachment (Part No. 51 11 2 462 319)
- BB** Underbody console (Part No. 51 11 2 468 536)
- BC** Black expanding rivet (10 x, Part No. 51 77 7 171 004)
- BD** Expanding rivet (14 x, Part No. 51 47 1 911 992)
- BE** Blind rivet (2 x, Part No. 07 14 9 140 786)
- BF** Hexagon screw (4 x, Part No. 07 14 9 126 886)
- BG** Cleaner (not included in parts kit, see EPC for details and part number)
- BH** Primer (not included in parts kit, see EPC for details and part number)
- BI** Liquid adhesive (not included in parts kit, see EPC for details and part number)

4. Black high gloss throughflow rear spoiler parts list

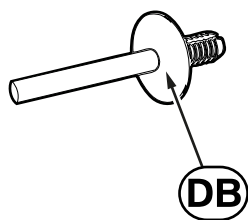
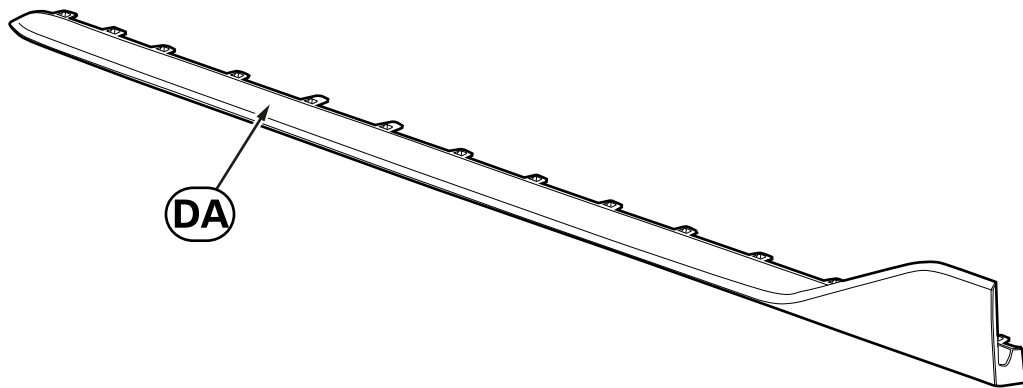


F40 0033 V

Legend

- CA** Black high gloss throughflow rear spoiler
- CB** Primed boot lid spoiler (Part No. 51 62 7 490 371, included in parts kit 51 19 2 462 543)
- CC** Liquid adhesive (not included in parts kit, see EPC for details and part number)
- CD** Cleaner (not included in parts kit, see EPC for details and part number)

5. Black high gloss side skirt insert parts list



F40 0044 V

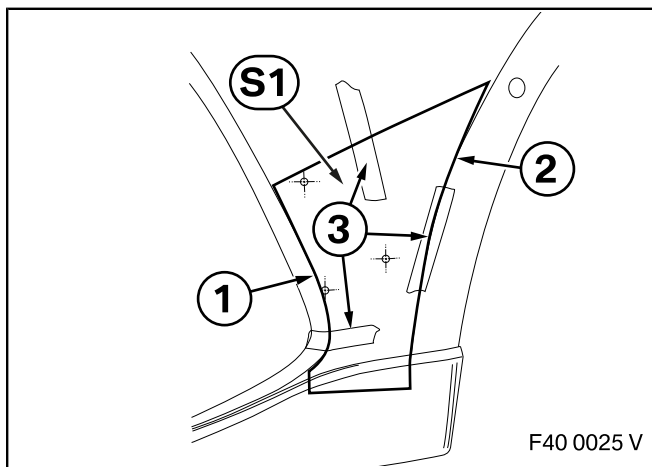
Legend

- DA** Black high gloss side skirt insert, left/right (the illustration shows the left side)
- DB** Expanding rivet (10 x per side)
- DC** Cleaner R2 (not included in parts kit, see EPC for details and part number)

6. Preparatory work

	ISTA/AIR No.
The following components must be removed first of all	
None	---

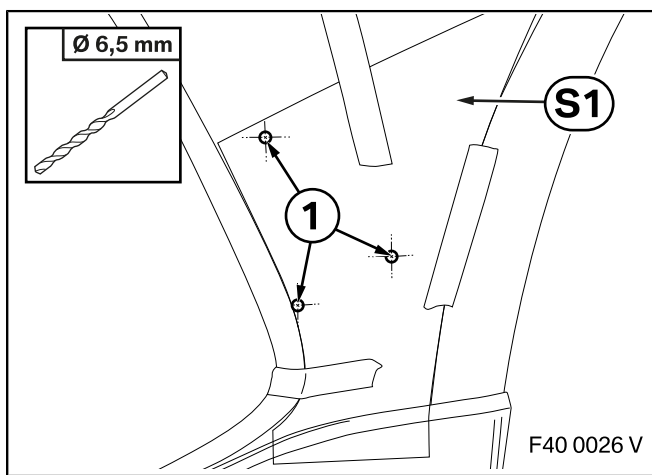
7. Aero Flick carbon side panel installation



Print the template **S1** in the annex **without** scaling on DIN A4 paper. To do this, in printer settings go to **“Actual size”**. The printer setting must not be set to **“Fit”**.

