

John Cooper Works Tuning.

Installation manual.



Retrofitting roof spoiler

MINI ONE (R50)

MINI COOPER (R50)

MINI COOPER S (R53)

Retrofit kit No.: 51 71 0 392 168
51 71 0 406 291
51 71 0 406 292
51 71 0 406 293

Installation time

Installation work will take approx. 1.25 hours (including dismantling the standard spoiler); this time may vary depending on the condition and equipment specification of the car.

Important notes

This installation manual is intended in the first instance for use within the MINI dealer organisation and by authorised BMW Service outlets.

The target group for this installation manual is always skilled personnel who have been trained on MINI vehicles and possess the corresponding specialist knowledge.

All work is to be performed using up-to-date MINI repair manuals, circuit diagrams, maintenance manuals and procedural instructions in a rational sequence and with the specified tools (special tools), taking into account the relevant safety regulations.

If assembly or functioning problems occur...

you can avoid unnecessary outlay and costs by contacting one of the following after a brief attempt at troubleshooting (approx. 0.5 hour):

- 1. Either our national subsidiary or your regional office, or**
- 2. The Support facility via the Aftersales Assistance Portal (ASAP), with the aid of the optional application "Technical Parts Support".**

Quote the vehicle identification number as well as the part number of the of the retrofit kit used and a precise description of the problem.

Do not file the printout of this installation manual, as there are daily updates via ASAP!

See ASAP for explanations of the pictograms.

All illustrations show left-hand-drive vehicles; proceed in the corresponding manner when working on right-hand-drive vehicles.

Pictograms:



Indicates notes that draw your attention to hazards.



Indicates notes that draw your attention to special points.

◀ Indicates the end of the note or warning.





Subject to technical modifications!

Notes on assembly

Clean bonding surfaces with Betaclean 3350.

Pretreat bonding surfaces on the roof spoiler **A** and rear lid with Betaprime 5402.

Bond on roof spoiler **A** with Betalink K2.

-  When bonding, the ambient and curing temperature may not fall below 20°C. ◀
-  At an ambient temperature of at least 20°C, the vehicle will be ready for driving after approx. **6 hours** and able to withstand car washes, subject to certain restrictions, after **120 hours**. ◀
-  The roof spoiler **A** may only be bonded with the aid of the aforementioned original Betalink K2 components. Other adhesives, including those approved by BMW, do not achieve the necessary combined tension and shear resistance. ◀
-  **Betaprime 5402 becomes impossible to remove with a solvent after a very short time (approx. 2 minutes). It is therefore important to work as neatly as possible, masking off areas that are not to be treated.** ◀

Notes on ordering


The adhesive set is not included in the retrofit kit and must be ordered separately.

Adhesive gun: Betamix 3

BMW part number: 83 19 0 406 983

Adhesive set: Betalink K2

BMW part number: 83 19 0 406 974

-  Always check that Betaprime 5402 and Betalink K2 are within their expiry date. ◀

Notes on operation

The vehicle may no longer be put through gantry-type car washes (see customer information sheet).

No roof-mounted equipment (such as roof racks for carrying surfboards, skis, roof boxes, etc.) may be used in combination with the roof spoiler.

