

# Original BMW Accessories.

## Installation Instructions.



### M Performance Aerodynamics Package Retrofit Kit BMW X5 (F15)

#### Retrofit kit number

51 19 2 334 549	Carbon front splitter
51 19 2 339 222	Carbon rear diffuser
51 19 2 334 715	Aerodynamics package left tail flap
51 19 2 348 140	Aerodynamics package right tail flap
51 62 2 284 954	Rear spoiler

#### Installation time

The installation time is **approx. 4 hours**. This may vary depending on the condition of the car 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 (no charges may be made through the warranty).

#### Important information

 The carbon front splitter must only be installed in conjunction with the roof edge spoiler. ◀

These installation instructions are primarily designed for use within the BMW dealership organisation and by authorised BMW service companies.

In any event, the target group for these installation instructions is specialist personnel trained on BMW cars with the appropriate specialist knowledge.

All work must be completed using the latest BMW repair manuals, wiring diagrams, servicing manuals and work instructions, in a rational order, using the prescribed tools (special tools) and observing current health and safety regulations.

**If you experience installation or function 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 straight away to the technical parts support team via the Aftersales Assistance Portal (ASAP).

Quote the following information:

- Vehicle identification number,
- Retrofit kit part number,
- A detailed description of the problem,
- Any work already carried out.

Do not archive the hard copy of these installation instructions since daily updates are provided via ASAP!

#### 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**

Some of the installation steps are shown only on the left-hand side of the car, proceed in the same way on the right-hand side of the car.

All affected components must be at room temperature when they are being installed.

The areas being bonded must be completely dry, clean and free from wax or grease.

All pictures show LHD cars; proceed accordingly on RHD cars.



The car may be driven after approx. 24 hours and may be taken through a car wash after approx. 48 hours. ◀

### **Ordering instructions**

To install the front carbon Aerodynamics package, Betalink must also be ordered (for instructions and part numbers, see EPC).

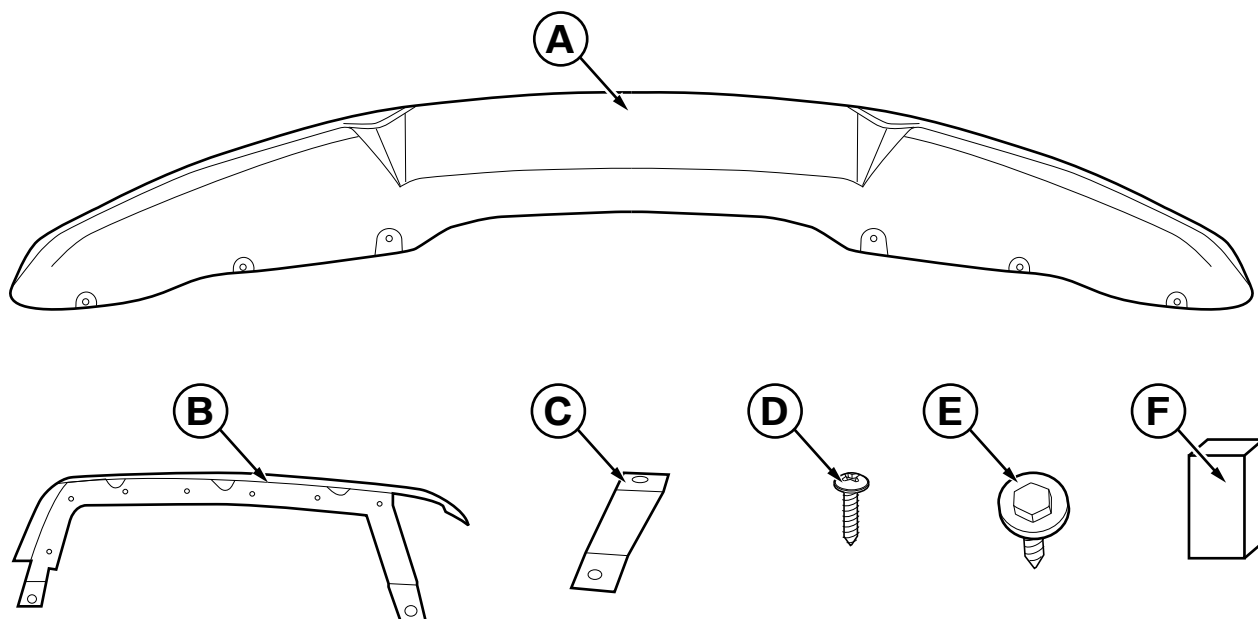
### **Special tools required**

None

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## 1. Front splitter parts list

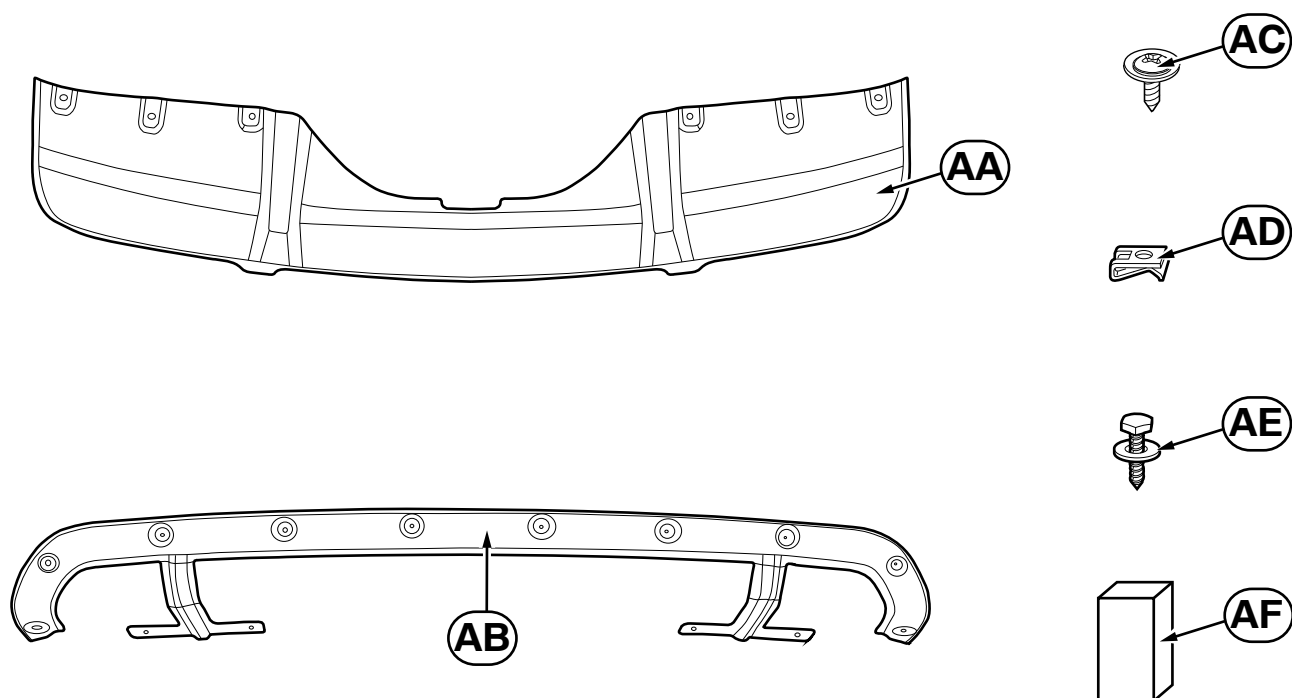


F15 0015 V

### Legend

- A** Front splitter
- B** Adapter (left/right)
- C** Z-holder (left/right)
- D** Screw (16 x)
- E** Screw (2 x)
- F** 2K Betalink (not included in the parts kit)

