

Original BMW Accessories.

Installation Instructions.



M Performance Aerodynamics Package Retrofit Kit

BMW 2 Series Coupé (F22)

Retrofit kit number

single-sided single-pipe	single-sided twin-pipe	double-sided single-pipe	Component designa- tion	Type	Installa- tion time (h)
	51 19 2 343 354	51 19 2 343 355	Matt black rear diffuser	F22/F23	0.25
	51 19 2 343 367		Matt black front add-on	F22	0.50
	51 19 2 298 287		Matt black left side sill add-on	F22/F23	0.75
	51 19 2 298 286		Matt black right side sill add-on	F22/F23	0.75
	51 19 2 298 285		Side skirt foil left/right	F22/F23	0.75
	18 30 2 287 042		Intermediate pipe set	F22/F23	0.25
	18 30 2 287 043		Intermediate pipe set	F22/F23	0.25
	18 30 2 354 364		Chrome 235i tailpipe finisher	F22/F23	0.25
	18 30 2 355 889		Carbon 235i tailpipe fin- isher	F22/F23	0.25
	18 30 2 336 864		Chrome 228i tailpipe finisher	F22/F23	0.25
	51 62 2 334 541		Carbon rear spoiler	F22/F23	0.50

Installation time

The installation time is **approx. 4.0 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

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 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.

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 tailpipe finisher adapter must also be installed in 228i and 235i cars (for instructions and part numbers see EPC).

The installation of the tailpipe finisher is described in EBA 01 29 2 287 618.

The installation of the side sill is described in EBA 01 29 2 298 066.

The installation of the film adhesive for the side sill is described in EBA 01 29 2 298 023.



The car may be driven after approx. 6 hours and may be taken through a car wash after approx. 24 hours. ◀



If an M Performance rear spoiler is to be installed, any rear spoiler already in place must be removed / dismantled as per ISTA. ◀

Special tools required

None

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 ...).



Both the front add-on and the rear diffuser each have multiple painting gaps. This allows a customised design to be created in line with the customer's wishes. The customer must be informed of this in advance and the customer's preferences enquired about. ◀

Information to be provided to the customer

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



The black matt M Performance front add-on may only be installed in conjunction with the M Performance carbon rear spoiler (for part number and instructions see EPC). ◀

