

Original BMW Accessories.

Installation Instructions.



Aerodynamic Peripheries Retrofit Kit

BMW M3 (F80)

BMW M4 (F82/F83)

Retrofit kit number

Number	Component designation	Type	Installation time (h)
51 19 2 350 712	Carbon left/right front add-on section	F80/F82/F83	0.25
51 19 2 350 711	Matt black front add-on section	F80/F82/F83	0.50
51 19 2 350 697	Carbon rear diffuser	F80/F82/F83	0.10
51 14 2 350 435	Left/right side skirt film	F80	0.75
51 14 2 350 706	Left/right side skirt film	F82/F83	0.75
51 19 2 350 719	Matt black left side sill add-on	F82/F83	0.50
51 19 2 350 720	Matt black right side sill add-on	F82/F83	0.50
51 71 2 240 832	Carbon rear spoiler	F80	0.25
51 19 2 349 678	Matt black rear spoiler	F80	0.50
51 19 2 350 722	Carbon rear spoiler	F82	0.25


Installation time

Installation time see table. 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

 On the F80, the matt black front add-on section must only be installed in the car in conjunction with a rear spoiler (for instructions and part numbers, see EPC). ◀

Through the installation of the carbon rear diffuser on vehicles with SA 322 (comfort access), the part-function "Smart Opener" of this SA is no longer available, and can therefore no longer be used.

After the installation of the carbon rear diffuser retrofit set, it must be programmed/coded via the – **Conversions** – path.

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

Check that all the parts fit accurately on the car before fitting them.

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

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**. ◀

Painting instructions

Check that all the parts fit accurately on the car before painting them. Primed parts must be pre-treated accordingly before painting.

To ensure correct painting, the EBA must be provided to the painter.

The BMW painting instructions must be observed (see ISTA No. 99 00 ...).

Ordering instructions

To install the F80 matt black rear spoiler (PU), Betalink and Sika Activator 205 must also be ordered (for instructions and part numbers, see EPC).

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

Special tools required

None

Information to be provided to the customer

Matt black front add-on section **F**, matt black left side sill add-on section **BA** and matt black right side sill add-on section **BB** can be painted in accordance with the customer's wishes.

Once the matt black front add-on section is installed, the ramp angle and floor clearance are reduced.


 The black matt front add-on section reduces the car's floor clearance and reduces the overhang angle at the front. The matt black front add-on section must be checked at regular intervals for damage caused by collisions and, in the event of any such damage, be replaced by trained specialist personnel. ◀

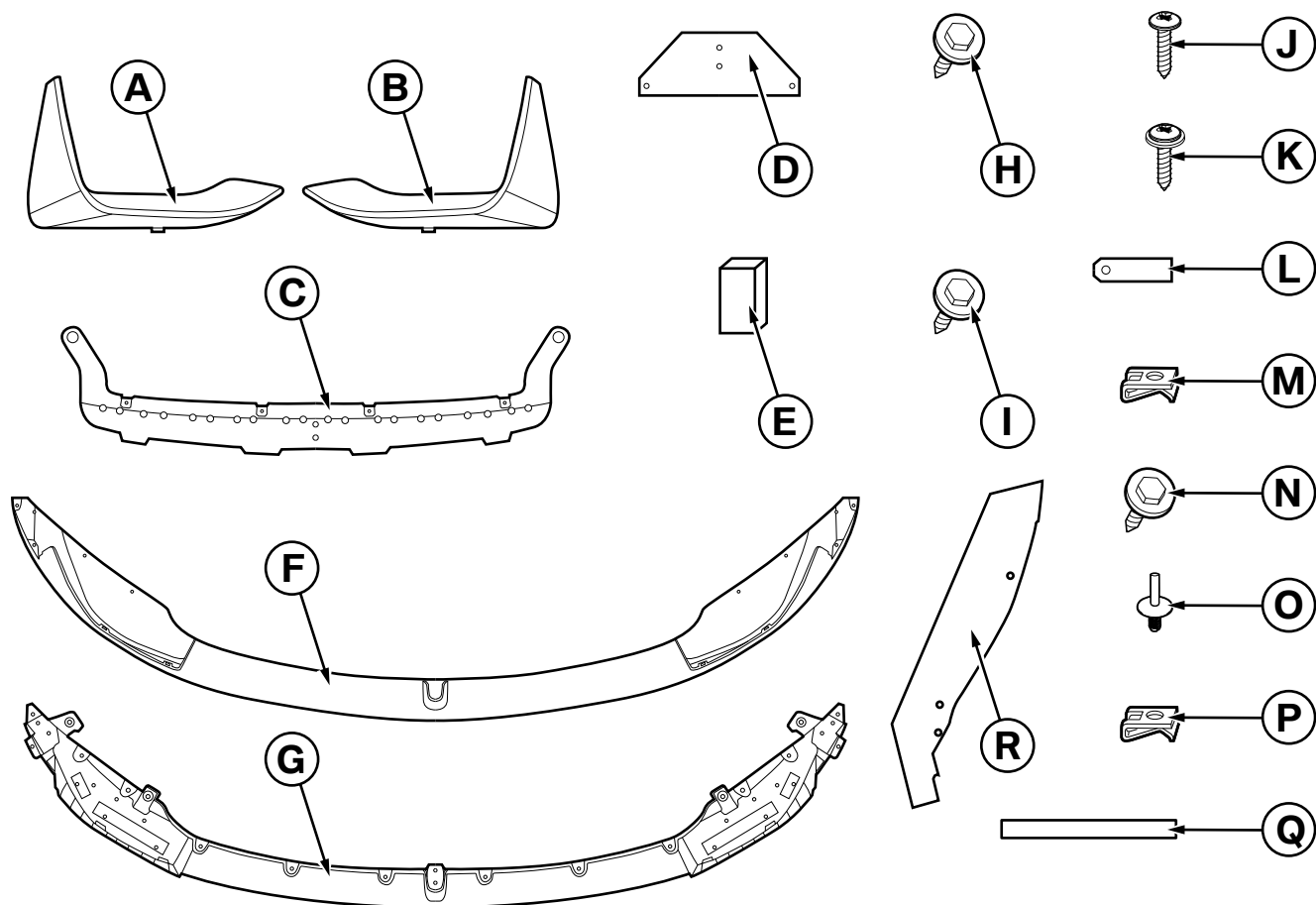
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1. Preparatory work

The following components must be removed first of all	ISTA No.
Only when the left/right carbon front add-on section is installed	
Left/right air guide	---
Only when the left/right carbon front add-on section and matt black front add-on section are installed	
Left/right air guide and front engine shield	---
Only when the carbon F80 rear spoiler or matt black F80 rear spoiler are installed	
Rear spoiler installed as standard	---

2. Parts list for front peripheries

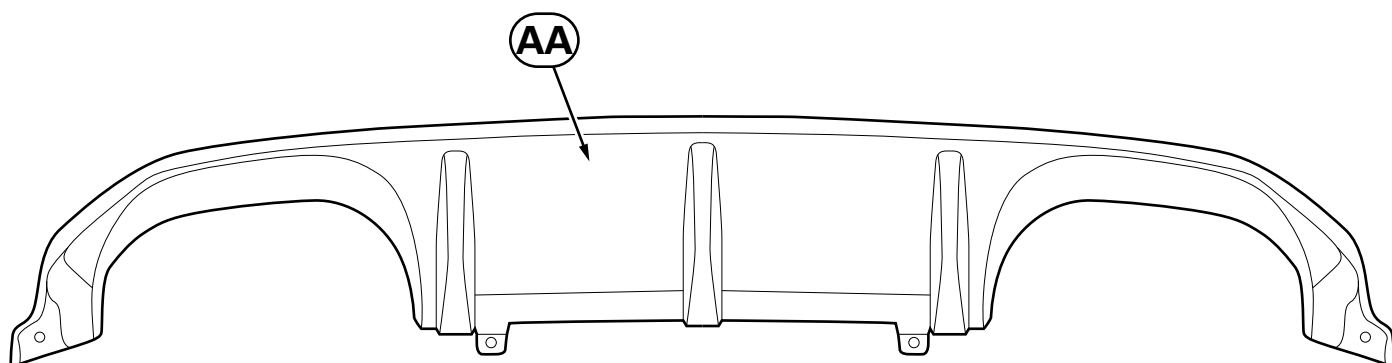


F82 0000 V

Legend

- A** Carbon right front add-on section
- B** Carbon left front add-on section
- C** Front upper adapter
- D** Template
- E** 2K Betalink incl. primer (not included in the parts kit)
- F** Matt black front add-on section
- G** Front bottom adapter
- H** Hexagon screw M5 x 14 incl. washer D15 x 1 (2 x / pouch 1)
- I** Hexagon screw incl. washer D22 x 1.6 (12 x / pouch 2)
- J** Sheet metal screw 4.8 x 16 (2 x / pouch 3)
- K** Sheet metal screw 4.8 x 25 incl. spacer 6 x 12 x 1 (4 x / pouch 4)
- L** Plastic plates (4 x / pouch 4)
- M** C-clip (4 x / pouch 4)
- N** Hexagon screw incl. washer D18 x 1.6 (4 x / pouch 5)
- O** Folding blind rivet (16 x / pouch 6)
- P** C-clip (8 x / pouch 7)
- Q** Black adhesive tape (2 x)
- R** Air guide template

