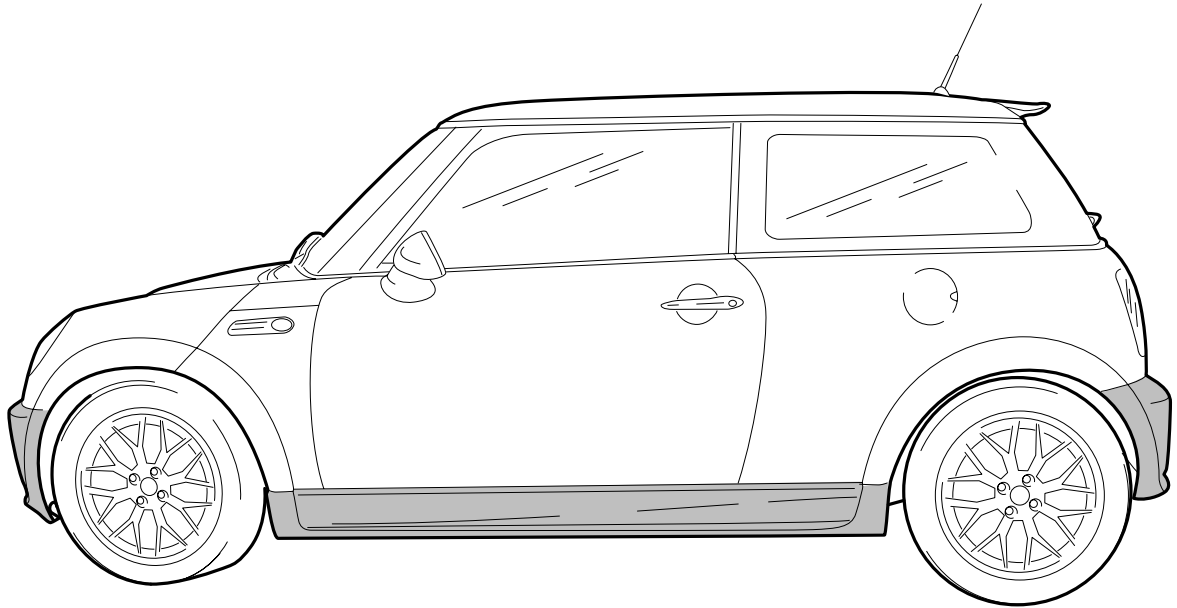




Parts and Accessories Installation Instructions



050 0121 B

Mini accessory aerodynamic package installation kit Mini (R50/R53)

Only valid for cars without towing hitch SA (special equipment)
Only valid for cars without SZ (special accessory) mudflaps

Specialist knowledge required.

The installation time is approx. 2.0 hours but this may vary depending on the condition of the car and the equipment in it.

Retrofit / Installation kit No. 0 140 629, 0 021 929, 0 140 630,
0 140 631, 0 021 932, 0 021 933,
0 140 632, 0 021 931, 0 139 659,
0 140 259, 0 140 255, 0 139 106,
0 140 257, 0 140 258, 0 141 383,
0 141 384

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1. Important information for the installation of the Mini (R50/R53) aerodynamics package

Only for use in the BMW / Mini dealer organisation.

The aerodynamics package may only be installed by a specialist workshop that has the required special tools and manuals (servicing, repair, diagnostics, etc.).

All the work is shown for a LHD car, the same procedure should be used as appropriate on RHD cars.

All the work is shown on the left-hand side of the car, the same procedure should be used as appropriate on the right-hand side.

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

Subject to technical modifications

Required tools and equipment

Set of Philips screwdrivers
Socket set
Angle cutter

Set of flat screwdrivers
Set of files
1/4 inch socket set

2. Important painting instructions for the Mini (R50/R53) aerodynamic components (only valid for repairs or primed version)

The aerodynamics package is supplied ready primed and must undergo the appropriate pre-treatment. Follow the BMW / Mini painting instructions for all painting work.

Procedure: The aerodynamics package is made of PUR-R-RIM.
BMW Mini acrylic paint + 30% softface additive.
The maximum temperature for stoving the paint is 80°C.



Check that all the parts fit accurately on the car before painting them. ◀



If they are not fixed securely for painting and stoving the parts may suffer deformation. ◀

Safety instructions

It is essential to ensure that mechanical work or painting work does not destroy the model plate or the embossing in the front apron, rear apron and side skirts or render it illegible.