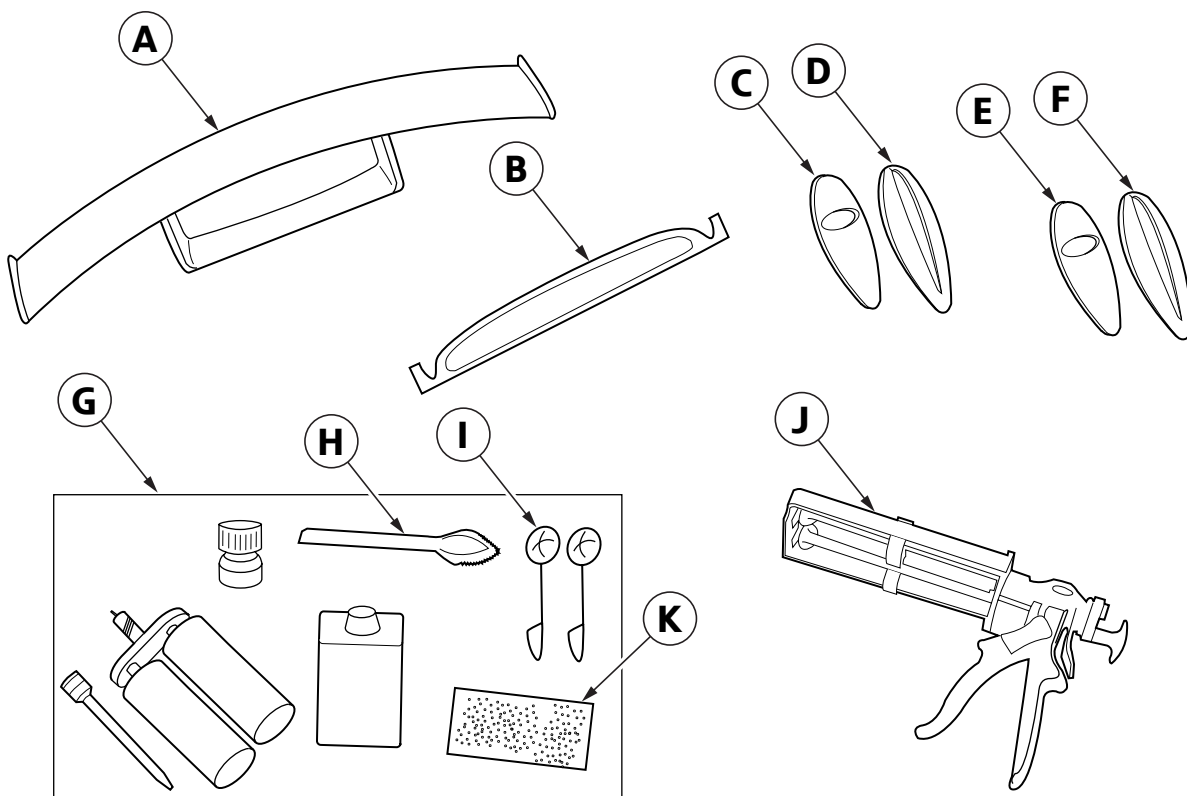
Special tools required

00 9 318, wedge

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1. Overview of parts



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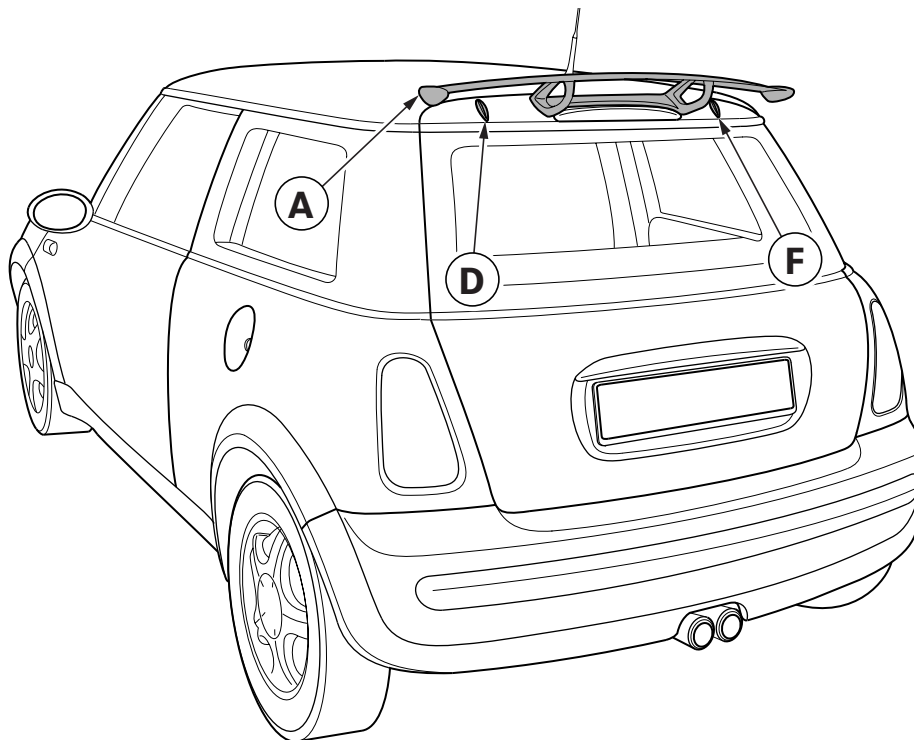
Legend