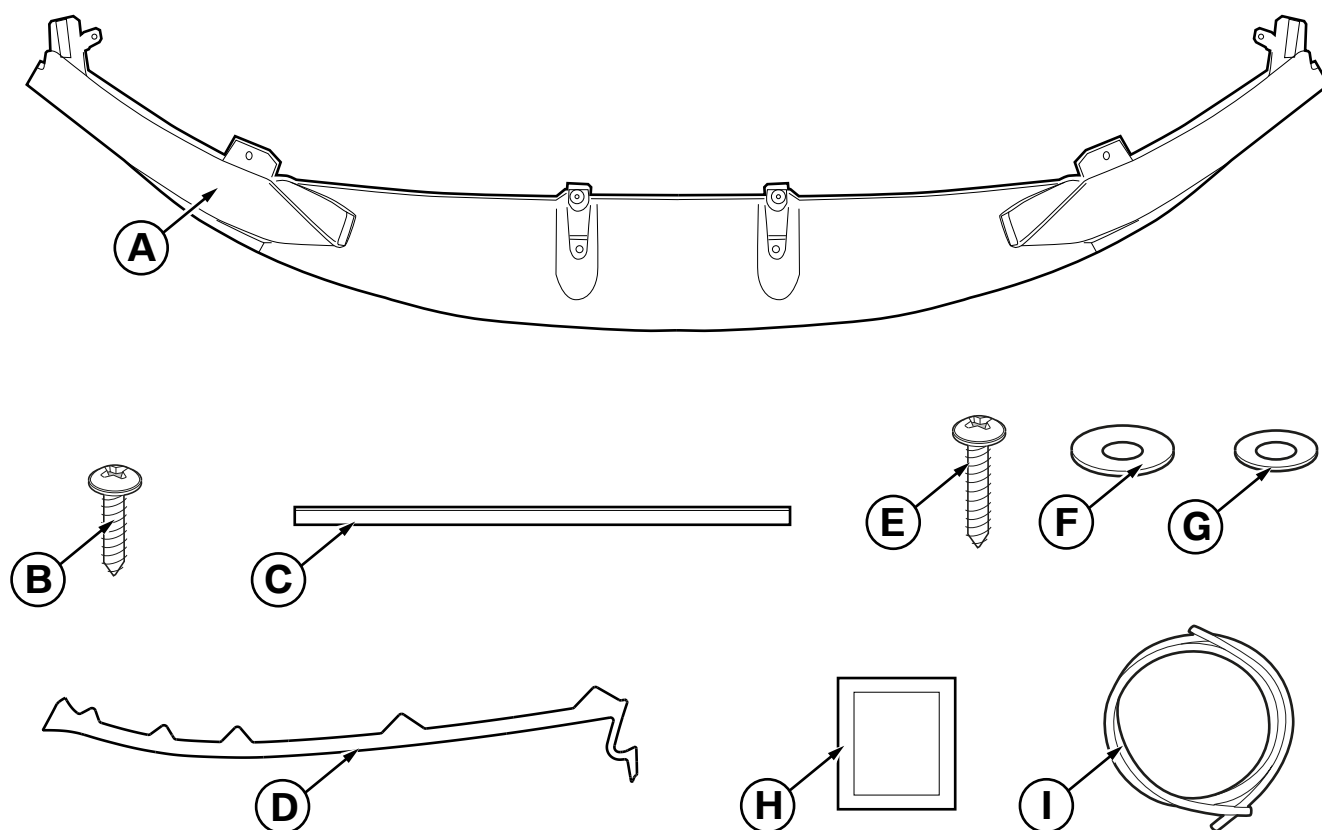


The black matt M Performance front add-on reduces the car's floor clearance and reduces the overhang angle at the front. The BMW M Performance front add-on must be checked at regular intervals for damage caused by collisions and, in the event of any such damage, replaced by trained specialist personnel.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

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1. Front add-on parts list

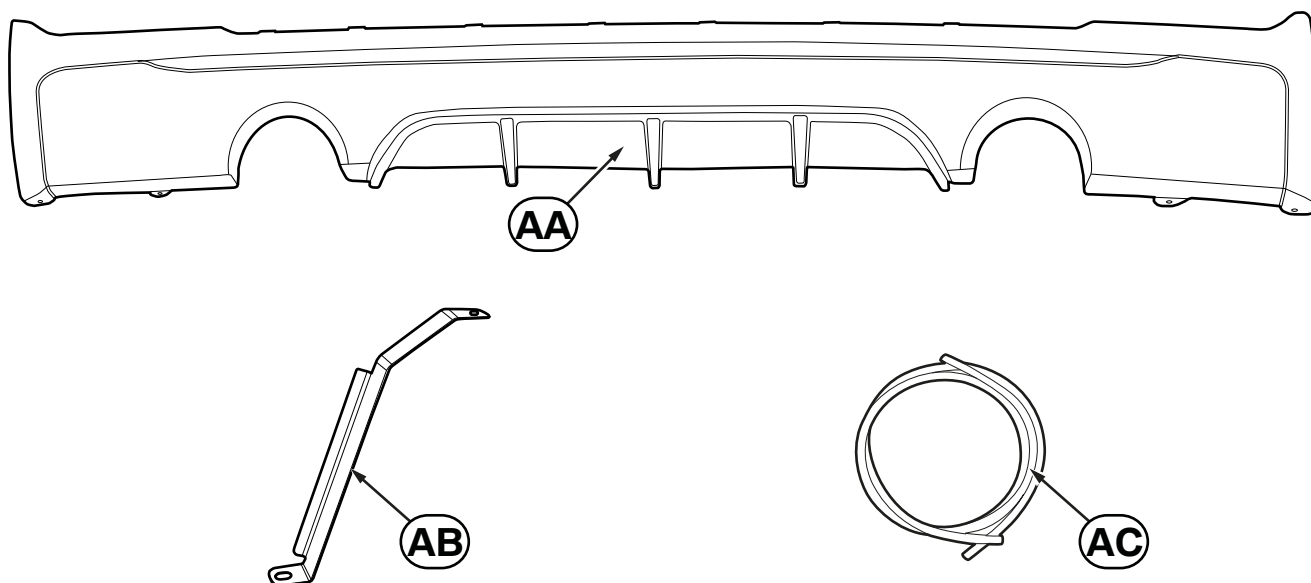


F22 0013 V

Legend

- A** Front add-on
- B** Screw 4.8 x 19 mm (2 x)
- C** Foam adhesive tape
- D** Left/right punched part decorative film (2 x) (right only shown)
- E** Screw 4.8 x 25 mm (6 x)
- F** Washer internal diameter 6.4 mm, external diameter 18 mm (4 x)
- G** Washer internal diameter 6.4 mm, external diameter 14 mm (2 x)
- H** Cleaning pad (2 x)
- I** Masking string

2. Rear diffuser parts list

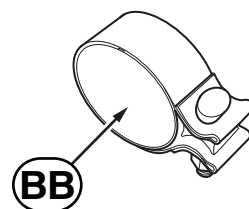
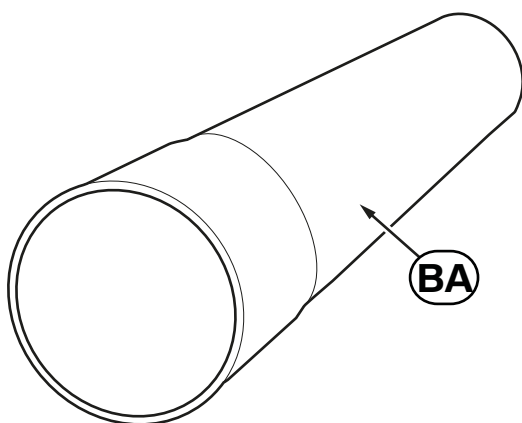


F22 0017 V

Legend

- AA** Rear diffuser
- AB** Left/right angle bracket (2 x) (right only shown)
- AC** Masking string