Check the reference dimension on the print-out using a ruler. ◀

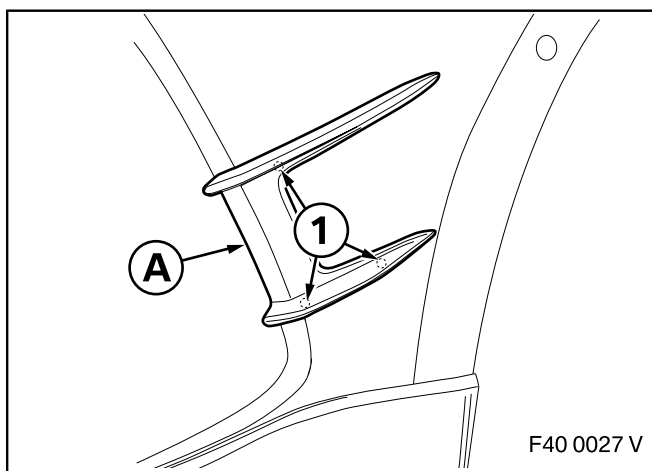
Position the template **S1** on contour (1) and contour (2) of the wheel arch, align it and secure it with suitable adhesive tape (3).



Drill through the marks (1) with a **6.5 mm** drill bit. ◀

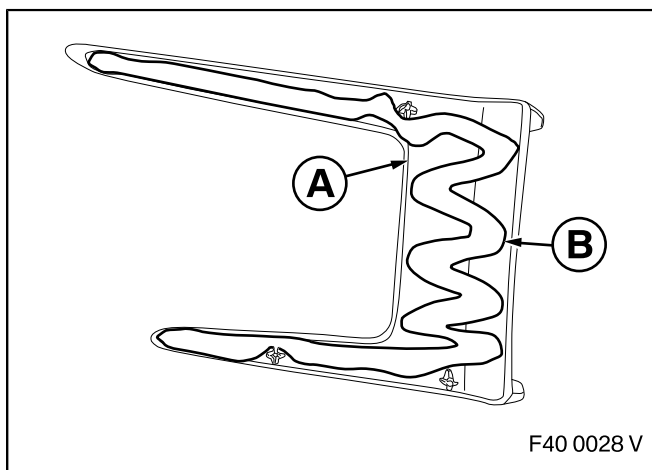
Drill holes at the marks (1) on template **S1** with a **6.5 mm** drill bit.

Then remove the template **S1**.



Place the Aero Flick **A** in the three boreholes (1) and check that it is positioned correctly.

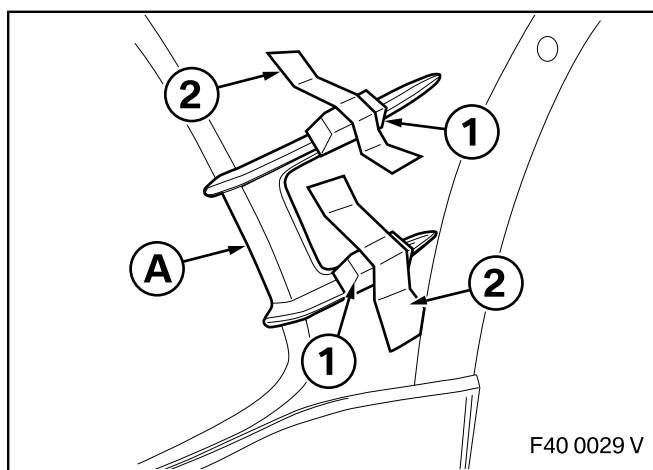
Remove the Aero Flick **A** again.



Clean the rear of the Aero Flick **A** and the car's surface in the bonding area using the cleaner **C**. ◀

Apply a bead of liquid adhesive **B** as shown to the rear of the Aero Flick **A**.

7. Aero Flick carbon side panel installation

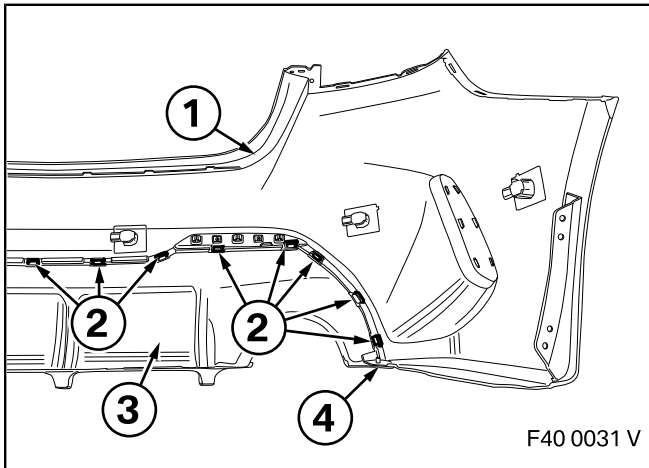


▶ Remove any excess liquid adhesive immediately using suitable equipment. ◀

Position the Aero Flick **A** and press it firmly into place.