## 2. Rear diffuser parts list

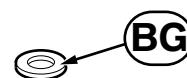
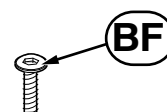
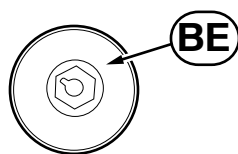
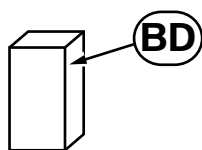
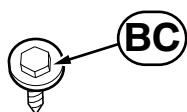
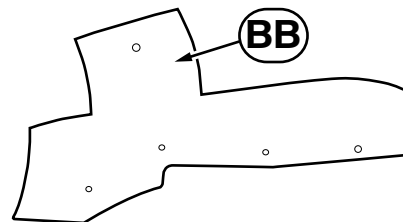
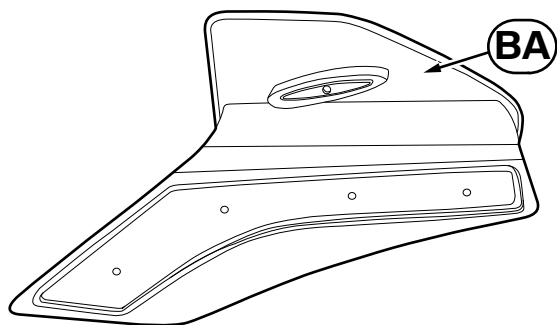


F15 0026 V

### Legend

- AA** Rear diffuser
- AB** Adapter
- AC** Screw (10 x)
- AD** C-clip (2 x)
- AE** Hexagon screw with washer (2 x)
- AF** 2K Betalink (not included in the parts kit)

### 3. Tail flaps parts list

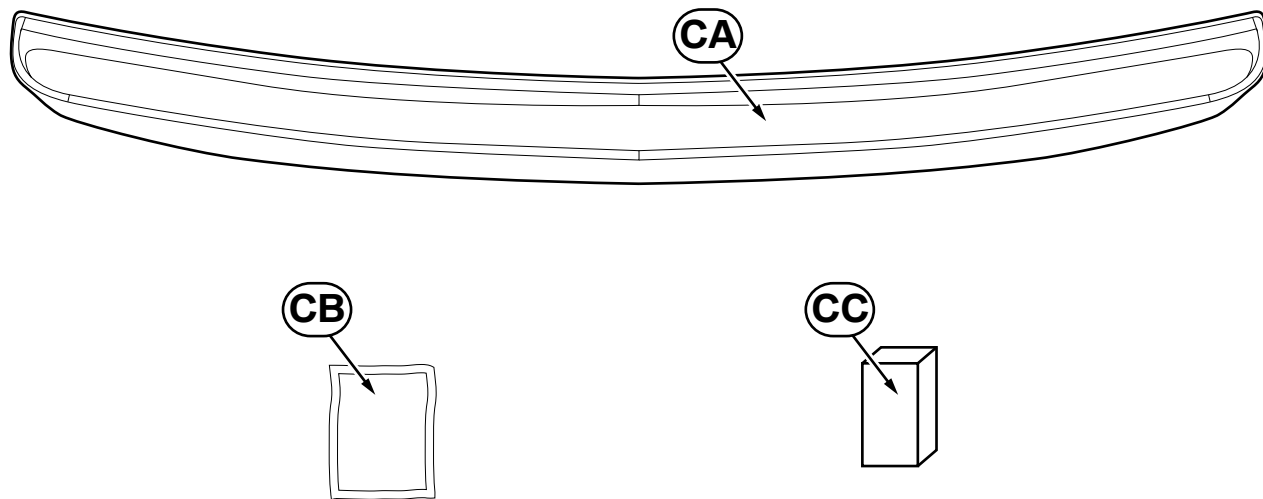


F15 0038 V

#### Legend

- BA** Tail flap (left/right)
- BB** Template
- BC** Sheet metal screw (4 x per side)
- BD** 2K Betalink incl. primer (not included in the parts kit)
- BE** Sheet metal nut (4 x per side)
- BF** Interior Torx screw (1 x per side)
- BG** Shim (1 x per side)

#### 4. Parts list for rear spoiler



F15 0096 V

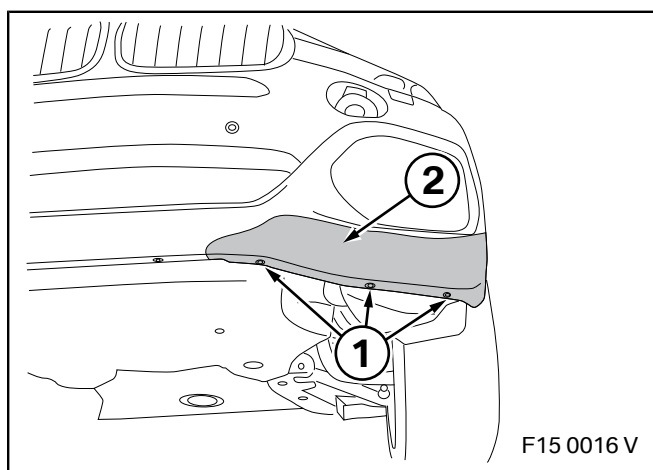
#### Legend


- CA** Rear spoiler
- CB** Cleaning pad
- CC** Betalink (not supplied)

5. Preparatory work

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

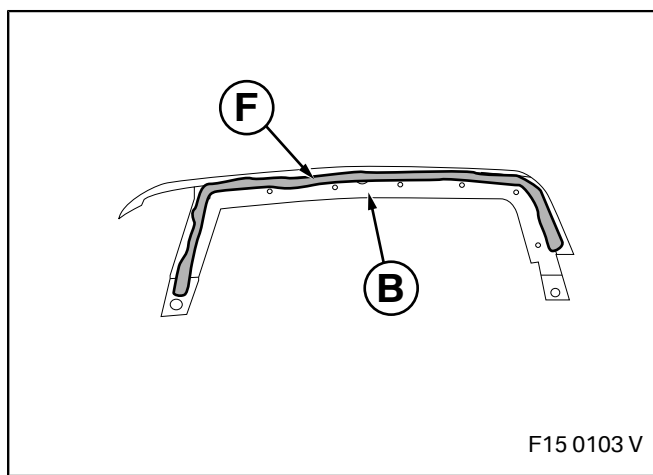
## 6. Fitting the front splitter



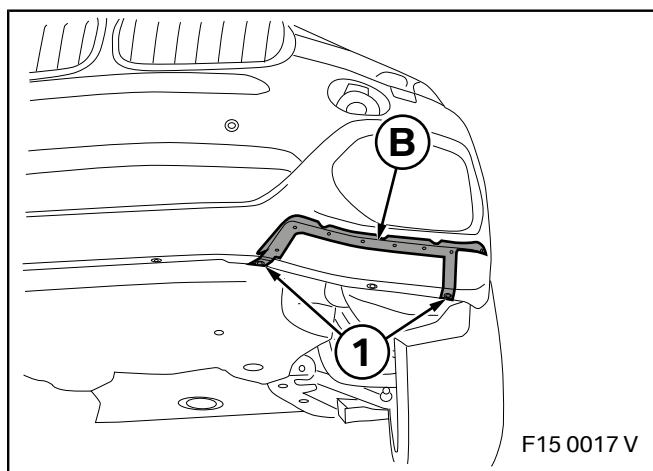
 The areas being bonded must be completely dry, clean and free from wax or grease. ◀


Remove the screws (1) and keep them safe.