3. Carbon rear diffuser parts list

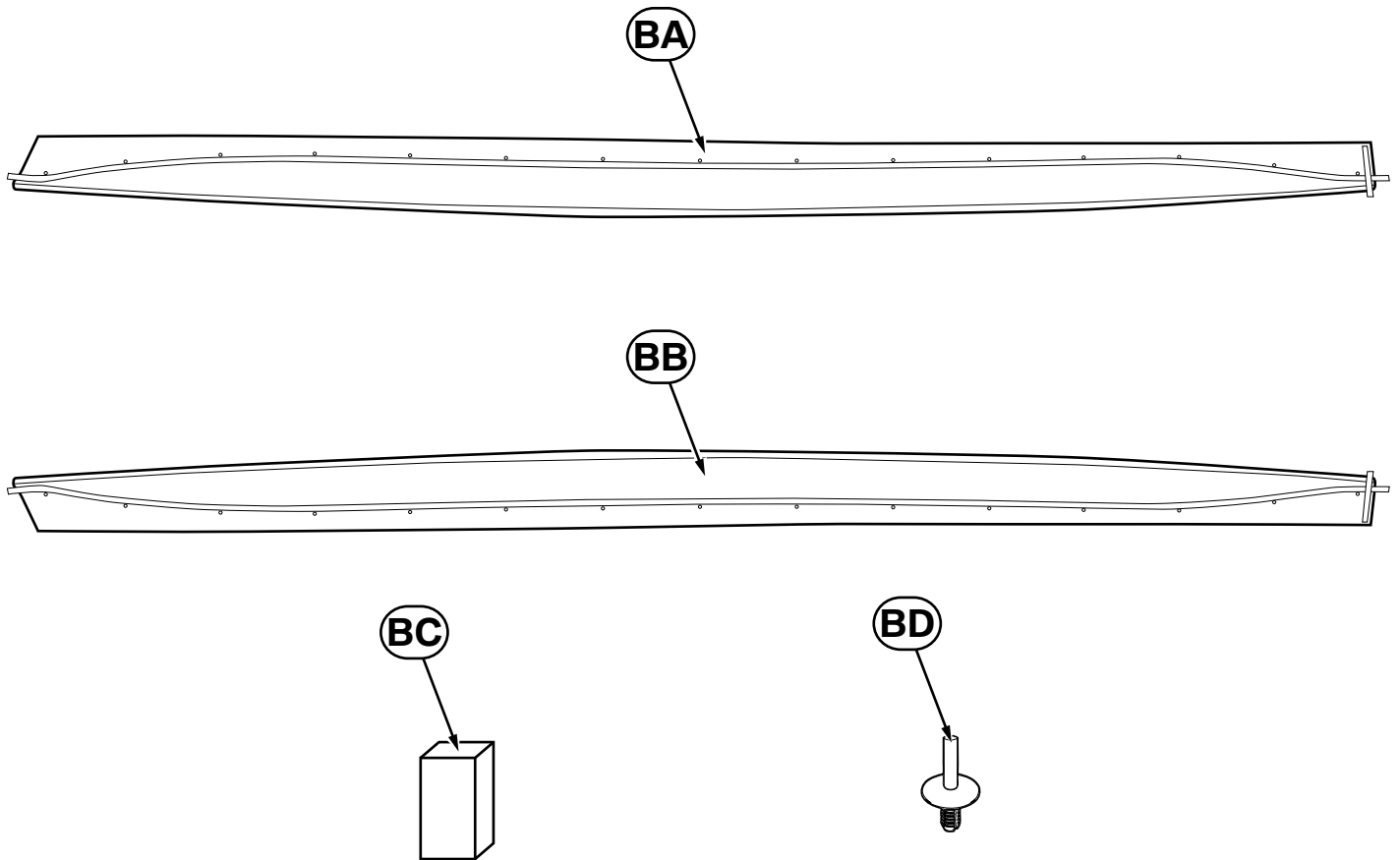


F82 0001 V

Legend

AA Carbon rear diffuser

4. Matt black F82/F83 side sill add-on section parts list

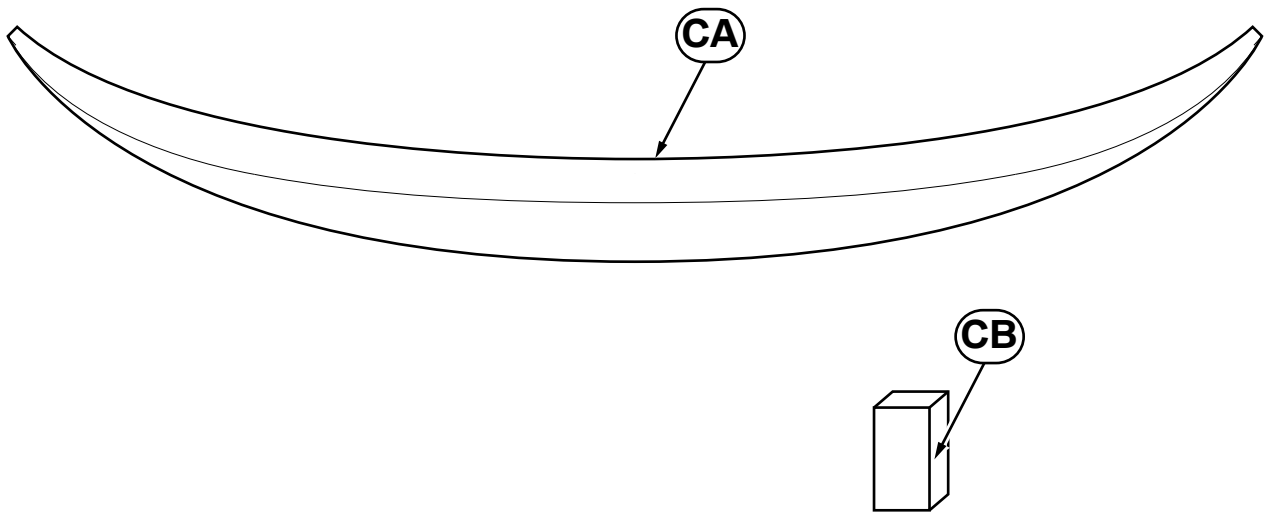


F82 0002 V

Legend

- BA** Matt black right side sill add-on
- BB** Matt black left side sill add-on
- BC** 1K Betalink (not included in the parts kit)
- BD** Expanding rivet (15 x per side)

5. F80 carbon rear spoiler parts list

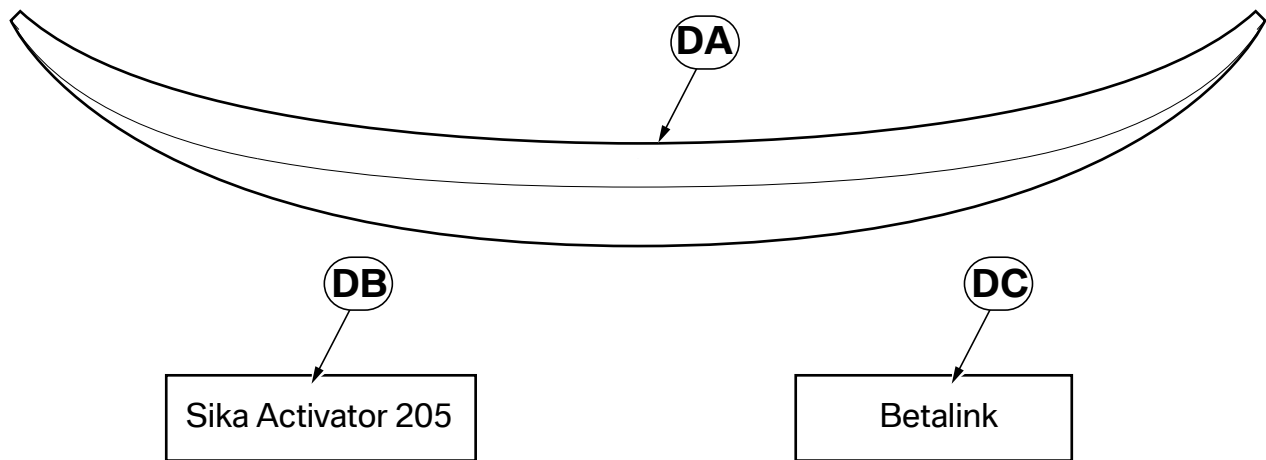


F80 0018 V

Legend

- CA** Carbon rear spoiler
- CB** Betalink (not supplied)

6. Matt black F80 rear spoiler parts list

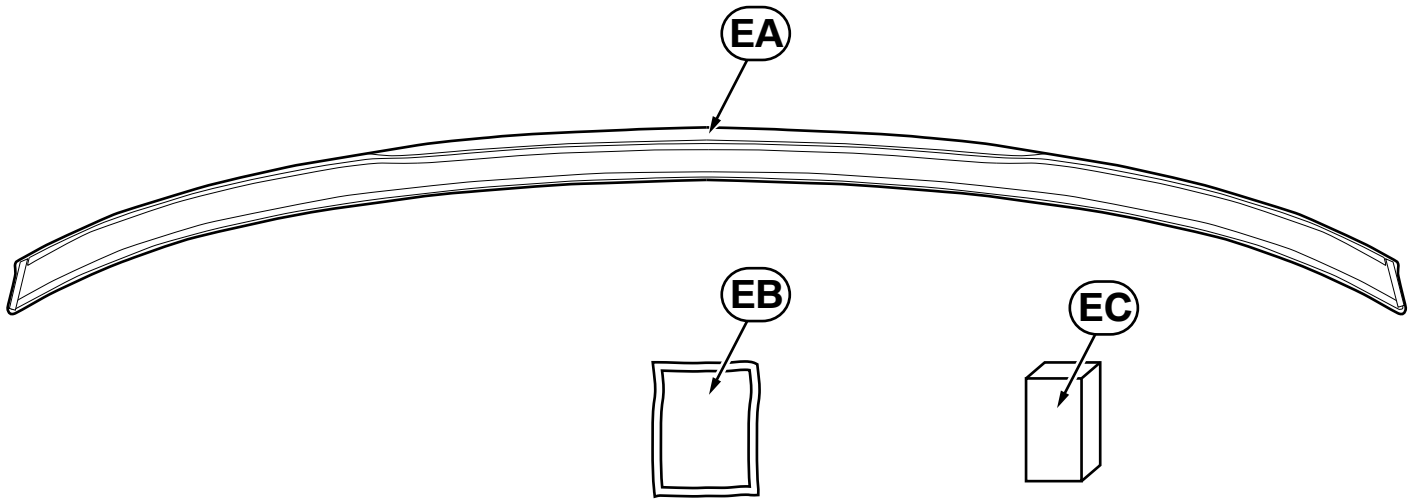


F82 0035 V

Legend

- DA** Matt black rear spoiler
- DB** Sika Activator 205 (not supplied)
- DC** Betalink (not supplied)

