

Original BMW Accessories.

Installation Instructions.



Aerodynamic Components Retrofit Kit BMW X5 (F15)

Retrofit kit number

51 19 2 364 672	Front aerodynamic components
51 19 2 364 673	Rear aerodynamic components
51 19 2 364 723	Matt black rear diffuser
51 62 2 284 954	M Performance high-gloss black rear spoiler
18 30 2 287 155	M Performance chrome diesel tailpipe finisher
18 30 2 287 154	M Performance chrome petrol tailpipe finisher

Installation time

The installation time is **approx. 2.5 hours**. 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 (no invoicing via 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 vehicles 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 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:

- Chassis number,
- Retrofit kit part number,
- A detailed description of the problem,
- And 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. 12 hours and may be taken through a car wash after approx. 48 hours. ◀

Ordering instructions

To install the aerodynamic components, Betalink (for instructions and part number, see EPC) and six retaining clamps (for instructions and part numbers, see EPC) must also be ordered.

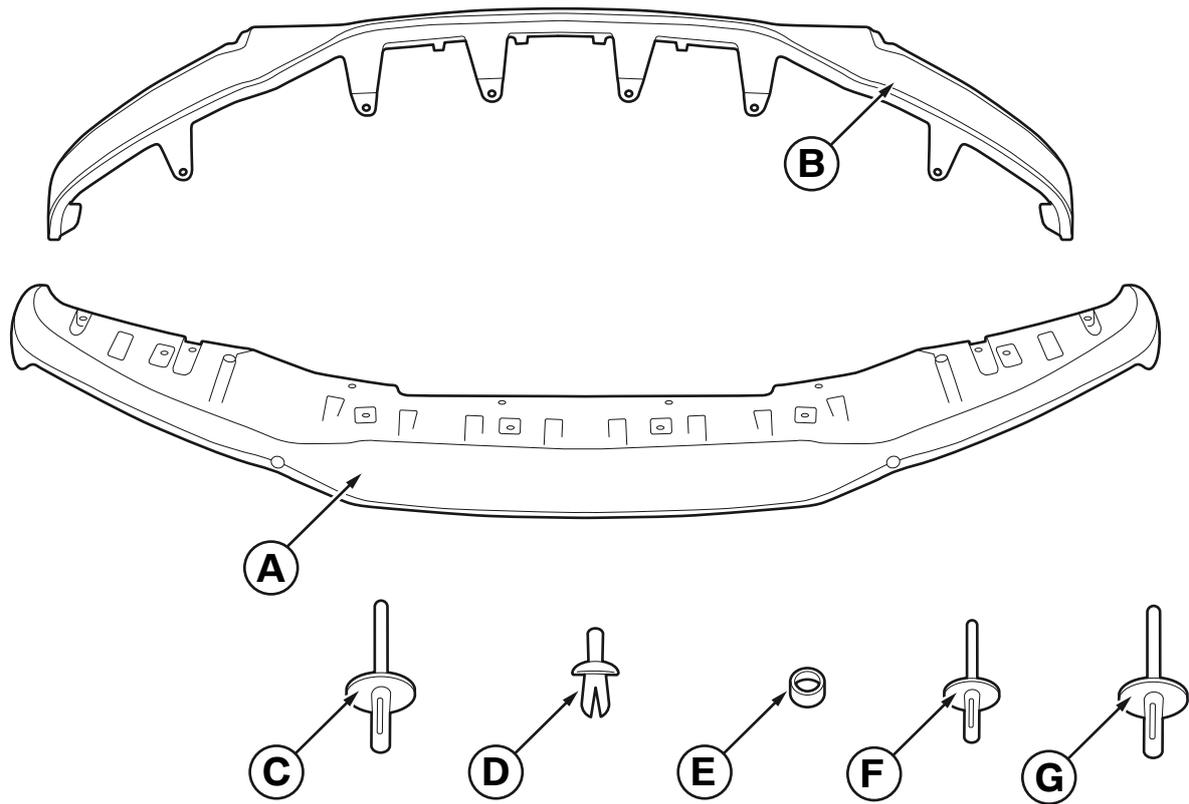
Special tools required

None

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1. Front aerodynamic components parts list

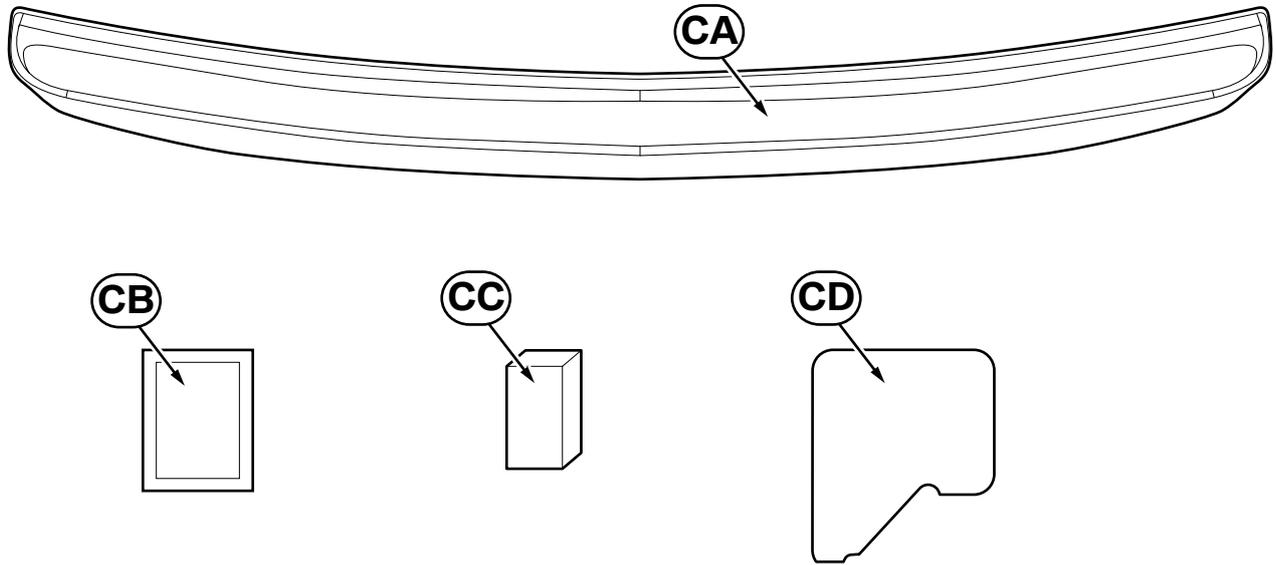


F15 0101 A

Legend

- A** Front add-on
- B** Grained front
- C** Blind rivet (8 x)
- D** Expanding rivet (2 x)
- E** Sleeves (8 x)
- F** Blind rivet (2 x)
- G** Wheel arch blind rivet (8 x)

