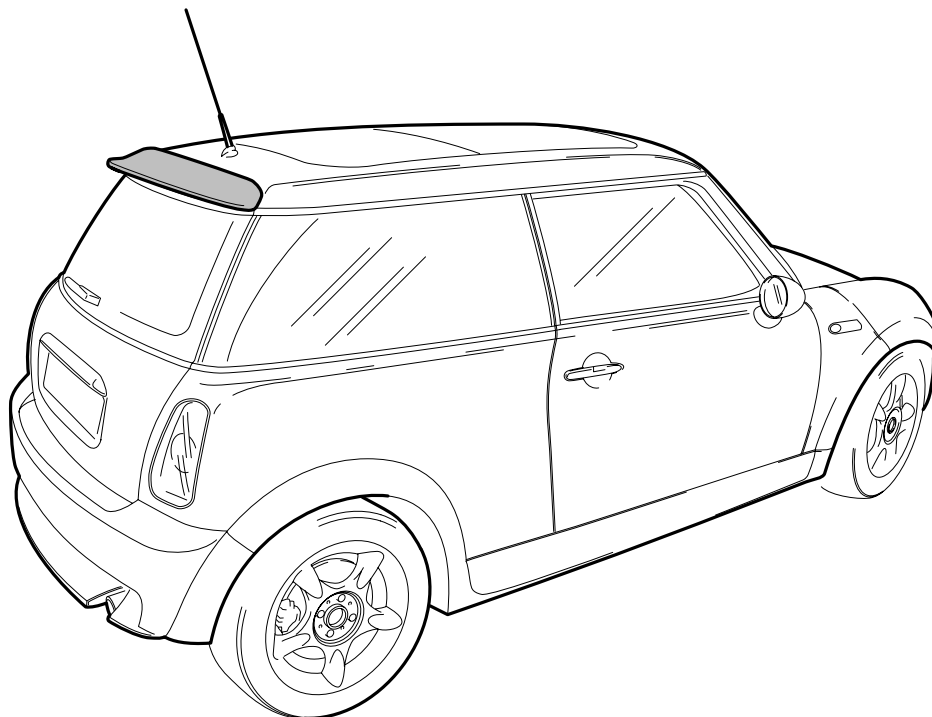




Parts and Accessories Installation Instructions



050 0115 B

Mini accessory rear spoiler Mini (R50/R53)

Specialist knowledge required.




The installation time is approx. 0.5 hours but this may vary depending on the condition of the car and the equipment in it.

Retrofit / Installation kit No. 51 71 0 140 633 / 51 71 0 021 542

Contents



Section	Page
1. Important information for the installation of the accessory rear spoiler.	3
2. Preparations only required for cars with a standard rear spoiler	5
3. Parts list	6
4. To install the accessory rear spoiler	7

1. Important information for the installation of the accessory rear spoiler

-  The manufacturer cannot accept any liability for damage caused by a failure to follow the work and instructions set out in these installation instructions. In addition all warranty claims against the manufacturer will be rendered void if you install and handle the product in a way other than as set out in the installation instructions. ◀
-  The accessory rear spoiler is to be checked for accuracy before it is fitted. The car must not be moved for 6 hours after the last gluing operation. The glued joints can be taken through a car wash after 48 hours. ◀
-  On cars with a standard rear spoiler it must be removed (no longer required). ◀

Subject to technical modifications

Installation information

-  The boot lid must have a temperature of at least 18°C for gluing the accessory rear spoiler. ◀
-  All the gluing surfaces on the boot lid and the accessory rear spoiler must be cleaned. ◀

Item numbers refer only to the overview drawings and to the texts next to the appropriate figure.

Painting instructions for repair work

Follow the BMW painting instructions for all painting work.

Procedure:

The rear spoiler is made of PUR.

BMW acrylic paint +10% softface additive, maximum temperature for stoving 80°C. Cover the complete contact area for the painting work so that the adhesion of the glue bond is not adversely affected.

Required tools and equipment

Paintbrush
Cleaning product
Cleaning cloths

1. Important information for the installation of the accessory rear spoiler

Equipment required for gluing

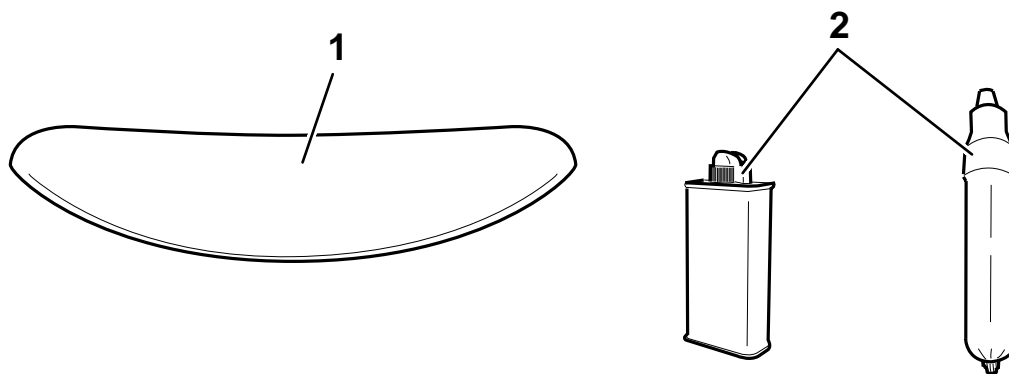
The Betalink adhesive must be ordered separately, see EPC (electronic parts catalogue).
BMW Part No. 82 69 9 408 866.