7. F82 carbon rear spoiler parts list

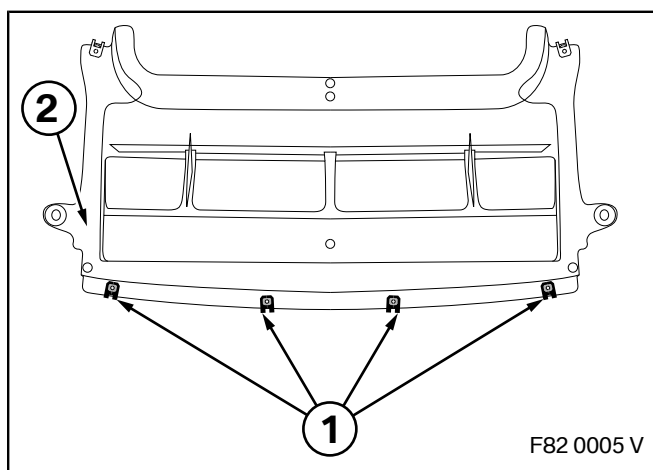


F82 0061 V

Legend

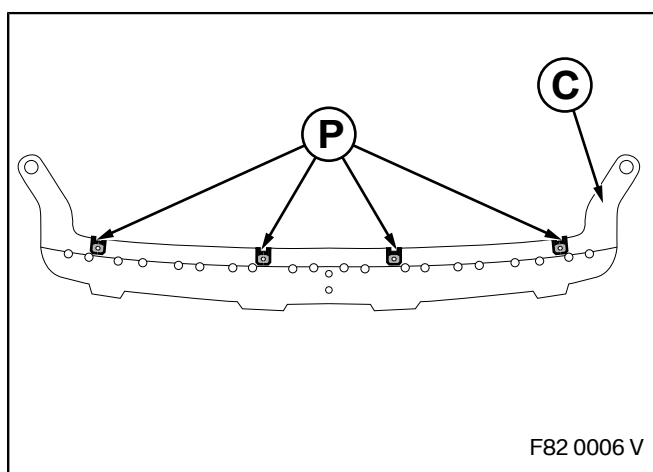
- EA** Carbon rear spoiler
- EB** Cleaning pad
- EC** Betalink (not supplied)

8. Installation of the front peripheries

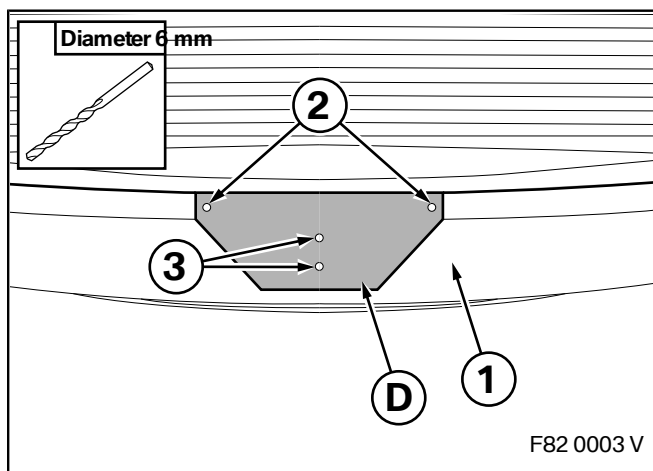


Only for "matt black front add-on section"

Remove the C-clips (1) in the engine shield (2).

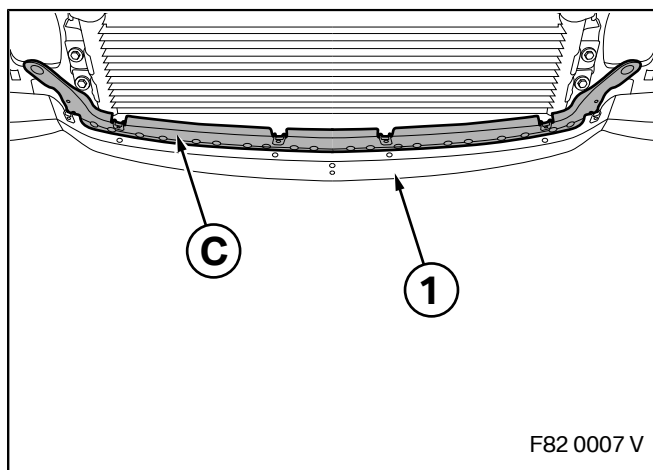


Place C-clips **P** on front upper adapter **C**.



Position template **D** from underneath onto the front apron (1), align with the drill holes (2) and secure in place using suitable materials.

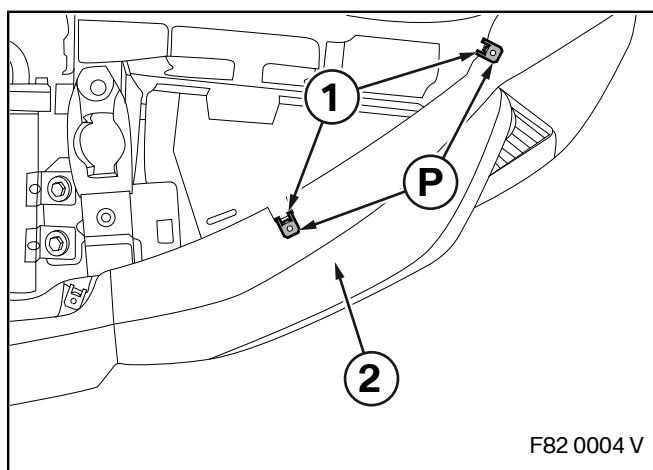
Transfer the drill holes (3) using a **6 mm diameter** drill bit to the front apron (1).



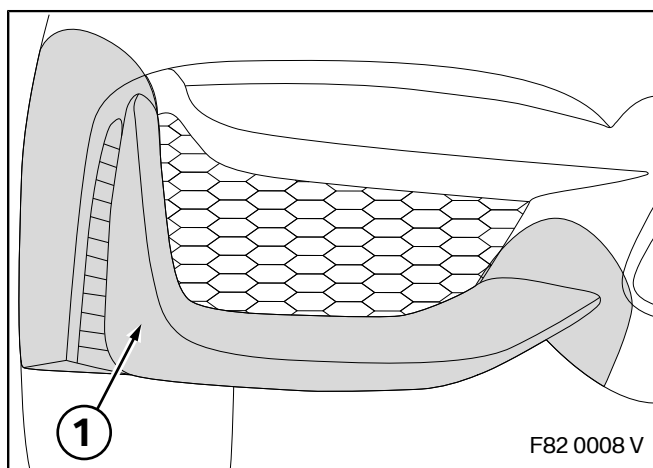
Push front upper adapter **C** under the front apron (1).

Then fit the engine shield as per **ISTA**.


8. Installation of the front peripheries



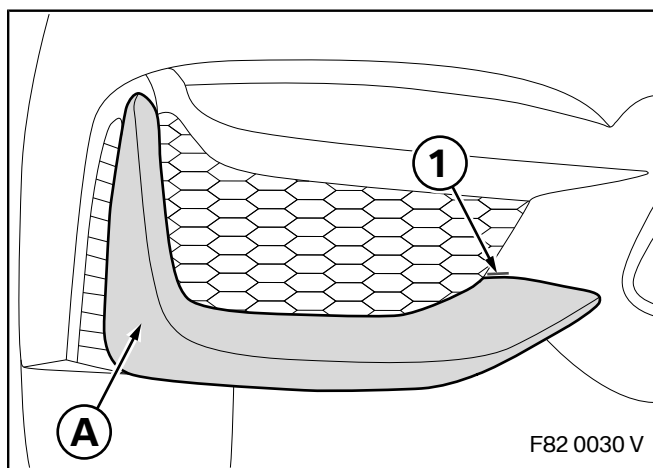
Replace the C-clips (1) on the front apron (2) with C-clips **P**.



For all retrofitted peripheries

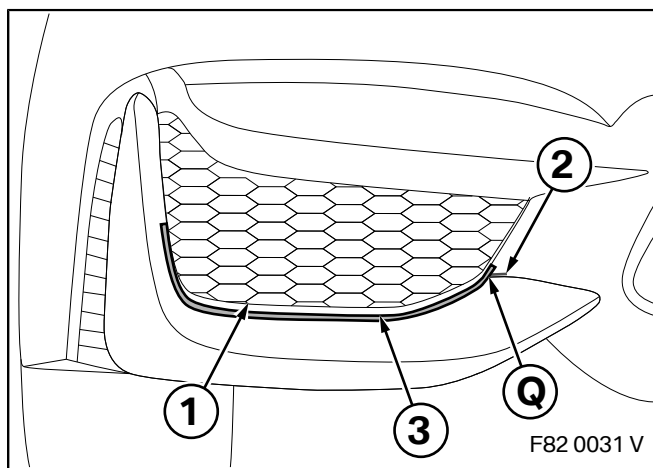
 The areas being bonded must be completely dry, clean and free from wax or grease. ◀

Clean the surface (1) of the car with suitable agents.



Position carbon front add-on section **A**, align it and draw a mark on the inside (1).