2. M Performance high-gloss black rear spoiler parts list

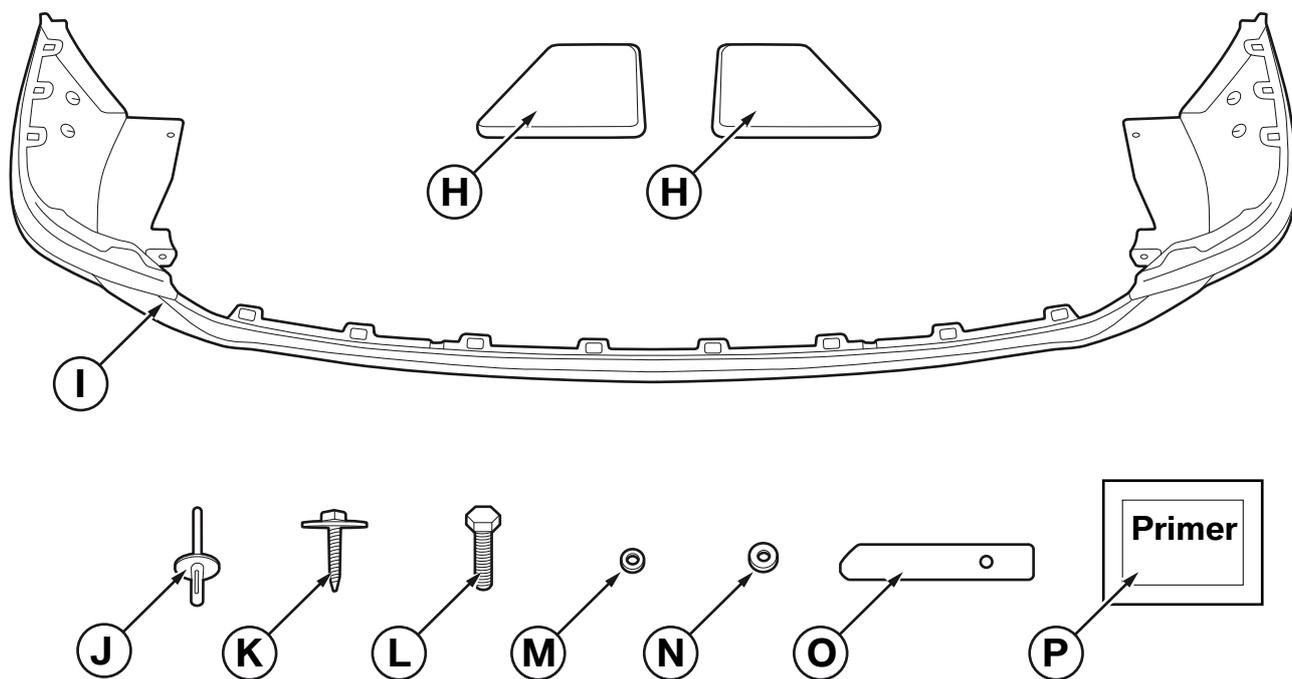


F15 0130 A

Legend

- CA** Rear spoiler
- CB** Cleaning pad
- CC** Betalink (not supplied)
- CD** Template (AI03 only)

3. Rear aerodynamic components parts list

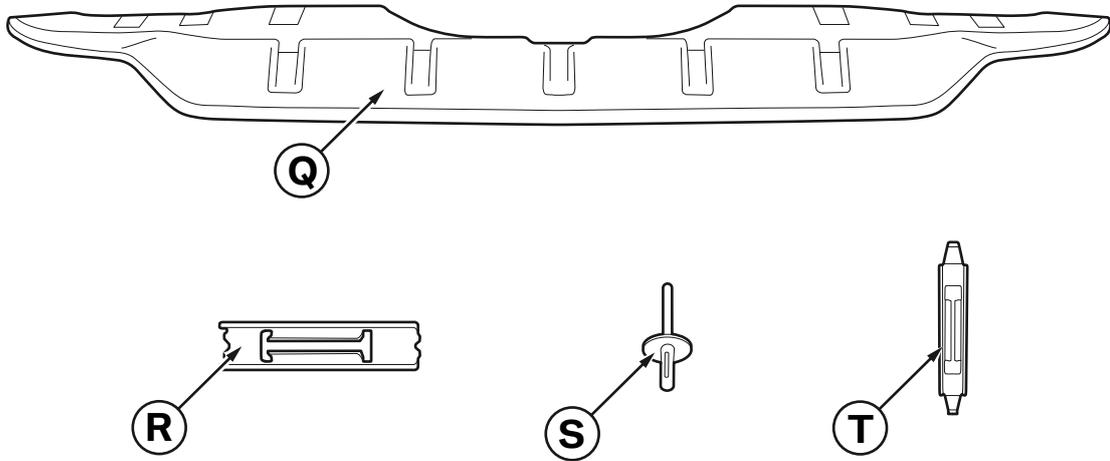


F15 0102 A

Legend

- H** Left/right flap
- I** Grained rear
- J** Wheel arch blind rivet (8 x)
- K** Hexagon screw (2 x)
- L** Screw M5 (4 x)
- M** Shim (4 x)
- N** Plastic washer (4 x)
- O** Adapter (2 x)
- P** 3M primer pad