- A** Roof spoiler (1x)
- B** Bonding template (1x)
- C** Adhesive pad for left cover cap (only Cooper S) (1x)
- D** Left cover cap (only for Cooper S) (1x)
- E** Adhesive pad for right cover cap (only Cooper S) (1x)
- F** Right cover cap (only for Cooper S) (1x)
- G** Betalink K2 adhesive set (1x) (not included in delivery specification)
- H** Spatula (1x) (included in adhesive set)
- I** Swabs (2x) (included in adhesive set)
- J** Betamix 3 adhesive gun (1x) (not included in delivery specification)
- K** Sandpaper (1x) (included in adhesive set)

2. Preliminary work

	TIS No.
Dismantle the following components in advance	
Only for Cooper S	
Remove rear spoiler	51 71 407
Only for Cooper	
Remove rear spoiler	51 71 407

3. Installation diagram for roof spoiler

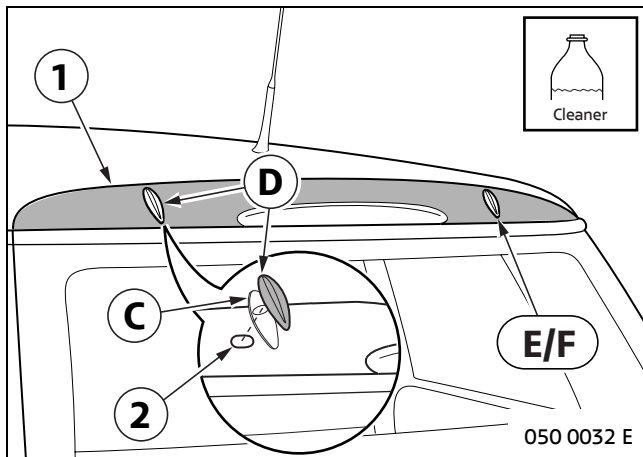


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Legend

- A** Roof spoiler
- D** Cover cap, left (only Cooper S)
- F** Cover cap, right (only Cooper S)

4. Fitting the roof spoiler



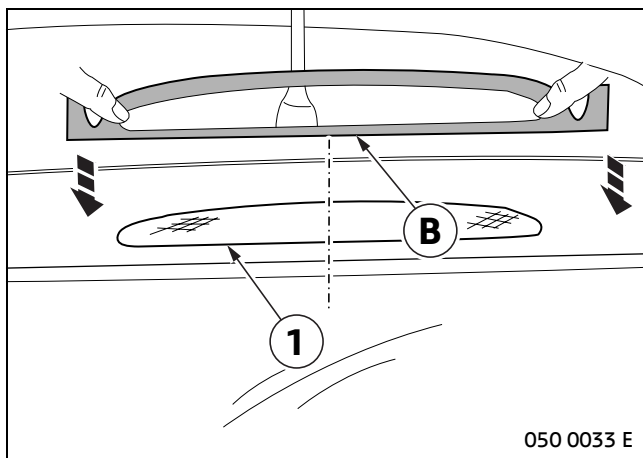
Remove original rear spoiler as described in **TIS**.
Clean bonding surface (1) with Betaclean 3350.

 **Only for Cooper S.**

Check alignment of cover caps **D/F** before bonding.