Remove carbon front add-on section **A**

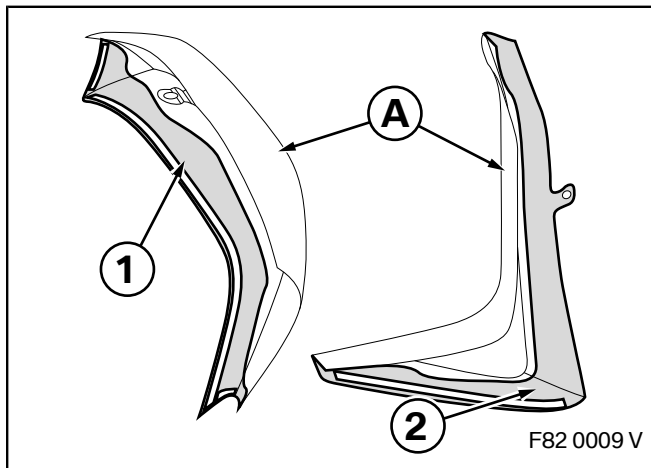


Release the grille (1) from its anchor points and push it inwards.

Place black adhesive tape **Q** over the mark (2) as shown and stick it in place so that a small part of black adhesive tape **Q** can be folded around the edge (3).

Then fold black adhesive tape **Q** around the edge (3) and pull the grille (1) forwards until it engages.

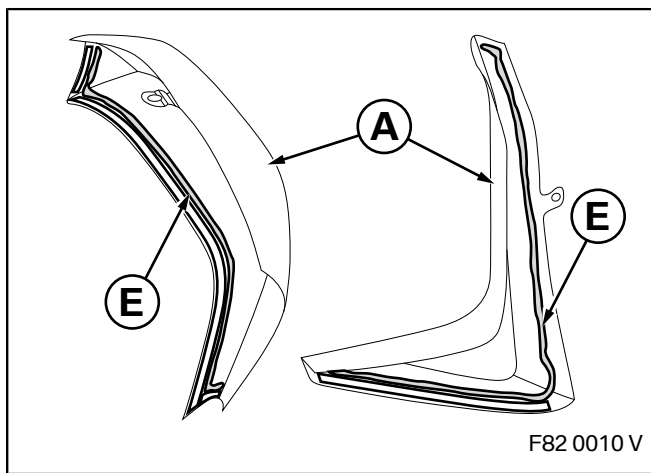
8. Installation of the front peripheries



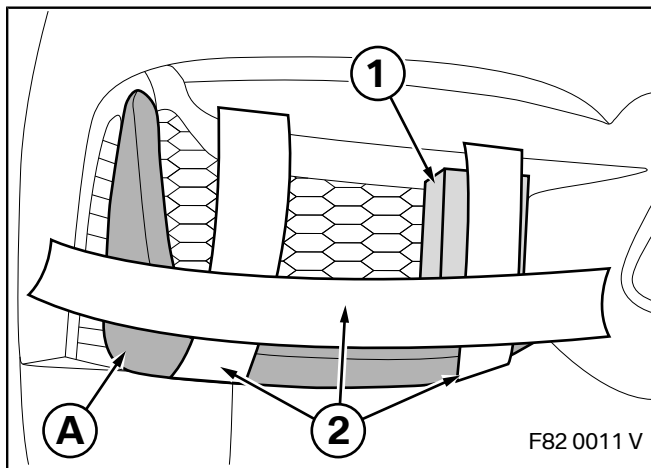
- ▶ The areas being bonded must be completely dry, clean and free from wax or grease. ◀

When the surfaces (1) and (2) of carbon front add-on section A using suitable agents, clean them and prime them with primer from Betalink E.

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



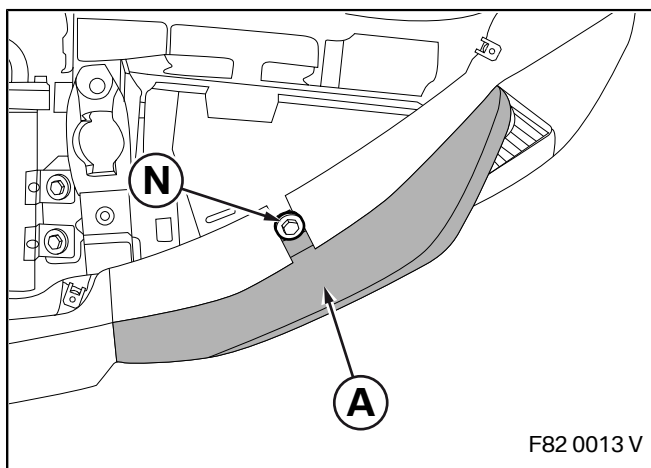
Apply Betalink E as shown on carbon front add-on section A.



- ▶ Remove any Betalink that oozes out immediately. ◀

Position carbon front add-on section A in place and firmly press it on.

Secure carbon front add-on section A using the foam block (1) or other suitable agents and adhesive strips (2) as shown.

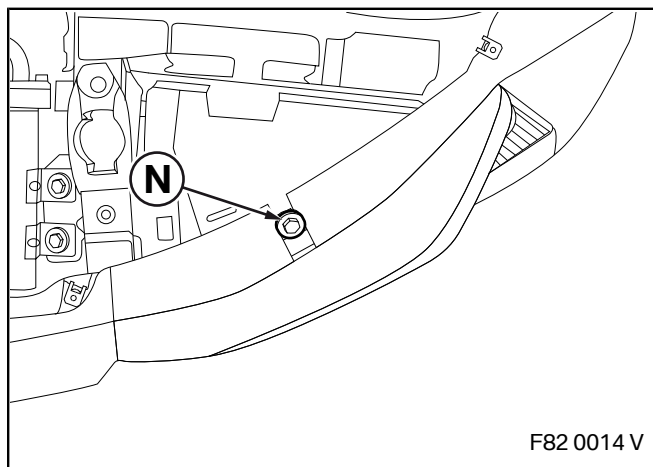


Secure carbon front add-on section A using hexagon screw N.

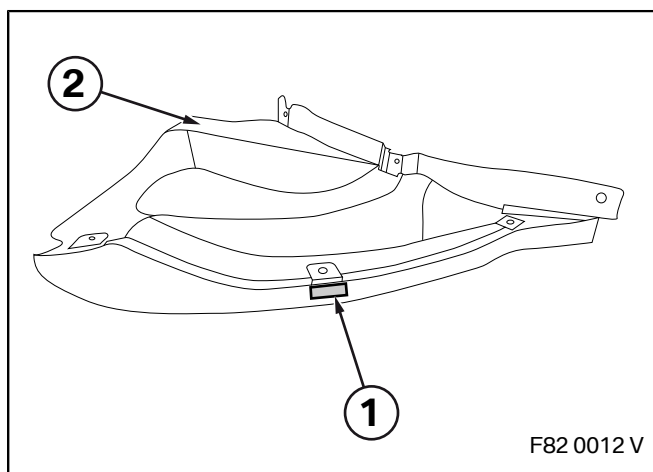
Remove the adhesive strips and foam block after **30 minutes**.

- ▶ Continue installation only once the adhesive strips have been removed. ◀

8. Installation of the front peripheries



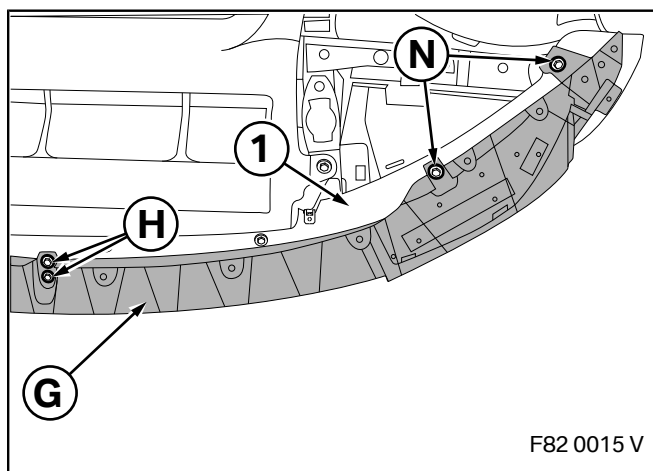
Remove and keep hexagon screw **N** safe.



For "carbon front add-on section" only

In the area (1) of the air guide (2), create a slit for the tab on carbon front add-on section **A** so that carbon front add-on section **A** can be screw-connected to the air guide (2) on the car.

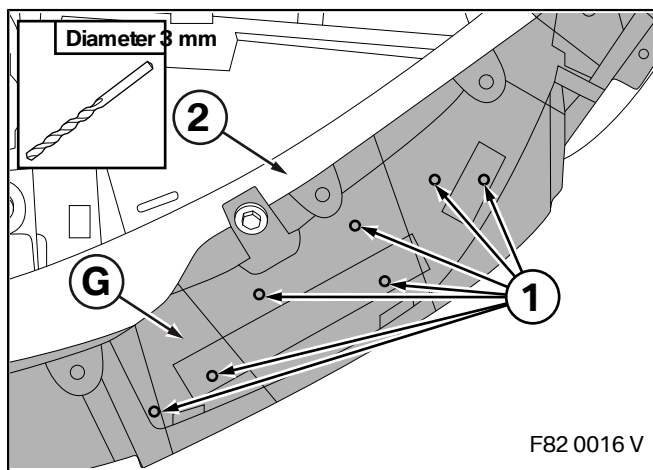
Fit the air guide (2) as per **ISTA**.