3. Tailpipe finisher adapter parts list

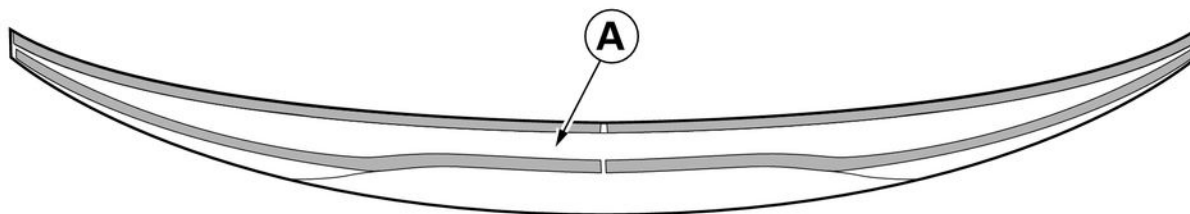


F22 0018 V

Legend

- BA** Tailpipe finisher adapter
- BB** Torca clamp

4. Carbon rear spoiler parts list



F32 0000 V

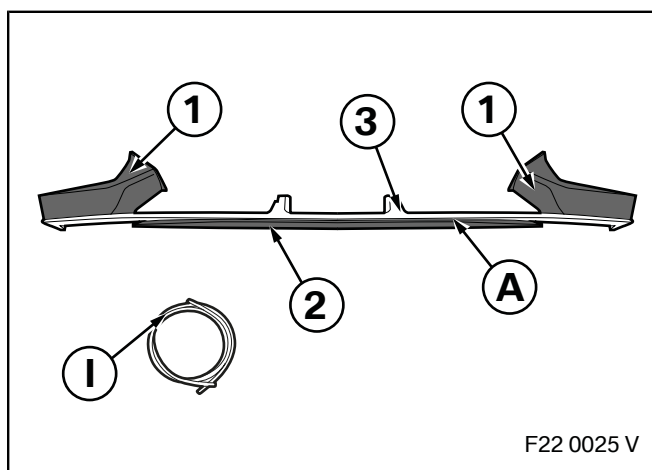
Legend

A Rear spoiler including cleaning pad

5. Preparatory work

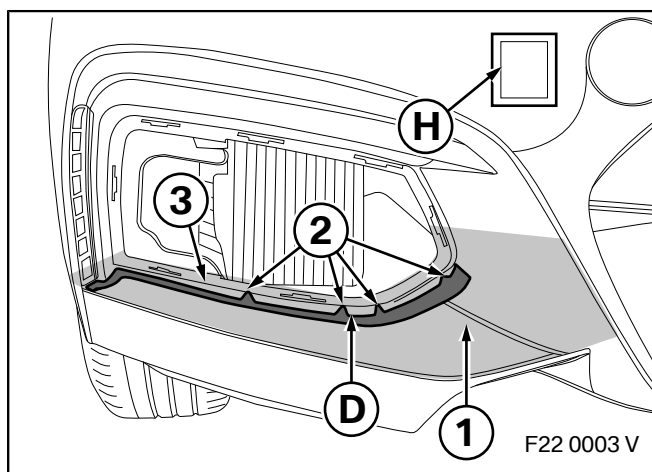
The following components must be removed first of all	ISTA No.
Front left/right air inlet grille	---
Rear diffuser	
Remove / dismantle the rear spoiler if necessary	

6. Fitting the front add-on



Front add-on **A** has multiple masking gaps. This allows a customised design to be created in line with the customer's wishes. The customer must be informed of this in advance and the customer's preferences enquired about. ◀

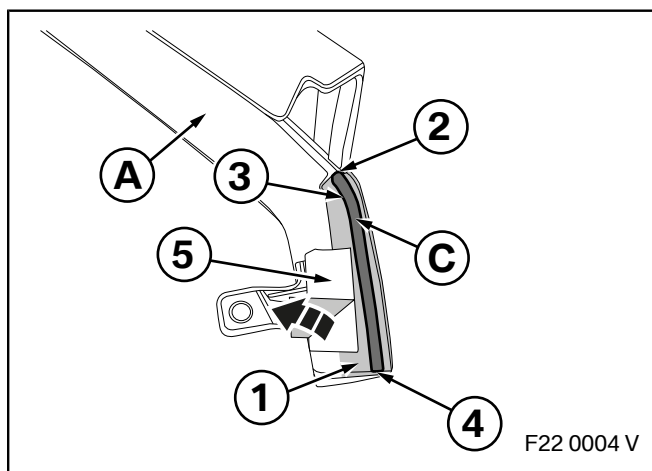
Mask front add-on **A** according to the customer's wishes with masking tape and masking string **I**. The unmasked areas **(1)** and/or **(2)** and/or **(3)** can be painted.



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

Clean the bonding surface **(1)** with cleaning pad **H**.

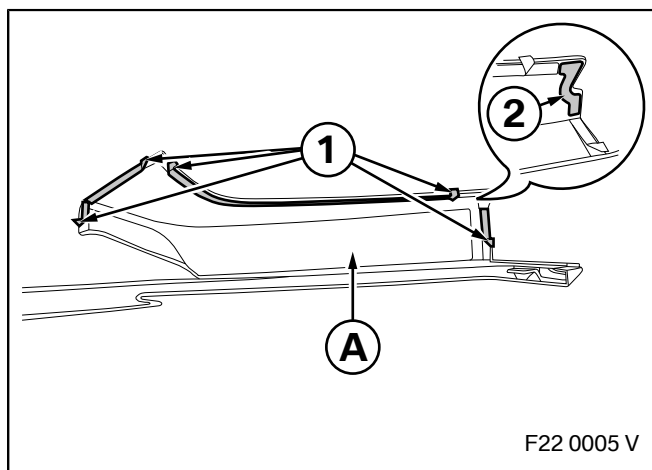
Stick the positioning tips **(2)** of punched part decorative film **D** along the contour **(3)**.



