

# Original BMW Accessories. Installation Instructions.



## Retrofit - Aerodynamics package BMW X5 (E 70)

<b>Retrofit kit No.:</b>	51 19 0 413 823	Aerodynamics package, painted
	51 19 0 413 824	Aerodynamics package, primer-coated

### Installation time

The installation time is:

- approx. **0.5** hours for front panelling
- approx. **0.5** hours for rear panelling

The specified installation times may vary depending on the vehicle condition and equipment.

### 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, circuit diagrams, servicing manuals and work instructions, in a rational order, using the prescribed tools (special tools) and observing current health and safety regulations.

### **In the event of installation or functional problems, limit troubleshooting to 0.5 hours for mechanical jobs and 1.0 hours for electrical jobs.**

To avoid unnecessary work and costs, send a corresponding enquiry via the Aftersales Assistance Portal (ASAP) using the technical parts support application.


Please quote the following:

- Vehicle identification number
- Part number of retrofit kit
- Exact description of the problem
- Work already carried out

Do not archive the hard copy of these installation instructions since daily updates are made by ASAP!

All pictures show LHD cars; proceed accordingly on RHD cars.

## Pictograms

 Denotes instructions that draw your attention to special features.

◀ Denotes the end of the instruction or other text.

## Installation information

The installation instructions describe the procedure on the right-hand side of the vehicle only. The same procedure should be followed analogously on the left-hand side of the vehicle.

Clean adhesion surfaces with a suitable cleaning agent. They must be free of oil and grease.

The ambient temperature for adhesive bonding must not be below 15 °C or above 35 °C.

The vehicle can be driven through a car wash after **48** hours.

## Ordering information

The following parts are not included in the retrofit kit and must be ordered separately:

(see EPC for part number and instructions):