Only for "matt black front add-on section"

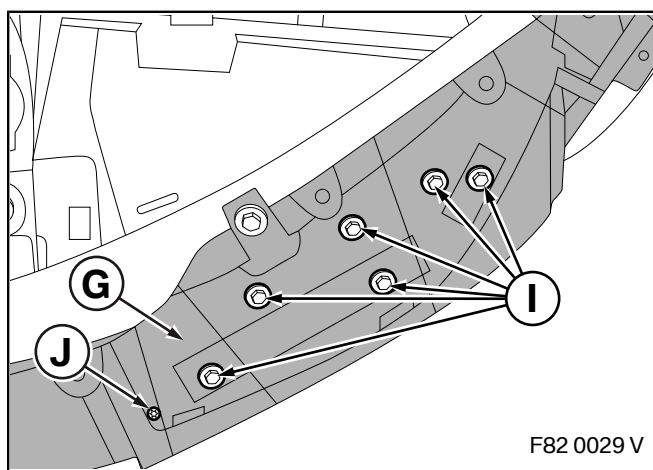
Place front bottom adapter **G** onto the front apron (1) and fit using hexagon screws **H** and hexagon screw **N** until hand-tight.

Tighten hexagon screws **H** and hexagon screws **N**.

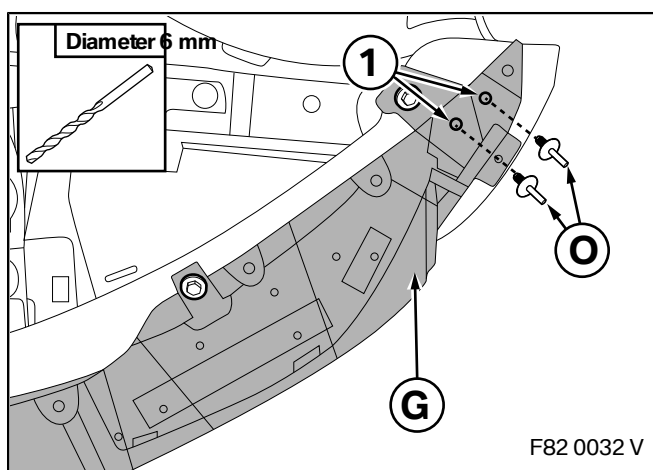


Transfer the drill holes (1) from front bottom adapter **G** using a **3 mm diameter** drill bit to the front apron (2) and carbon front add-on section **A**.

8. Installation of the front peripheries

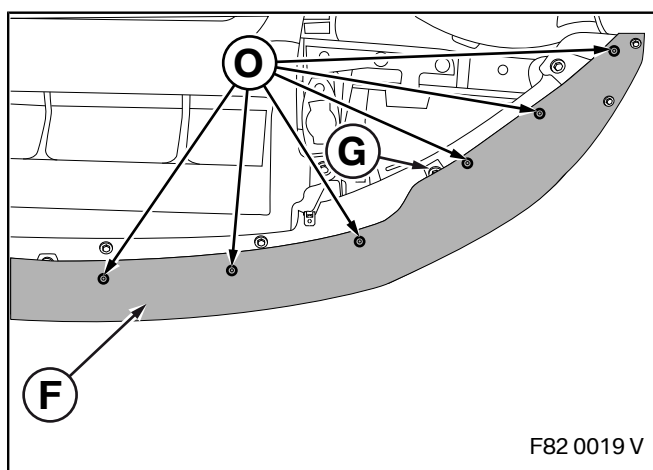


Secure front bottom adapter **G** using six hexagon screws **I** and sheet metal screw **J**.



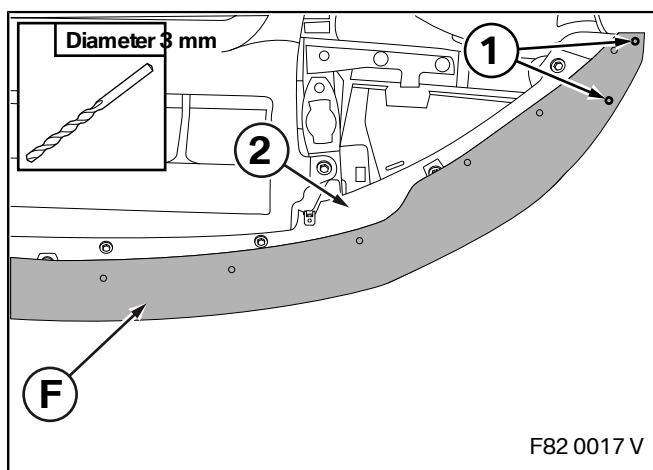
Transfer the drill holes (1) from front bottom adapter **G** using a **6 mm diameter** drill bit to the front apron (2).

Secure front bottom adapter **G** using folding blind rivets **O**.



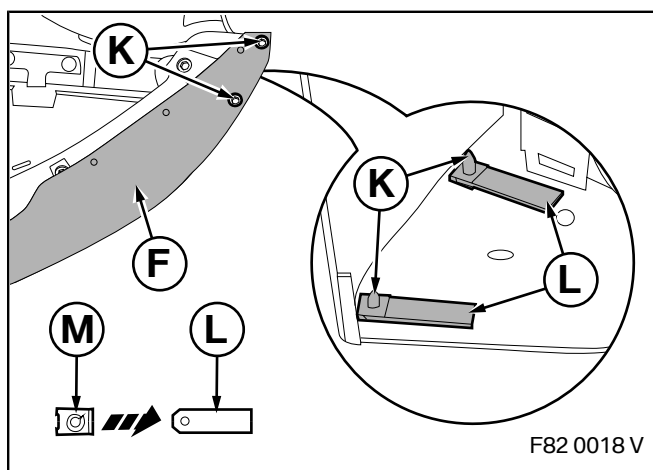
Place matt black front add-on section **F** onto front bottom adapter **G** on the front apron (1).

Secure matt black front add-on section **F** using folding blind rivets **O**.



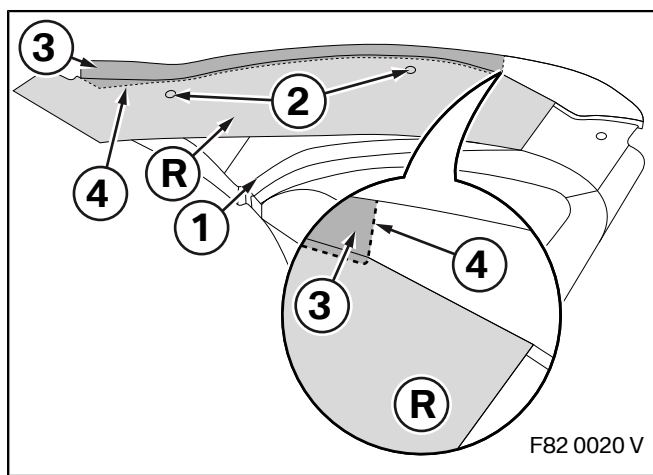
Transfer the drill holes (1) from matt black front add-on section **F** using a **3 mm diameter** drill bit to the front apron (2).

8. Installation of the front peripheries



Place C-clips **M** on plastic plates **L**.

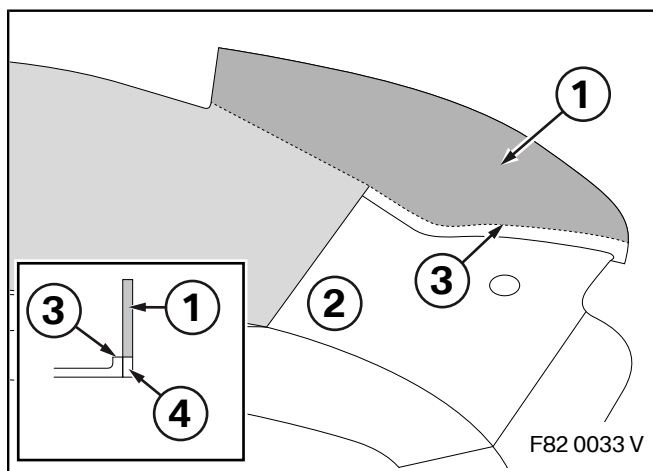
Secure matt black front add-on section **F** using plastic plates **L** and sheet metal screws **K**.



Place air guide template **R** on the air guide (1) as shown, align using the drill holes (2) and secure in place using suitable agents.

Mark the area (3) as shown.

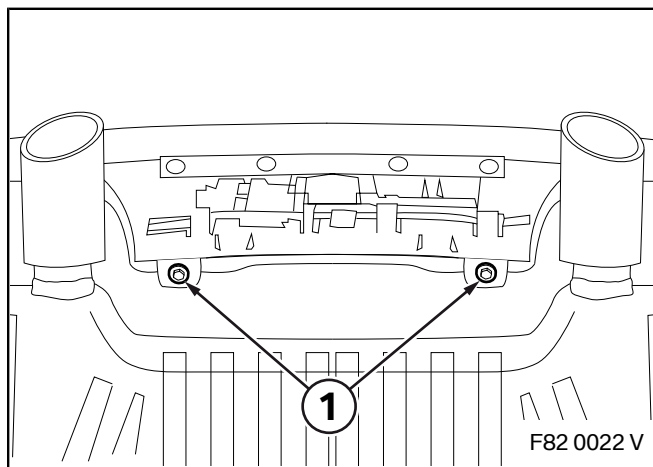
Cut off the area (3) (hard and soft plastic) of the air guide (1) at the line (4) (hard plastic) using suitable tools.



Cut off the area (1) (soft plastic) of the air guide (2) at the edge (3) (hard plastic) using suitable tools so that the area (4) (soft plastic) is preserved.