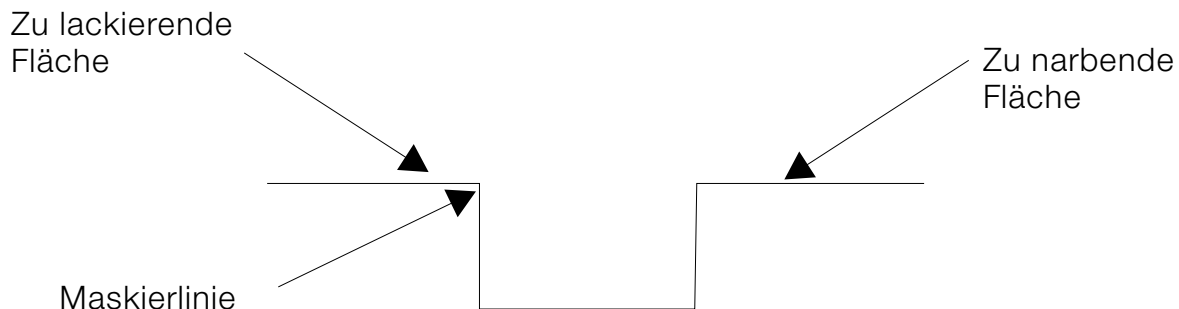
2. Important painting instructions for the Mini (R50/R53) aerodynamic components (only valid for repairs or primed version)

A structured paint is required for highlighting the grained surface.

Structured paint: 0.5 litre 51 91 0 027 551 (Mini structured paint black matt)
1.0 litre 51 91 0 027 552 (Mini structured paint black matt)

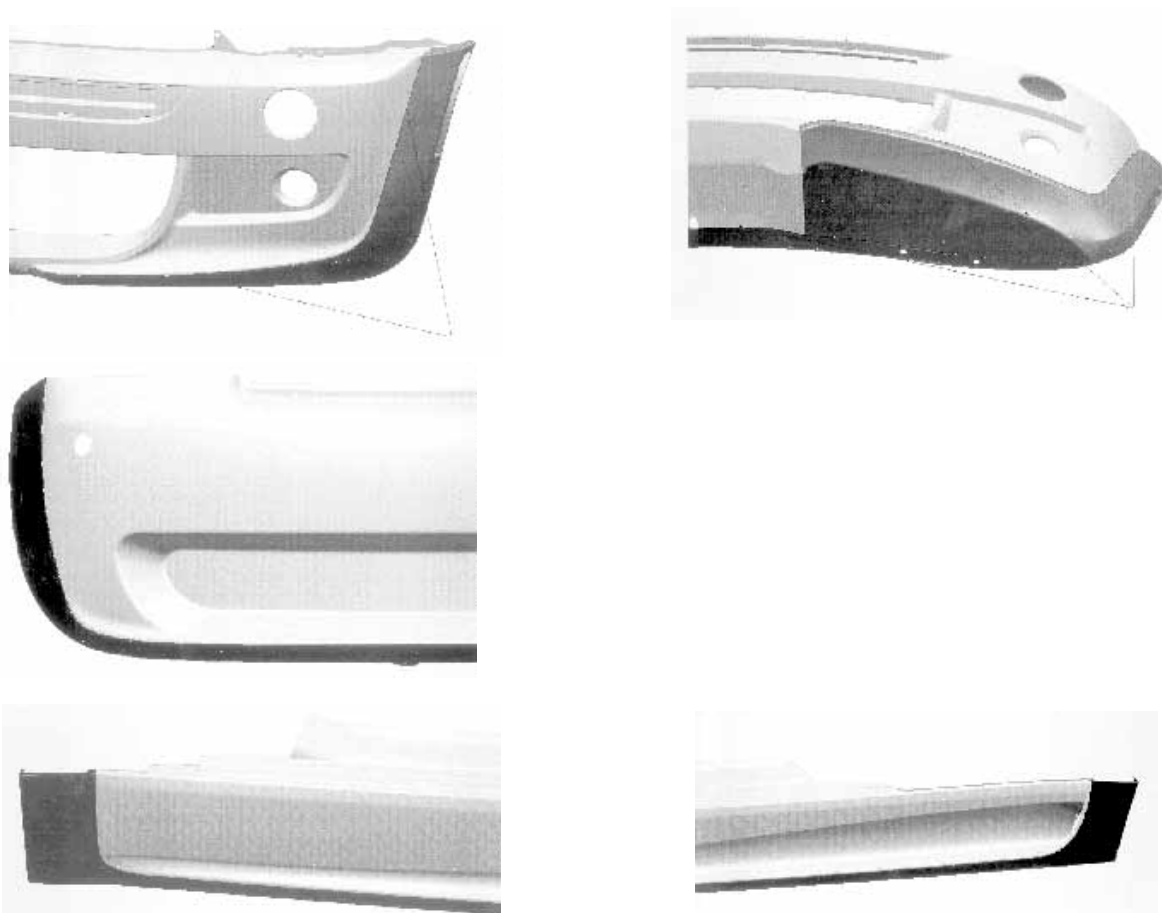
It is possible to make the grain with an appropriately colour coded structured paint (ready-mixed version being prepared)

The components all have a clearly identifiable masking line.
The graining must be completed after the top coat has been applied.