Betalink 1C adhesive package, part number 82 699 408 866

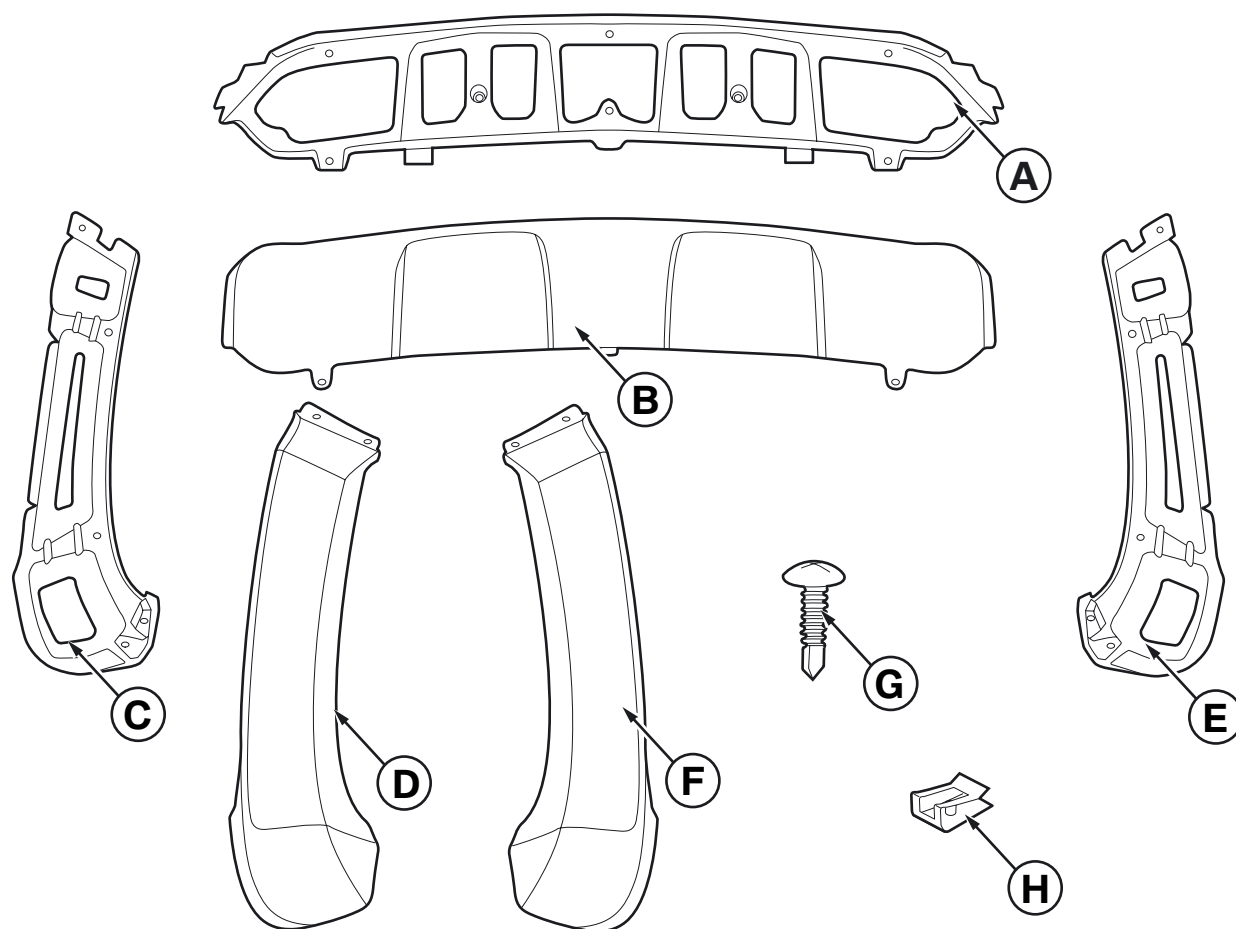
## Special tools required

None

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## 1. Parts overview - front aerodynamics package