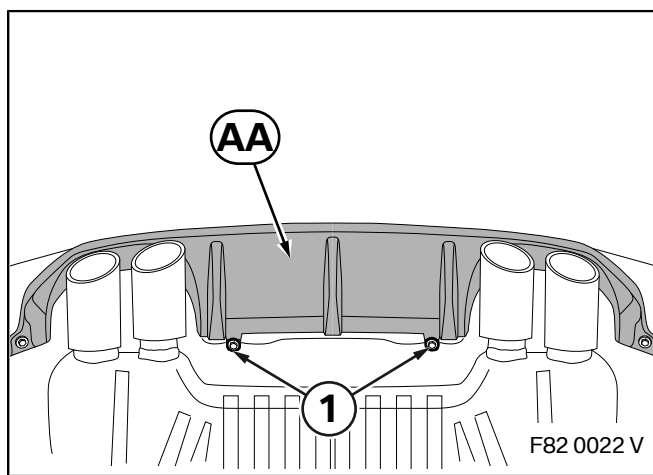
Fit the air guide (2) as per **ISTA**.

9. Fitting the carbon rear diffuser



Remove the diffuser as per **ISTA**.

Then remove the screws (1) and keep them safe.

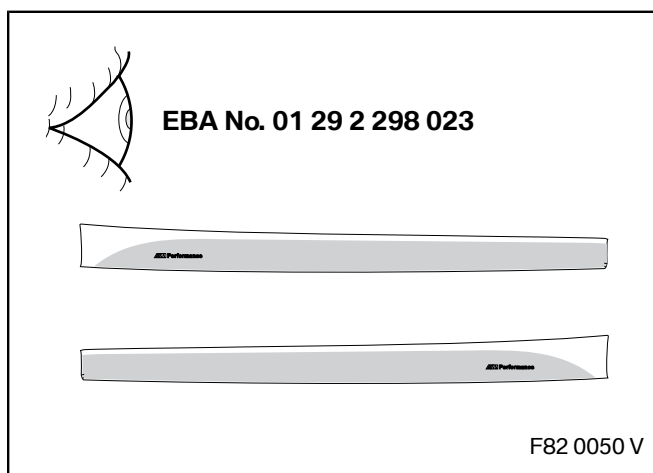


Position carbon rear diffuser **AA** and fit it as per **ISTA**.

▶ Ensure that the screws (1) are screwed first through carbon rear diffuser **AA** and then through the heat shield into the plastic part. ◀

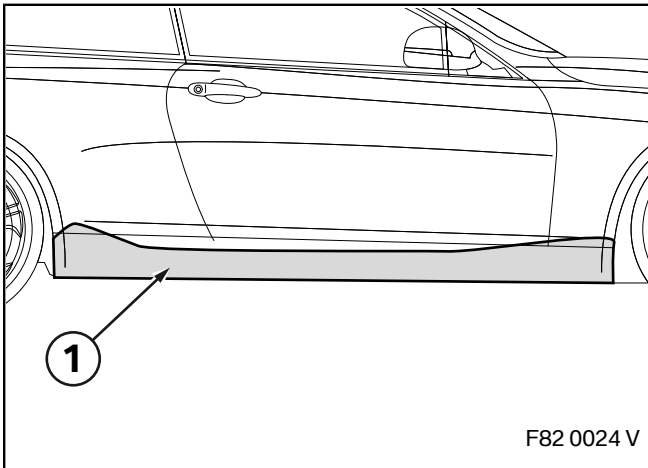
Fit the screws (1).

10. Fitting the left/right side skirt film



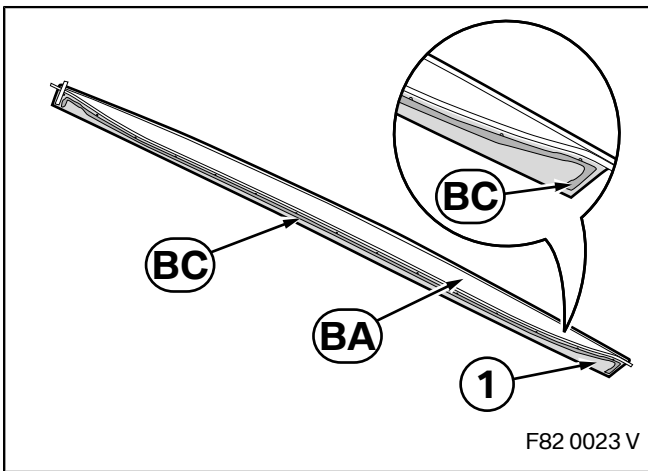
- ▶ Before installing the left/right matt black side sill add-on, the left/right side skirt film must be installed in accordance with the installation instructions bearing part number 01 29 2 298 023. ◀

11. Fitting the matt black F82/F83 side sill add-on section



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

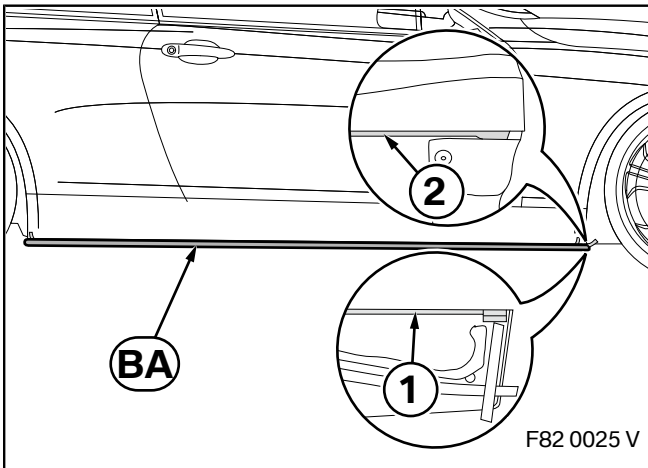
Clean the surface (1) of the car with suitable agents.



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

Clean the surface (1) of matt black side skirt add-on section **BA** with suitable agents.

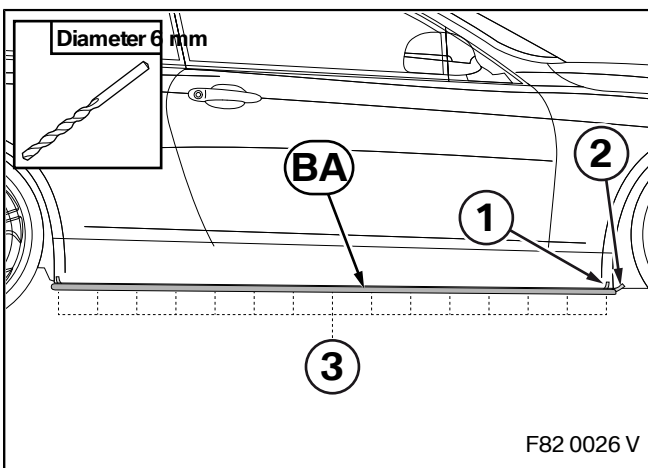
Apply Betalink **BC** as shown to matt black side skirt add-on section **BA**.



- ▶ Ensure that all tabs on the adhesive backing film are visible. ◀

Position matt black side skirt add-on section **BA** so that the edge (1) of matt black side skirt add-on section **BA** lies behind the edge (2) of the car.

- ▶ Remove any Betalink that oozes out immediately. ◀



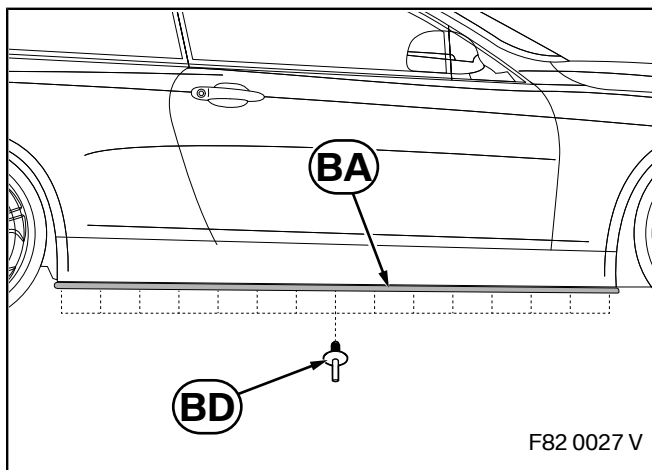
Carefully remove the adhesive strip (1) from front to back and firmly press on matt black side skirt add-on section **BA**.

Carefully remove the adhesive strip (2) from the outside inwards and firmly press on matt black side skirt add-on section **BA**.

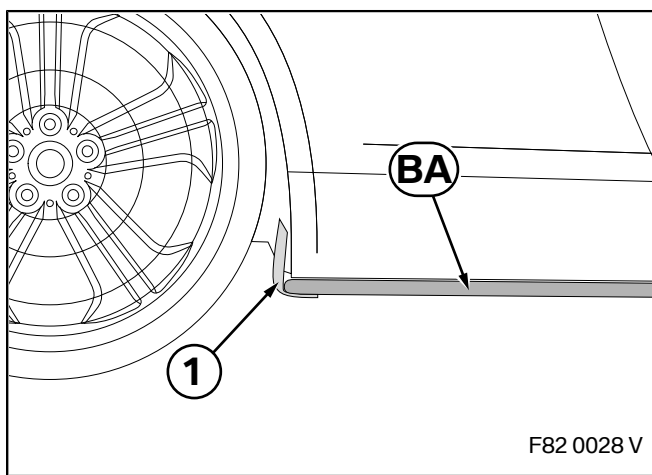
- ▶ When drilling down to the drill depth, take care not to damage parts underneath. ◀

Using a **6 mm** diameter drill bit, transfer the 15 holes (3) from matt black side skirt add-on section **BA** to the side skirt.

11. Fitting the matt black F82/F83 side sill add-on section

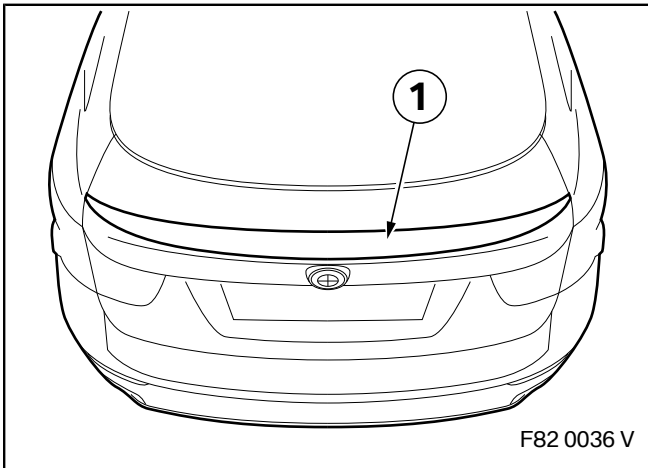


Secure matt black side skirt add-on section **BA** using 15 blind rivets **BD**.