4. Matt black rear diffuser parts list

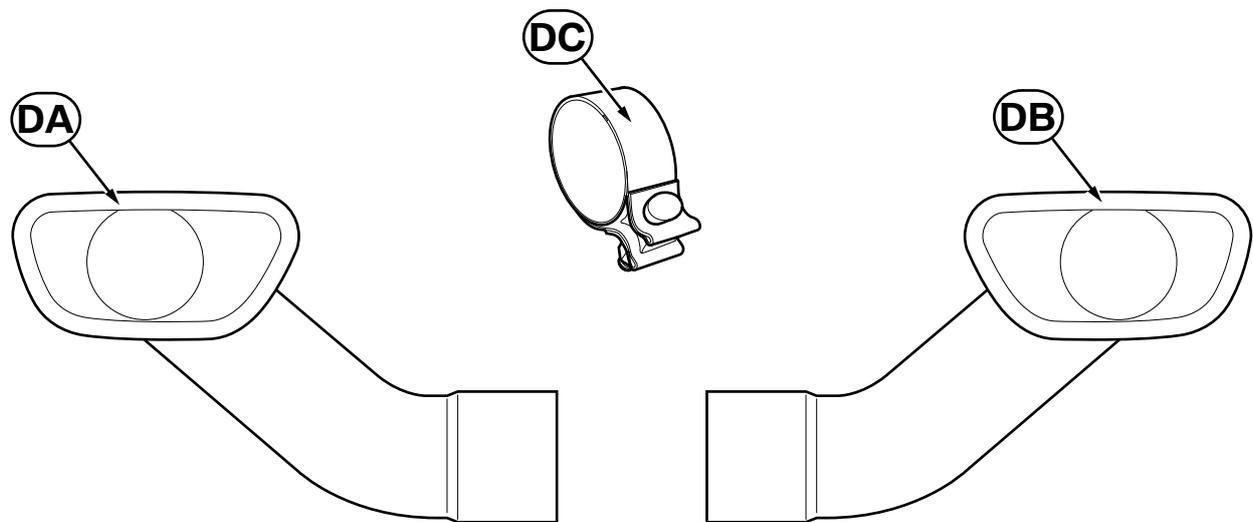


F15 0125 A

Legend

- Q** Rear diffuser
- R** Raymond clip (4 x)
- S** Blind rivet (6 x)
- T** Retaining clamps (6 x, not included in the parts kit, see EPC)

5. M Performance chrome tailpipe finisher parts list



F15 0120 A

Legend

- DA** Left-hand chrome tailpipe finisher
- DB** Right-hand chrome tailpipe finisher
- DC** Clamping ring (2 x)

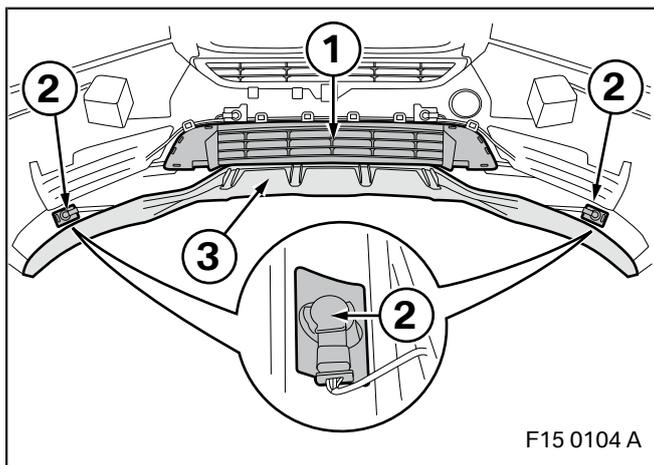
6. Preparatory work

The following components must be removed first of all

ISTA No.

None

7. Installing the front aerodynamic components



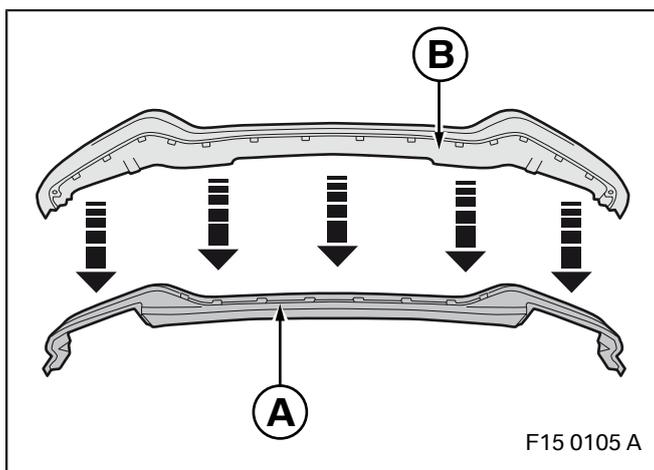
▶ Front add-on section **A** can be painted in the car colour, as per the customer's wishes. ◀

Remove the front apron as per ISTA

Keep the screws as they will be reused later.

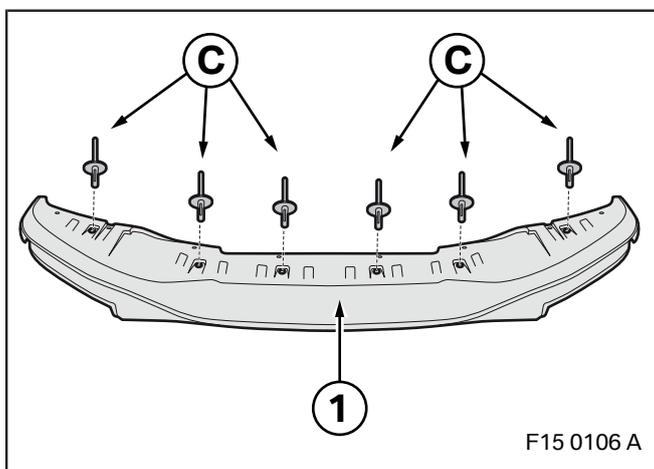
Remove the trim lower section (3).

Remove the original grille (1) and PDC sensors (2).