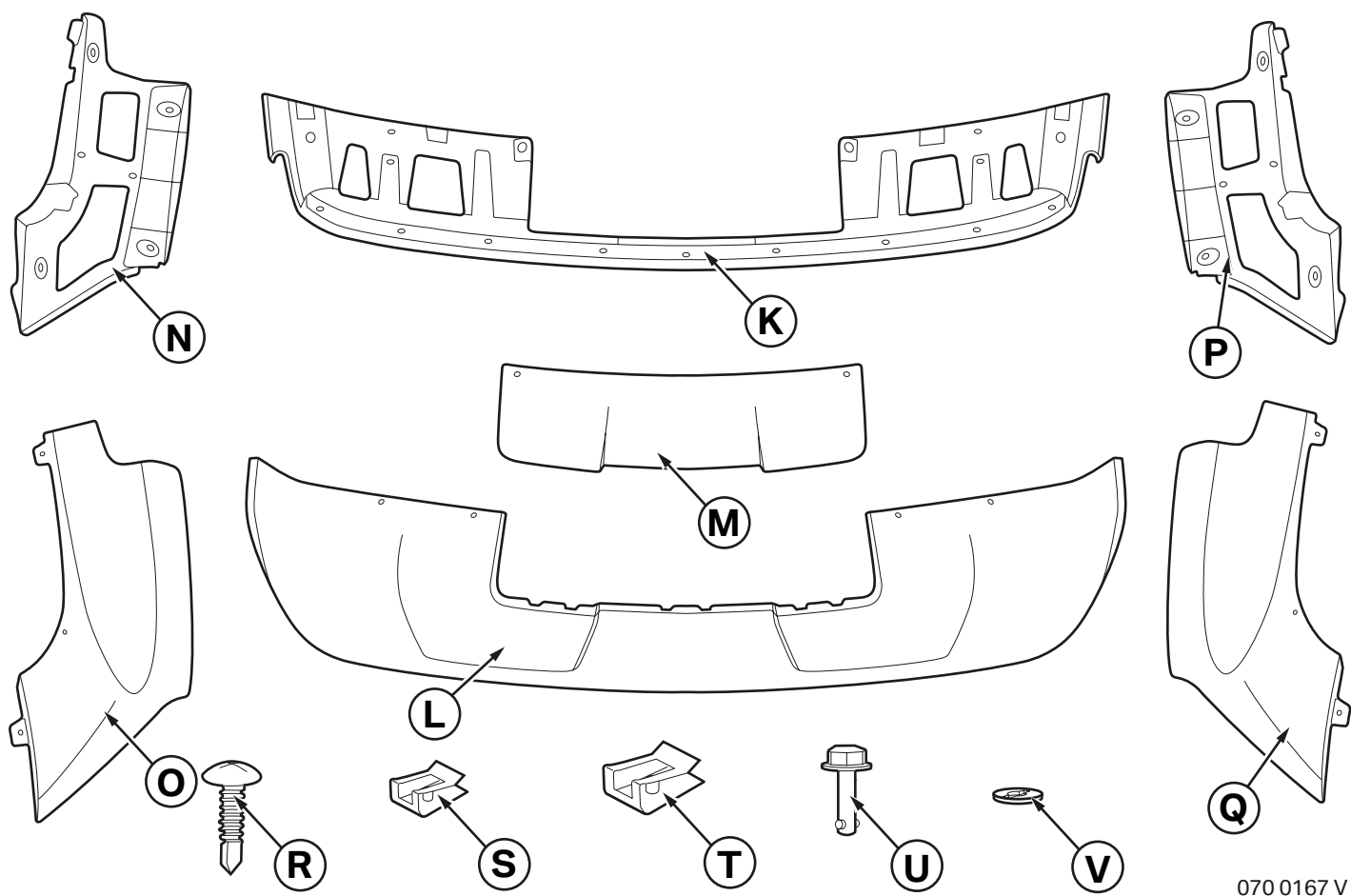
070 0166 V

### Legend

**A** Carrier, centre  
**B** Panel, centre  
**C** Carrier, left  
**D** Panel, left  
**E** Carrier, right

**F** Panel, right  
**G** Self-tapping screw (30x)  
**H** Speed nut (4x)  
**I** Speed nut (no longer required)  
**J** Hexagon head screw (no longer required)

## 2. Parts overview - rear aerodynamics package



070 0167 V

### Legend

**K** Carrier, centre

**L** Panel, centre

**M** Cover for towing hitch

**N** Carrier, left

**O** Panel, left

**P** Carrier, right

**Q** Panel, right

**R** Self-tapping screw (39x)

**S** Speed nut (10x)

**T** Speed nut (2x)

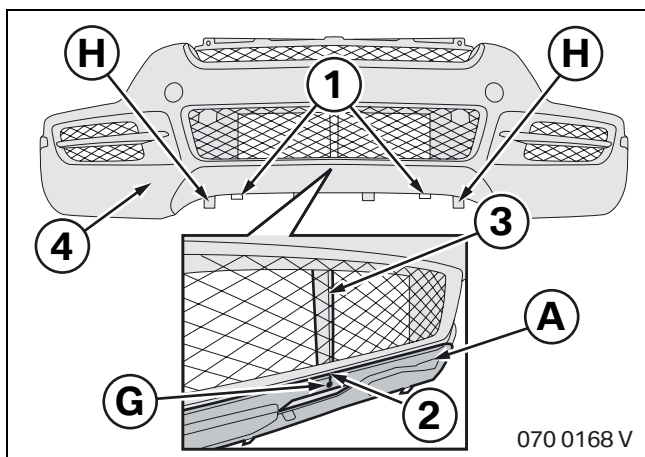
**U** Camloc (2x)