Cleaner (supplied with the Betalink adhesive)

2. Preparations only required for cars with a standard rear spoiler

Preparations	TIS instruction No.
Remove the standard spoiler and cover the holes with adhesive tape	---

3. Parts list



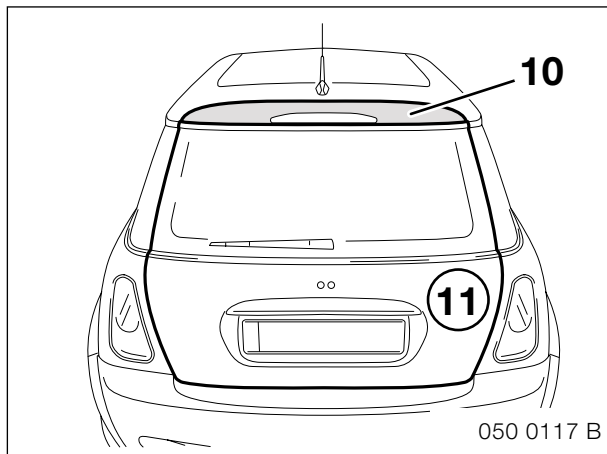
050 0116 B

Legend

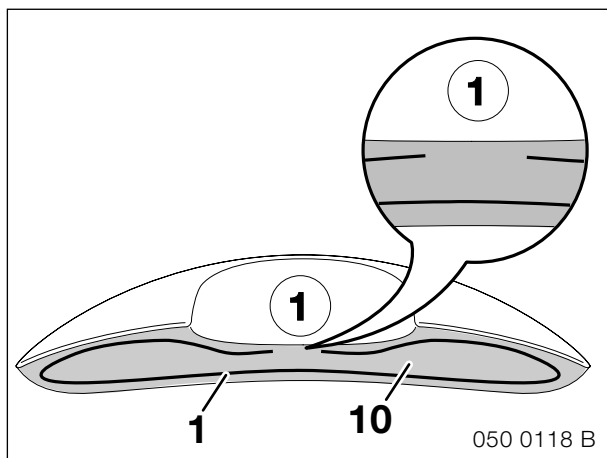
- 1 Accessory rear apron
- 2 Betalink adhesive pack* (cleaner and adhesive)

The Betalink adhesive pack must be ordered separately, see EPC (electronic parts catalogue) BMW Part No. 82 69 9 408 866

4. To install the accessory rear spoiler



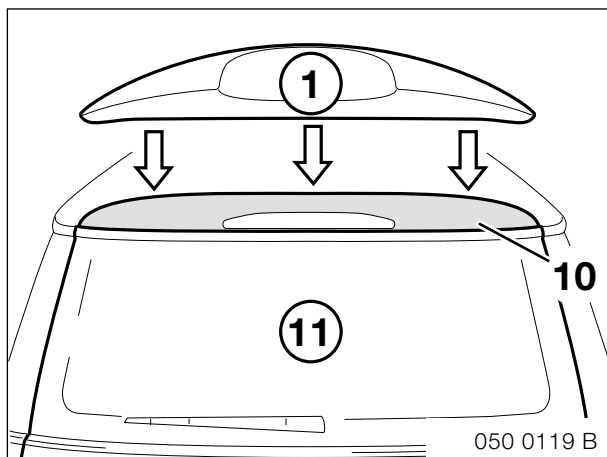
Clean the areas marked grey (10) on the boot lid (11) with benzene.



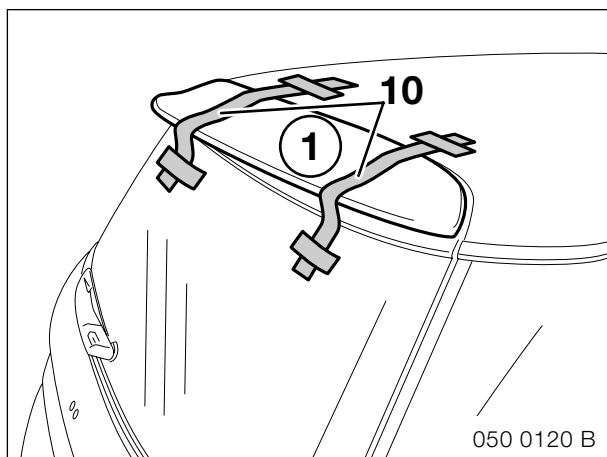
☐ The point to be glued (11) is milled into the accessory rear spoiler. ◀

Clean the areas marked grey (10) on the accessory rear spoiler (1) with benzene. Apply an even bead of Betalink adhesive to the milled groove (11) on the accessory rear spoiler (1).

☐ The bead of adhesive must have a break of **30 mm** as shown in the magnified section. (the adhesive surface does not have to be sealed air tight). ◀



Affix the accessory rear spoiler (1) to the prepared standard area (10) of the boot lid (11).



Secure adhesive tape (10) at uniform distances on the accessory rear spoiler as shown in the figure so that the edge of the accessory rear spoiler (1) is pressed against the surface of the boot lid.

☐ Secure the accessory rear spoiler (1) with adhesive tape (10) without prestressing it. ◀

☐ Leave the adhesive tape (10) in place for 6 hours. ◀

☐ Remove any surplus adhesive immediately. ◀