L= left
R= right

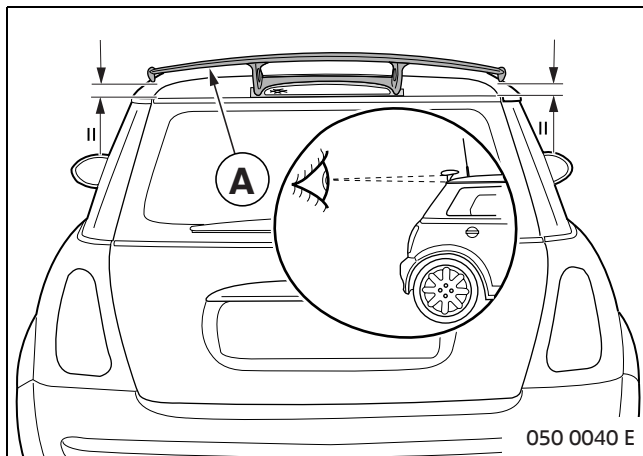
Affix adhesive pads **C/E** to cover caps **D/F** and stop up assembly holes (2). ◀




For all vehicles.

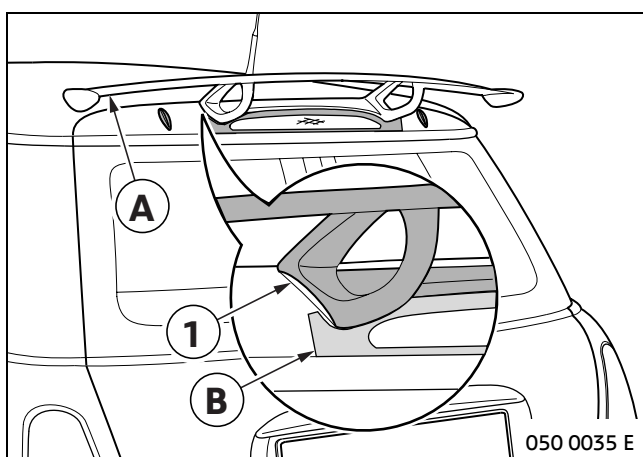
Remove protective film from bonding template **B**, hold with both thumbs and align with third brake light (1), then bond in place.

 The gap left between the template and the third brake light is required in order to comply with the operating permit. ◀



 The assistance of a second person is required when offering up and aligning the roof spoiler **A**.

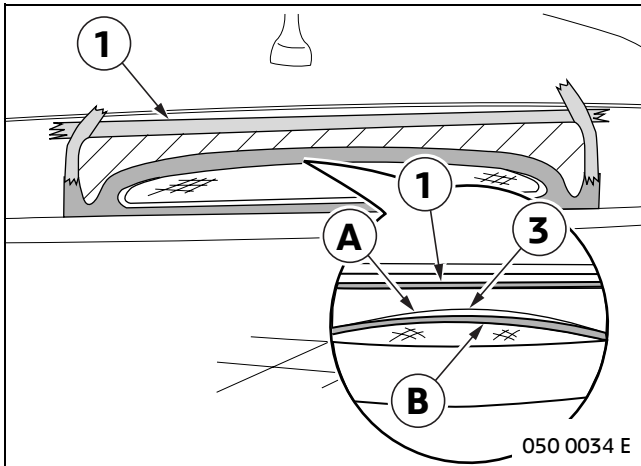
The second person should stand about 3 metres behind the vehicle and guide the fitter. ◀



Offer up roof spoiler **A** to bonding template **B** and align it exactly.

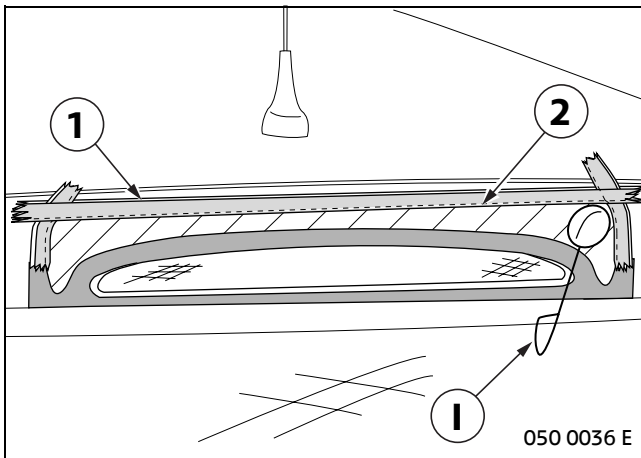
Any gap (1) remaining is filled by bonding with viscous Betalink K2.

4. Fitting the roof spoiler



Affix adhesive tape (1) precisely around the perfectly aligned roof spoiler.