Clean the surface (2) of the front apron with suitable agents




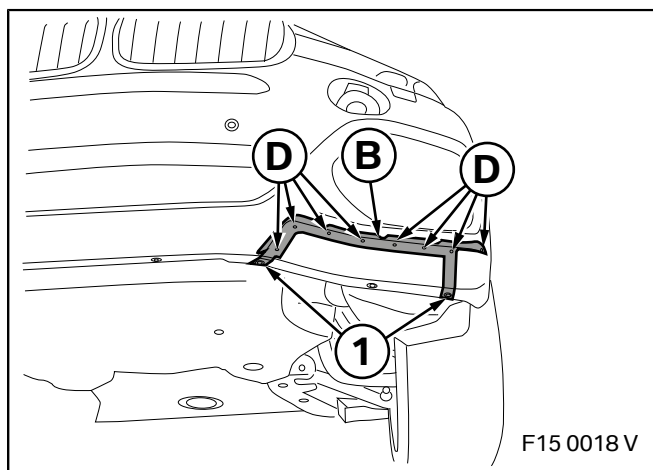
Generously apply Betalink **F** on the inside of adapter **B** as shown.



 The areas being bonded must be completely dry, clean and free from wax or grease. ◀

Affix adapter **B** and secure in place with the existing screws (1).

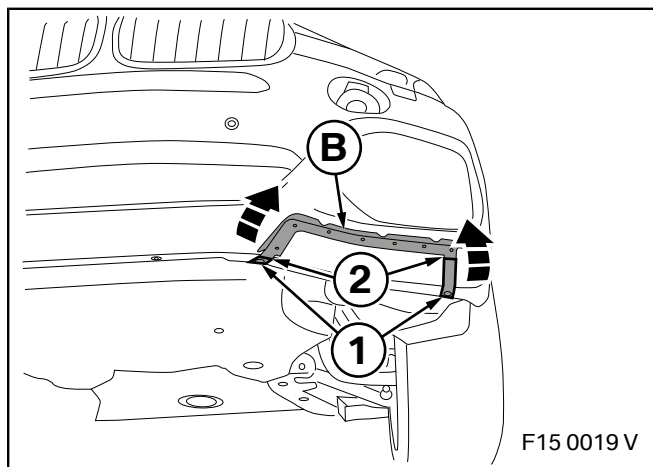
 Remove any Betalink that oozes out immediately. ◀



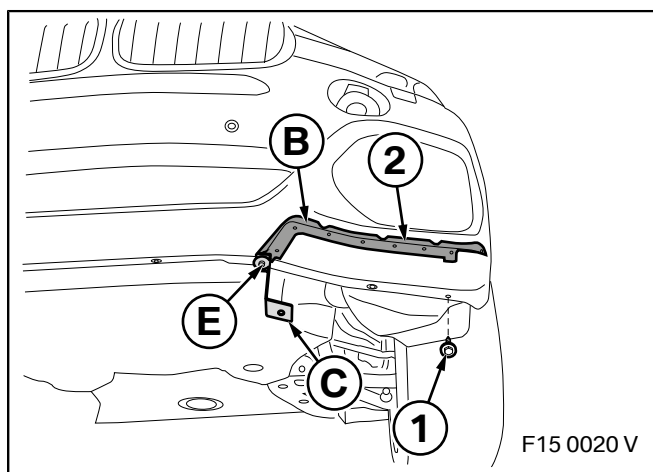
Secure adapter **B** using eight screws **D** to the front apron.

Remove the screws (1) and keep them safe.

## 6. Fitting the front splitter



Break off the positioning aids (1) on adapter **B** by bending them several times at the edges (2).



Secure Z-holder **C** using screw **E** onto the underside of the front apron.

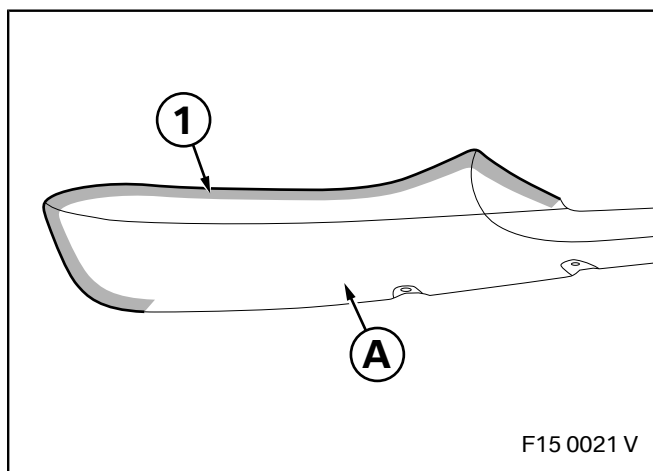
Screw in the existing screw (1).

Sand the area (2) of adapter **B** using suitable agents.

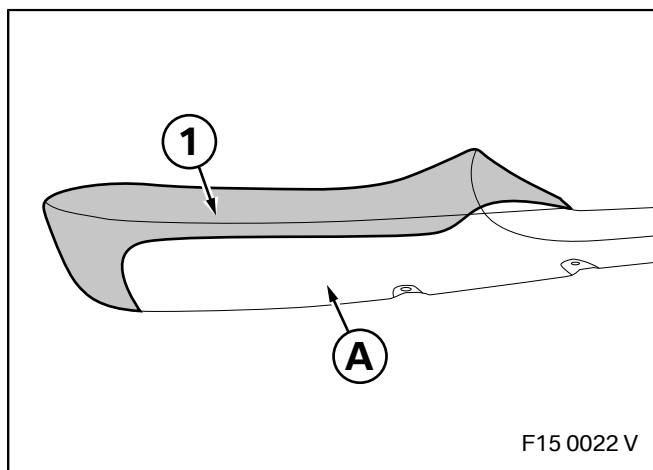
▶ The areas being bonded must be completely dry, clean and free from wax or grease. ◀

Clean and prime the area (2) of adapter **B** using suitable agents.

▶ Note the ventilation time of **5 minutes**. ◀



Sand the area (1) of front splitter **A** using suitable agents.

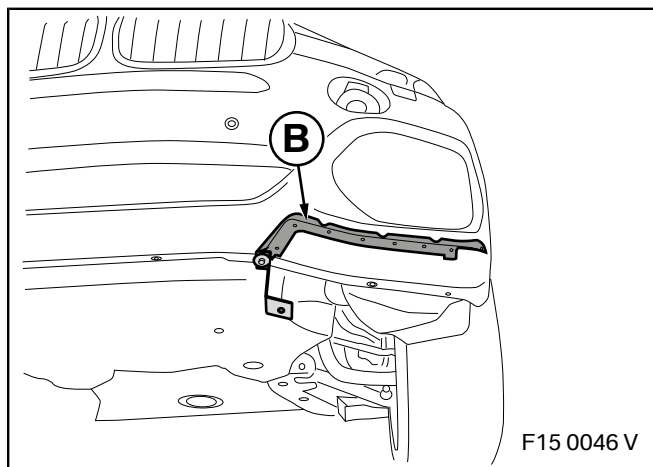


▶ The areas being bonded must be completely dry, clean and free from wax or grease. ◀

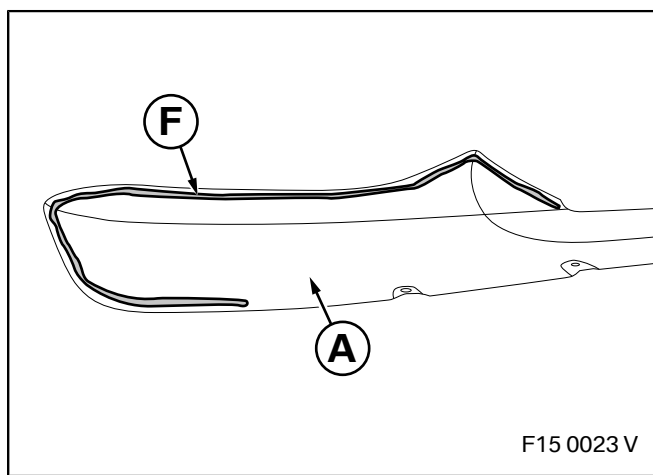
Clean and prime the area (1) of front splitter **A** using suitable agents.