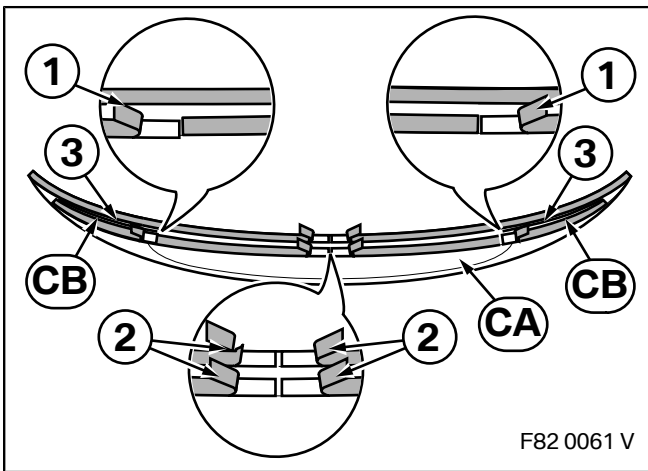
Secure the rear part of matt black side skirt add-on section **BA** as shown using a suitable adhesive strip (1).

12. Fitting the F80 carbon rear spoiler



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

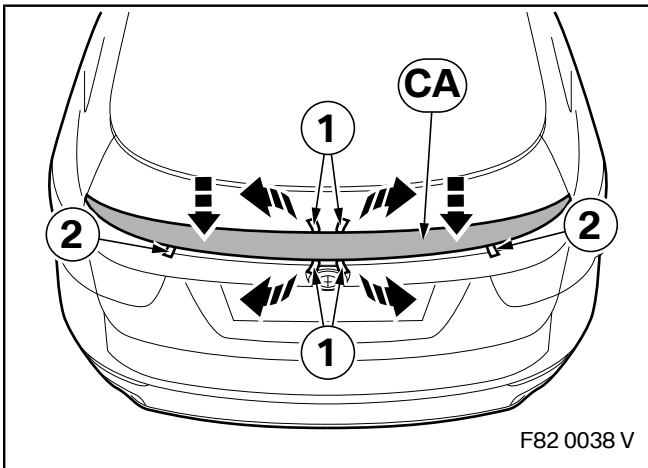
Clean the bonding surface (1) on the car with a suitable cleaning agent to ensure it is free from grease.



Remove the adhesive backing film on the left and right just enough to form small tabs (1).

Cut the adhesive backing film on carbon rear spoiler **CA** in the middle and remove it just enough to form small tabs (2).

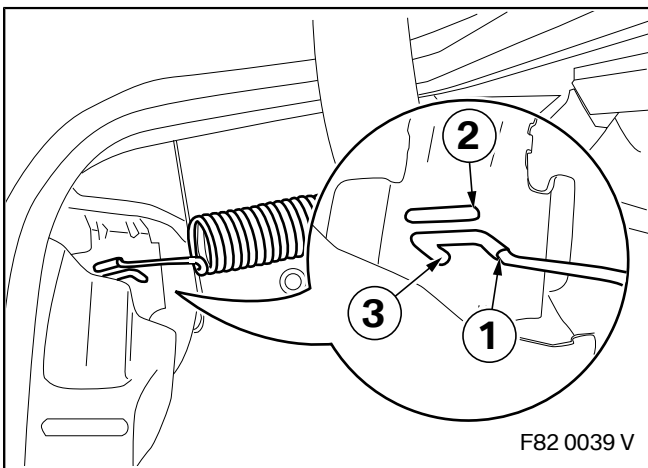
Sand and clean the area (3) between the adhesive strips using suitable tools and then apply Betalink **CB**.



Position carbon rear spoiler **CA** on the edge of the tailgate, average it out and then pull adhesive backing films (1) from the centre outwards in stages.

Then pull the adhesive backing films (2) from the inside outwards.

- ☒ Press carbon rear spoiler **A** firmly and **repeatedly** onto the tailgate. ◀
- ☒ Remove any Betalink that oozes out immediately. ◀



- ☒ Positions (1), (2) and (3) are provided for the tailgate's tension spring. ◀

Move the tailgate's tension spring to **position (2)**.

- ☒ After repositioning the tension springs, check that the tailgate is able to open properly and adjust the position of the tension springs accordingly if necessary. ◀

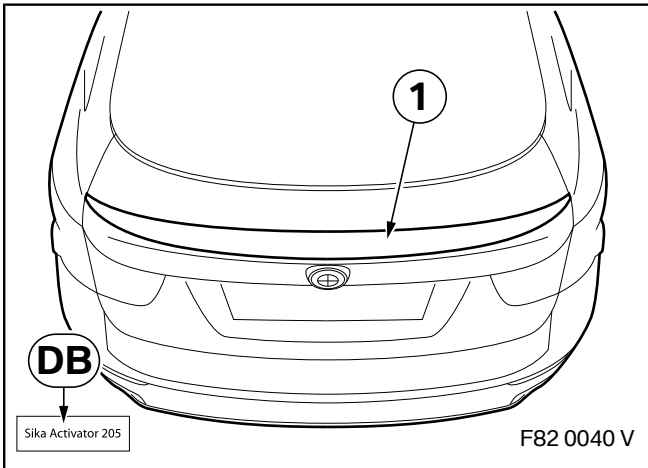
13. Fitting the F80 matt black rear spoiler

Painting instructions

Check that all the parts fit accurately on the car before painting them. Primed parts must be pre-treated accordingly before painting.

The BMW painting instructions must be observed (see ISTA No. 99 00 ...).

▶ Retrofit kit 51 19 2 349 678 is supplied painted matt black. The spoiler can be fitted directly the way it is or painted in accordance with the customer's wishes before installation. ◀

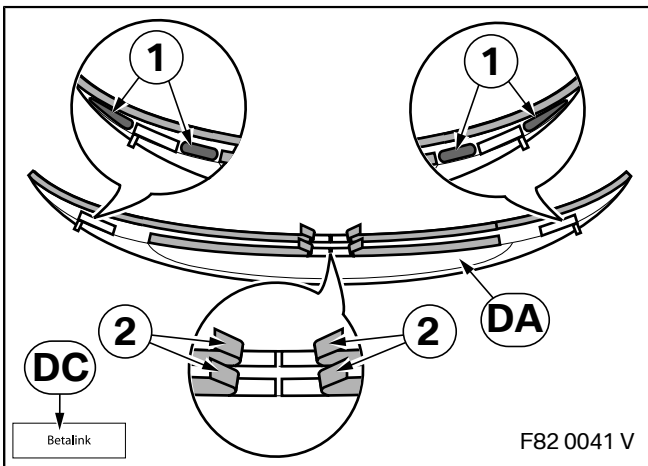


▶ The areas being bonded must be completely dry, clean and free from wax or grease. ◀

Clean the bonding surface (1) on the car with a suitable cleaning agent to ensure it is free from grease.

▶ Note the ventilation time and other instructions for use that come with Sika Activator 205 **DB**. Only treat the bonding surface (1) with Sika Activator 205 **DB**.

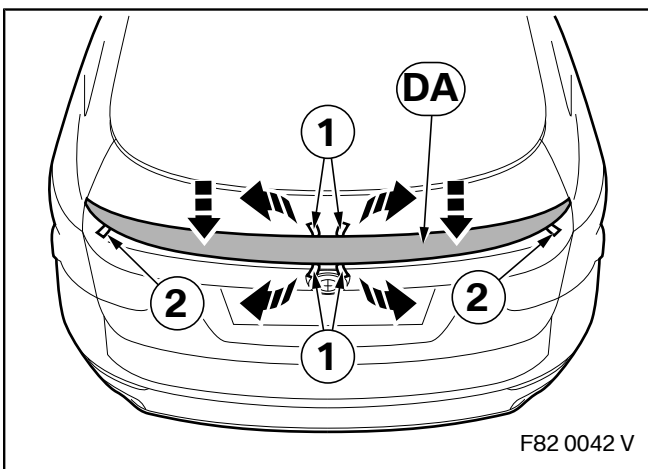
Then apply Sika Activator 205 **DB** to the bonding surface (1). ◀



Sand and clean the surfaces (1) with suitable agents.

Apply Betalink **DC** to the surfaces (1) of matt black rear spoiler **DA**.

Cut the adhesive backing film on matt black rear spoiler **DA** in the middle and remove it just enough to form small tabs (2).



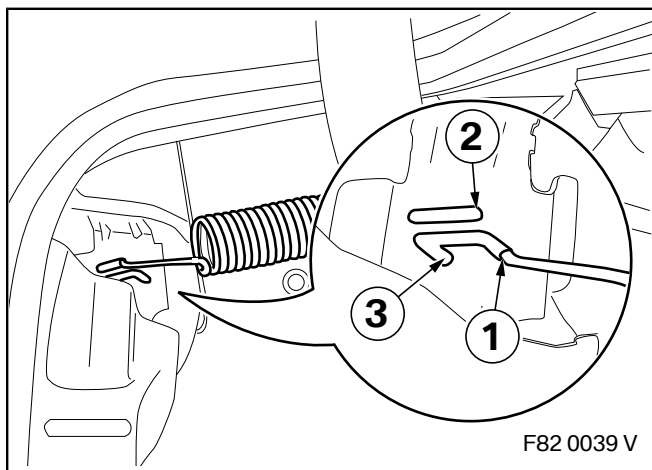
Position matt black rear spoiler **DA** on the edge of the tailgate, average it out and then pull adhesive backing films (1) from the centre outwards in stages.