Apply pressure to the Aero Flick **A** using suitable pieces of foam (1) and adhesive tape (2) and follow the instructions for use for the liquid adhesive.

8. Carbon rear diffuser installation



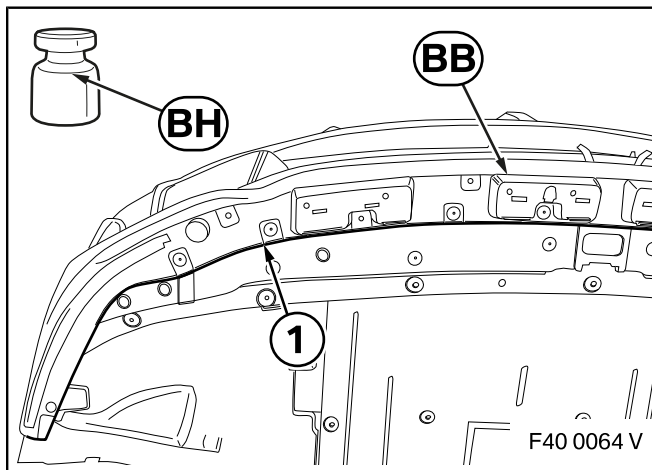
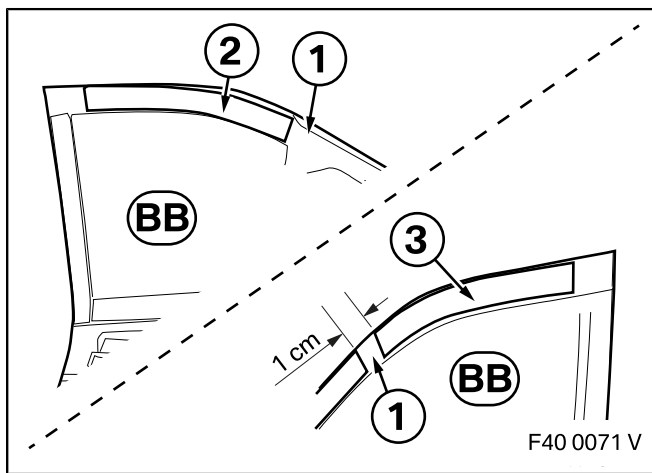
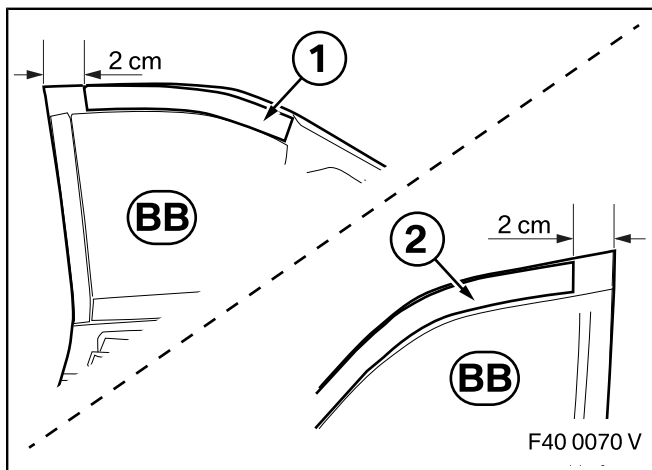
▶ Remove the rear apron (1) as described in **ISTA/AIR**. ◀

Release the clips (2) on the standard rear diffuser (3). Also remove the plastic rivets (4) on both sides.

Click the carbon rear diffuser **AA** into the rear apron and ensure that it is secure. Insert the two plastic rivets (4) again.

Install the rear apron (1) as described in **ISTA/AIR**.

9. Installing the black high gloss front attachment



For front attachment retrofit kit AI01 (change index 01)

- Parts of the adhesive tape (1) and adhesive tape (2) must be removed from both the inside and outside of the underbody console **BB** so that additional liquid adhesive can be applied for the installation process. ◀

Cut and completely remove a length of **approx. 2 cm** of the adhesive tape (1) and adhesive tape (2) from the outside edge on the **inside and outside** of the underbody console **BB**.

In addition, at the point (1) at which the adhesive tape (2) inside, a length of **1 cm** of the adhesive tape (3) must be completely removed in the identical area (1) on the outside.