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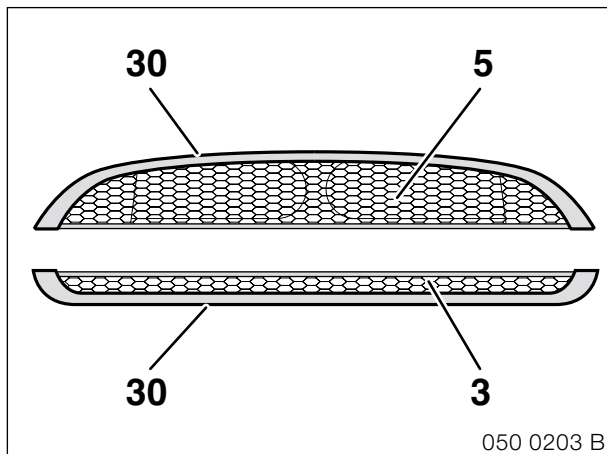
The figure shows a section through the component and masking joint.



050 0202 B

2. Important painting instructions for the Mini (R50/R53) aerodynamic components
(only valid for repairs or primed version)

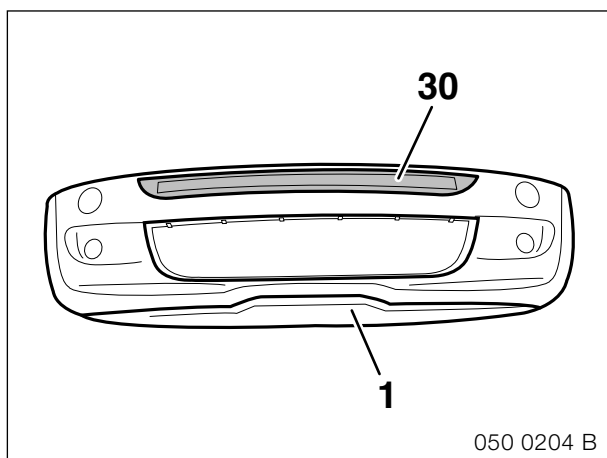
Painting instructions and non-binding colour suggestion



▶ The figure shows the radiator grille (5) and top bumper grille (3). ◀

To achieve an even more sporty appearance of the aerodynamic package we recommend that you paint the areas marked in grey (30) in the body colour.