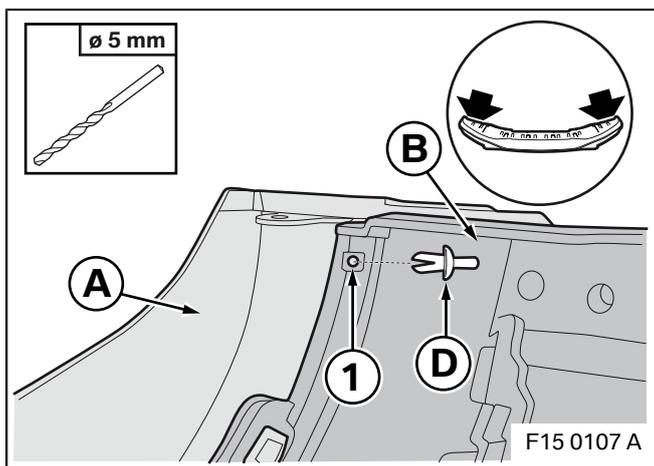


Installing the front aerodynamic components: Place front add-on section **A** on grained front **B** and engage in the clip channel.

▶ Ensure correct clipping in the clip channel. ◀

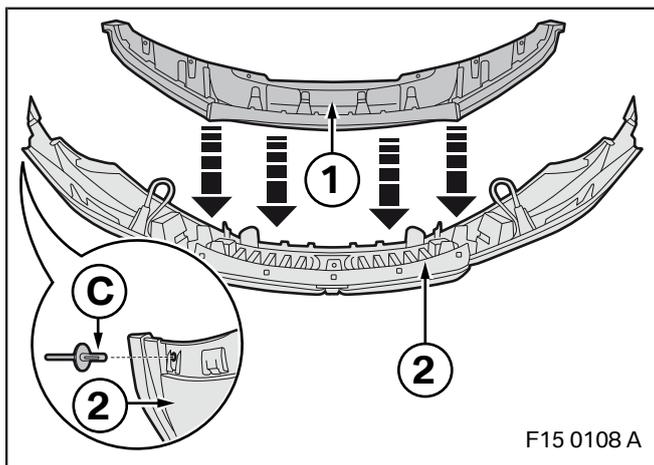


Fit blind rivets **C** into to the front aerodynamic components (1).



Drill holes for the expanding rivets through front add-on section **A** and grained front **B** (1) and then insert expanding rivet **D**.

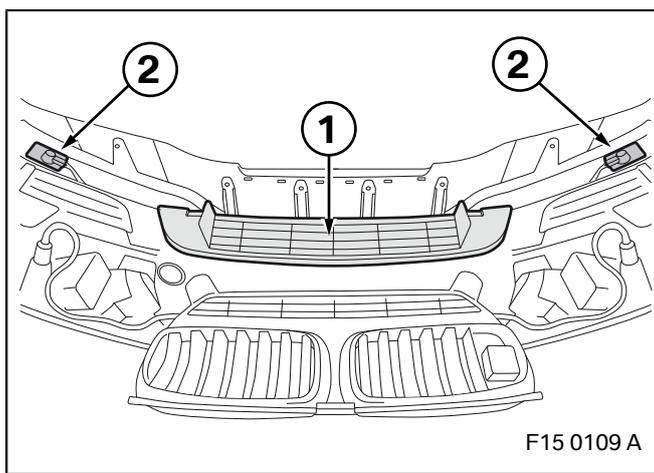
7. Installing the front aerodynamic components



Engage the front aerodynamic components (1) in the original channel on the front apron (2).

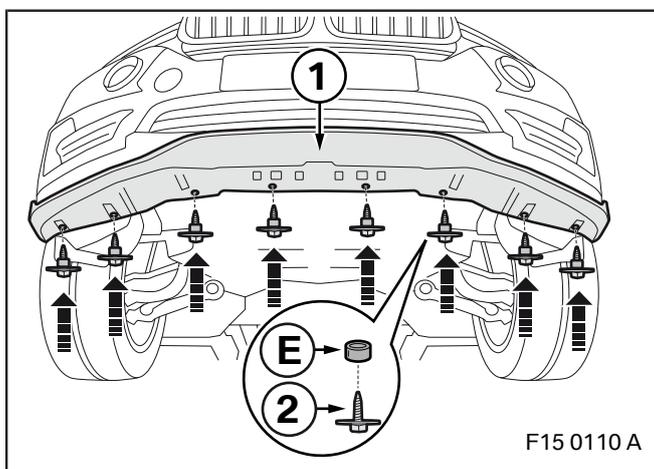
▶ Ensure that the parts are correctly engaged in the clip channel. ◀

Insert left and right blind rivets **C**.



Insert the original grille (1) and PDC sensors (2). Then fit the front apron onto the car using the original screws.

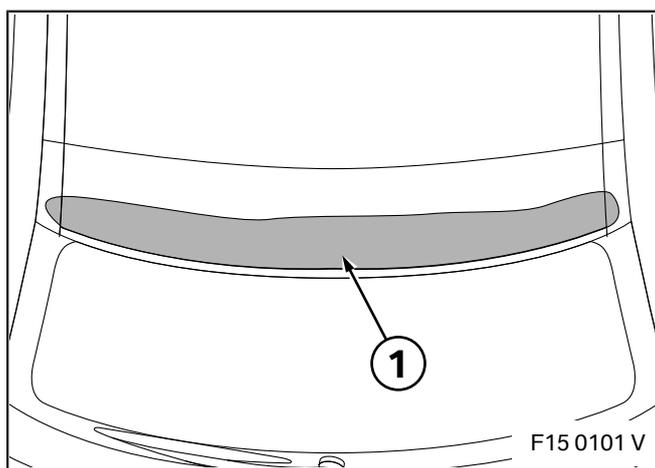
▶ To screw on the underbody, see the next step. ◀



Fit the front apron (1) onto the underbody using the original screws (2) and additional sleeves **E**.