**V** Retaining ring (2x)

### 3. Preparatory work

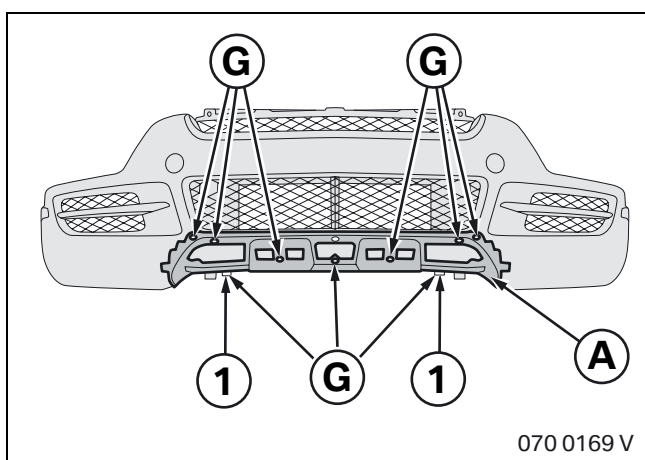
	TIS No.
Perform quick test	—
Disconnect negative terminal of battery	12 00 ...
<b>Remove the following components</b>	
None	—

## 4. Installing front aerodynamics package




The centre carrier **A** must be aligned with respect to front apron (4), for this purpose:

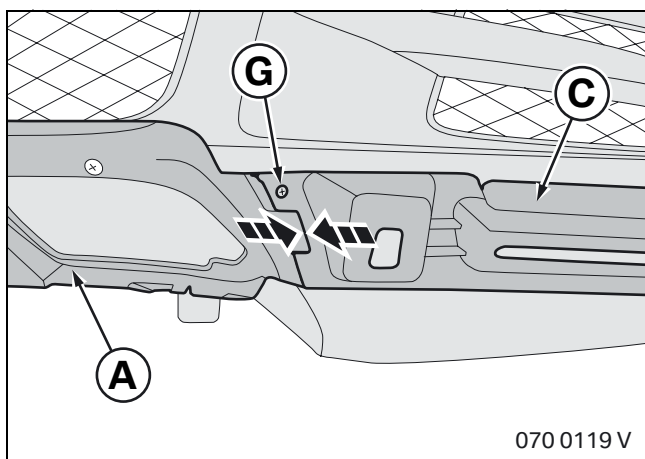
- Undo screws (1) on underguard.
- Align mark (2) on centre carrier **A** flush with web (3) on front apron (4)
- Secure centre carrier **A** hand-tight with self-tapping screw **G**
- Fit speed nuts **H**



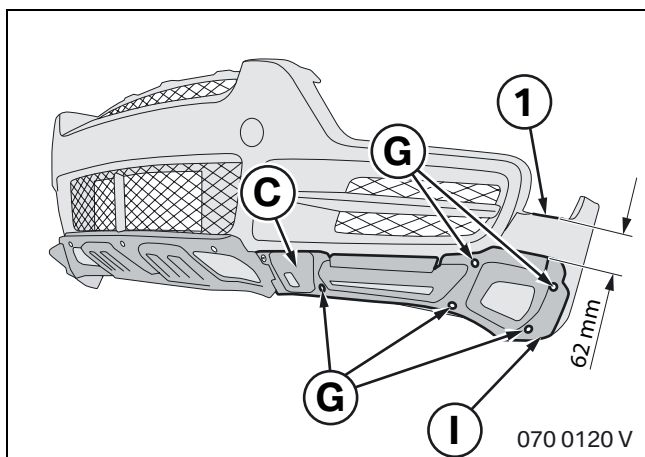
Align centre carrier **A** horizontally and secure with 9 self-tapping screws **G**.

The tabs (1) of centre carrier **A** are secured with 2 self-tapping screws **G** in the screw connection for the assembly guard.

 The powerdriver must only be used to initially fit the screws **G**. They must then be carefully tightened using a screwdriver. ◀



Fit left carrier **C** in position, aligned with the groove, against centre carrier **A** and loosely secure with self-tapping screw **G**.