▶ See also the BMW/ Mini painting instructions for ABS plastics. ◀

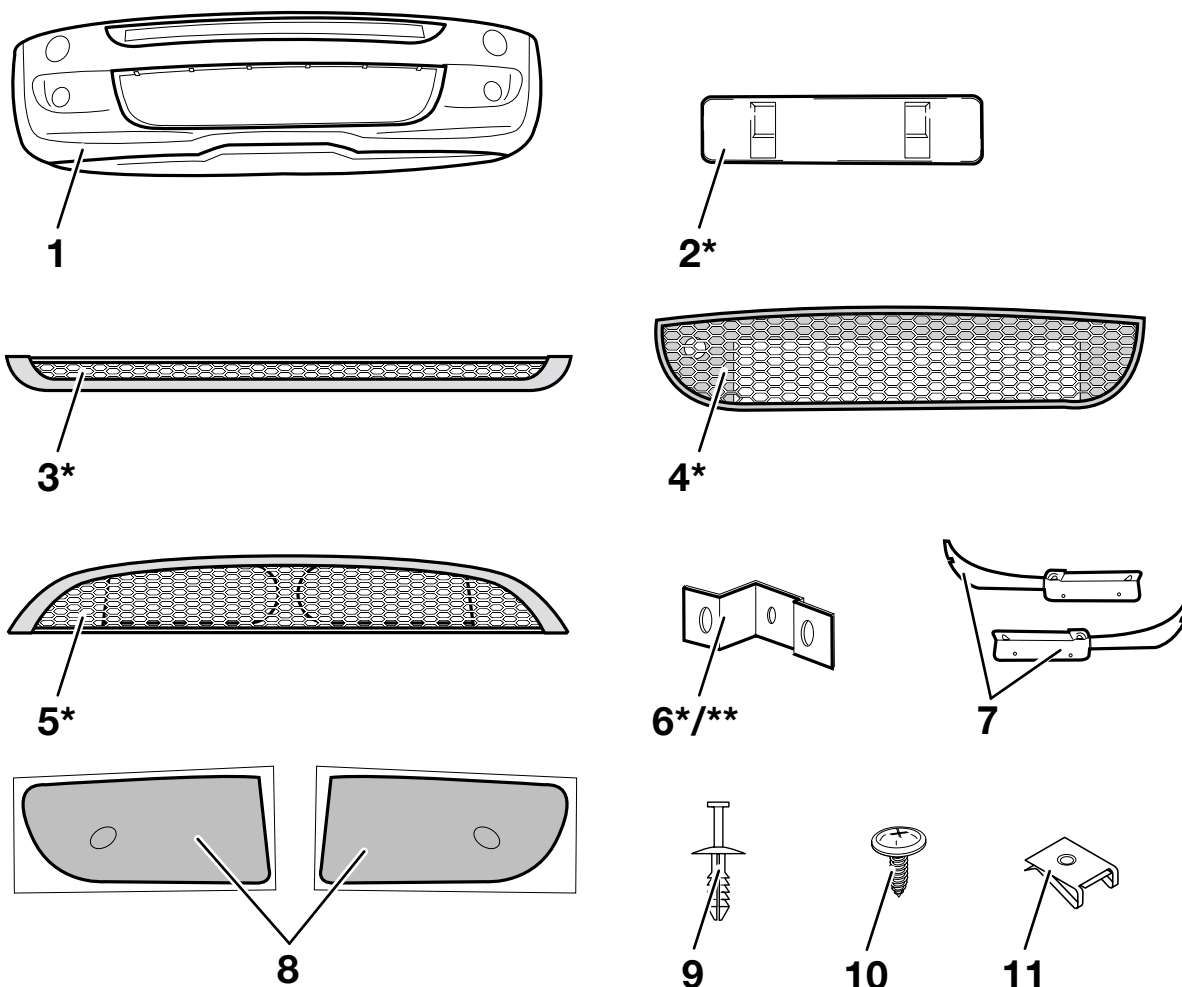


The area marked in grey (30) on the accessory front apron (1) must be painted black to prevent the top coat shining through it.

3. Preparations

	TIS instruction No.
Remove the standard front apron (no longer required)	---
Remove the indicator lights from the standard front apron.	---
Remove the temperature sensor from the standard front apron.	---
Remove the standard rear apron, unclip the reversing light from the standard rear apron (the standard rear apron is no longer required).	---
Remove the metal brackets from the standard rear apron	---
Remove the standard side skirts (no longer required)	---
Remove the standard radiator grille from the bonnet (no longer required)	---

4. Accessory front apron parts list



050 0205 B

Legend

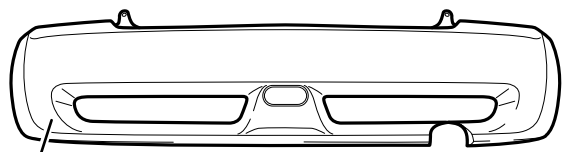
- 1 Accessory front apron
- 2 Registration plate holder*
- 3 Top bumper grille*
- 4 Bottom bumper grille*
- 5 Accessory radiator grille*
- 6 Indicator adapter bracket (2x)*/**
- 7 Securing bracket (left / right)
- 8 Fog light foil (left / right)
- 9 Expanding rivet (4x)
- 10 Plastic self-tapping screw (2x)
- 11 Speed nut (2x)

*Parts 2, 3, 4, 5 and 6 are not supplied with the accessory front apron and must be ordered separately using the electronic parts catalogue (EPC).

**Ensure that when you install the front apron on Mini cars with the old indicator mountings an adapter bracket with BMW/ Mini Part No. 63 13 6 920 889 must also be ordered using the electronic parts catalogue (EPC).

The adapter bracket is not required for cars with a production date after 10/01.