- Adhesive residues must be completely removed from the cleared areas using suitable materials. ◀

For all cars

- The bonding surfaces must be completely clean, and free from wax or grease. Clean the surfaces with cleaner **BG**. ◀

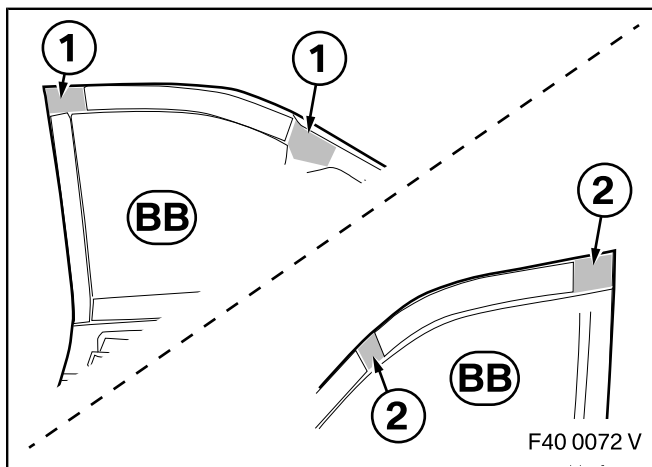
Sketch the contours (1) of the underbody console **BB** with a water-soluble pen by holding the underbody console **BB** in position.

- Apply the primer **BH** accurately as otherwise it will discolour the front apron in black. ◀

Remove the underbody console **BB** and apply the primer **BH** accurately within the contours (1) level with the adhesive bond.

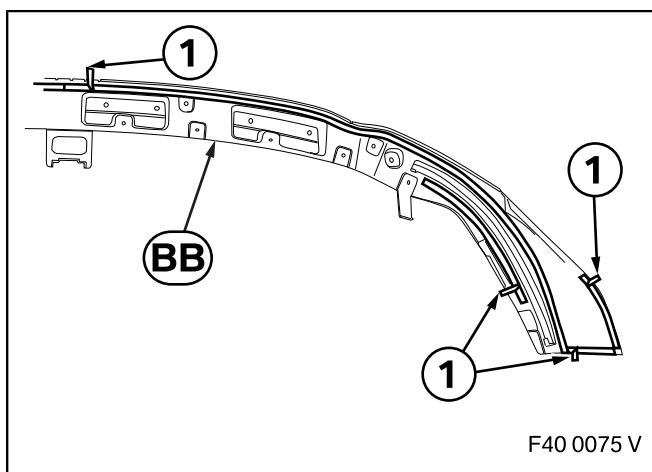
- Wait for the full drying time to elapse. ◀

9. Installing the black high gloss front attachment

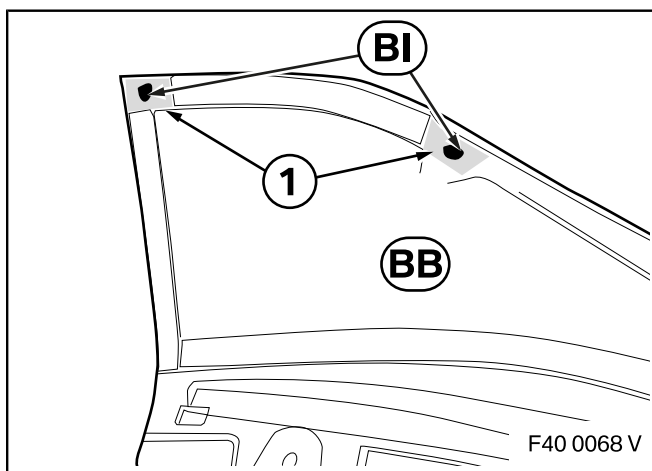


Abrade and clean the areas (1) on the **inside** and the areas (2) on the **outside** of the underbody console **BB** using suitable materials.

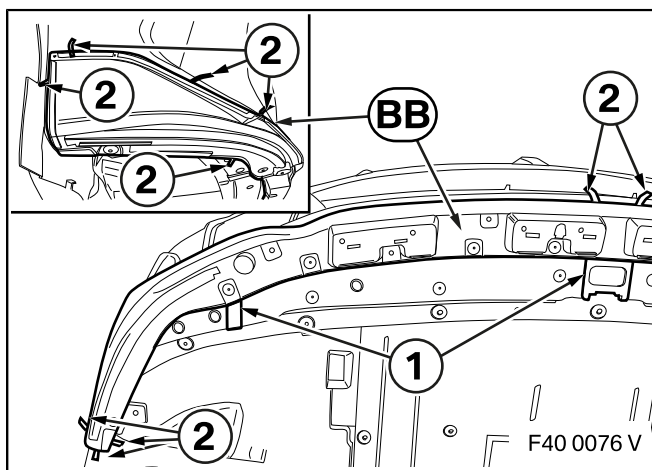
Also abrade and clean the inside of the front bumper attachment **BA** in the area in which the liquid adhesive is used (not shown).



Remove the ends of the backing foils (1) on the adhesive tape before positioning the underbody console **BB** and bend them outwards.



