Original BMW Parts and Accessories.
Installation Instructions.

M Performance Exterior Components Retrofit Kit.
BMW iX3 (NA5)

Retrofit kit number

Number	Component designation	Installation time (h)
51 11 5B72E52	Black high-gloss front attachment, centre right	0.25
51 11 5B72E51	Black high-gloss front attachment, centre left	0.25
51 13 5B72DC8	Right front attachment	0.5
51 13 5B72DC7	Left front attachment	0.5
51 62 5B73935	Black high-gloss roof edge spoiler	0.67
51 12 5B70207	Black high-gloss diffuser	0.5

Installation time
Installation time, see table. This may vary depending on the condition of the vehicle, the equipment in it and the type of retrofit.

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 (must not be invoiced under the warranty).

Important information
These installation instructions are primarily designed for use within the BMW dealership organisation and by authorised BMW service companies.

When installing the front attachment, a specific parameter set (customer service word) must be uploaded/flashed to the control unit. The parameter set of the NA05-25-07-540 release can be used as this parameter set.

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 logical order, using the prescribed tools (special tools), and observing current health and safety regulations.

If you experience installation or functional 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 to the technical parts support team.

Quote the following information:

- VIN,
- retrofit kit part number,
- a detailed description of the problem,
- any work already carried out.

Do not archive the printout of these installation instructions. The current version can be found in the EPC.

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

- All contact/bonding surfaces on the components being installed must be absolutely dry, clean, and free of wax, silicone and grease. These surfaces must be treated with a suitable BMW cleaner or BMW primer (see EPC for details), using the appropriate product application instructions.
- If you use adhesive tape, it must be applied using a contact pressure of between 10 N/cm² and 50 N/cm². (A forceful press of your thumb will reach around 35 N/cm².) It is not how long you apply this pressure, but the force with which it is applied that counts. Press the component into place over the entire bonding area. Removing the adhesive tape after pressing the component into place will destroy the bond.
- Take care not to damage the parts when opening the packaging.
- Check that all the parts fit accurately on the car before installing them.
- All the components and their bonding surfaces must be at room temperature for installation. The ideal relative humidity is 50%. Different values will change the specified times.
- After completing the bonding and installation work, the car must remain stationary at room temperature for at least 12 hours.
- If adhesives are used, the car may be driven after 24 hours, and may be taken through a car wash after 48 hours. The car may only be driven at a speed of v_{max} < 100 km/h for a period of 24 to 48 hours.
- The installed parts may become loose and fly off the car if you fail to wait for the primer/adhesive to dry fully. Danger of accidents!
- 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 illustrations show LHD cars; proceed in the same way on RHD cars.
- To prevent damage to the component surfaces during transport and installation, protective films have been applied to the surfaces of the front attachment parts. Only remove these protective films after the installation if possible.

Ordering instructions

Primer must be ordered separately.

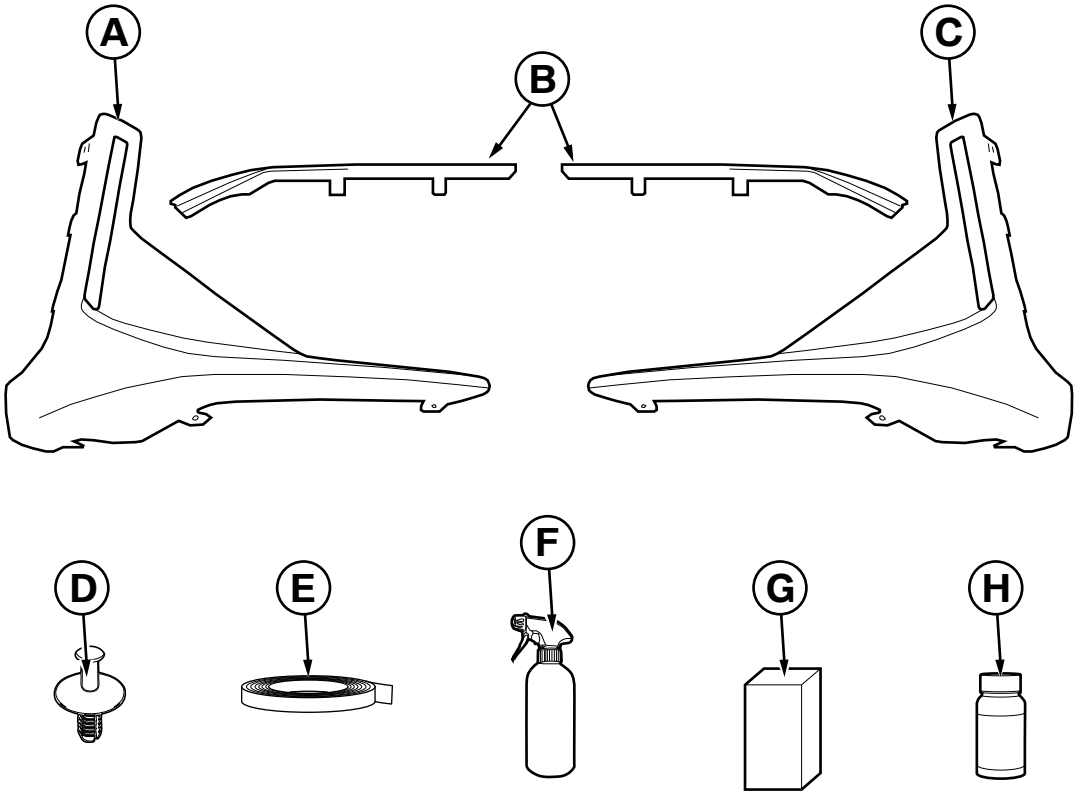
Special tools required

- None

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1. Front attachment parts list



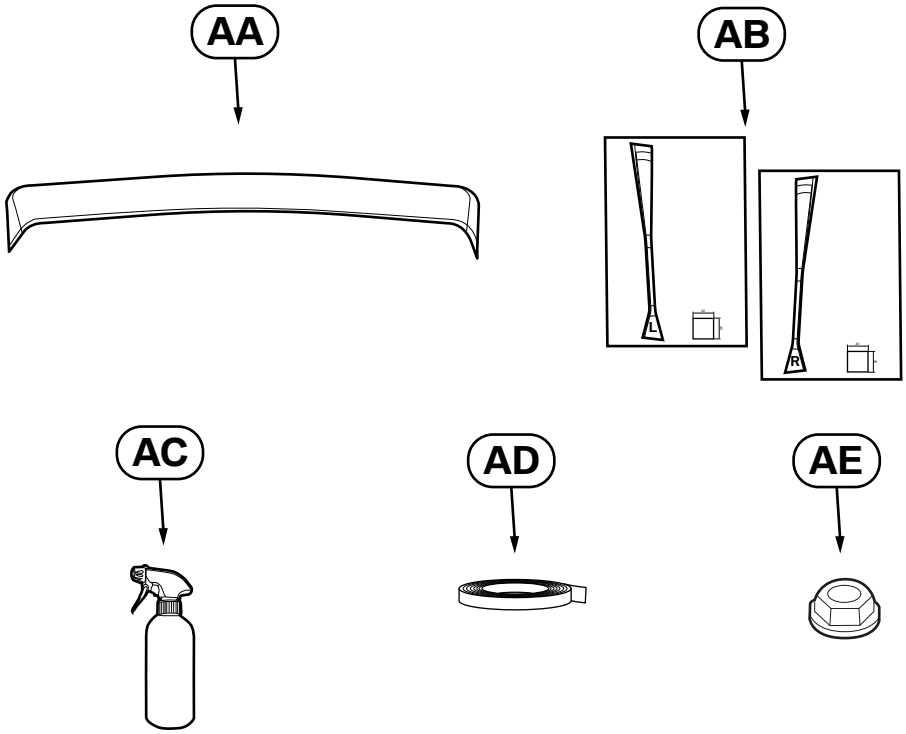
NA5 0001 E

Legend

A Right front attachment
B Centre front attachment
C Left front attachment
D Expanding rivet (4 x, part no. 8174185, not included in parts kit, see EPC for details)
E Roll of adhesive tape (use suitable material)
F Cleaner (not included in parts kit, see EPC for details and part number)
G Liquid adhesive (not included in parts kit, see EPC for details and part number)
H Primer (not included in parts kit, see EPC for details and part number)