5. Accessory rear apron parts list



12



13*

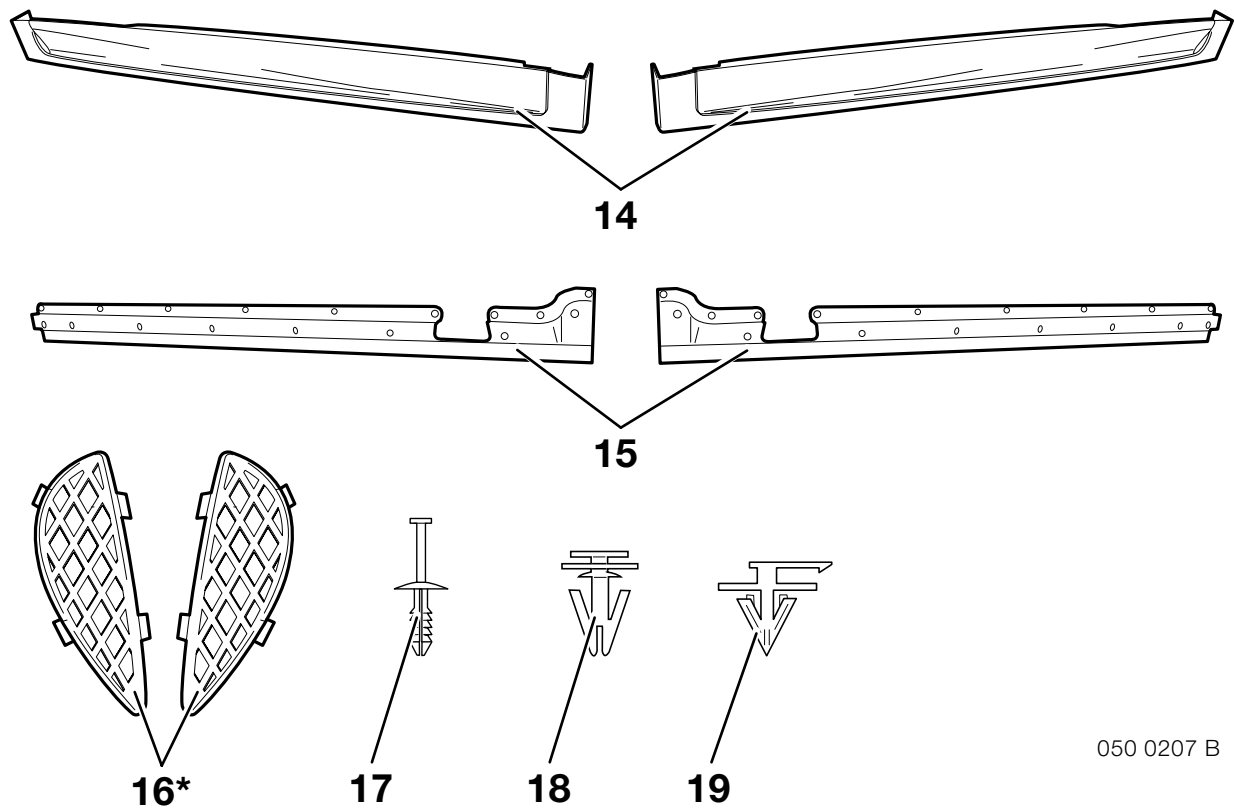
050 0206 B

Legend

- 12 Accessory rear apron
- 13 Foils* (left / right)

*These foils are only supplied with primed versions of the accessory rear apron.