▶ If front aerodynamic components are being installed, the M Performance high-gloss black rear spoiler must also be fitted as described in Section 8 "Fitting the M Performance high-gloss black rear spoiler". ◀

8. Fitting the M Performance high-gloss black rear spoiler

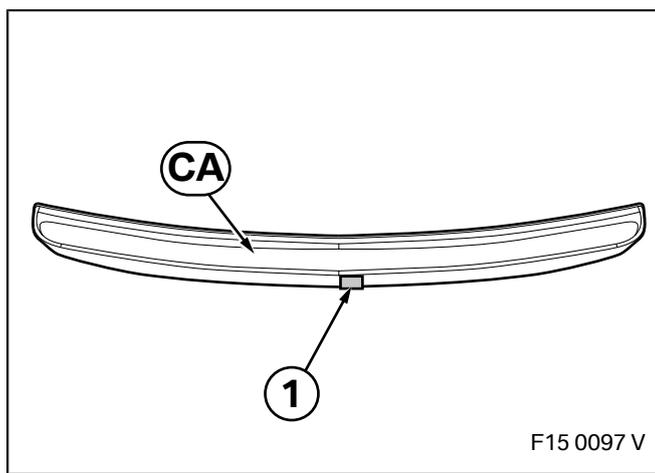


☐ The areas being bonded (1) must be completely dry, clean and free from wax or grease. ◀

☐ Rear spoiler **CA** can be painted in the car colour, as per the customer's wishes. ◀

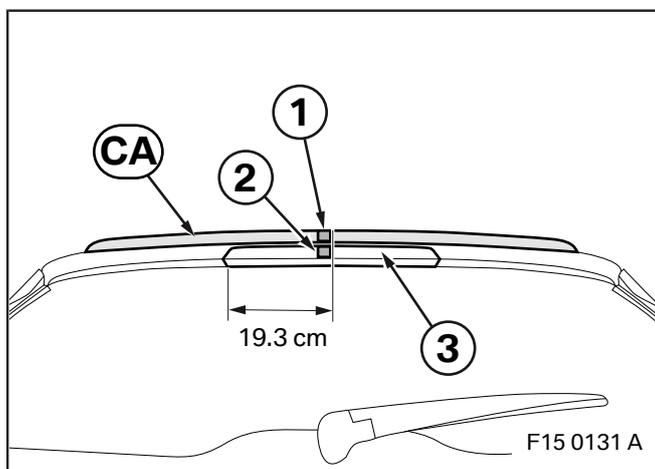
Clean the surface (1) with cleaning pad **CB**.

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



☐ The centre of rear spoiler **CA** is marked with a cut-out. ◀

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



Only AI01 and AI02

☐ Template **CD** is located at the end of this EBA. ◀

Print out template **CD** and cut out along the contour.

For AI01, AI02 and AIXX

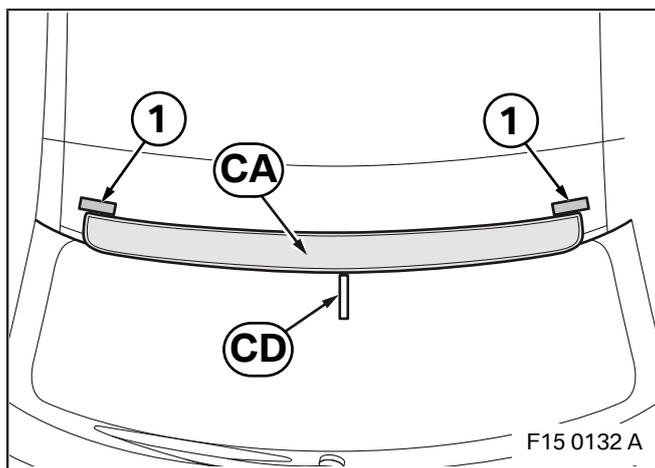
Measure the centre of the brake light (3) using a suitable tool ($x = 19.3$ cm) and mark with adhesive tape (1) and (2).

Position rear spoiler **CA** on the edge of the tail gate so that markings (1) and (2) form a single line.

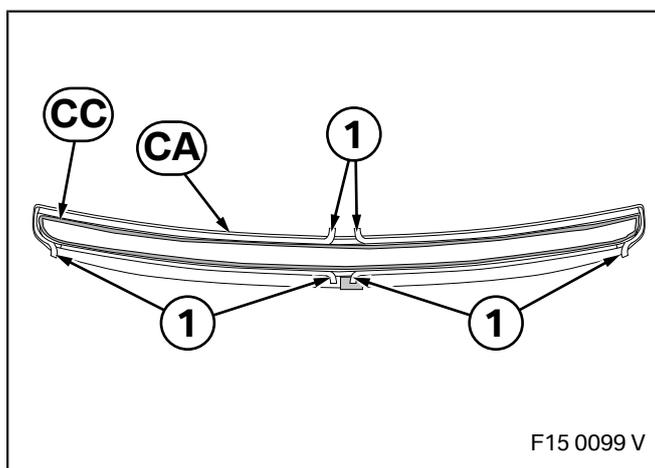
Place template **CD** on the centre markings.

☐ Template **CD** must lie following the contours on M Performance rear spoiler **CA** and at the upper edge of the brake light. ◀

Mark the upper edges of M Performance rear spoiler **CA** using suitable adhesive tape (1).

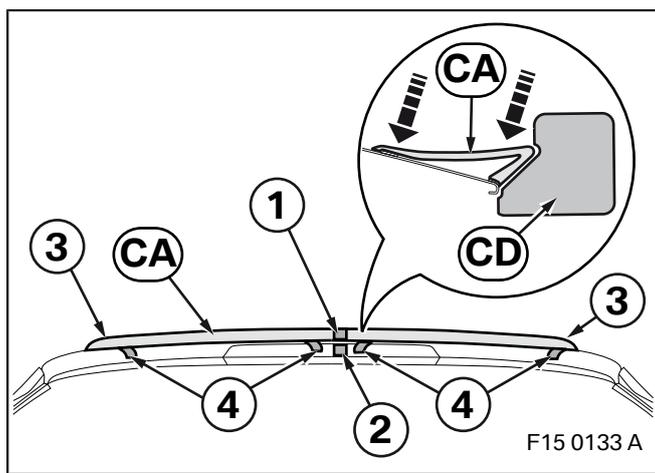


8. Fitting the M Performance high-gloss black rear spoiler



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

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



Position rear spoiler **CA** using template **CD** on the edge of the tail gate.