▶ Note the ventilation time of **5 minutes**. ◀

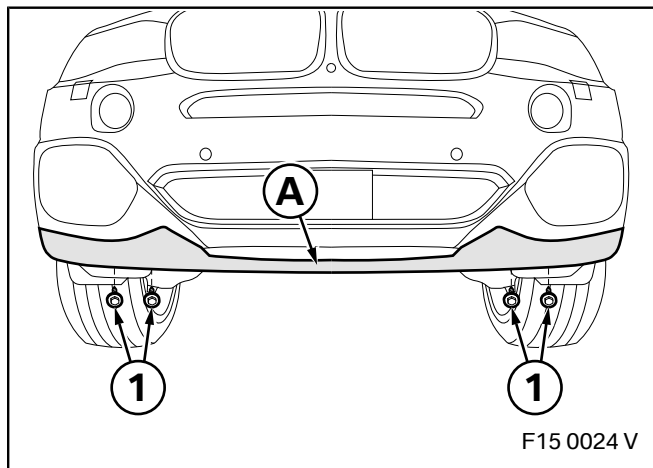
## 6. Fitting the front splitter



Apply Betalink **F** to adapter **B**.



Generously apply Betalink **F** on the inside of front splitter **A** as shown.

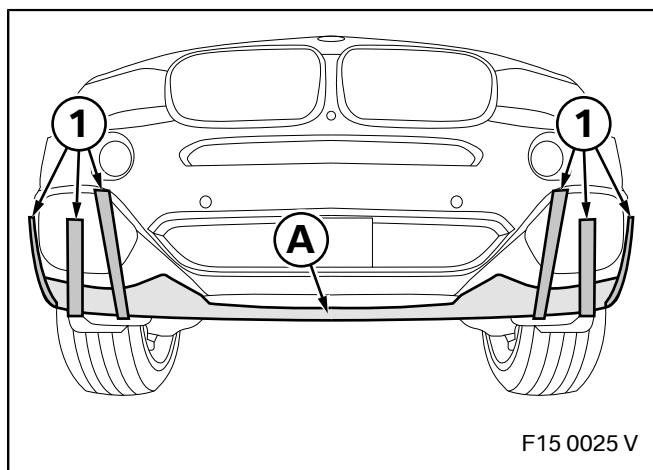


▶ The areas being bonded must be completely dry, clean and free from wax or grease. ◀

Place front splitter **A** on the car's front apron, align and press into place.

Screw the existing screws (1) through front splitter **A** into Z-holder **C** and the serial connection.

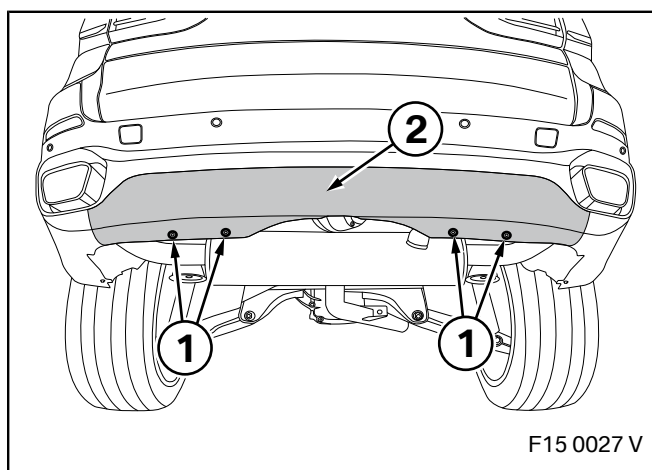
▶ Remove any Betalink that oozes out immediately. ◀



Secure front splitter **A** using a suitable adhesive strip (1) as shown.

▶ Do not remove the adhesive strips for around 24 hours and do not move the car. ◀

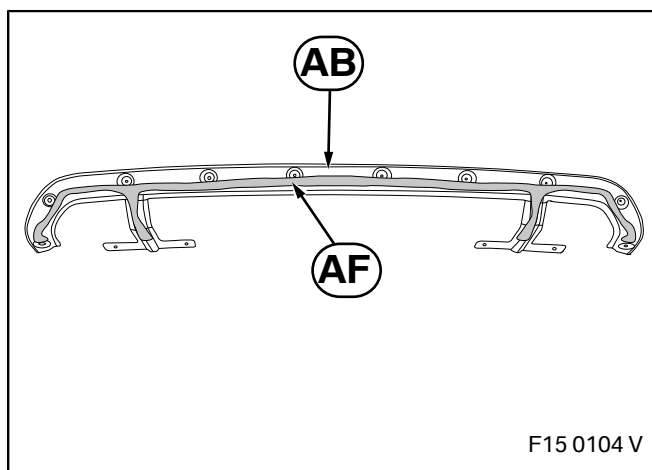
## 7. Fitting the rear diffuser



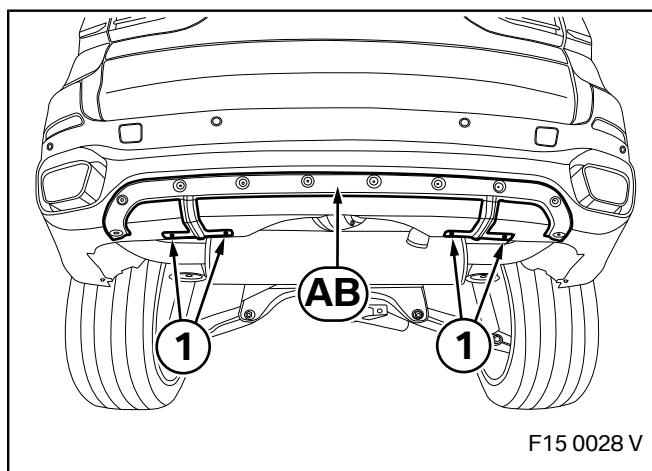
▶ The areas being bonded must be completely dry, clean and free from wax or grease. ◀

Remove the screws (1) and keep them safe.

Clean the surface (2) of the rear apron with suitable agents.



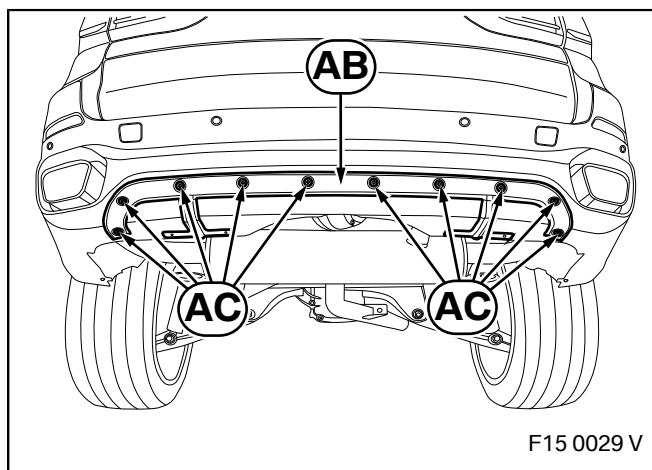
Generously apply Betalink **AF** on the inside of adapter **AB** as shown.