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

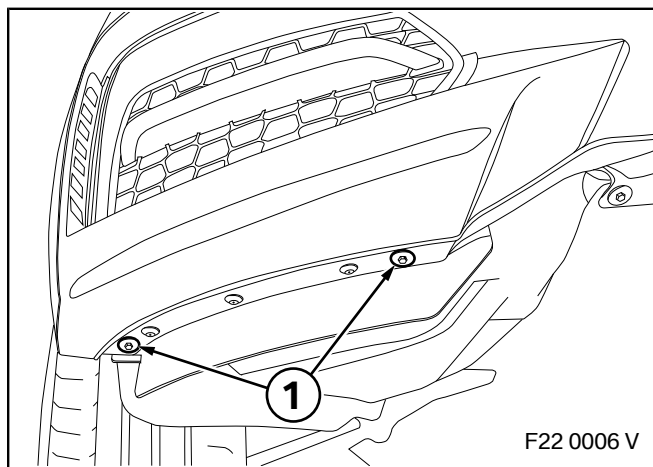
Clean the bonding surfaces **(1)** with cleaning pad **H**.

Stick foam adhesive tape **C** **(2)** flush at the end and along the marking line **(3)** on front add-on **A** as shown. Shorten foam adhesive tape **C** flush at the outer end **(4)**. Fold over the backing film **(5)** of the adhesive tape.

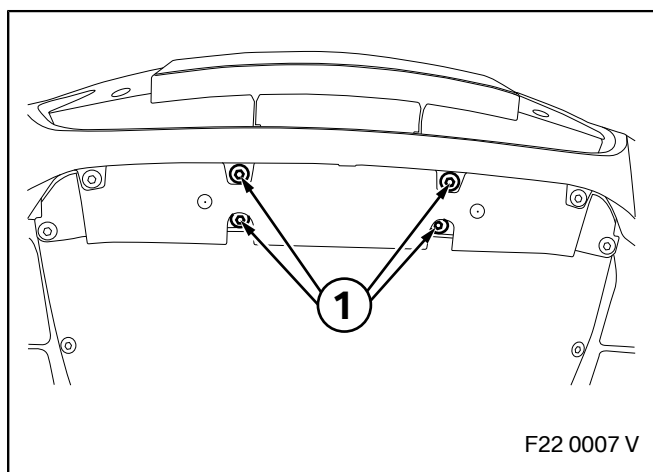


Loosen the ends of the protective film **(1)** on the adhesive strip and fold them outwards. Completely remove the protective film from the short adhesive tape **(2)**.

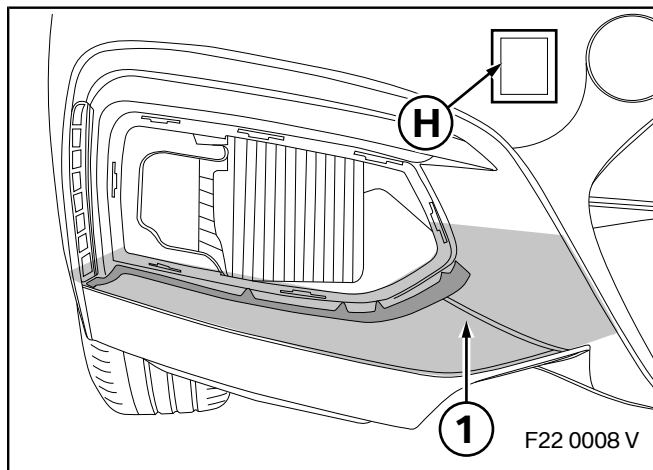
6. Fitting the front add-on



Remove the two screws shown (1).

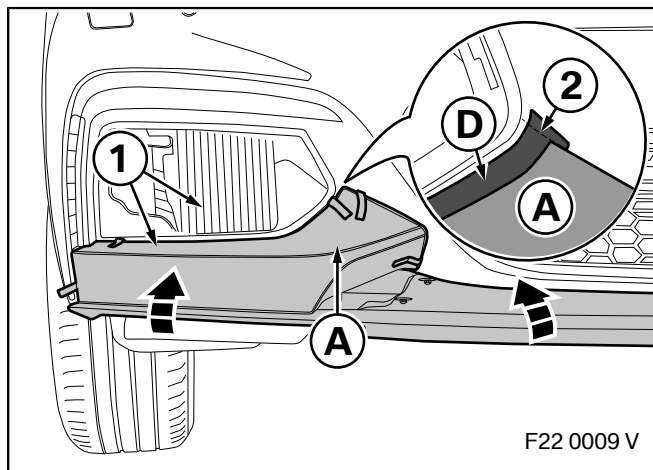


Remove the four screws (1).