When installing the front attachment, a specific parameter set (customer service word) must be uploaded/flashed to the control unit. The parameter set of the NA05-25-07-540 release can be used as this parameter set. ◀

2. Parts list for rear spoiler



NA5 0031 E

Legend

AA Roof edge spoiler

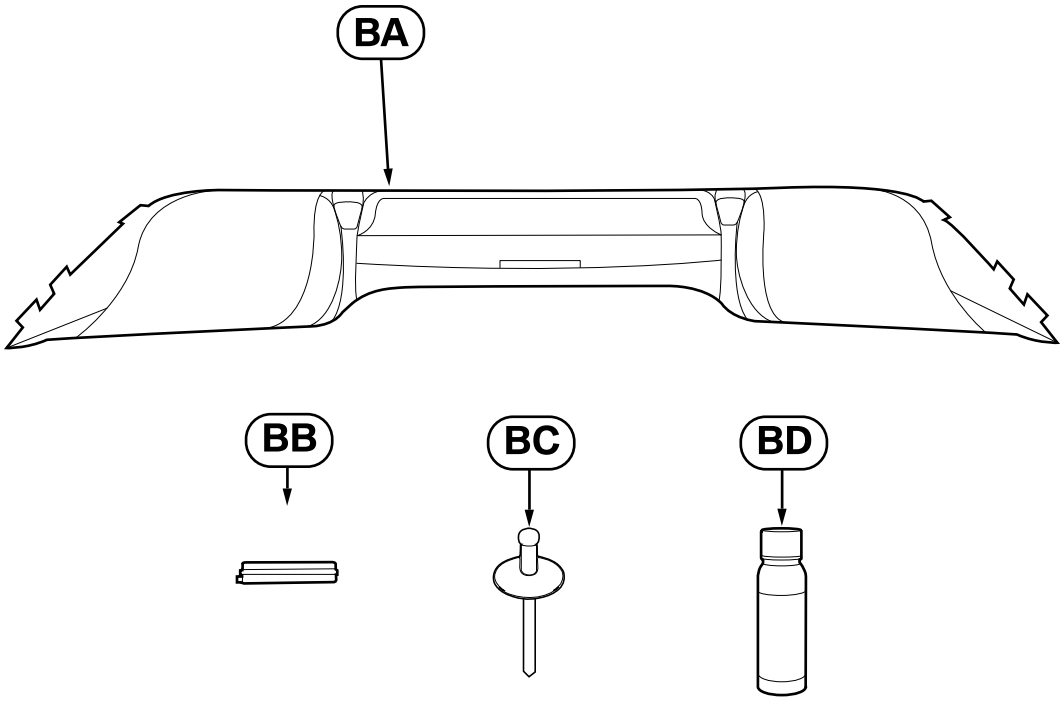
AB Roof edge spoiler template
(in the appendix of these installation instructions, **print without scaling**)

AC Cleaner (see EPC for details and part number)

AD Double-sided gluing cut-out sheet (4 x)

AE M5 nut (4 x)

3. Diffuser parts list



NA5 0019 E

Legend

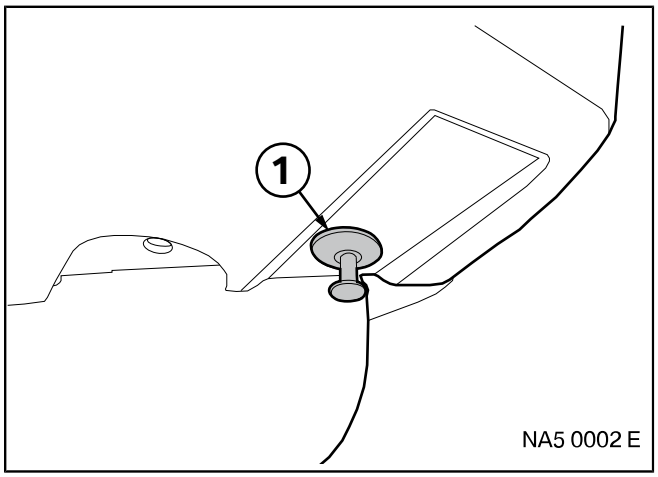
BA Black high-gloss diffuser
BB Centre light (not included in parts kit, see EPC for details and part number)
BC Blind rivet (not included in parts kit, see EPC for details and part number)
BD Cleaner (not included in parts kit, see EPC for details and part number)

The original diffuser and the Park Distance Control (PDC) sensors built into it are painted in the vehicle colour, depending on the configuration. The Park Distance Control (PDC) sensors must be ordered in black colour if necessary. ◀

4. Preparations

	ISTA/AIR No.
The following components must be removed first of all	
For installing the front attachment only – Aircurtain trim	REP-TAT-P-5111-01
For installing the roof edge spoiler only – Tailgate trim	---
For installing the rear diffuser only – Bumper panel	---

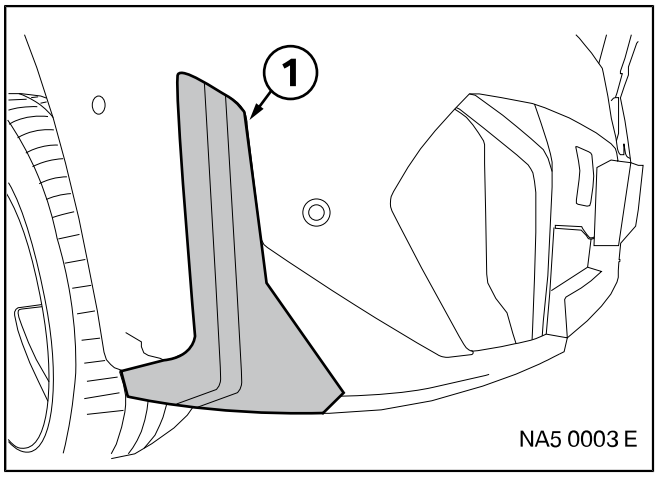
5. Installing the front attachment



For greater clarity, only the right side is shown. Proceed in the same way on the left. ◀

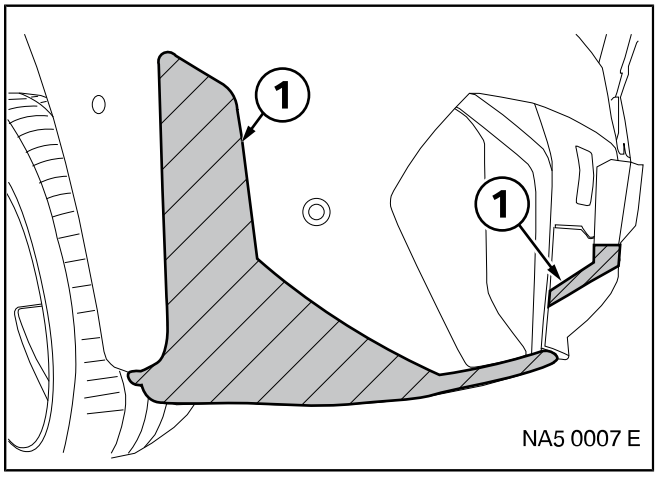
The bonding surfaces must be completely dry, clean, and free of wax or grease. ◀

Unclip the Aircurtain trim on both sides. Remove the expanding rivets (1) on both sides and place them ready for the installation of the new front attachment.