▶ The areas being bonded must be completely dry, clean and free from wax or grease. ◀

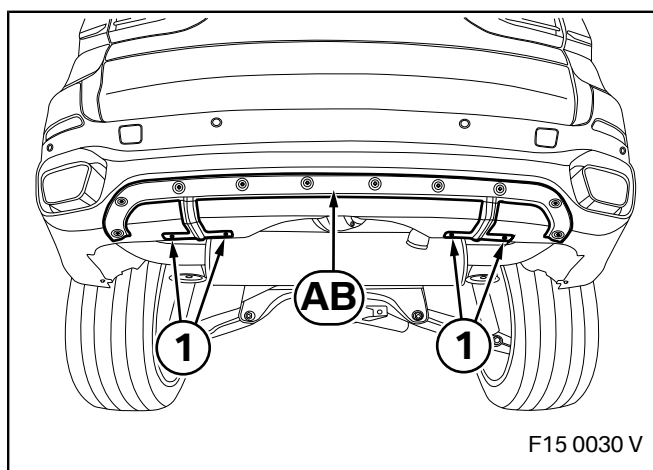
Affix adapter **AB** and secure in place with the existing screws (1).

▶ Remove any Betalink that oozes out immediately. ◀

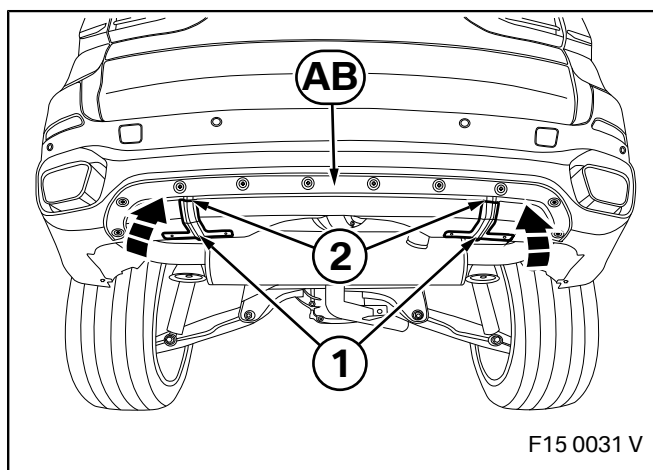


Secure adapter **AB** using ten screws **AC** to the front apron.

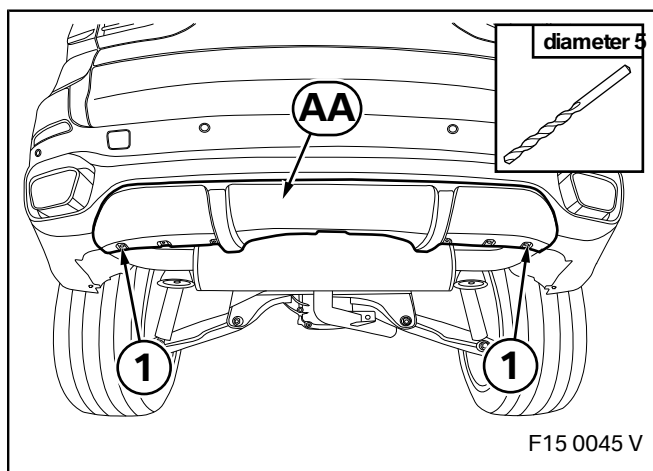
## 7. Fitting the rear diffuser



Remove the screws (1) and keep them safe.



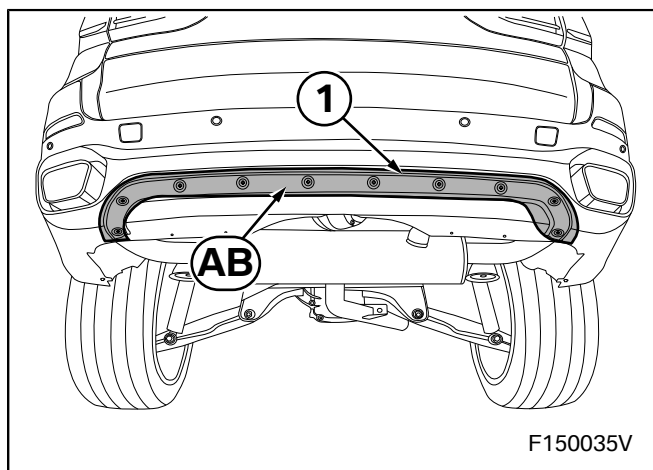
Break off the positioning aids (1) on adapter **AB** by bending them several times at the edges (2).



Place rear diffuser **AA** on the car's rear apron, align and transfer the drill holes (1) onto the rear apron. Remove rear diffuser **AA**.

Drill through the marks (1) on the rear apron using a **5 mm diameter** drill bit.

Place C-clip **AD** on the drill holes (1).



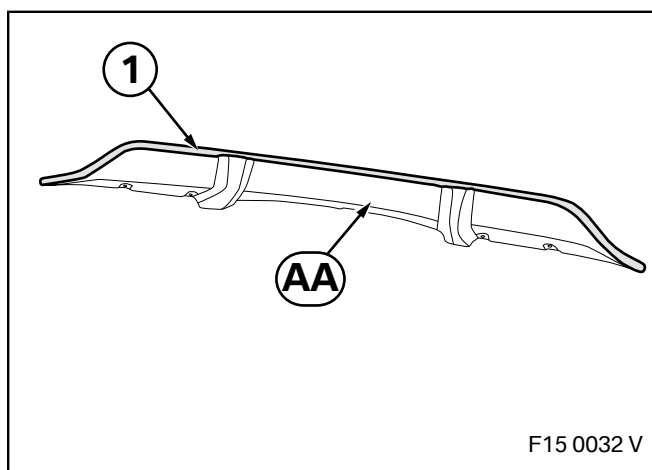
Sand the area (1) of adapter **AB** using suitable agents.

▢ The areas being bonded must be completely dry, clean and free from wax or grease. ◀

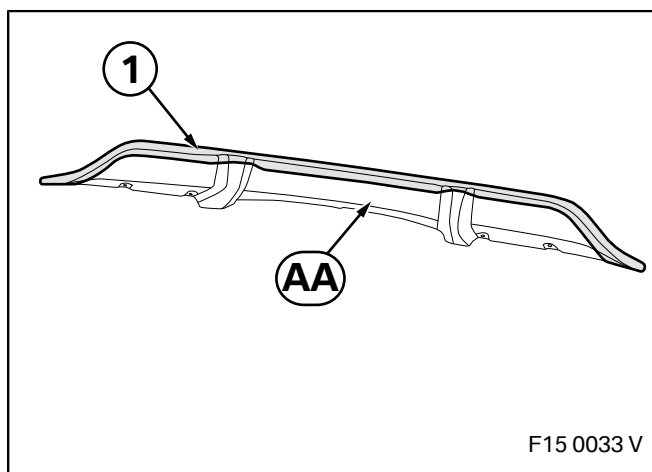
Clean and prime the area (1) of adapter **AB** using suitable agents.

▢ Note the ventilation time of **5 minutes**. ◀

## 7. Fitting the rear diffuser



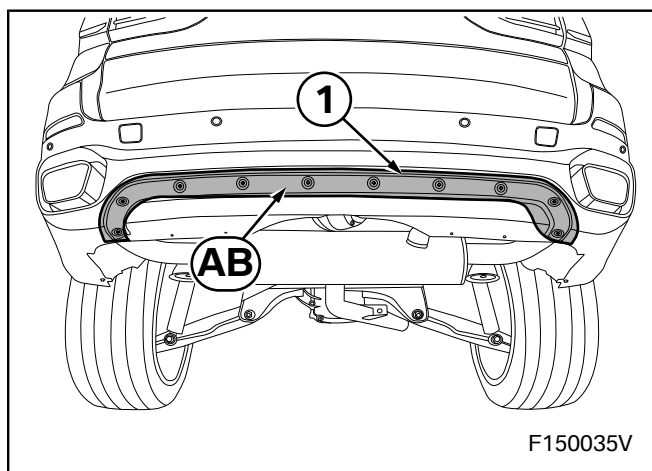
Sand the area (1) of rear diffuser **AA** using suitable agents.