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

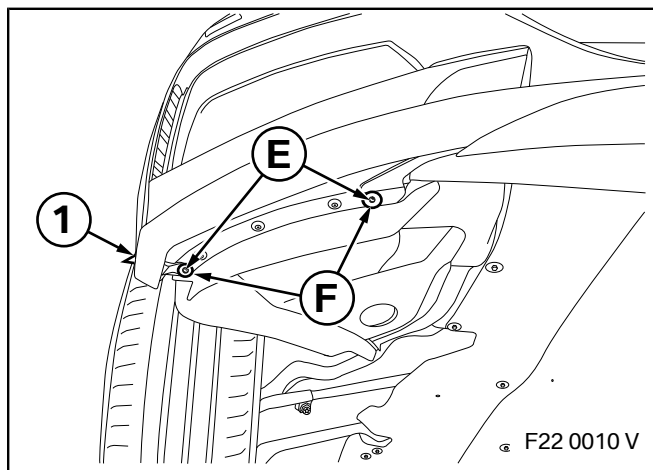
Clean the bonding surface (1) again with cleaning pad **H**.



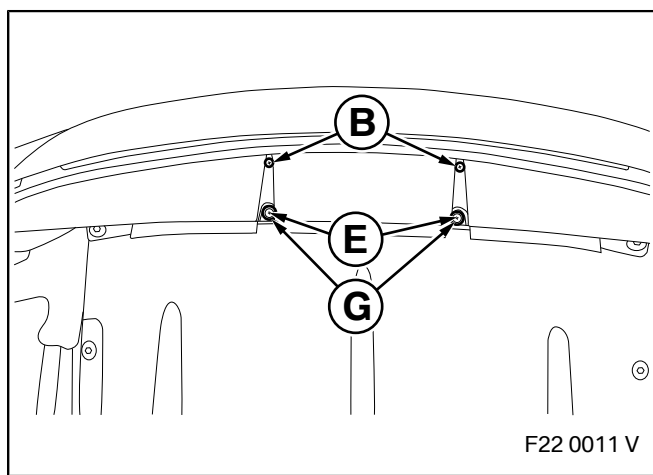
Place front add-on **A** in position, ensuring that the protective films (1) are all visibly orientated outwards. Pull out the protective films (1) and press front add-on **A** firmly onto the car.

▶ If necessary, trim the overhang (2) of punched part decorative film **D** using a scalpel to match the contour. ◀

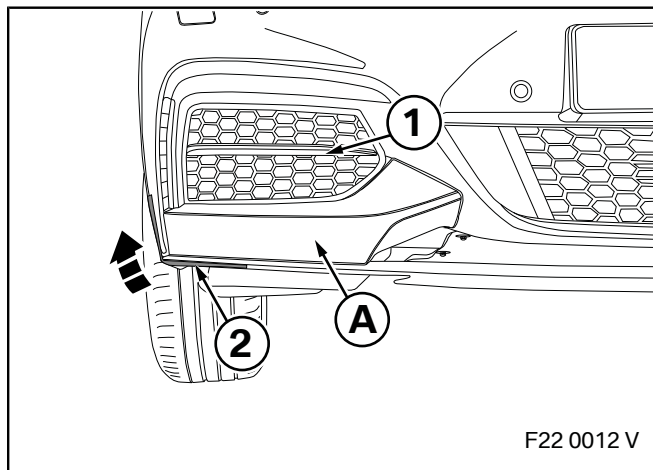
6. Fitting the front add-on



Remove the protective film (1). Screw in screws **E** together with washers **F**.



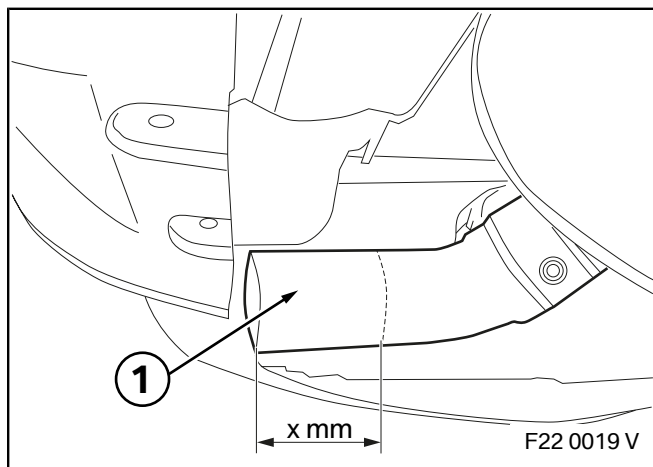
Screw screws **B** into the drill holes facing forwards at the front. Screw screws **E** with washers **G** into the two rear drill holes.



Fit the air inlet grille (1). Using a suitable adhesive tape (2), press front add-on **A** on the side upwards onto the bodywork.