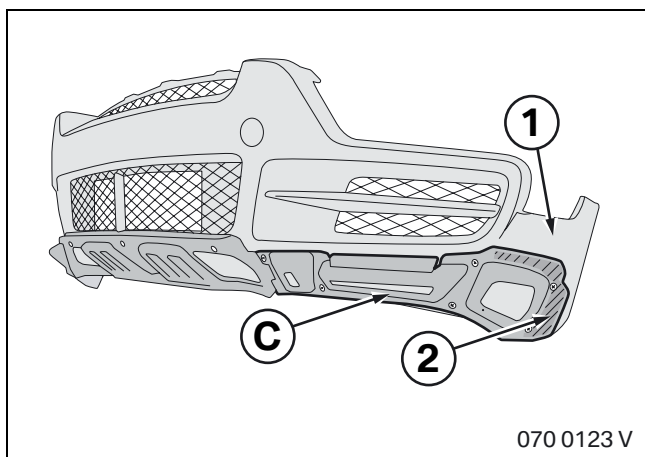


Adjust the distance of left carrier **C** from the mark to edge (1) to 62 mm.

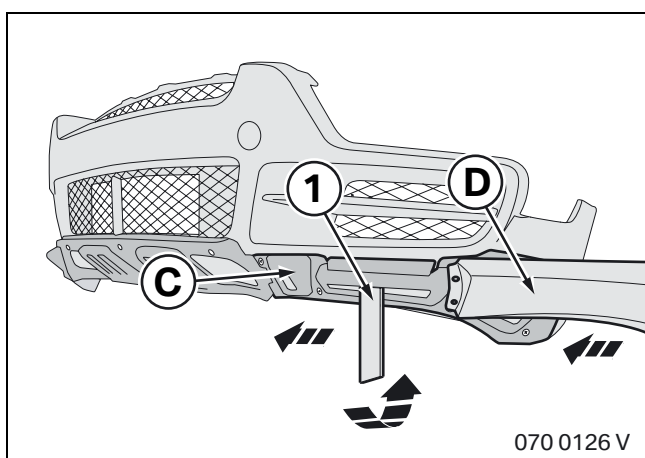
Use 5 self-tapping screws **G** to secure the right carrier **C**. Now firmly tighten all self-tapping screws **G** and fit speed nuts **I**.

Follow the same procedure to install the right carrier **E**.

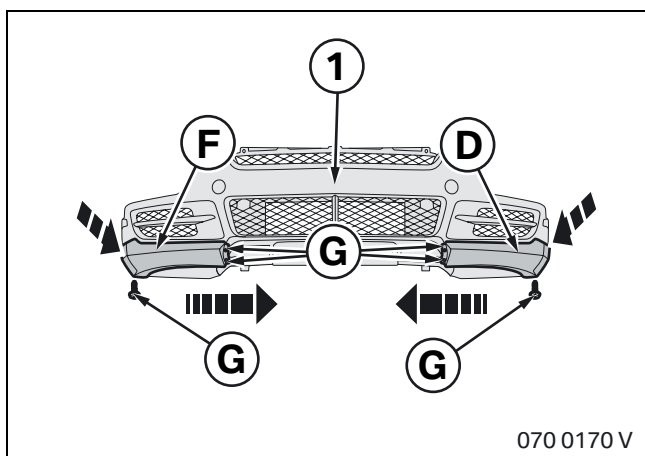
## 4. Installing front aerodynamics package



▶ If the gap between left carrier **C** and front apron (1) is too big, use a hot air blower to carefully form marked area (2) of left carrier **C**. ◀