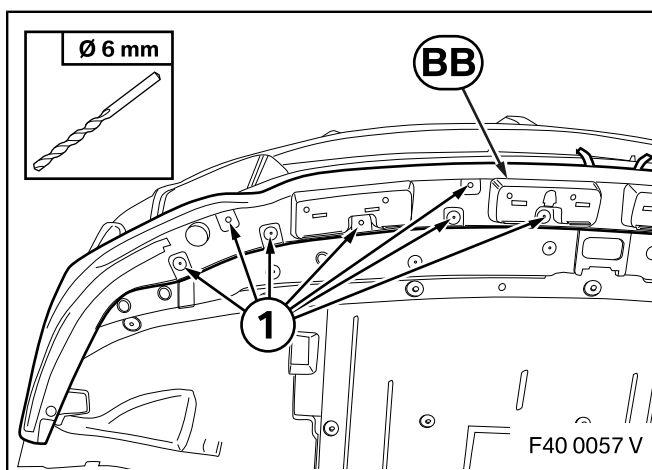
Apply a dot of liquid adhesive **BI** on the inside of the underbody console **BB** in each of the marked areas (1).



Position the underbody console **BB** on the front apron using the positioning tools (1), press it gently into place and pull out the backing foil (2) from inside to outside. Then press the underbody console **BB** firmly and repeatedly into position to bond it to the front apron.

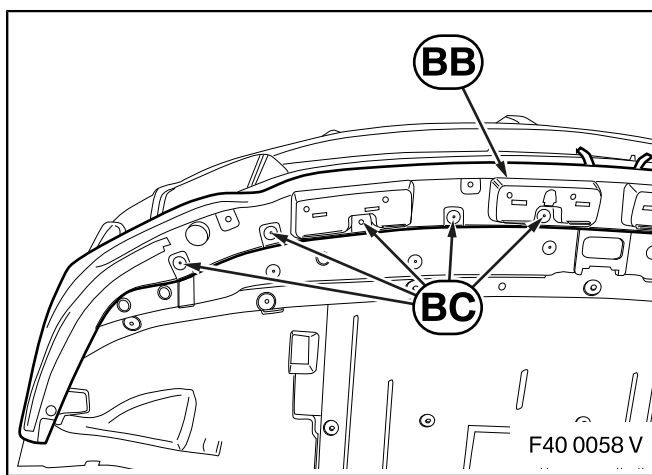
☐ Remove any excess liquid adhesive immediately using suitable equipment. ◀

9. Installing the black high gloss front attachment



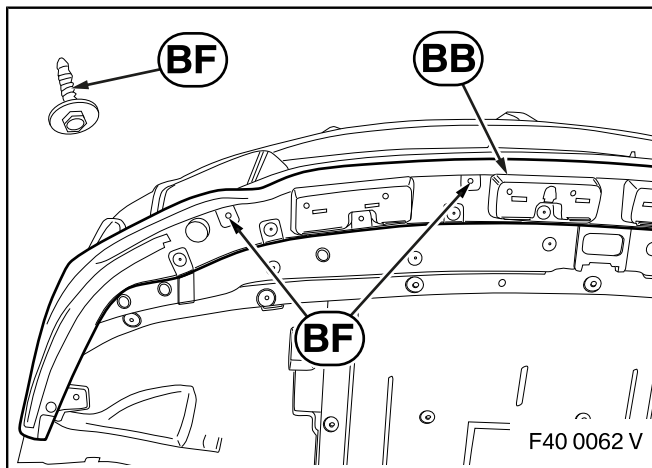
▶ **For MPA (M Performance cars)**
If necessary, redrill the existing boreholes (1) with a **6 mm** drill bit. ◀

▶ **For MSP (M Performance sport)**
Drill the boreholes (1) with a **6 mm** drill bit. ◀

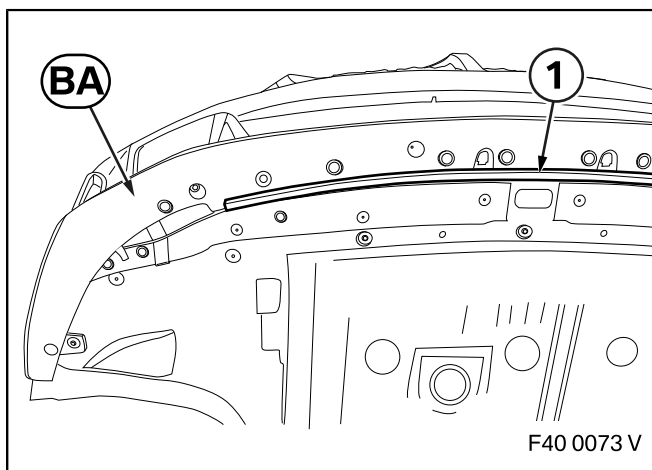


For all cars

Secure the underbody console **BB** using the expanding rivets **BC**.



Secure the underbody console **BB** at the screw points using the hexagon screws **BF**.

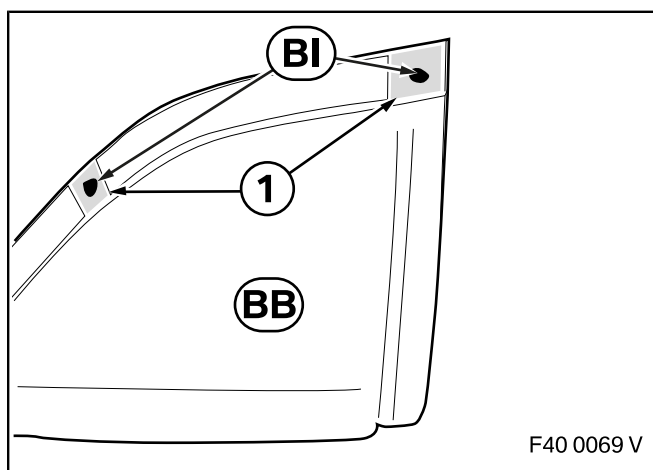


Take the standard air guide (1) and install it on the front bumper attachment **BA**.