Then remove the adhesive backing films (2) from the outside inwards, using the grab tabs.

▶ Press matt black rear spoiler **DA** firmly and repeatedly onto the tailgate and remove any Betalink that escapes immediately.

Do not open the tailgate for 6 hours and note the installation instructions on page 2. ◀

13. Fitting the F80 matt black rear spoiler

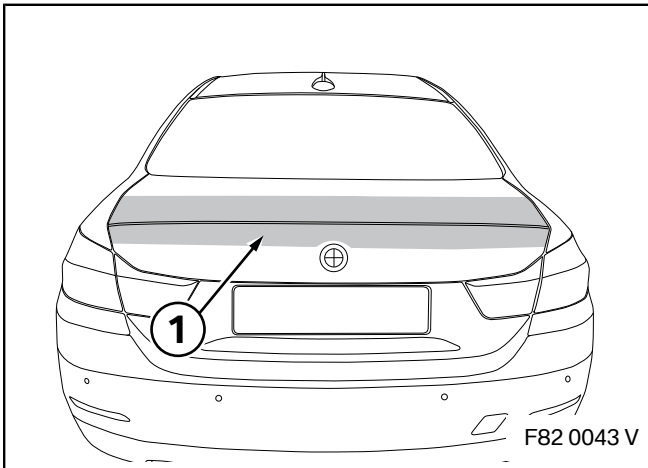


- ▶ Positions (1), (2) and (3) are provided for the tailgate's tension spring. ◀

Move the tailgate's tension spring to **position (3)**.

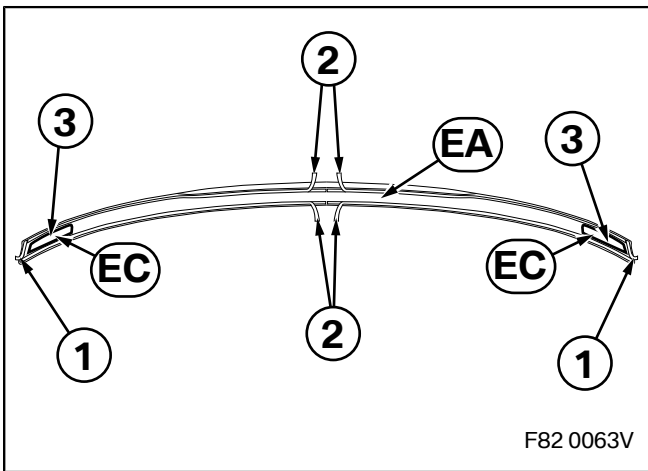
- ▶ After repositioning the tension springs, check that the tailgate is able to open properly and adjust the position of the tension springs accordingly if necessary. ◀

14. Fitting the F82 carbon rear spoiler



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

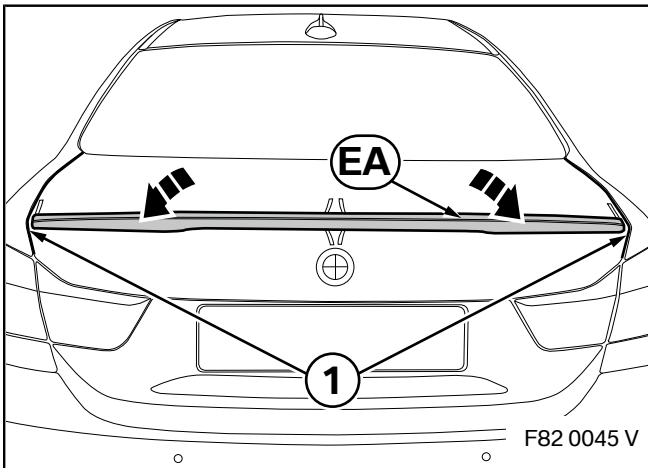
Clean the bonding surface (1) on the car with cleaning pad **EB** and ensure it is free from grease.



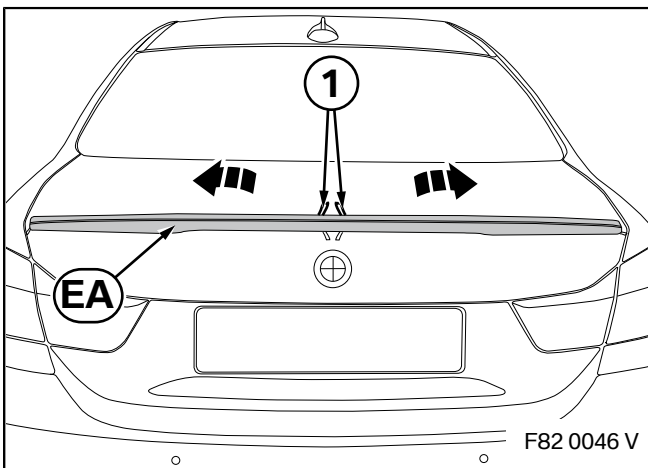
Remove the adhesive backing film on the left and right just enough to form small tabs (1).

Cut the adhesive backing film on carbon rear spoiler **EA** in the middle and remove it just enough to form small tabs (2).

Sand the area (3) between the adhesive strips using suitable tools and clean with cleaning pad **EB**. Then apply Betalink **EC** as shown.

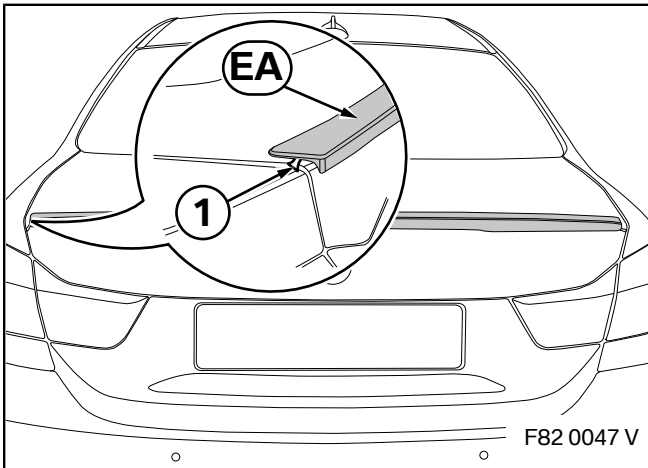


Place carbon rear spoiler **EA** on the edge of the tailgate and average it out.

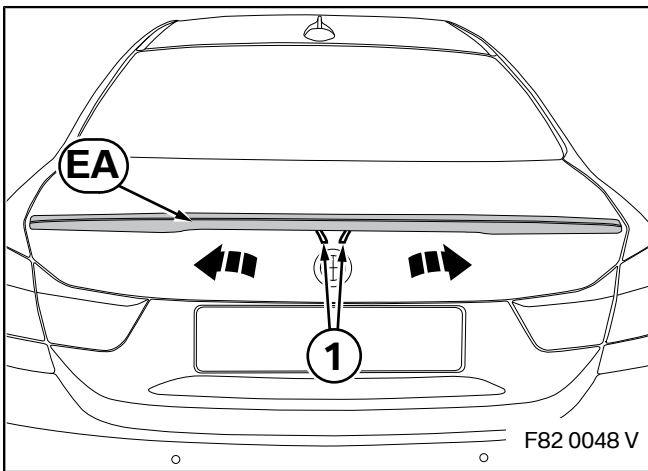


Pull off the upper adhesive backing films (1) of carbon rear spoiler **EA** starting from the middle.

14. Fitting the F82 carbon rear spoiler



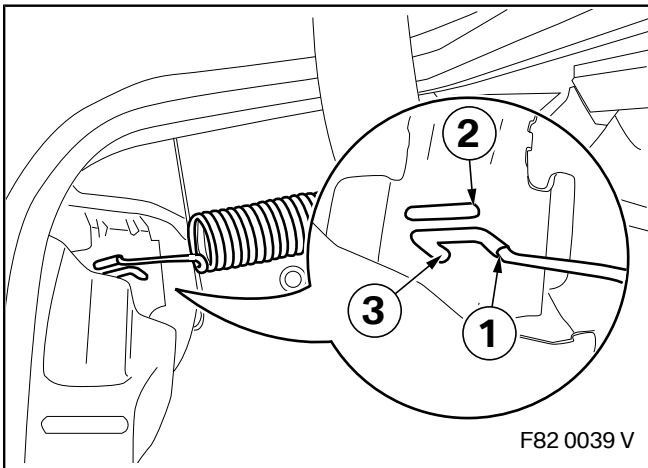
Pull off the side adhesive backing films (1) of carbon rear spoiler **EA**.



Pull off the lower adhesive backing films (1) of carbon rear spoiler **EA** starting from the middle.

Press carbon rear spoiler **EA** firmly and repeatedly onto the tailgate.

▶ Remove any Betalink that oozes out immediately. ◀



▶ Positions (1), (2) and (3) are provided for the tailgate's tension spring.

Move the tailgate's tension spring to **position (3)**.

▶ After repositioning the tension springs, check that the tailgate is able to open properly and adjust the position of the tension springs accordingly if necessary.

15. Concluding work and coding

The retrofit system is relevant to programming/coding only if the carbon rear diffuser retrofit set is installed.

- Connect the battery
- Connect the battery charger to the car
- Connect the car to the ISTA workshop system
- Call up the ISTA/P car programming facility
- If using ISTA/P, please note the instructions provided in the ISTA/P application documentation
- Retrofit K-word: Select "DSMO" via the - **Conversion** - path and work through the created action plan
- If necessary, carry out a car test using the ISTA system and note or work through any entered error memory
- Conduct a function test
- Re-assemble the car in a logical manner
- Give the customer the customer information