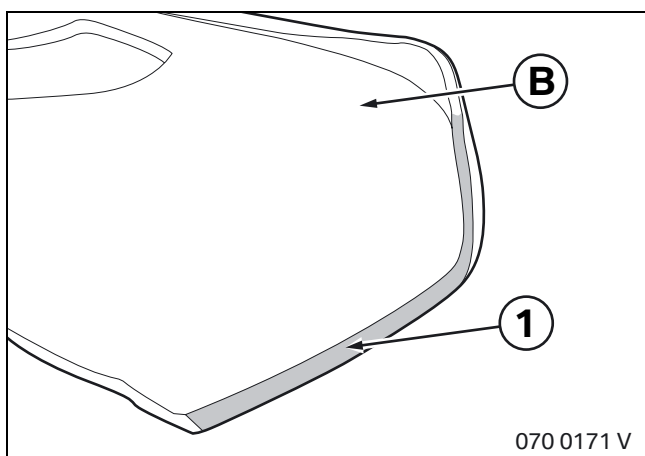
Use panel wedge (1) to carefully spread apart left carrier **C**. Working from the outside, now slide left panel **D** on to the carrier by moving the panel wedge (1) together with left panel **D** towards the centre of the vehicle and remove wedge.



Loosely secure left panel **D** and right panel **F** with self-tapping screws **G** from below.

Ensure the gap between the panels and front apron (1) is even by pressing the corners of left panel **D** and right panel **F** and by pressing towards the centre of the car.

Secure the panels in this position with self-tapping screws **G**.



▶ Observe the instructions from the Betalink adhesive package. ◀

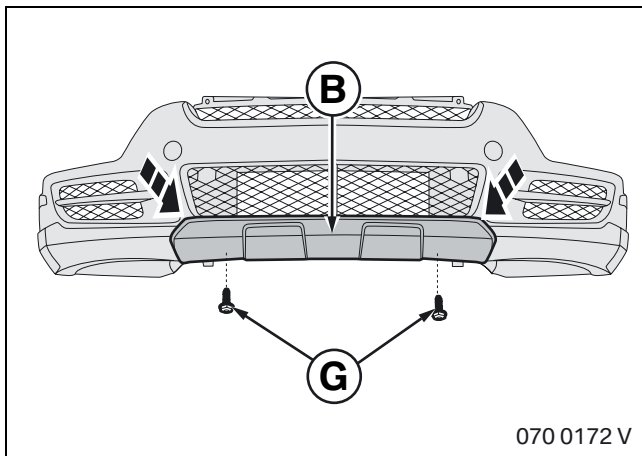
Thoroughly clean the contact surface (1) of centre panel **B** on both sides with Beta Clean.

Also thoroughly clean the corresponding contact surfaces on the vehicle with Beta Clean.

Apply Betalink adhesive to the contact surface (1).



## 4. Installing front aerodynamics package

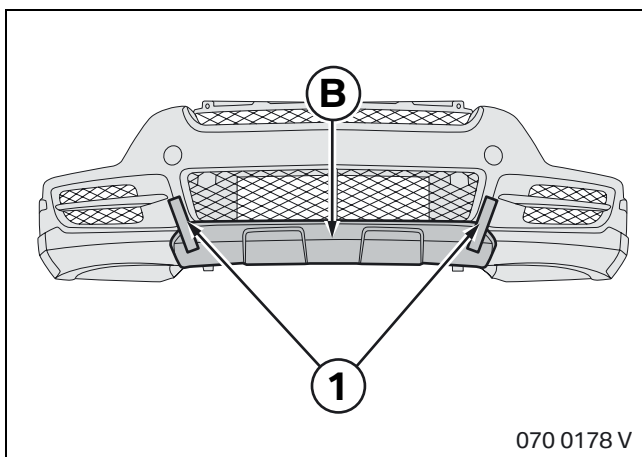


Fit centre panel **B** from above on to centre carrier **A** and loosely secure in this position with two self-tapping screws **G** from below.

Ensure the gap between the outer panels and centre panel is even by pressing the corners of centre panel **B**.

Firmly tighten the self-tapping screws **G** in this position.