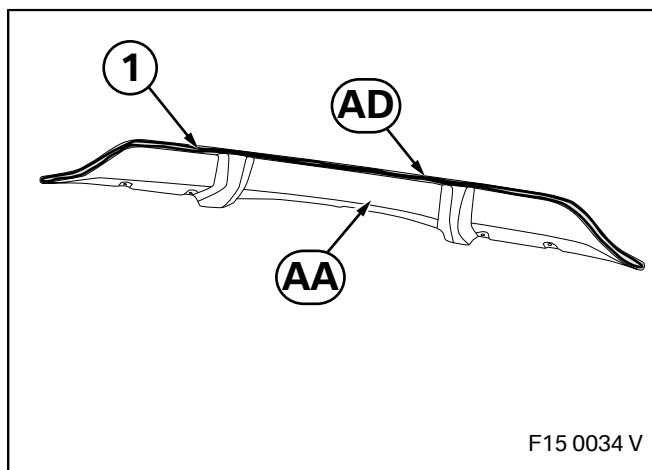
▢ The areas being bonded must be completely dry, clean and free from wax or grease. ◀

Clean and prime the area (1) of rear diffuser **AA** using suitable agents.

▢ Note the ventilation time of **5 minutes**. ◀

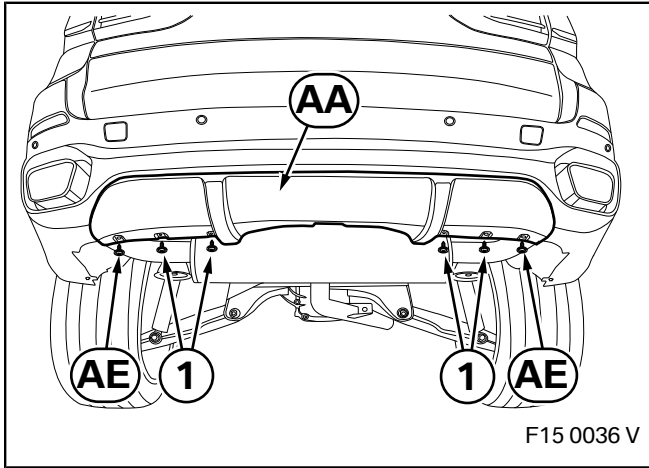


Apply Betalink **AF** on the surface (1) of adapter **AB**.




Generously apply Betalink **AF** on the surface (1) of rear diffuser **AA** as shown.

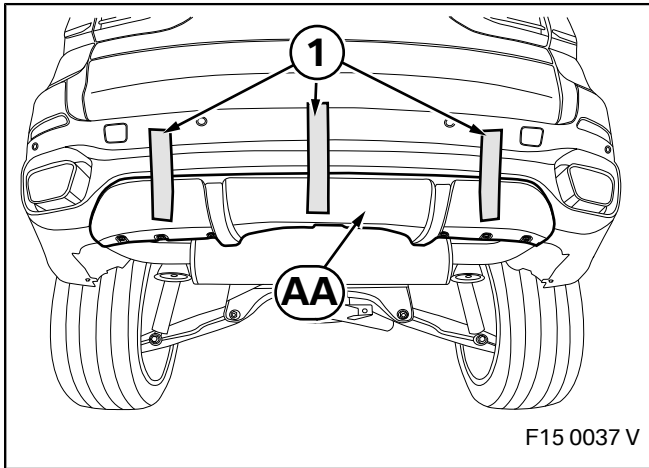
## 7. Fitting the rear diffuser




Place rear diffuser **AA** on the car's rear apron, align and press into place.

Then secure rear diffuser **AA** using the existing screws (1) and hexagon screw **AE**.

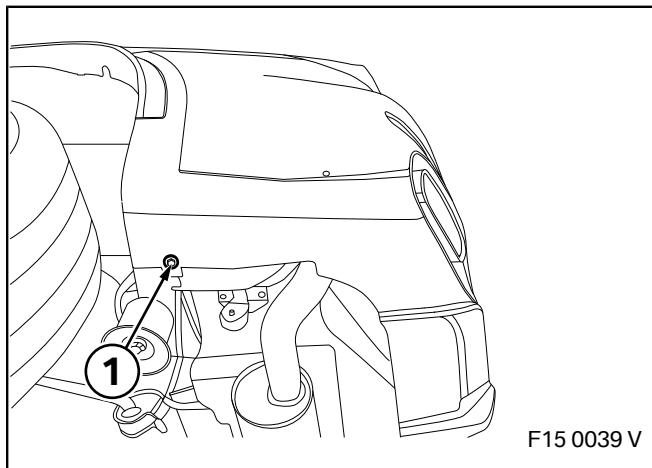
 Remove any Betalink that oozes out immediately. ◀



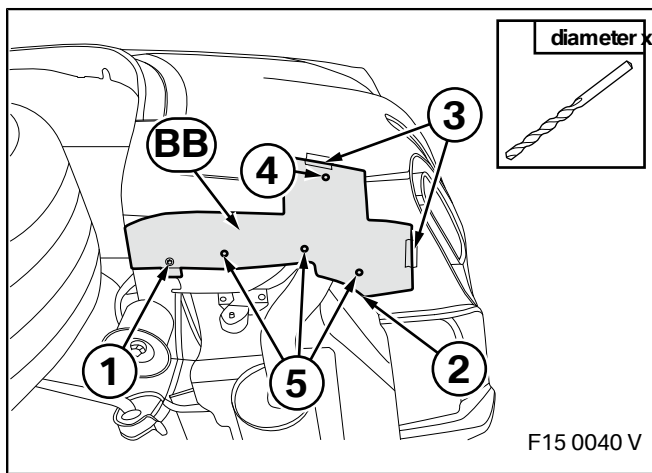
Secure rear diffuser **AA** using a suitable adhesive strip (1) as shown.

 Do not remove the adhesive strips for around 24 hours and do not move the car. ◀

## 8. Fitting the tail flaps



Remove the screw (1) and keep it safe.



Attach template **BB** and secure with the screw (1).

Align template **BB** with the edge (2) and secure in place with a suitable adhesive strip (3).

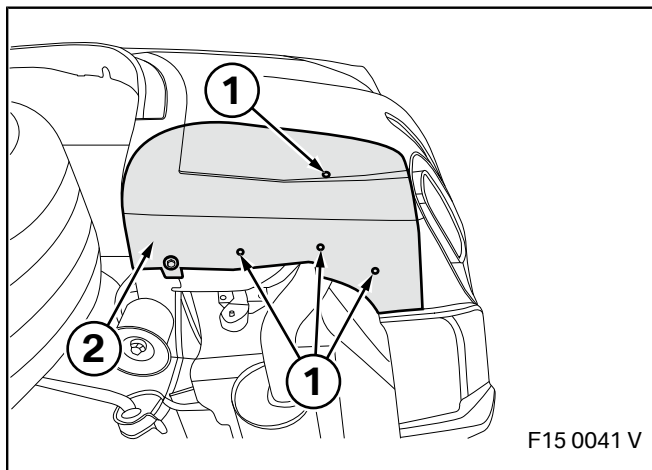
Drill a hole (4) through the rear apron using a **10 mm diameter** drill bit.

Drill holes (5) through the rear apron using a **6 mm diameter** drill bit.

Remove the screw (1) and keep it safe.