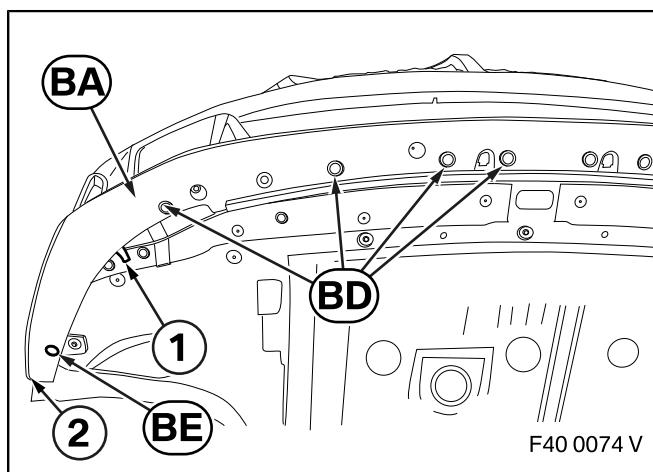
Apply the primer **BH** to the inside of the front bumper attachment **BA** around the bonding seam to the underbody console **BB** (not shown).

▶ Wait for the full drying time to elapse. ◀

9. Installing the black high gloss front attachment



Apply a dot of liquid adhesive **BI** on the outside of the underbody console **BB** in each of the marked areas (1).

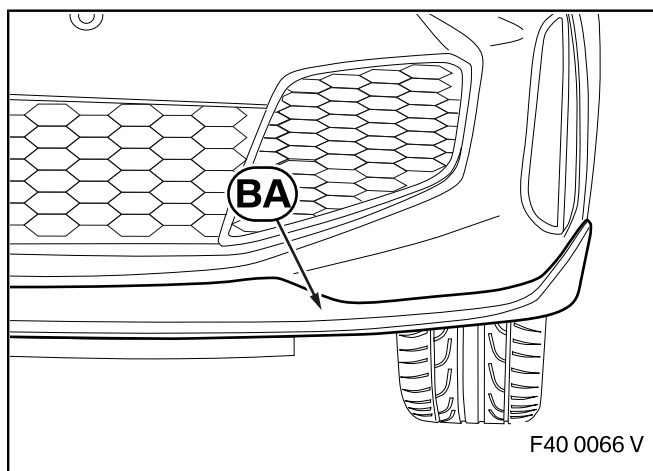


Bend over the ends of the backing foil (1) on the underbody console **BB**.


Position the front bumper attachment **BA** on the underbody console **BB** from the front, centre it so that the distance to the wheel arch (2) on both sides is identical and then gently press it into place.

Pull out the end of the backing foil (1) completely and secure the expanding rivet **BD**.

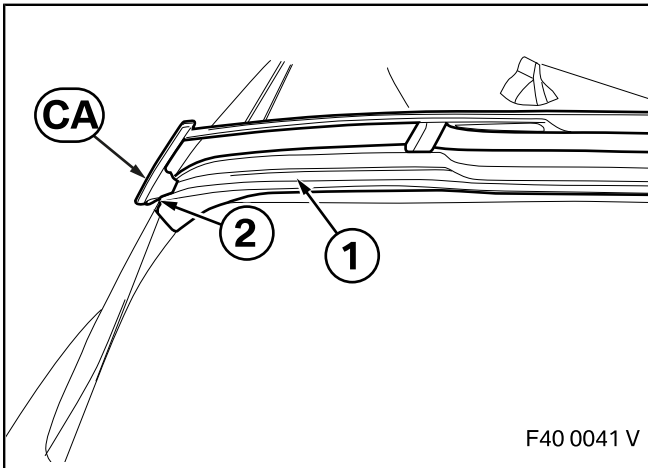
Use the blind rivets **BE** for the two outermost riveting points.



Repeatedly press the front bumper attachment **BA** into place firmly.

 Remove any excess liquid adhesive immediately using suitable equipment. ◀

10. Installing the black high gloss throughflow rear spoiler



For MSP (M Performance sport)

First of all, the primed boot lid spoiler **CB** (Part No. 51 62 7 490 371) must be installed as described in **ISTA/AIR**.