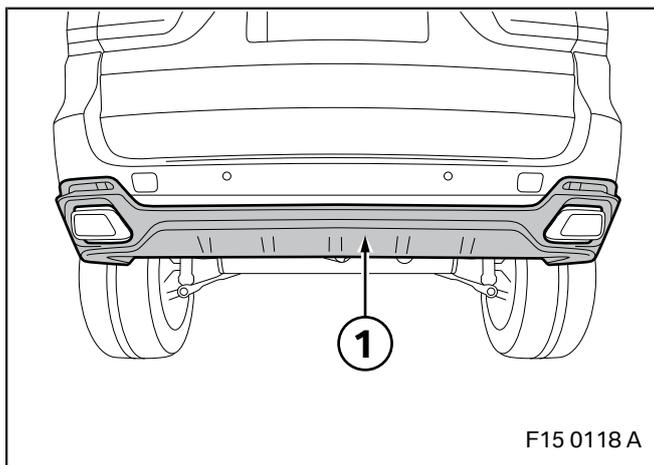
Centre rear spoiler **CA** using adhesive tape (1) and (2) and the top, previously marked adhesive strips (3) (not visible in the image).

Gradually remove all adhesive backing films (4) from the centre outwards.

▶ Press rear spoiler **CA** firmly and repeatedly onto the tailgate. ◀

▶ Remove any Betalink **CC** that escapes immediately using a suitable implement. ◀

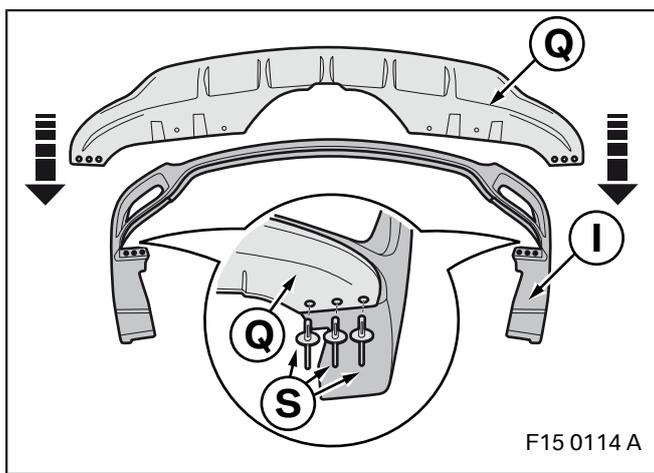
9. Installing the rear aerodynamic components



Flaps **H** and rear diffuser **Q** can be painted in the car's colour in line with the customer's wishes. ◀

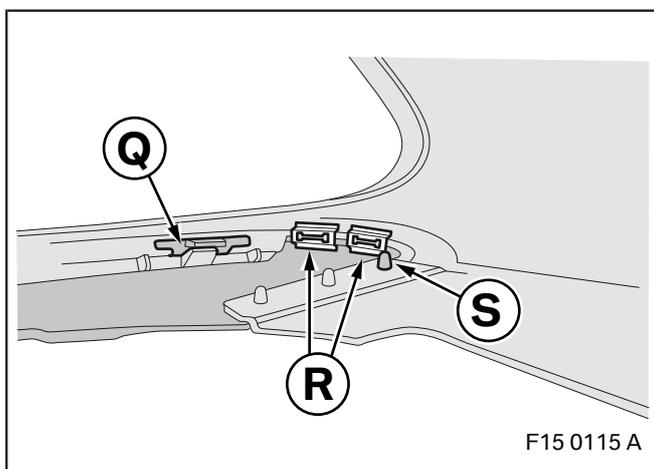
Remove the rear lower section of the rear apron (1) and keep the screws.

For cars with N57 or N55 engine, the tailpipe must be switched to an 8-cylinder tailpipe, as described in Section 10 "Fitting the M Performance chrome tailpipe finisher", **before the next step is carried out.** ◀

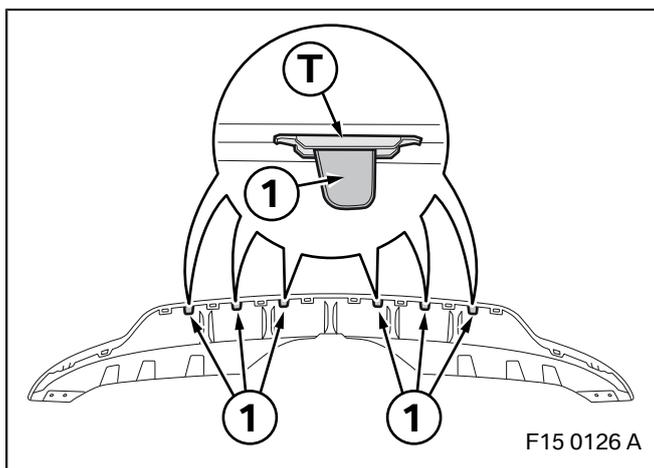


Engage rear diffuser **Q** in grained rear **I** in the clip channel and ensure it is engaged correctly!

Connect rear diffuser **Q** with grained rear **I** using blind rivets **S**.

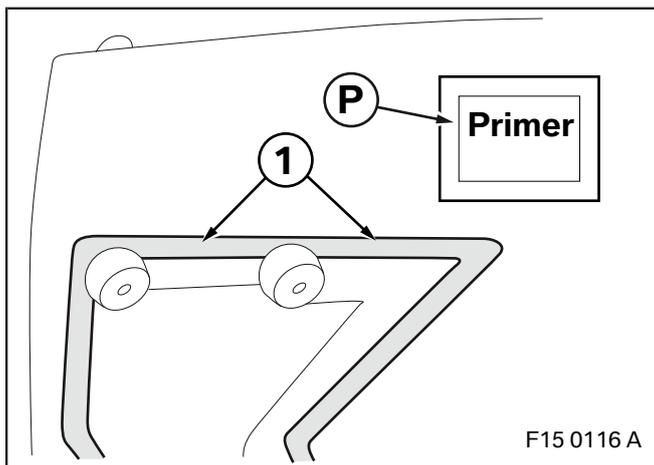


Attach Raymond clips **R** between blind rivet **S** and the last engagement of rear diffuser **Q** as an additional securing mechanism.