The roof spoiler **A** must be resting fully on the bonding template **B**. If there is a gap (3), adjust the bonding template **B** until it is eliminated.

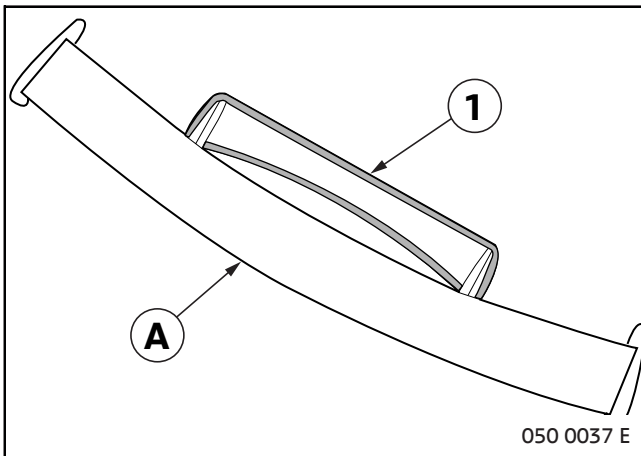


! Once Betaprime 5402 has dried, it can no longer be removed; it must therefore be kept off surfaces on which it is not required. ◀

Mask off the bonding area (2) again with adhesive tape (1), applying the tape one millimetre further in around the inner edge.

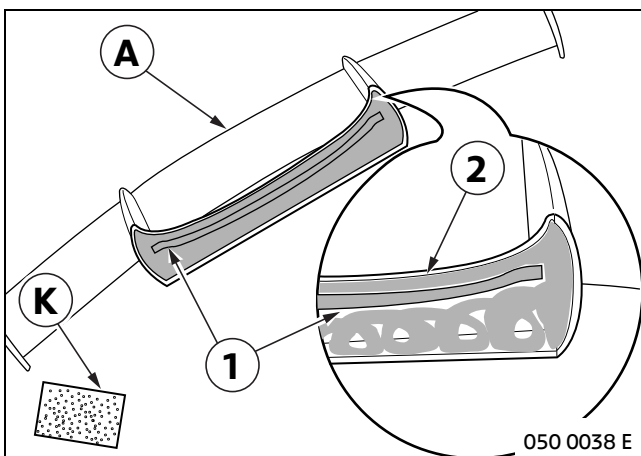
Carefully apply Betaprime 5402 to the bonding surface (1) with the swab **I**.

After about one minute, pull off the second layer of adhesive tape (1) and immediately remove any running 5402 primer with Betaclean 3350.



To prevent Betaprime 5402 and Betalink K2 adhesive from contaminating adjacent painted surfaces, the plinth of the roof spoiler **A** must likewise be masked off with adhesive tape (1).

◻ Notes on how to use the adhesive gun **J** are supplied together with the adhesive set. ◀



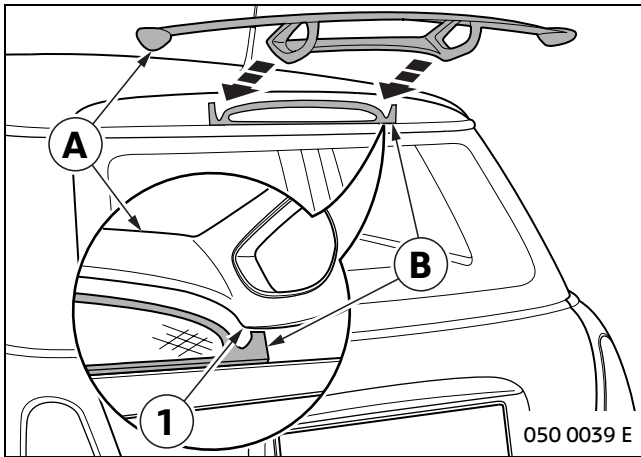
Preparing bonding surface of roof spoiler **A**:

1. Roughen with sandpaper **K**
2. Clean with Betaclean 3350
3. Apply Betaprime 5402 using the second swab, carefully removing any excess before applying.

To prevent moisture from penetrating subsequently, fill the bonding gap (1) and the entire contact area (2) of the roof spoiler **A** amply with Betalink K2.