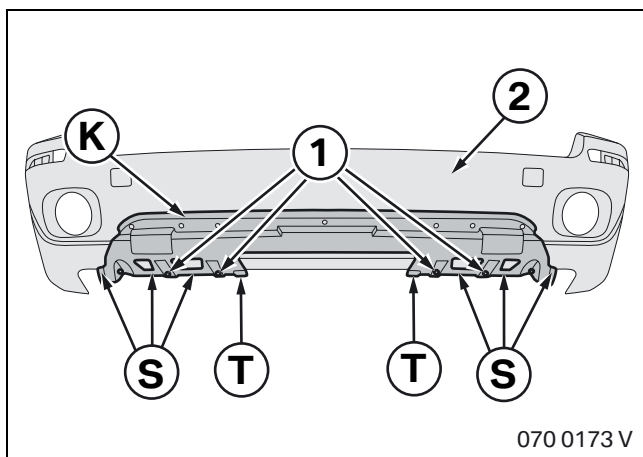
▶ Immediately remove any excess Betalink adhesive and clean surfaces with Beta Clean. ◀



Secure centre panel **B** with adhesive tape (1).

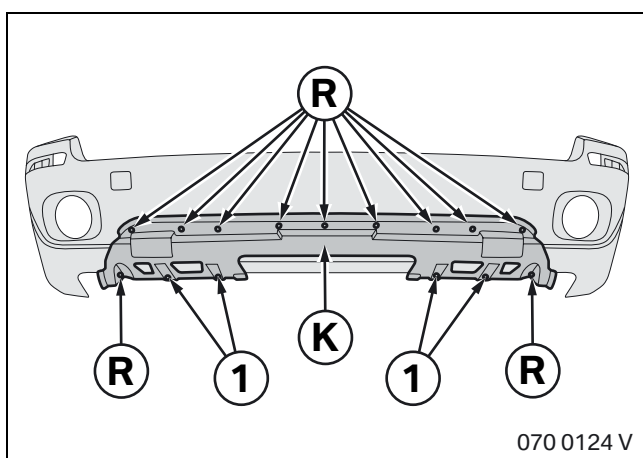
▶ The vehicle can be driven through a car wash after **48** hours. ◀

## 5. Installing rear aerodynamics package



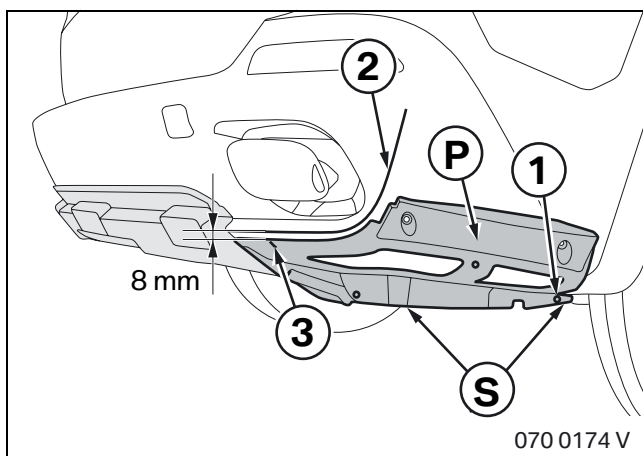
Undo screws (1).

Fit speed nuts **S** and speed nuts **T**, place centre carrier **K** on bumper panel (2) and centre.



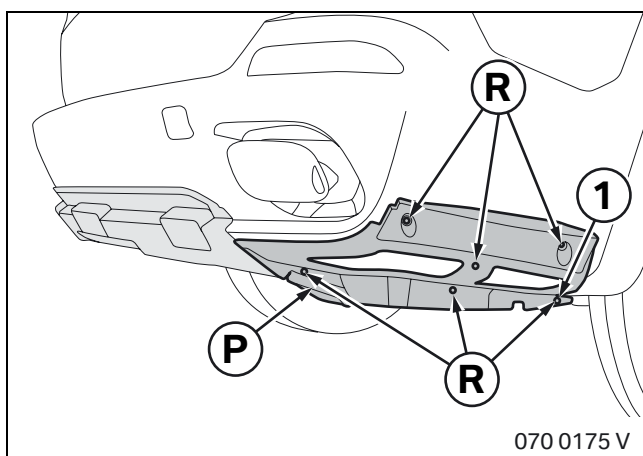
Secure centre carrier **K** with standard screws (1).