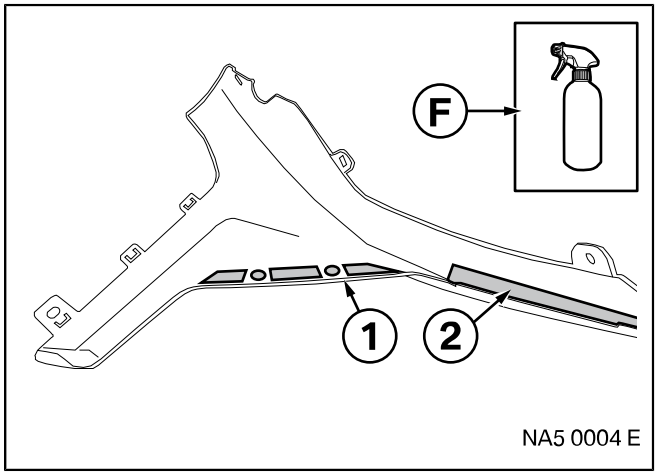


Remove the Aircurtain trim (1).

Dismantle the Aircurtain trims in accordance with ISTA/AIR (Removing front bumper panel_REP-TAT-P-5111-01).



Clean the installation position (1) on the vehicle with solvent cleaner **F**.

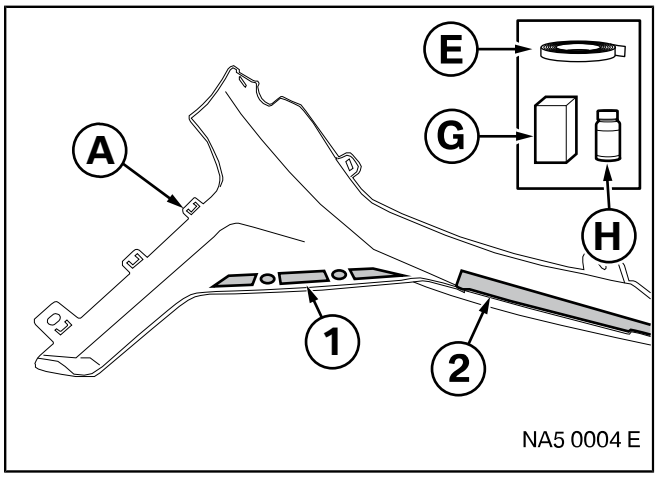


Clean the new front attachments **A** and **C** with solvent cleaner **F**.

The bonding surfaces (1) and (2) are processed further in different ways. ◀

Sand the right bonding surface (2).

5. Installing the front attachment



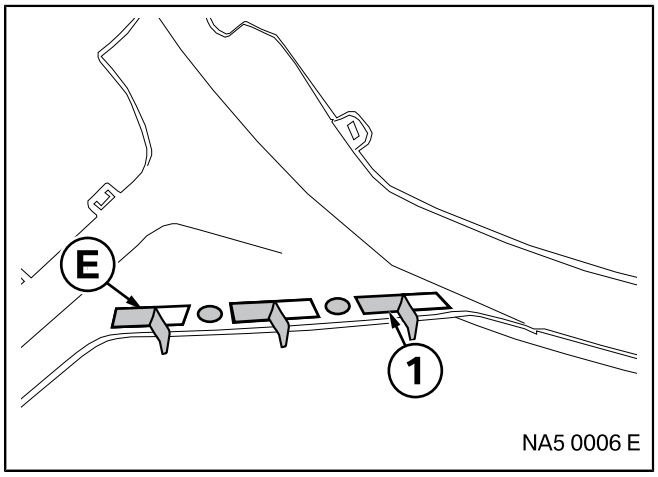
Sand the bonding surface (1) between the strips of adhesive tape.

Prime the bonding surface (1) **H** and allow to dry.

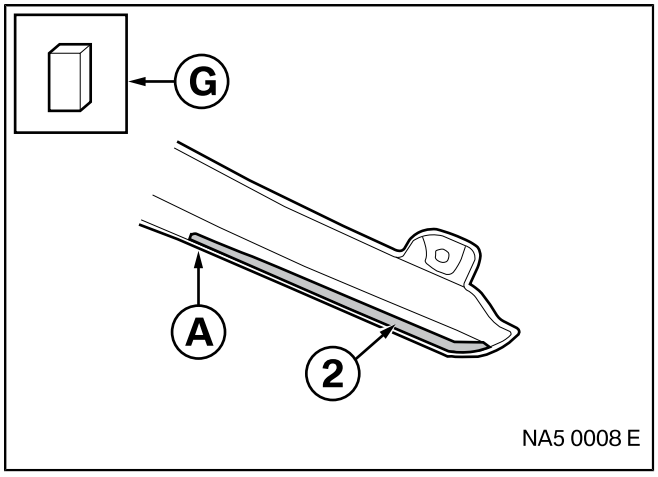
Attach double-sided adhesive tape **E** to the bonding surface (1) as shown.

Apply liquid adhesive **G** between the strips of adhesive tape and to the bonding surface (2).

Press the adhesive tapes into position using a contact pressure of between 10 N/cm² and 50 N/cm². (A forceful press of your thumb will reach around 35 N/cm².) It is not how long you apply this pressure, but the force with which it is applied that counts. Press the component into place over the entire bonding area. Removing the adhesive tape after pressing the component into place will destroy the bond. ◀

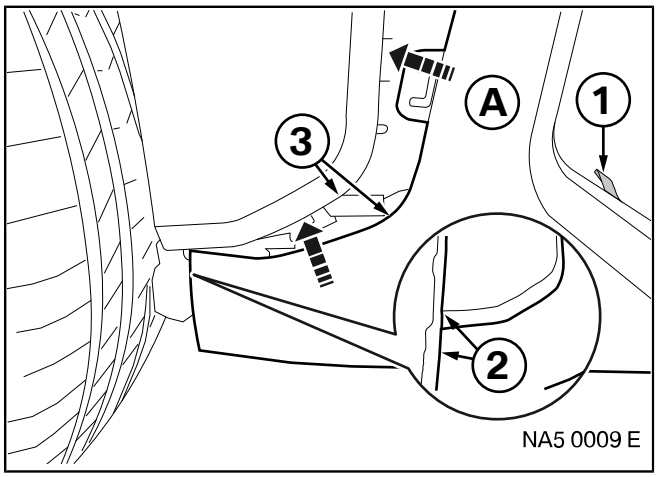


Bend over the ends of the protective film (1) of the adhesive tape **E**.



Apply liquid adhesive **G** as far as the tips of the bonding surfaces (2) of the lateral front attachments **A** and **C**.

5. Installing the front attachment

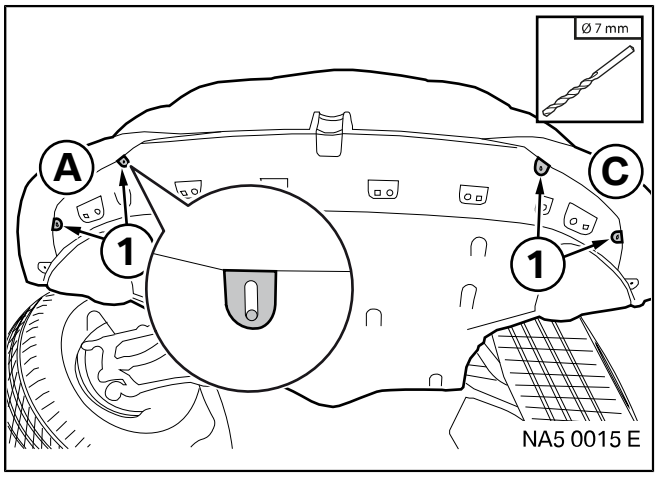


The protective films (1) of the adhesive tapes must remain visible. ◀

Push the lateral front attachments **A** and **C** at the bottom into the guide.