The bonding surface must be completely clean and free from grease. ◀

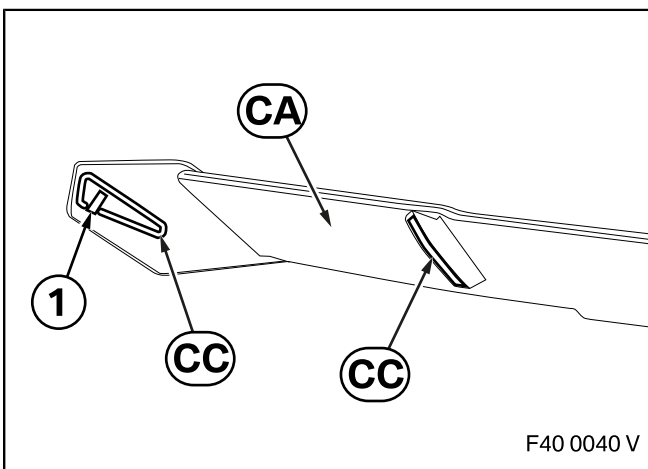
For all cars

Clean the bonding surface with cleaner **CD**. Position the rear spoiler **CA** on the roof edge spoiler (1). Fit the contours (2) of the rear spoiler into the contours of the roof edge spoiler (1), then centre it and make a mark on the left and right using suitable equipment.

Then remove the rear spoiler **CA**.

◻ Clean the bonding surfaces with cleaner **CD**. ◀

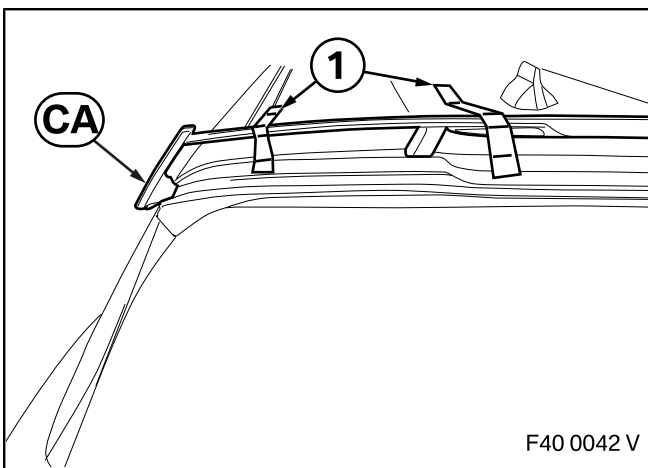
Remove the backing film (1) from the adhesive tape. Apply a bead of liquid adhesive **CC** to the inside as shown.



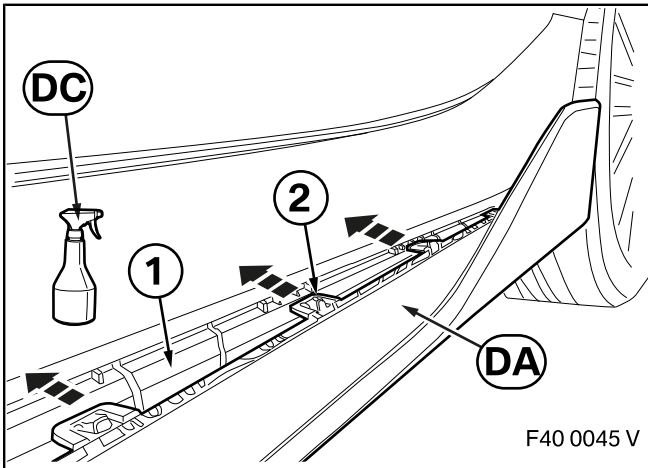
Position the rear spoiler **CA**, align it using the marks and press it into position. Secure it using suitable adhesive tape (1).

◻ Remove any excess liquid adhesive immediately using suitable equipment.

Refer to the installation instructions on page 2. ◀



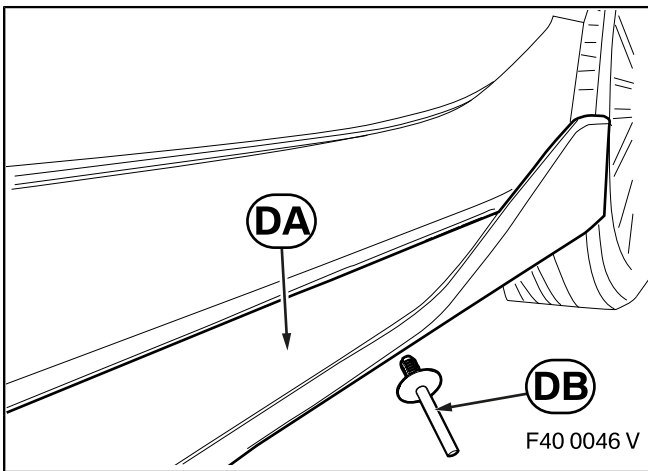
11. Installing the black high gloss side skirt insert



▶ Cut the expanding rivets on the standard side sill insert using suitable tools and remove the standard side sill insert, starting from the front. ◀

Wet the side skirt (1) and the high gloss black side skirt insert **DA** with cleaner R2 **DC** to make them easier to install.

Press the high gloss black side skirt insert **DA** into position, starting from the rear so that the locking lugs (2) engage.



Insert and secure the expanding rivets **DB** in the existing boreholes on the underside of the high gloss black side skirt insert **DA**.