▶ After at least 30 minutes, carefully remove the adhesive tape (2) from front add-on **A** from the bottom to the top. ◀

7. Fitting the tailpipe finisher adapter for the tailpipe finisher



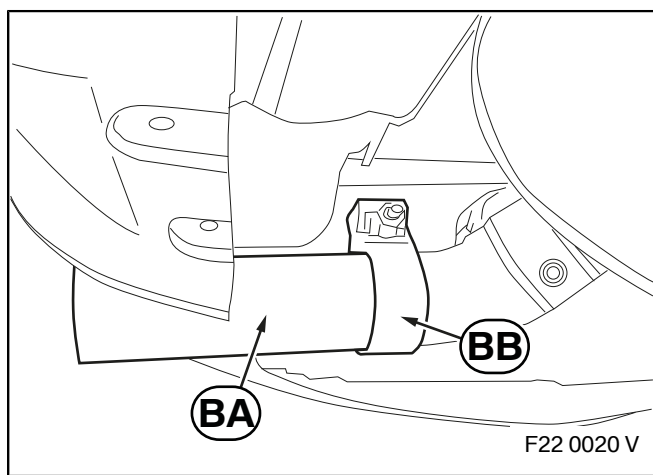
Only for cars with serial silencer 228i and 235i

▶ When installing the M Performance rear diffuser, a tailpipe finisher adapter must be installed (for instructions and part number see EPC). ◀

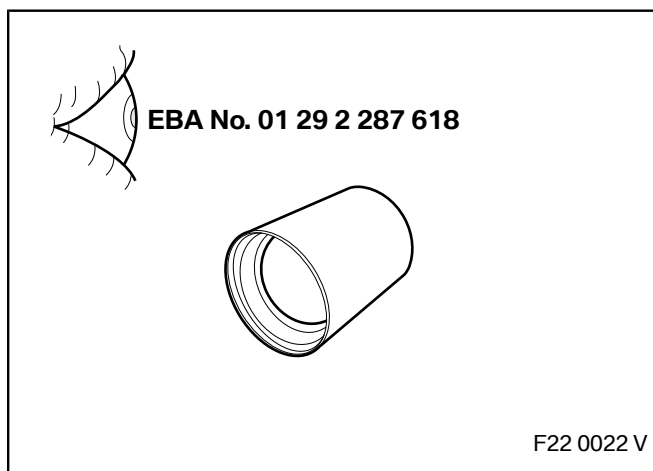
Shorten the tailpipe (1) from the end by **x mm** using a suitable tool. Deburr the cut edge and coat it with anti-corrosion preservative.

228i: x = 98 mm

235i: x = 120 mm

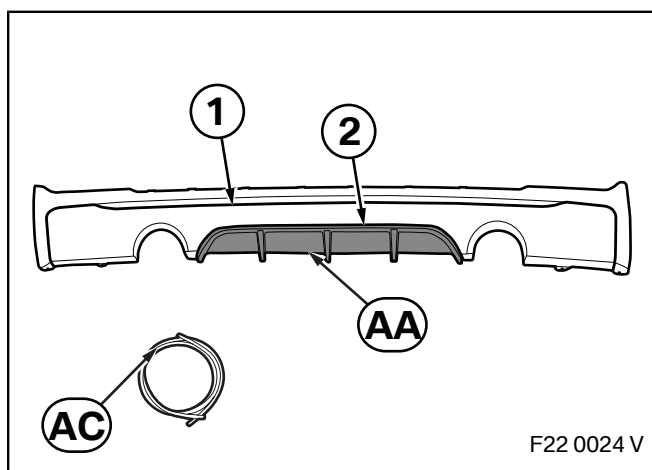


Place Torca clamp **BB** on the tailpipe (1), then place tailpipe finisher adapter **BA** onto the tailpipe (1). Average out Torca clamp **BB** as shown and tighten it to **70 Nm**.



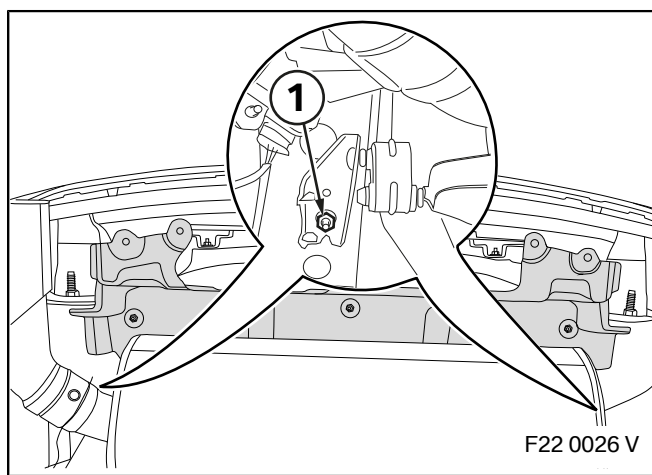
▶ Fitting the tailpipe finisher as per EBA part No. **01 29 2 287 618**. ◀

8. Fitting the rear diffuser

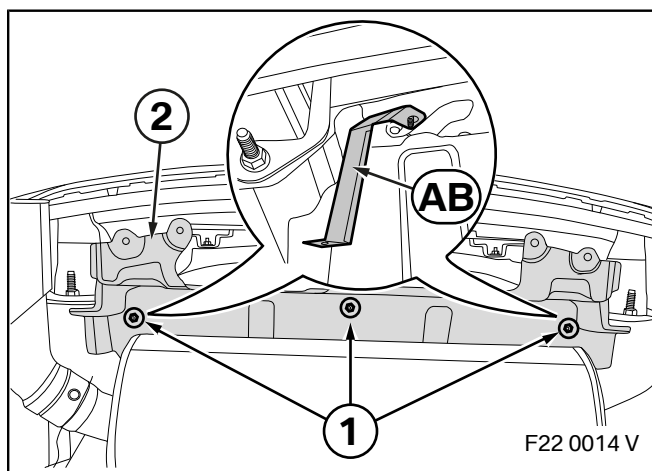


- ▷ Rear diffuser **AA** has multiple masking gaps. This allows a customised design to be created in line with the customer's wishes. The customer must be informed of this in advance and the customer's preferences enquired about. ◀