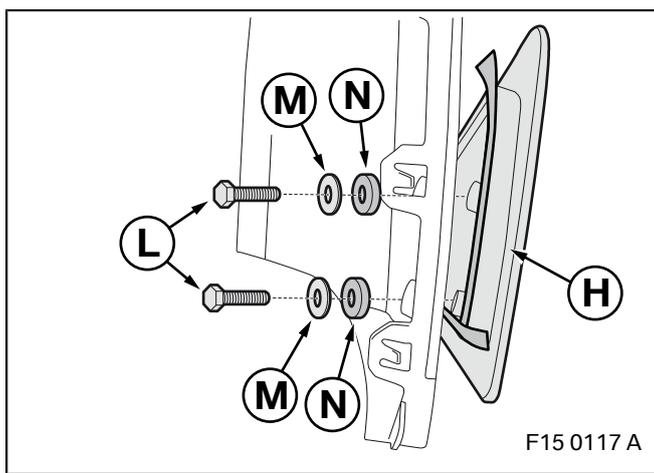
Push retaining clamp **T** onto the lugs (1) and press on firmly using a suitable tool until the springs on the left and right are lying flat and generating pre-tension.

9. Installing the rear aerodynamic components



To install side flaps **H**, the areas (1) (not grained) must be cleaned and pre-treated with primer **P**.

▶ Note the ventilation time of at least 5 minutes. ◀



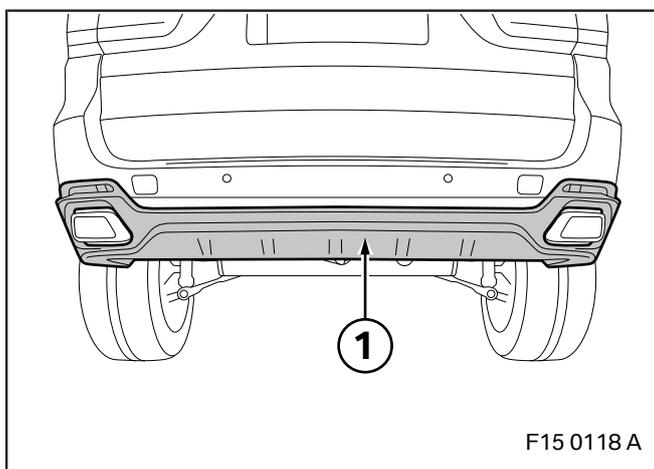
Fit flaps **H** on the side on the aerodynamic components.

Fit flaps **H** at the embossed area provided and then secure using M5 screw **L**, shim **M** and plastic washer **N**.

Proceed in exactly the same way on the opposite side.

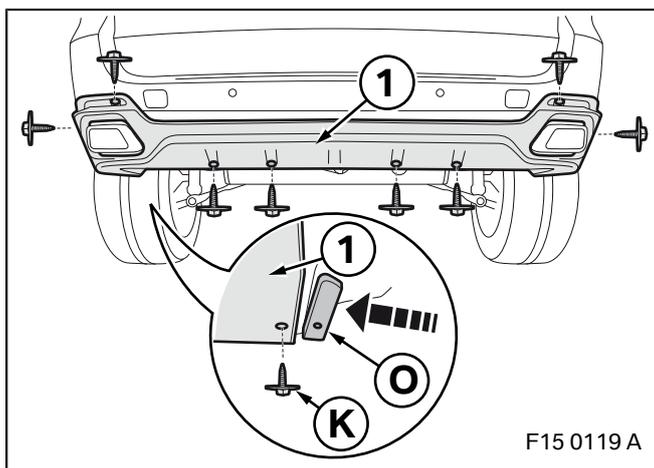
Remove the all-round backing film of the adhesive tape.

After removing the backing film, press on the flaps firmly and repeatedly.



Fit the rear aerodynamic components (1) to the car in the original clips channel.

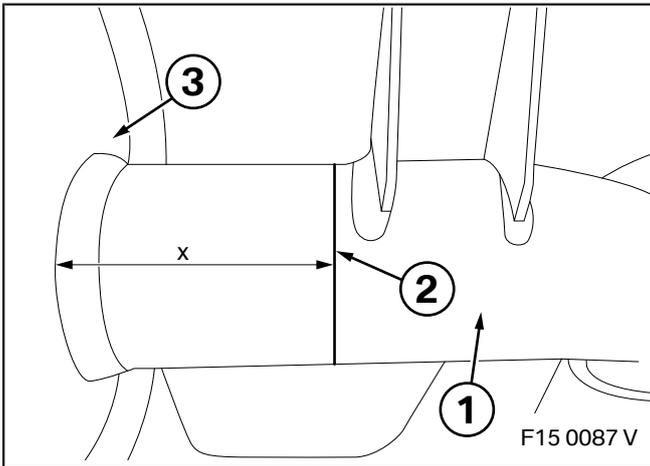
▶ Ensure they are clipped in correctly. If necessary, hold the rear apron to provide counterpressure. ◀



Fit the rear aerodynamic components (1) using the original screws. Insert adapter **O** and hexagon screws **K** and tighten them.

Secure the original wheel arches using blind rivets **J**.

10. Fitting the M Performance chrome tailpipe finisher

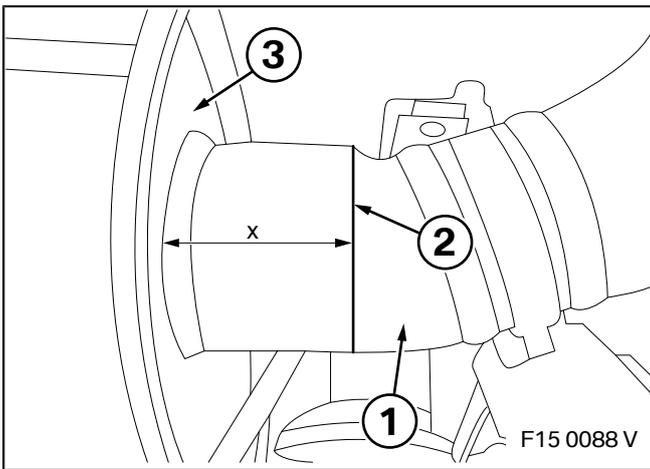


Only for cars with N57 engine

 Support the rear silencer before separating it using suitable means. ◀

Using suitable tools, mark and cut the tailpipe (1) at the line (2) with a distance of **x = 83 mm** from the end wall of the silencer (3).