Remove the adhesive strip (3) and template **BB**.

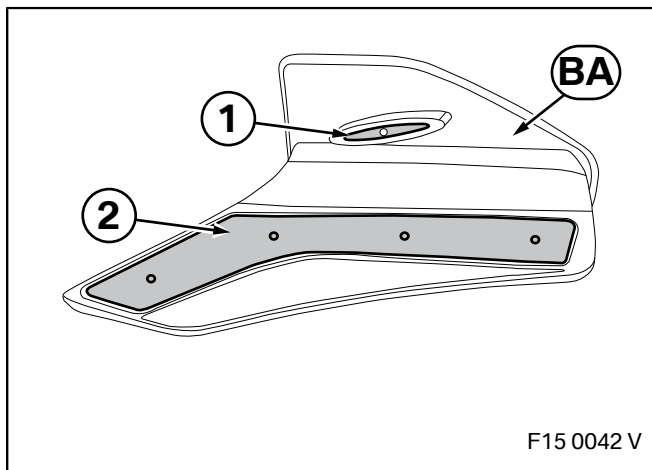
Screw in the screw (1).



☐ The areas being bonded must be completely dry, clean and free from wax or grease. ◀

Deburr the holes (1).

Clean the surface (2) with suitable agents.



☐ Check that the tail flaps fit accurately on the car before fitting them. ◀

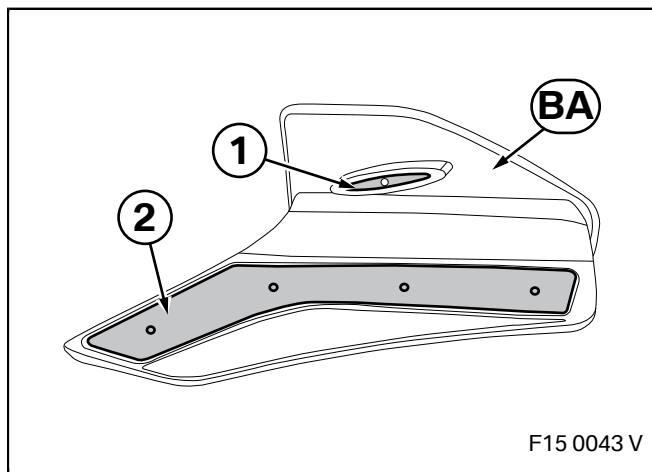
Sand surface (1) and (2) on tail flap **BA** using suitable agents.

☐ The areas being bonded must be completely dry, clean and free from wax or grease. ◀

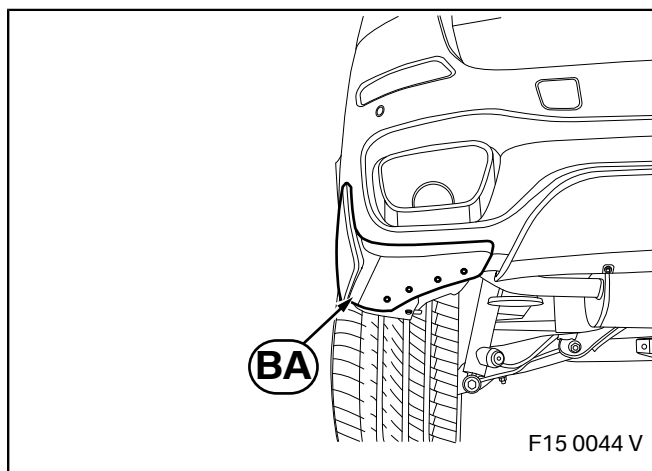
Clean and prime surface (1) and (2) on tail flap **BA** using suitable agents.

☐ Note the ventilation time of **5 minutes**. ◀

## 8. Fitting the tail flaps



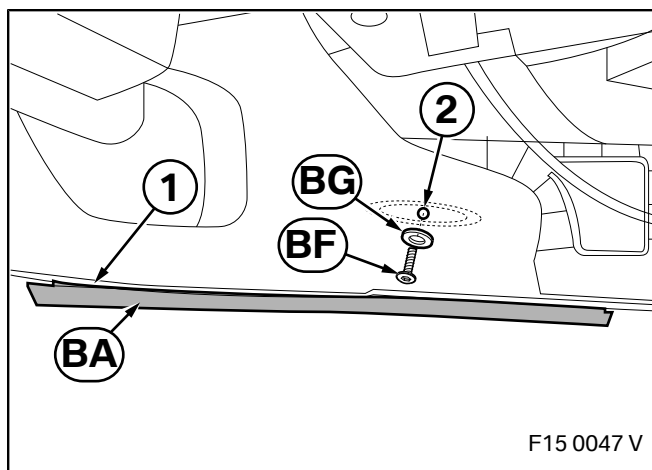
Generously apply Betalink **BD** on the surface (1) and (2) of rear diffuser **BA** as shown.



Ensure that tail flap **BA** covers the entire lower surface of the rear apron.

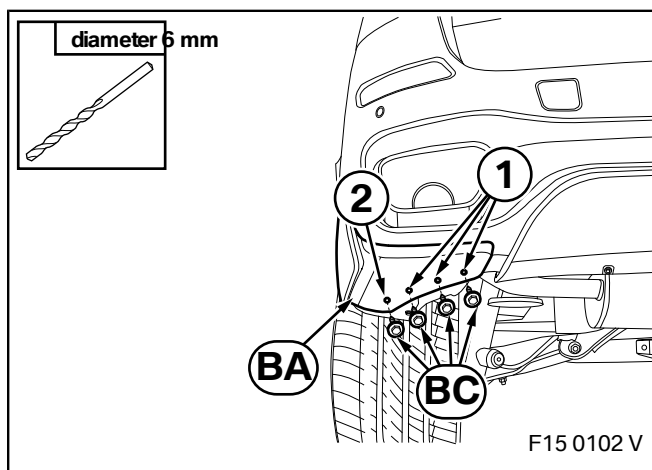
The drill holes determine the position of tail flap **BA**. ◀

Affix and align tail flap **BA**.



Ensure that tail flap **BA** covers the entire lower surface (1) of the rear apron. ◀

Secure tail flap **BA** from inside through the drill hole (2) on the rear apron with interior Torx screw **BF** and shim **BG**.

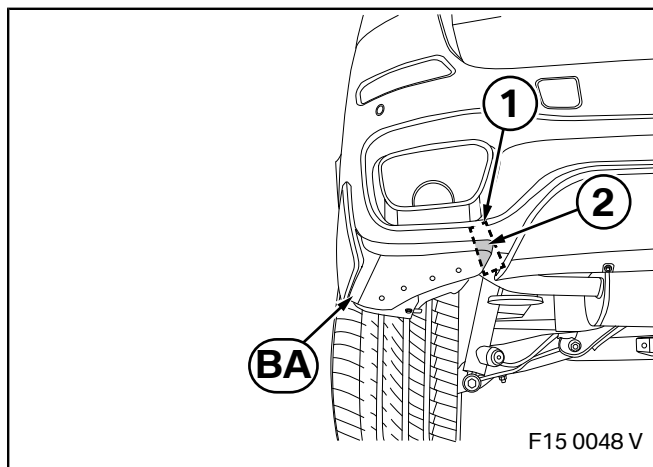


Secure tail flap **BA** through the drill holes (1) on the rear apron with sheet metal screws **BC** and sheet metal nuts **BE**.

Using a **6 mm diameter** drill bit, drill through the hole (2) on tail flap **BA** into the rear apron.

Secure tail flap **BA** through the drill hole (2) on the rear apron with sheet metal screw **BC** and sheet metal nut **BE**.