Ensure that the edge (2) is flush with the component edge.

Ensure that the edge (3) is flush with the component edge.



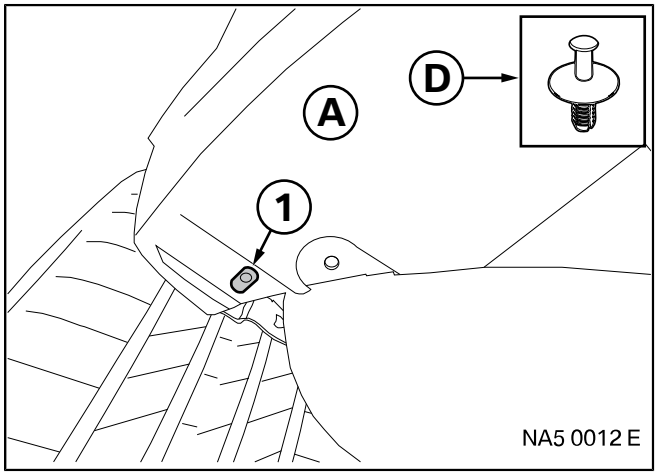
Note the drilling depth and the package space behind. ◀

Make sure that the drilled holes are drilled in the front apron on the rear end of the elongated holes of the front attachment **A** in order to guarantee active pedestrian protection. ◀

Drill four pilot holes (1) of the lateral front attachments **A** and **C** with **Ø = 3.0 mm** into the front apron, then counterbore to **Ø = 7 mm** and deburr them.

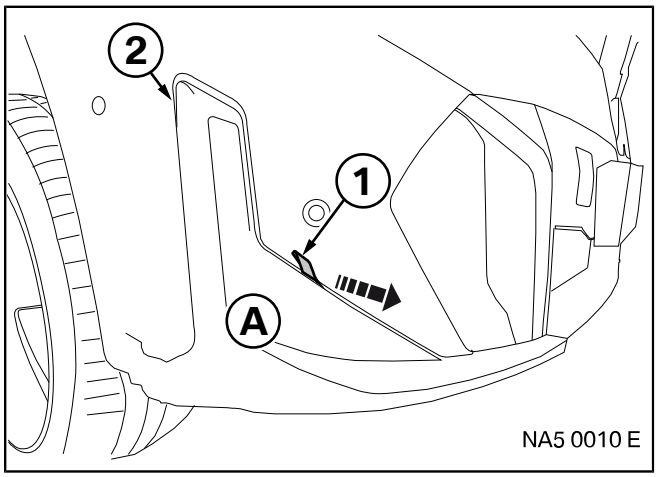
Press the four expanding rivets **D** into the lateral front attachments **A** and **C**.

Refer to the installation instructions on **page 2**. ◀



Secure the lateral front attachment **A** from below (1) with expanding rivets **D**.

5. Installing the front attachment

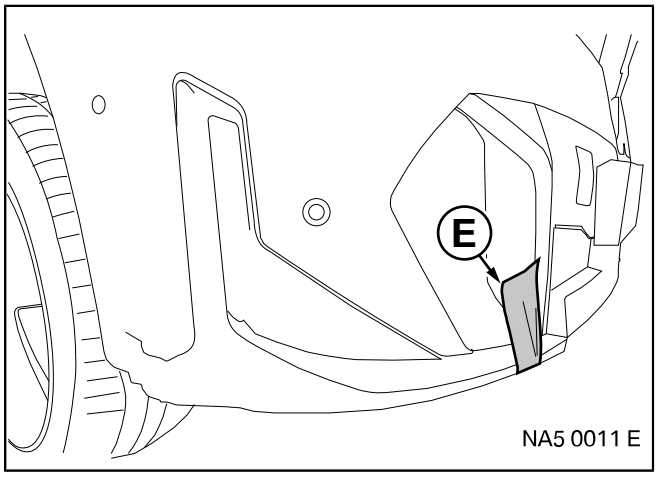


The backing films (1) of the adhesive tapes must be visible. ◀

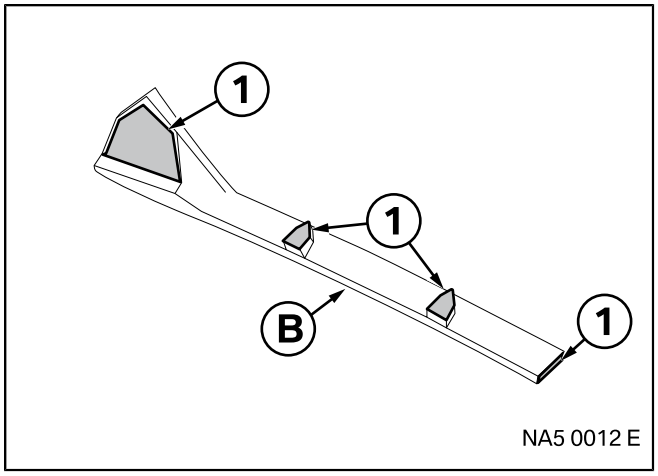
Push in the lateral front attachments **A** and **C** at the top (2) and clip them in.

Pull the protective film (1) off the adhesive tape and press it firmly onto the lateral front attachments **A** and **C**.

Press the adhesive tapes into position using a contact pressure of between 10 N/cm² and 50 N/cm². (A forceful press of your thumb will reach around 35 N/cm².) It is not how long you apply this pressure, but the force with which it is applied that counts. Press the component into place over the entire bonding area. Removing the adhesive tape after pressing the component into place will destroy the bond. ◀

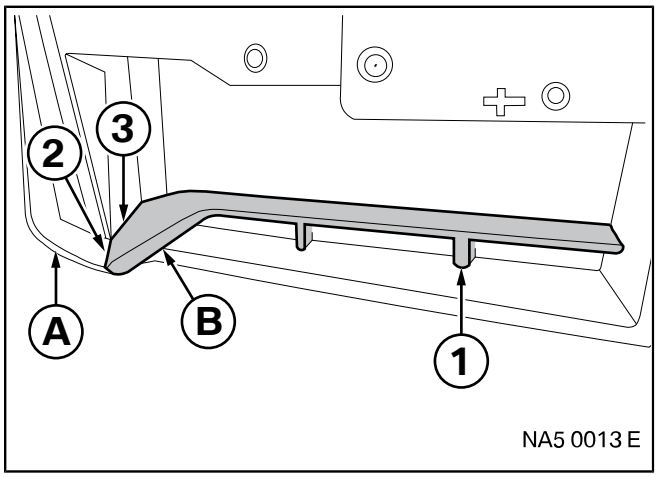


Secure the inserted front attachments with adhesive tape **E** until the liquid adhesive has hardened.



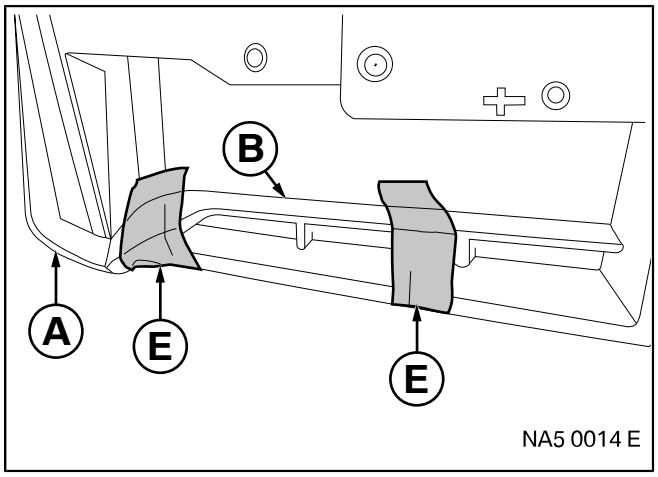
Sand the bonding surfaces (1) on the centre front attachments **B**, prime **H** and then apply the liquid adhesive **G**.