◻ The adhesive must be applied within 3 minutes. ◀

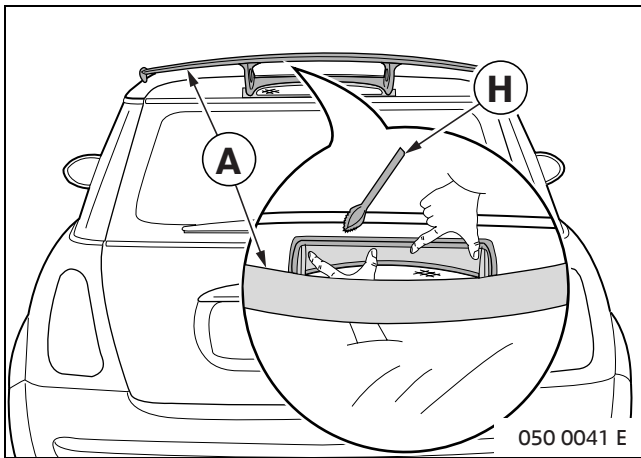
4. Fitting the roof spoiler



▶ It is essential to perform the next steps in the order specified. After this, it will no longer be possible to alter the position of the roof spoiler **A**. ◀

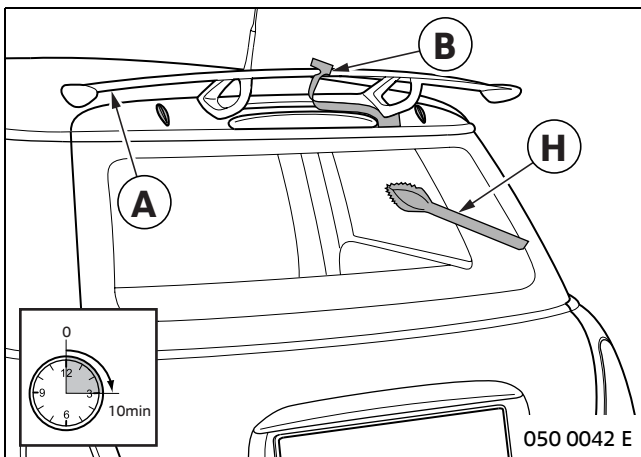
Offer up the roof spoiler **A** precisely with only its lower edge (1) resting against the bonding template **B**.

Align the roof spoiler **A** with the aid of the second person before pressing it onto the rear lid.



The entire contact surface of the roof spoiler **A** must be pressed onto the rear lid for about 2 minutes.

Scrape off any adhesive that has seeped out using spatula **H**.



During the setting phase, after approx. 5 minutes, carefully remove any further adhesive residue with the spatula **H**.

After allowing to cure for 7 minutes, remove first the bonding template **B** and then the adhesive tape.

5. Concluding tasks

Explain the risks of using gantry-type car washes to the customer and hand over the customer information sheet.

6. Customer information

- **To be handed to the customer and kept together with the Owner's Handbook for Vehicle.**

With the roof spoiler fitted, the vehicle can be put through car washes. Gantry-type car washes and car washes where the operator imposes restrictions are an exception.

Gantry-type car wash:

The vehicle is parked in this type of car wash.

The alternating direction of rotation of the washing brushes and the rearward movement of the gantry mean that the brushes could become caught in the spoiler, potentially damaging it.

Pull-through car wash:

The vehicle is drawn along through this type of car wash. The washing brushes are stationary and rotate in one direction only.

Notes on operation:

No roof-mounted equipment (such as roof racks for carrying surfboards, skis, roof boxes, etc.) may be used in combination with the roof spoiler.

General operating permit:

Retrofitting of the John Cooper Works roof spoiler does not invalidate your vehicle's operating permit!

The roof spoiler is covered by the European Operating Permit for your vehicle. It is not necessary to have the add-on part approved by a technical monitoring organisation or an entry made in the vehicle documents.

Signed

Bayerische Motorenwerke AG

Permit number: e1*74/483*87/354*0303*04 (External projections of motor vehicles,
Directive 74/483/EEC)

Correct as of November 2004