6. Accessory side skirt parts list



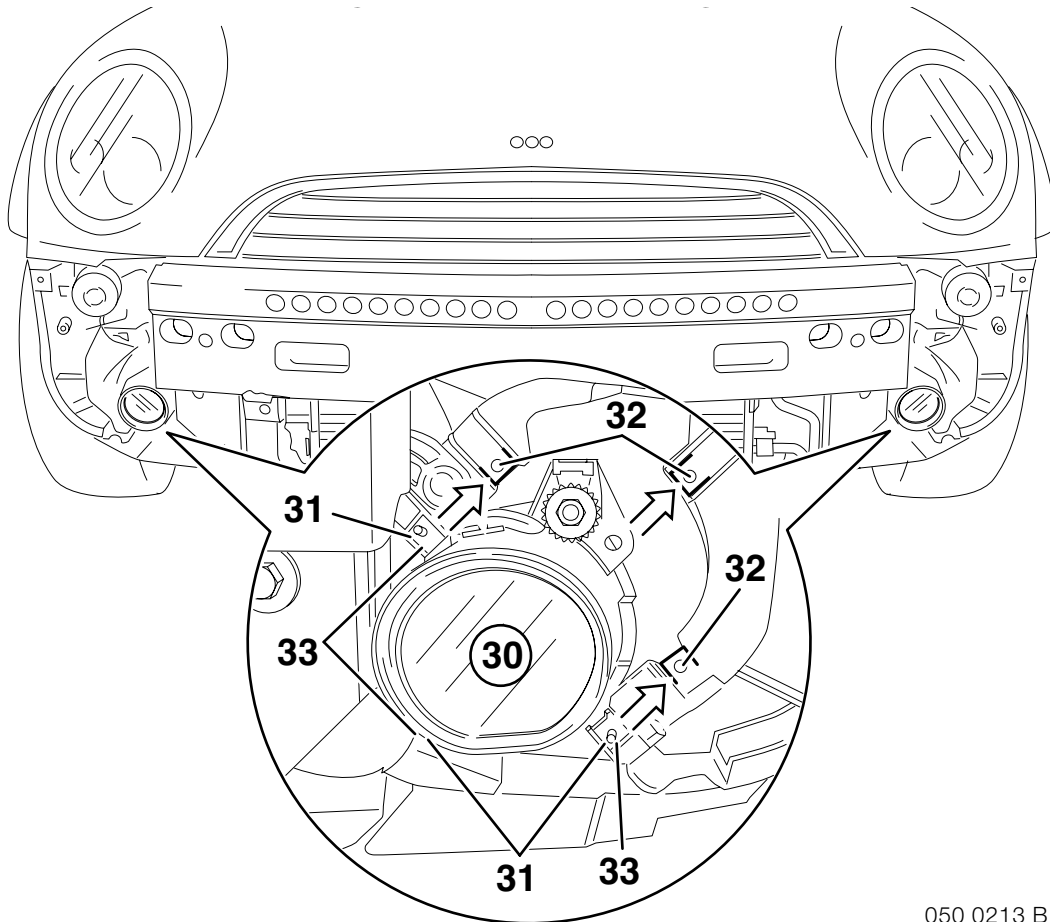
050 0207 B

Legend

- 14 Accessory side skirt (left / right)
- 15 Side skirt mountings (left / right)
- 16 Side skirt grille (left / right)*
- 17 Expanding rivet (18x)
- 18 Clip (4x)
- 19 Clip (6x)

*Part 16 is not supplied with the accessory side skirts and must be ordered separately using the electronic parts catalogue (EPC).

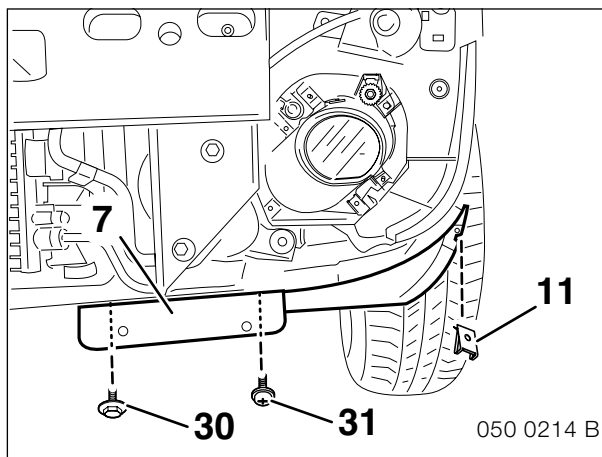
7 Modifications on the car



050 0213 B

▶ The magnified sections shows the fitted fog light. ◀

Release the fog light (30) from the three standard mounting points (31).
Drill the three new mounting points (32) at the existing marks with a diameter of 7 mm and then fit the existing metal slips (33) on them.
Screw the fog light (30) to the three new mounting points (32).



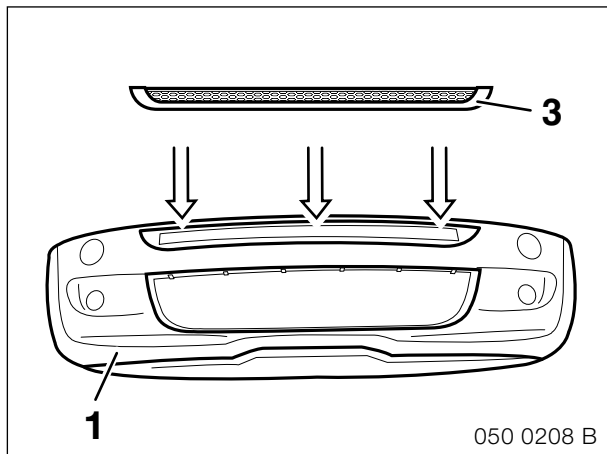
▶ The figure shows front left of the car. ◀

Install the mounting bracket (7) to the car using the existing hexagonal screw (30) and Philips screw (31).

▶ The existing oval holes in the mounting brackets (7) can be used to compensate for tolerances on the car and the accessory front apron. ◀

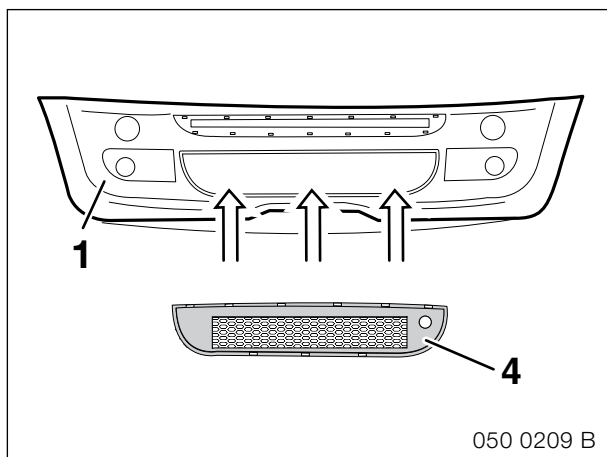
Push the clips (11) on to the mounting brackets (7) as shown in the figure.