5. Installing the front attachment

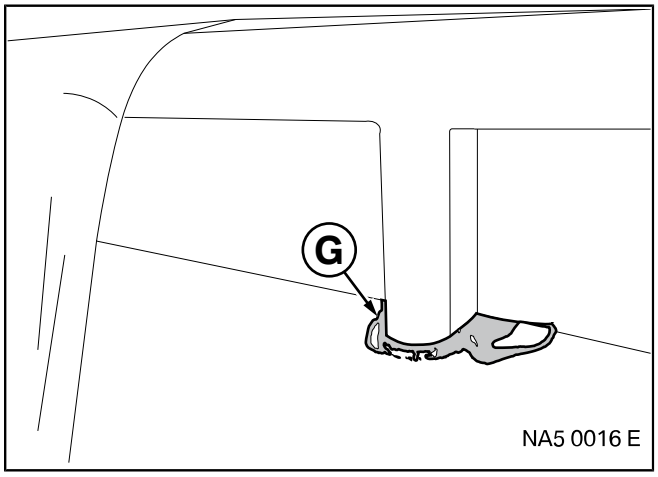


Attach the centre front attachments **B** and press on with the edge flush with the bumper (1).

Ensure exact alignment with the bumper edge and that the side sections are at the same height, so that there is no offset between lateral front attachments **A** and **C** and centre front attachment **B**. Adjust the gap dimension on the edge (2) and (3) for this purpose. ◀

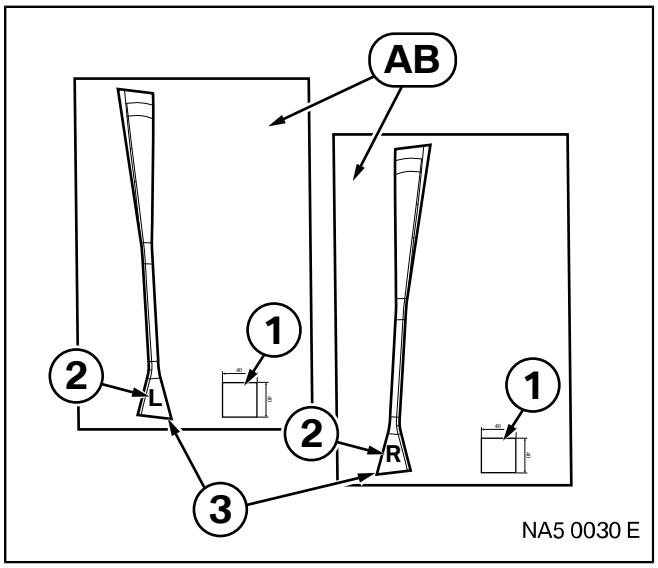


Secure the inserted front attachments **A** and **B** with adhesive tape **E** until the liquid adhesive has hardened. Make sure that the component **A** and **B** are flush with one another.



Remove surplus liquid adhesive **G**.

6. Installing the roof edge spoiler

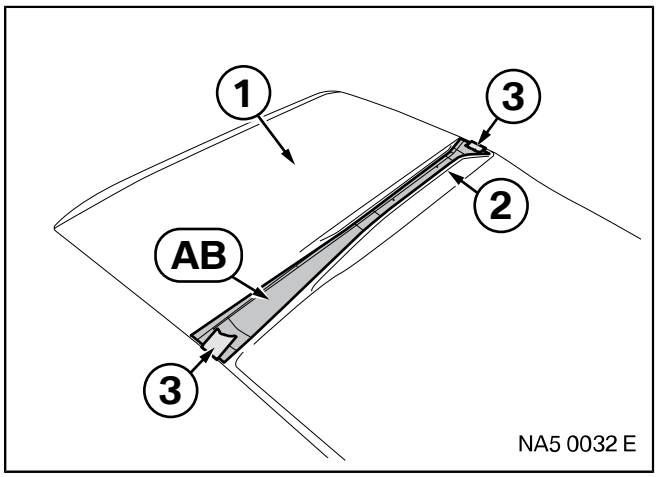


Print out the rear spoiler template **AB** **without scaling** from these installation instructions.

Check the scale (1) of the printout.

The templates are labelled (2). There is one template for the left side of the vehicle (L) and one template for the right side of the vehicle (R).

Cut out both templates (3). ◀

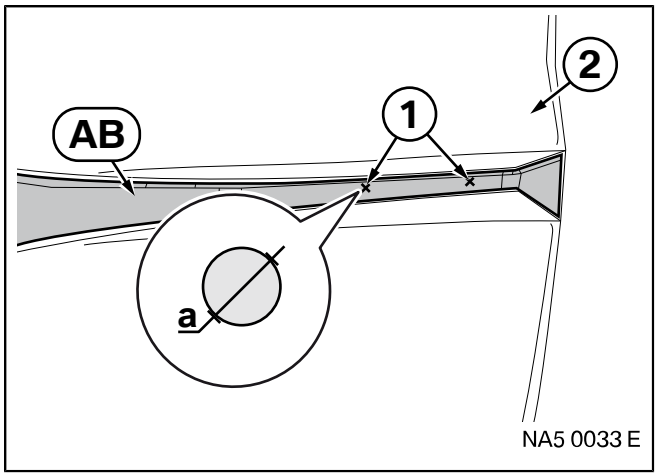


Remove the original roof edge spoiler (1).

Place the templates **AB** on the webs at the right and left of the original roof edge spoiler (1).

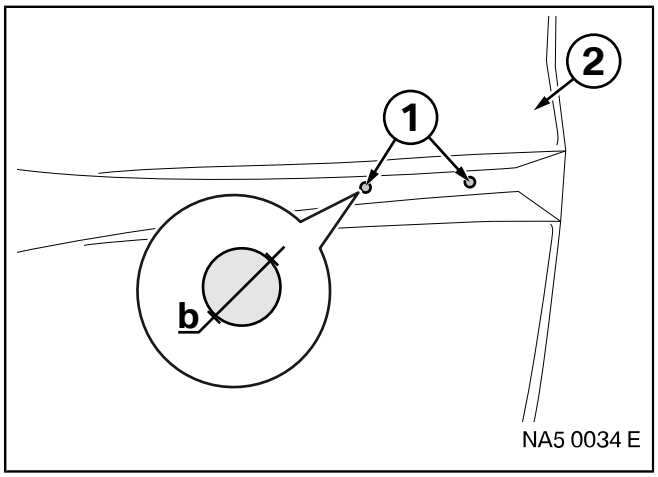
Align templates **AB** centrally on the web (2). ◀

Secure the templates **AB** with adhesive tape (3).



Drill pilot holes at each of the 2 drilling marks (1) on the left and right **Ø = 3.0 mm** (a) on the surface of the original roof edge spoiler (2) and remove the templates **AB**.

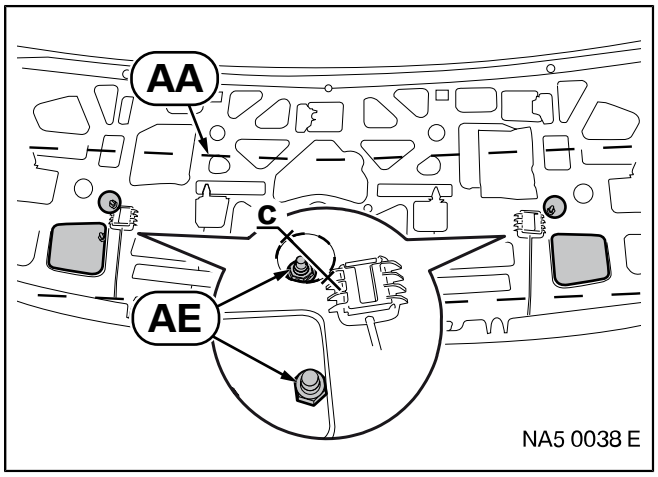
6. Installing the roof edge spoiler



When drilling, ensure the correct drilling angle.