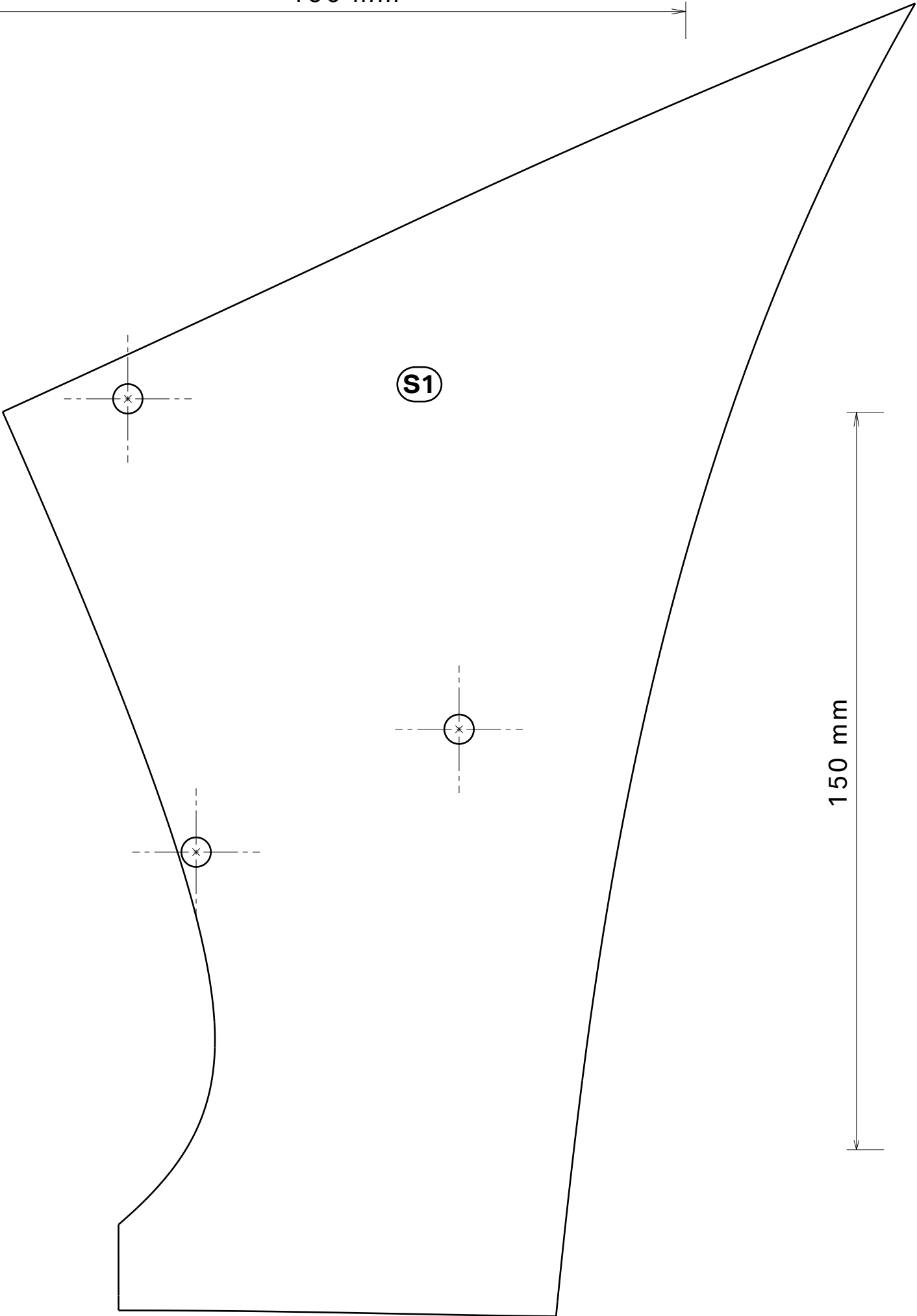
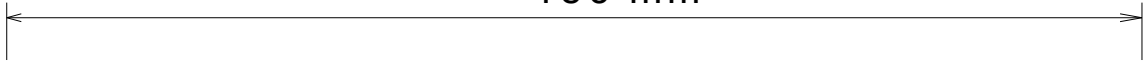
▶ If the Frozen Black foil application (part number: 51 14 2 465 580) is not fitted, the M Performance logo sticker (part number: 51 14 2 461 811, to be ordered separately) should be fitted. ◀

12. Concluding work and coding

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

- Connect the battery
- Connect the battery charger to the car
- Connect the car to the ISTA workshop system
- Open the ISTA/P car programming facility
- If using ISTA/P, please refer to the instructions provided in the ISTA/P application documentation
- Retrofit customer service word for carbon rear diffuser **AA**: Select "DSMO" via the – **Retrofits** – path and work through the action plan
- If necessary, carry out a vehicle test using the ISTA system, and note, or work through, any errors that have been recorded
- Conduct a function test
- Re-assemble the car
- Give the customer the customer information

150 mm



S1

150 mm