Now screw down centre carrier **K** with self-tapping screws **R**.



Undo screws (1) from bumper.

Place right carrier **P** in position, fit speed nuts **S** and position at a distance of 8 mm along mark (3) parallel to edge (2).

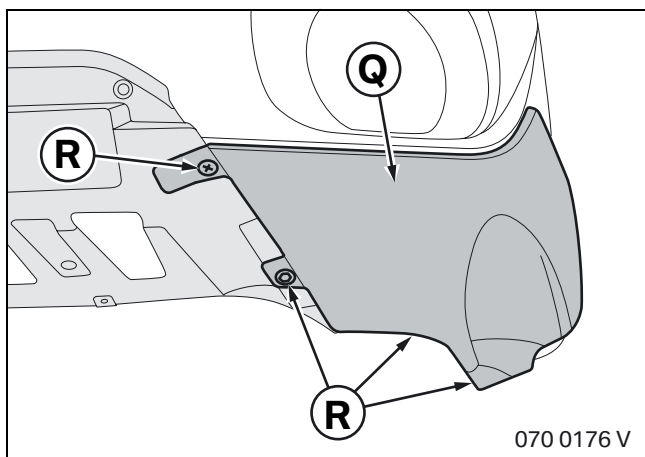


Fit self-tapping screw **R** in place of standard screw (1).

Make sure the entire surface of the component makes contact.


Screw down right carrier **P** with self-tapping screws **R**.

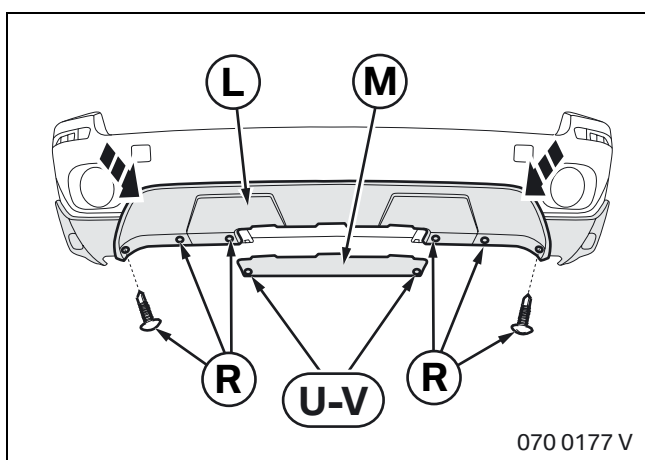
## 5. Installing rear aerodynamics package



Fit right panel **Q** from above onto right carrier **P** and secure with self-tapping screws **R**.

Follow the same procedure to install left carrier **M** and left panel **N**.

 Collision with the centre outer section may occur and gaps may form if the screws are not installed exactly. ◀



Fit centre panel **L** from above on to centre carrier **K** and position by lightly screwing down with self-tapping screws **R**.

Ensure the gap between the outer panels and centre panel is even by pressing the corners of centre panel **L**.

Fit the inner self-tapping screws **R** vertically in this position and tighten. Tighten the two outer screws in longitudinal direction until the side gap is closed.

Now tighten self-tapping screws **R** such that the component does not distort.

Slide cover **M** into centre panel **L** and secure with Camloc quick-release stud **U** and retaining ring **V**.

## **6. Concluding work and coding**

The retrofit system does not require encoding.

- Reconnect vehicle battery
- Perform quick test