The drilling angle must be 90°. ◀

Counterbore the 2 drilled holes (1) on the left and right of the original roof edge spoiler (2) with **Ø = 6.0 mm** (b) and deburr them.

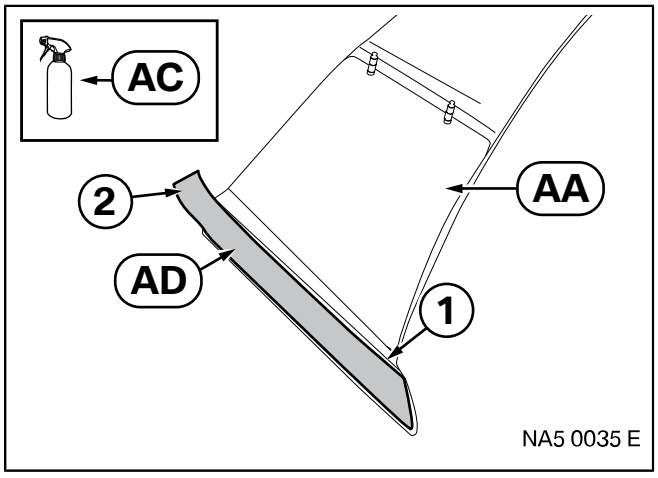


In order to fasten the M5 nut **AE** on the front bolt, use appropriate tools to saw a round opening (1) about **Ø = 19.0 mm** (c) into the underside of the original roof edge spoiler.

Clean the roof edge spoiler **AA** on the outside after sawing.

Press the adhesive tapes into position using a contact pressure of between 10 N/cm² and 50 N/cm². (A forceful press of your thumb will reach around 35 N/cm².) It is not how long you apply this pressure, but the force with which it is applied that counts. Press the component into place over the entire bonding area. Removing the adhesive tape after pressing the component into place will destroy the bond. ◀

Observe the curing time ◀



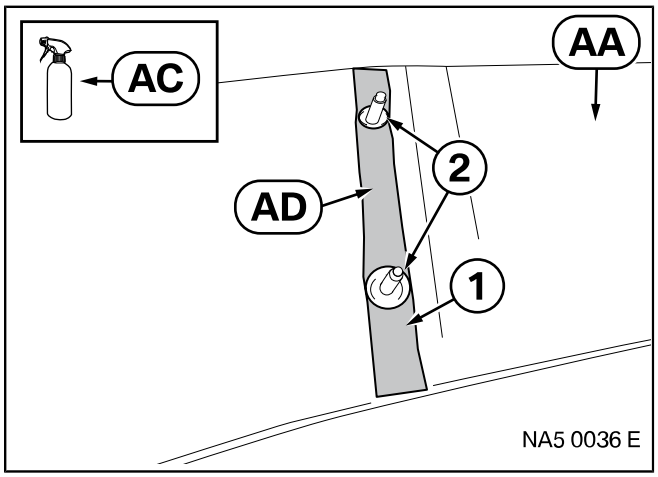
The bonding surfaces must be completely dry, clean, and free of wax or grease. ◀

Clean the surface (1) on the underside of roof edge spoiler **AA** on both sides with cleaner **AC** and prime.

Stick on gluing cut-out sheets **AD** on the right and left.

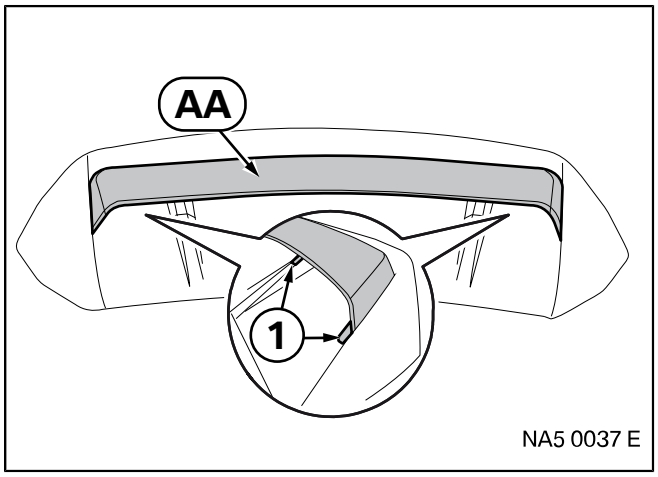
It must still be possible to grip the ends of protective films of the gluing cut-out sheets **AD** after positioning. The protective films of the gluing cut-out sheets **AD** are only pulled off after screwing firmly on the middle web. ◀

6. Installing the roof edge spoiler

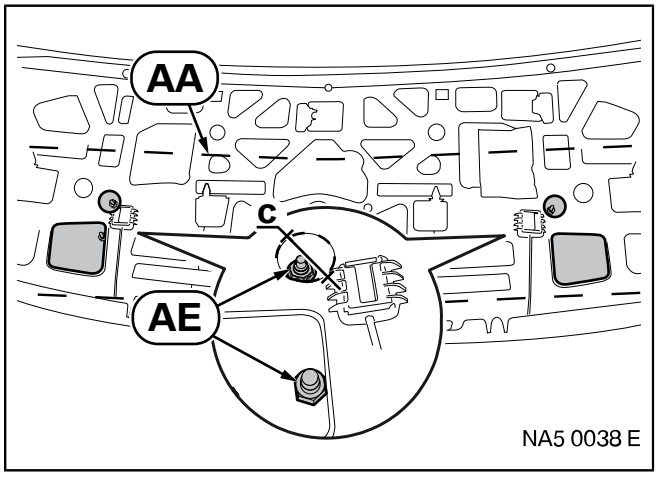


Clean the bonding surface (1) between, in front of and behind the bolts (2) on the right and left on the underside of roof edge spoiler **AA** on both sides with solvent cleaner **AC**.

Glue on gluing cut-out sheets **AD** between, in front of and behind the bolts (2).



Position roof edge spoiler **AA** on the original roof edge spoiler and ensure that the holes are positioned correctly.



Secure the roof edge spoiler **AA** from the underside with M5 nuts **AE**.

Fasten the M5 nuts **AE** to the bolts.

M5 nuts **AE** must be flush with the web. ◀

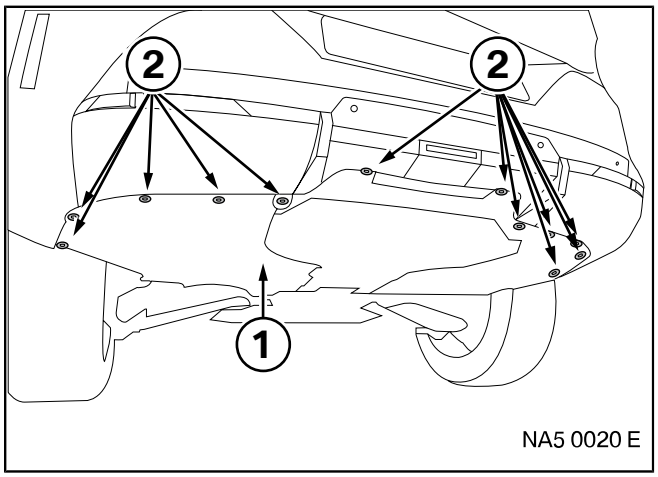
Reassemble the original roof edge spoiler in accordance with ISTA/AIR.

Pull the protective film out of the gluing cut-out sheets **AD** on the outside. Press on the roof edge spoiler **AA** firmly.