## 8. Fitting the tail flaps

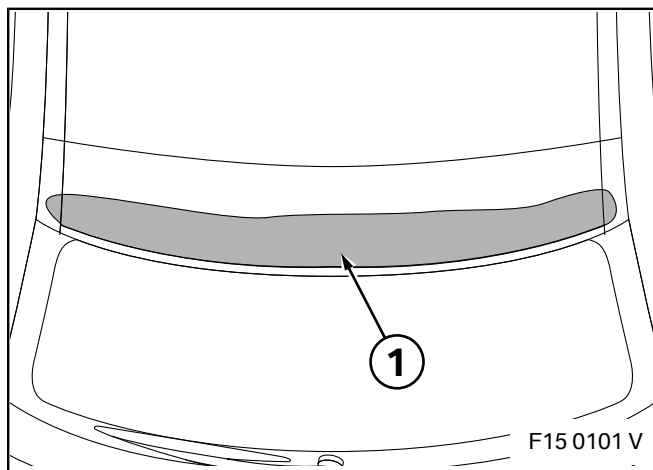


- ▶ The adhesive strip (1) must secure the area (2) of tail flap **BA** ◀

Secure tail flap **BA** using a suitable adhesive strip (1) as shown.

- ▶ Do not remove the adhesive strips for around 24 hours and do not move the car. ◀

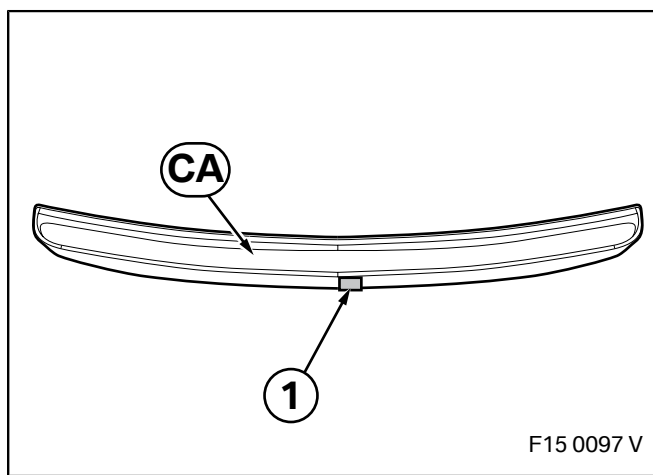
## 9. Fitting the roof edge spoiler



▶ The areas being bonded must be completely dry, clean and free from wax or grease. ◀

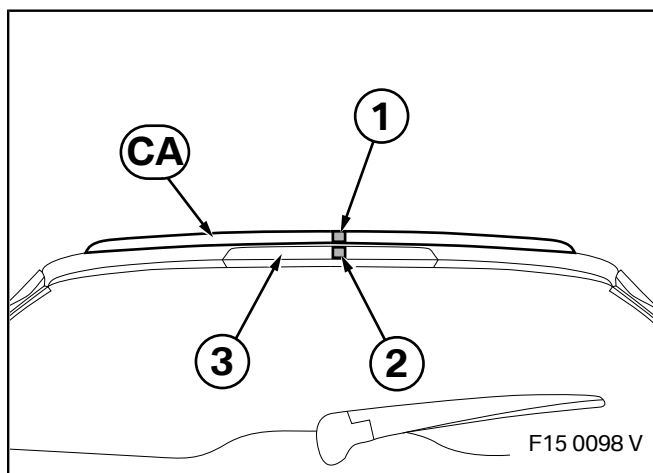
Clean the surface (1) with cleaning pad **CB**.

▶ Note the ventilation time of **5 min.** ◀



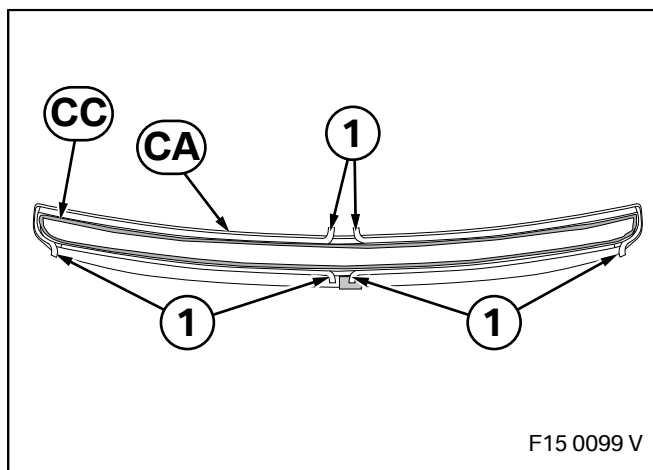
▶ The centre of roof edge spoiler **CA** is marked with a cut-out. ◀

Mark the centre of roof edge spoiler **CA** using a suitable adhesive strip (1).



Place roof edge spoiler **CA** on the edge of the tail gate and average it out.

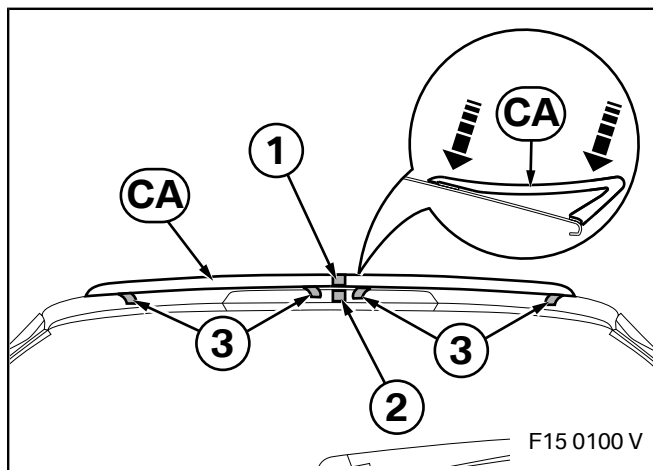
Transfer the marking (1) using a suitable adhesive tape (2) onto the brake light (3).



Remove the adhesive backing films on roof edge spoiler **CA** just enough to form small tabs (1).

Apply Betalink **CC** inside and along the adhesive backing films as shown.

## 9. Fitting the roof edge spoiler



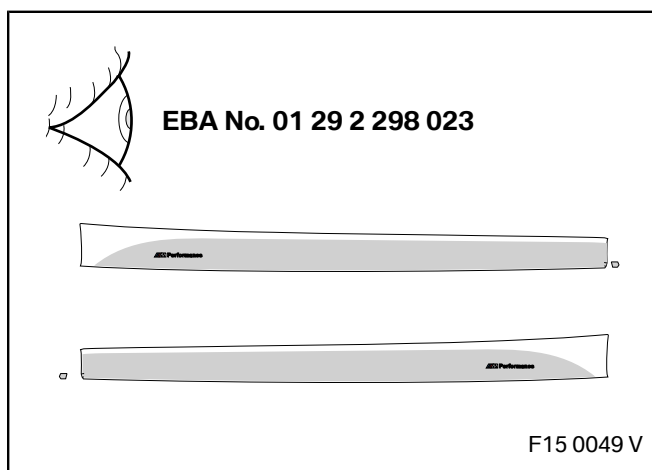
Place roof edge spoiler **CA** on the edge of the tail gate.

Align roof edge spoiler **CA** using the adhesive strip (1) and (2).

Gradually remove all adhesive backing films (3) from the centre outwards.

▶ Press roof edge spoiler **CA** firmly and repeatedly onto the tail gate. ◀

## 10. Fitting the side sill films



▶ Install the side sill films in accordance with the installation instructions bearing part number 01 29 2 298 023. ◀

## 11. Concluding work and coding

The retrofit system does not require coding.

- Conduct a brief test
- Conduct a function test
- Re-assemble the car in a logical manner