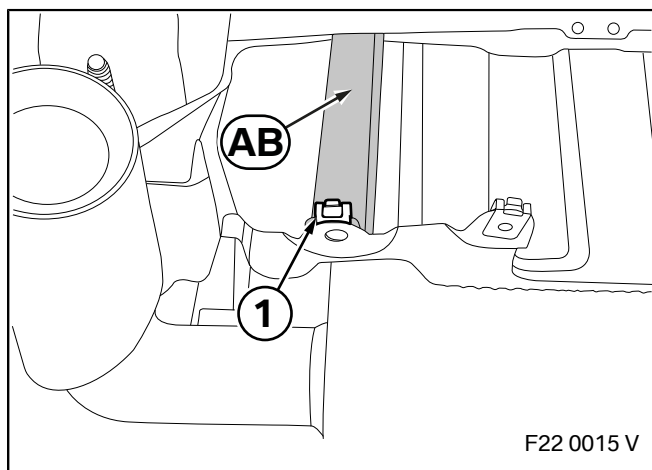
Mask rear diffuser **AA** according to the customer's wishes with masking tape and masking string **AC**. Use the gaps (1) and/or (2) provided for this. Paint the unmasked areas.



- ▷ If necessary, lower the exhaust system, loosening both nuts (1) to do this. ◀



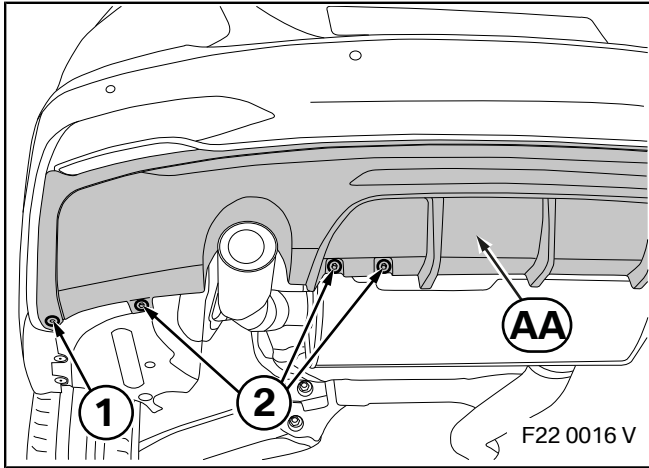
Remove the sheet metal nuts (1). Remove the heat shield (2). Place angle bracket **AB** with the drill holes on the left and right welding studs so that they stick out backwards when the vehicle is facing forwards. Fit heat guard (2) using sheet metal nuts (1) so that angle brackets **AB** are installed between the bodywork and the heat guard (2).



Place the existing C clip (1) of the heat guard on the end of angle bracket **AB**.

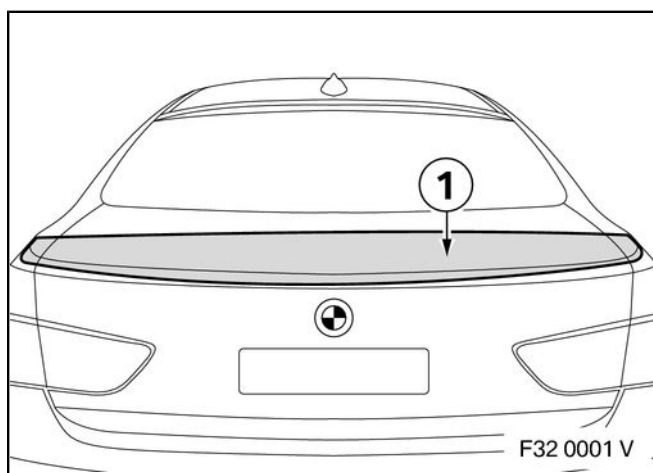
- ▷ Screw the exhaust system back on. ◀

8. Fitting the rear diffuser



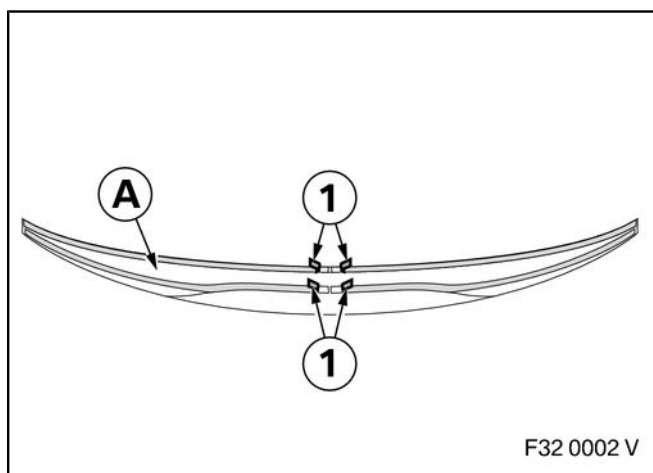
Place rear diffuser **AA** on the car and press it into place. Press in the plastic rivet (1) and tighten the screws (2).