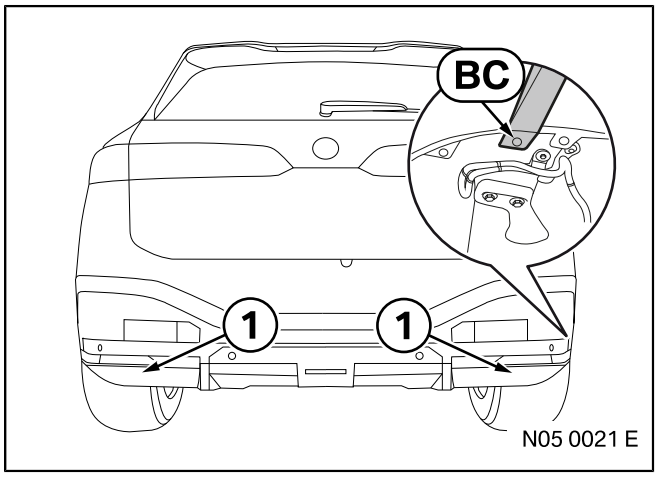
Press the adhesive tapes into position using a contact pressure of between 10 N/cm² and 50 N/cm². (A forceful press of your thumb will reach around 35 N/cm².) It is not how long you apply this pressure, but the force with which it is applied that counts. Press the component into place over the entire bonding area. Removing the adhesive tape after pressing the component into place will destroy the bond. ◀

Observe the curing time ◀

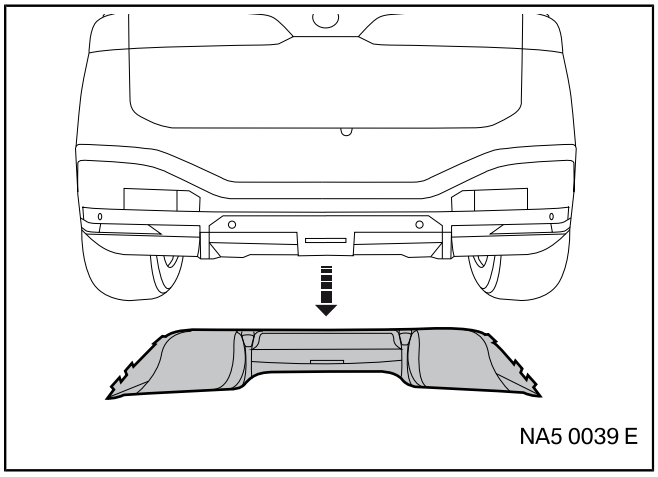
7. Installing the diffuser



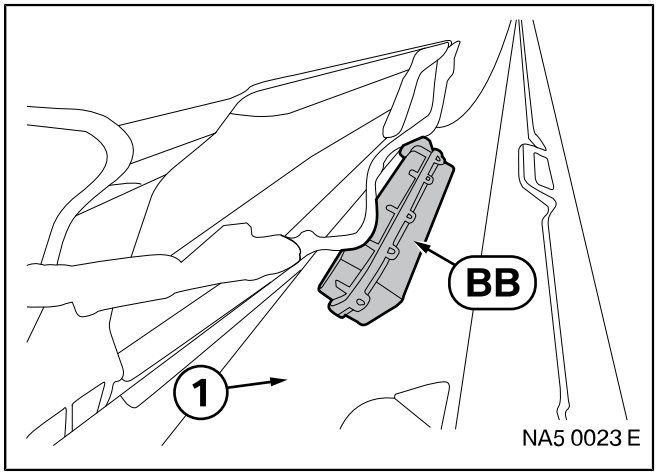
Loosen the twelve screw connections (2) between the underbody (1) and the bumper.



Remove the two blind rivets **BC** between the diffuser and bumper panel on the left and right (1).



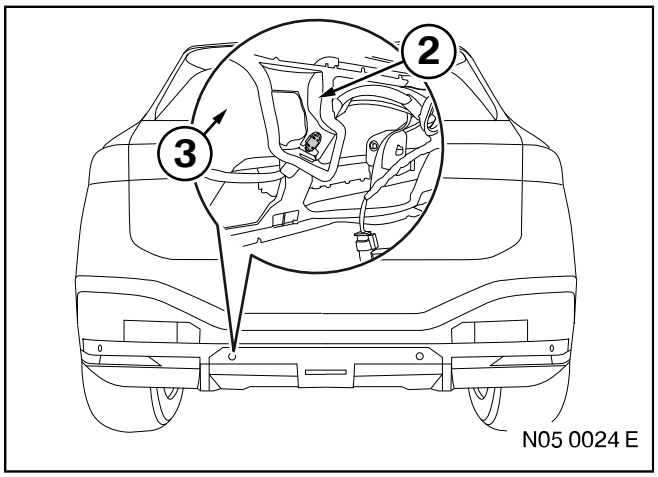
Unclip the **original diffuser** (1).



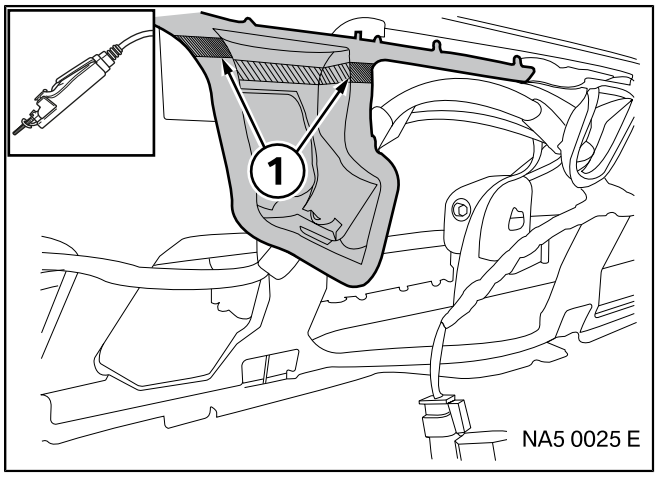
Disconnect the **PDC sensors** and centre light **BB** from the original diffuser (1).

The original diffuser and the Park Distance Control (PDC) sensors built into it are painted in the vehicle colour, depending on the configuration. The Park Distance Control (PDC) sensors must be ordered in black colour if necessary. ◀

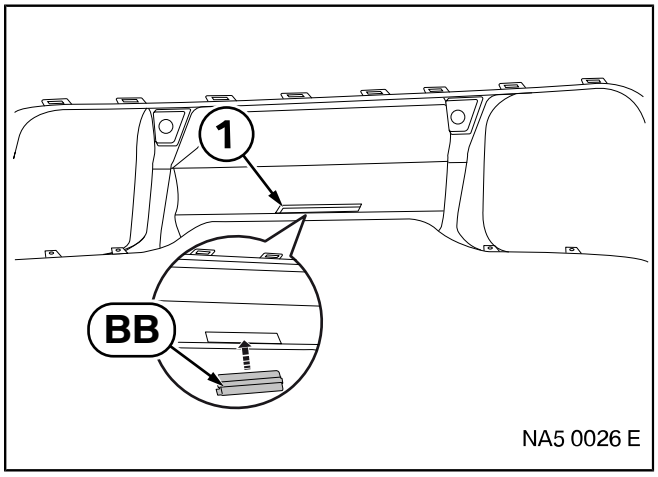
7. Installing the diffuser



Unclip the **wiring harness** from the fastening lugs (2) of the rear section (3).



Remove the lugs of the adapter carrier on both sides (1) using a suitable tool (e.g. oscillating saw) and de-burr.