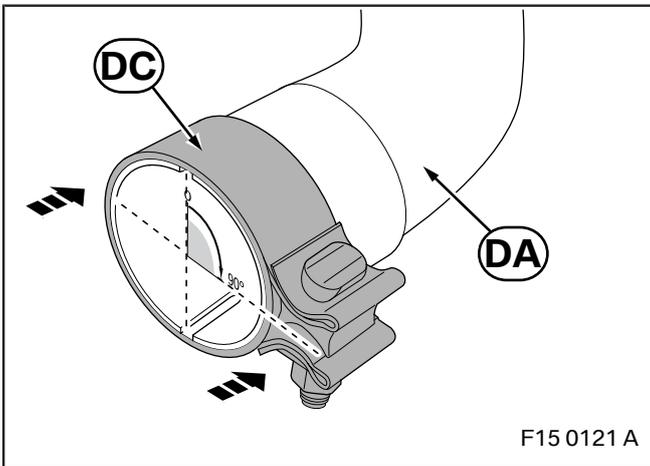
Remove the tailpipe (1) and deburr the edges on the rear silencer.



Only for cars with N55 engine

Using suitable tools, mark and cut the tailpipe (1) at the line (2) with a distance of **x = 60 mm** from the end wall of the silencer (3).

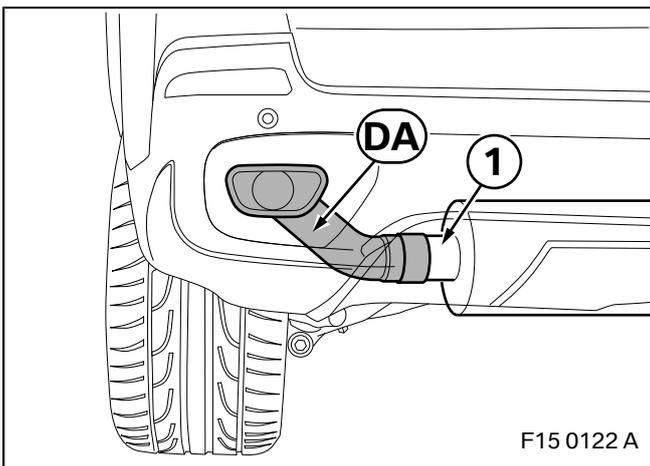
Remove the tailpipe (1) and deburr the edges on the rear silencer.



For all cars

 The lock on clamping ring **DC** must face the direction of travel. ◀

Place clamping ring **DC** on left chrome tailpipe finisher **DA**, aligning the ring lock at 90° to the groove. Align clamping ring **DC** flush with the end of chrome tailpipe finisher **DA**.

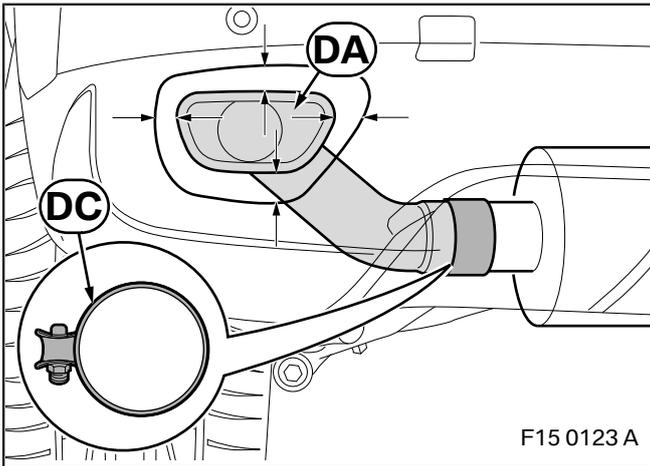


Place chrome tailpipe finisher **DA** on the cut-off tailpipe (1).

For design Basic/Pure Experience/Pure Excellence/Pure Extravagance only

Fit the bumper as per **ISTA No. 51 12 160**.

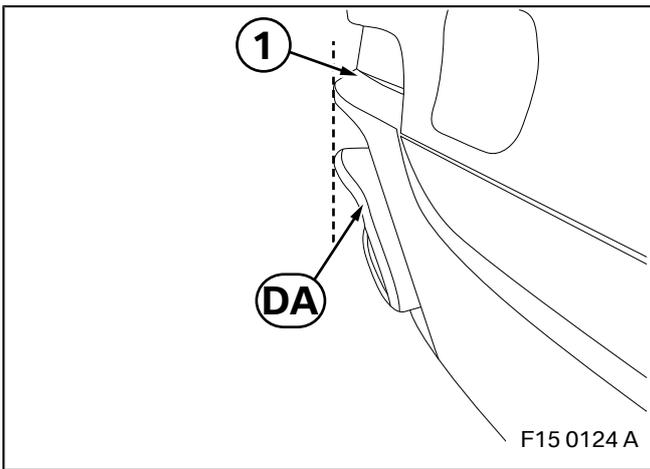
10. Fitting the M Performance chrome tailpipe finisher



For all cars

Check the position of tailpipe finisher **DA** relative to the bumper, re-averaging and re-aligning as necessary.

Then tighten clamping ring **DC** to 55 ± 8 Nm.



⏏ During installation and while driving (thermal expansion of the exhaust system), care must be taken to ensure that tailpipe finisher **DA** does not extend beyond the rear apron (1) (danger of burning!). ◀

11. Concluding work and coding

The retrofit system does not require programming / coding.

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

12. Template CD