9. Installing the carbon rear spoiler

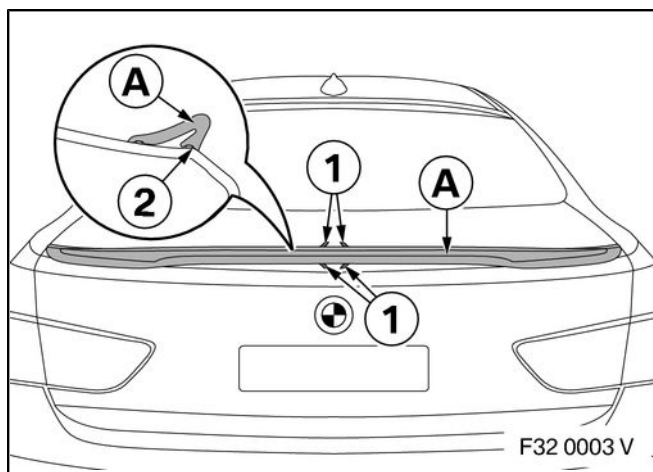


- ▢ Car surface (1) must be completely dry, clean and free from wax and grease. ◀

Clean the car surface (1) with suitable agents.



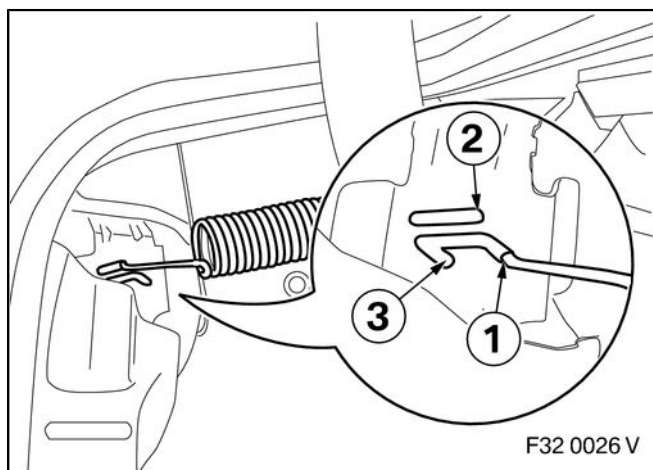
Pull back the ends of the adhesive backing film on rear spoiler **A** far enough so that small tabs (1) form.



- ▢ Ensure that all tabs on the adhesive backing film (1) are visible. ◀

Place rear spoiler **A** on the edge (2) of the luggage compartment lid and average it out.

Then, gradually remove the adhesive backing film (1) in sequence from the middle outwards and firmly and **repeatedly** press rear spoiler **A** onto the luggage compartment lid.

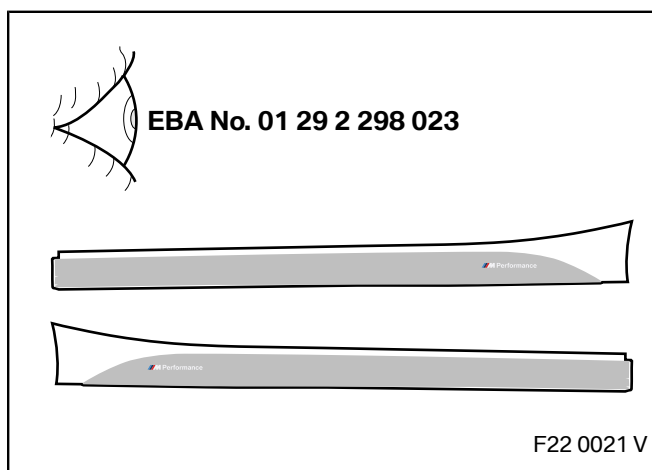


- ▢ Positions (1), (2) and (3) are provided for the tailgate's tension spring. ◀

Move the tail gate's tension spring to position (3).

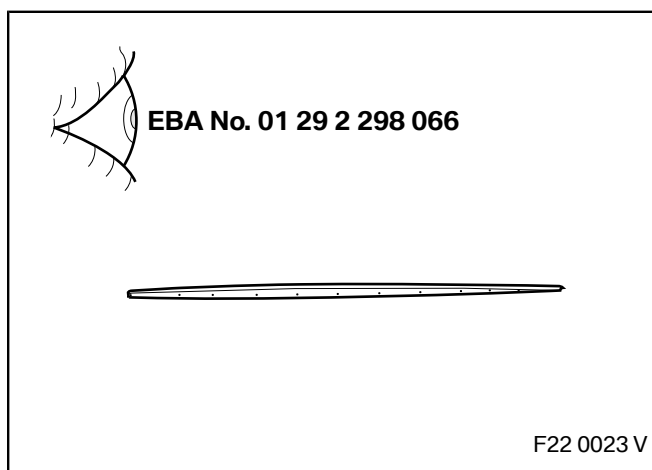
- ▢ After repositioning the tension springs, check that the tailgate is able to open properly and adjust the position of the tension springs accordingly if necessary. ◀

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. Fitting the side sill



Install the side sill in accordance with the installation instructions bearing part number **01 29 2 298 066**. ◀

12. 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

Information to be provided to the customer



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