8. Modifications to the accessory front apron



Clip the top bumper grille (3) into the accessory front apron (1).

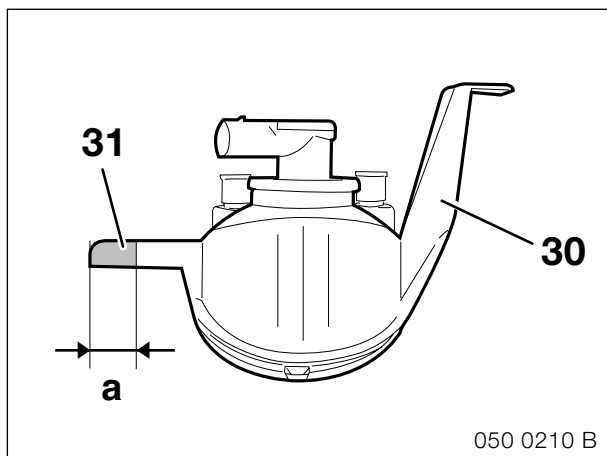
- ▶ Ensure that the top bumper trim is positioned precisely. ◀



- ▶ The figure shows the reverse of the accessory front apron. ◀

Clip the bottom bumper grille (4) into the accessory front apron (1).

- ▶ Ensure that the bottom bumper trim (4) is positioned precisely. ◀



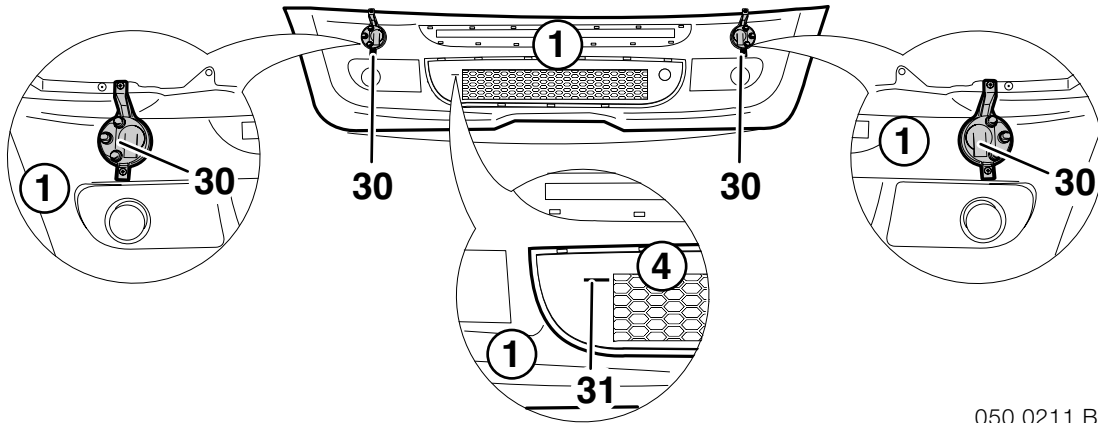
- ▶ The figure shows the removed left indicator (30). ◀

Cut the area marked grey (31) out of the indicator (30) using the appropriate tools (*). (* Angle cutter, oscillating saw, pneumatic saw).

- ▶ Otherwise this area (31) would collide with the accessory front apron. ◀

Dimension **a** = 20 mm

8. Modifications to the accessory front apron



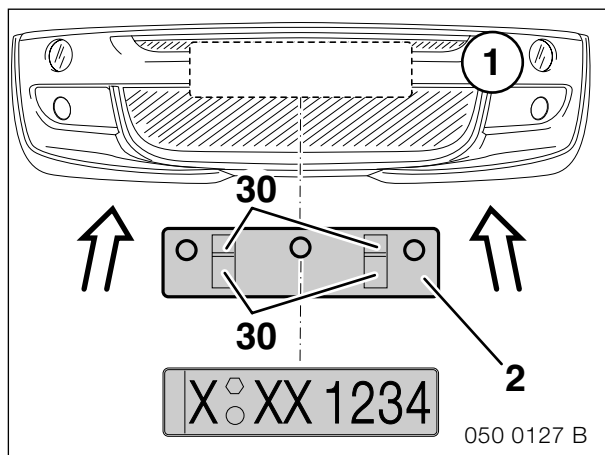
050 0211 B

Screw the modified indicator (30) to the accessory front apron (1).