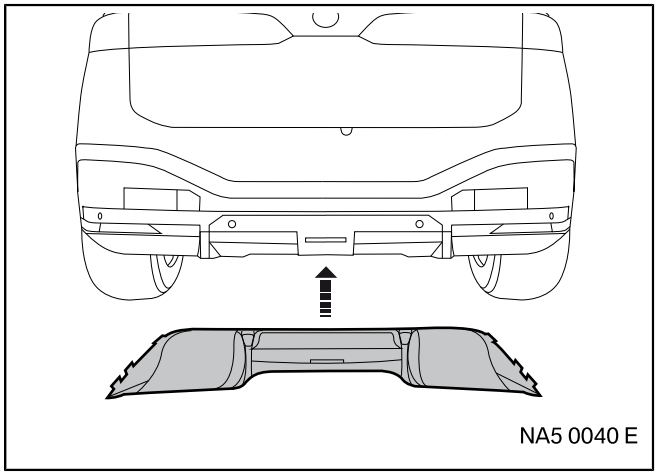
Check in which direction the electrical output of the centre light must point. Bond the adhesive pad for securing the centre light on the diffuser.

Degrease the bonding surfaces (1) and clean them with cleaner **BD**.

Install centre light **BB**.

Clip the PDC sensors into the diffuser **BA**

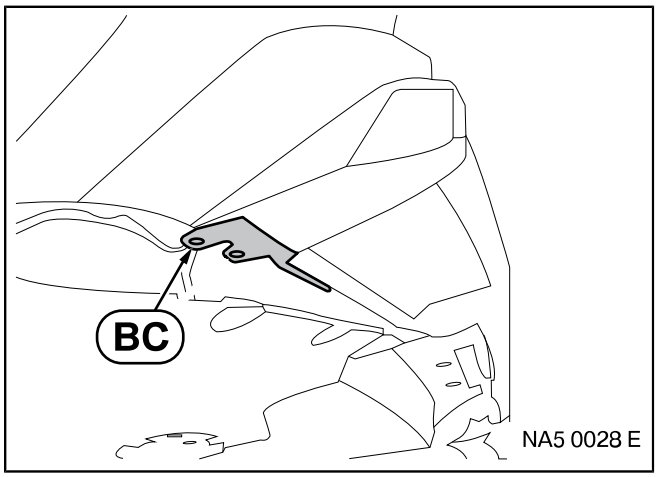
Connect the **PDC sensors** and the centre light **BB** to the connector.



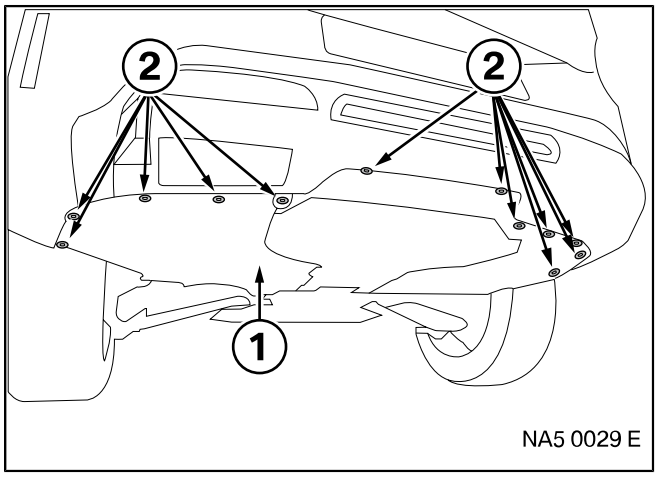
Attach the diffuser **BA from outside** and clip it in.

Make sure the lugs are correctly seated. ◀

7. Installing the diffuser



Use **one** blind rivet **BC** at the outer end to secure the diffuser on the bumper. On the other side, also use **one**blind rivet **BC** on the outer end to secure the diffuser.



Fasten the **underbody** (1) to the bumper and diffuser with **twelve screws** (2).

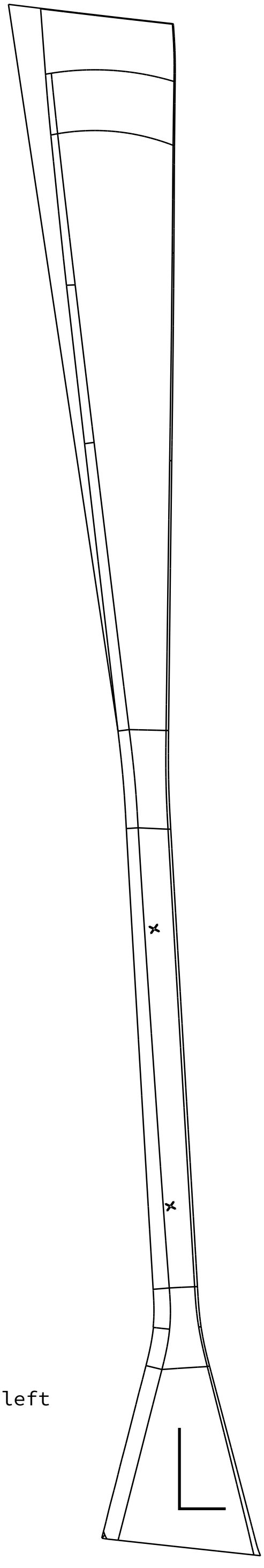
Check the function of PDC sensors and centre light. ◀

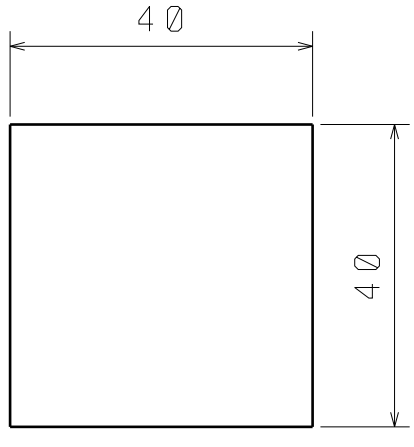
8. Concluding work and coding

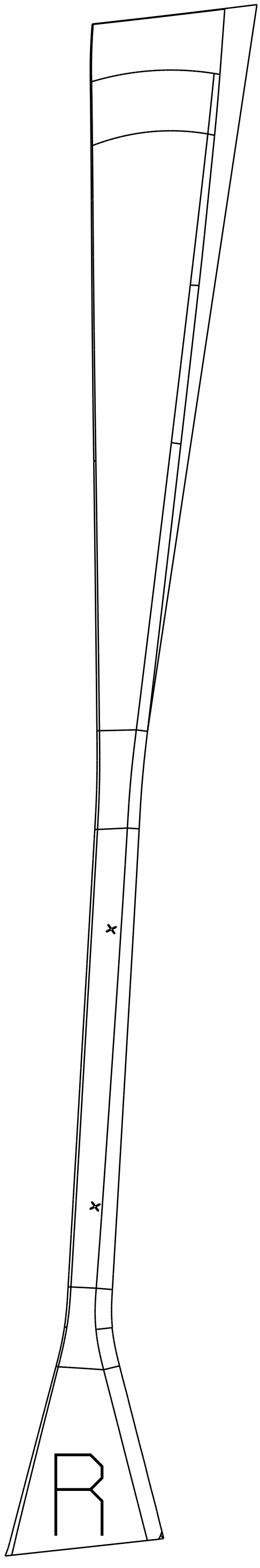
The retrofit system requires programming/coding.

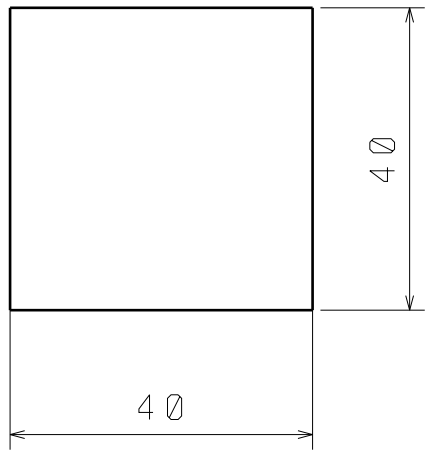
When installing the front attachment, a specific parameter set (customer service word) must be uploaded/flashed to the control unit. The parameter set of the NA05-25-07-540 release can be used as this parameter set.

NA5 Roof edge spoiler left









NA5 Roof edge spoiler right