- ▶ Ensure that when you install the front apron on Mini cars (R50/R53) with the old indicator mountings an adapter bracket with BMW Part No. 63 13 6 920 889 must be ordered separately. ◀
- ▶ The adapter bracket (BMW/ Mini Part No. 63 13 6 920 889) is not required for cars with a production date after 10/01. ◀

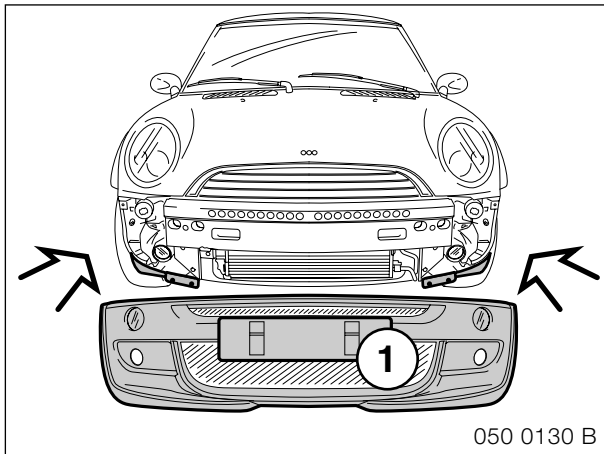
Place the temperature sensor (31) and retaining plate on the strut on the bottom bumper grille (4) shown in the magnified section.

- ▶ The temperature sensor (31) must be positioned so that it is not in the wind caused by the car moving. ◀

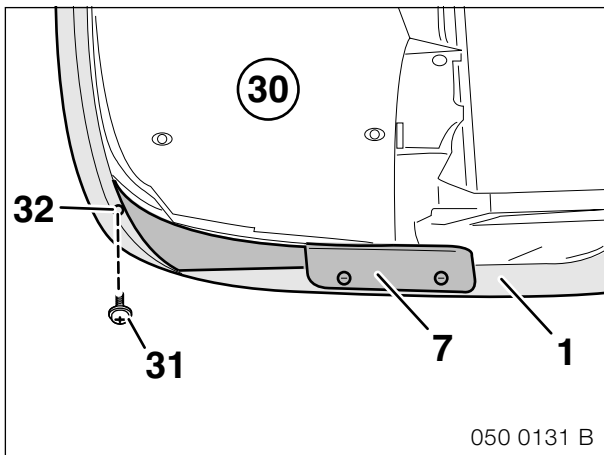


Screw the registration plate holder (2) to the accessory front apron (1) as shown in the figure using Philips screws (30).

9. To install the accessory front apron

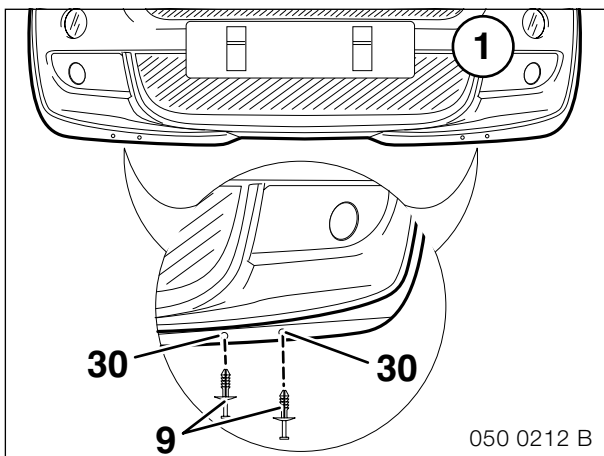


Secure the assembled accessory front apron (1) to the car in the same way as the standard front apron.



▶ The figure shows the wheel arch trim (30) at the front left with the fitted mounting bracket (7) (left). ◀

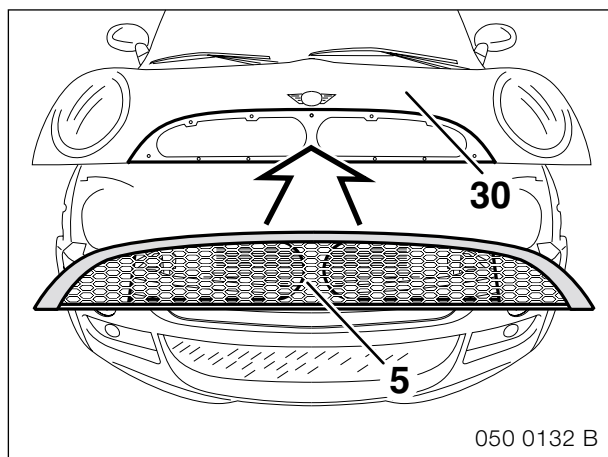
Screw the self-tapping screw (31) through the existing hole (32) into the accessory front apron (1) using the mounting bracket (7) (left).



▶ The figure the accessory front apron (1) mounted on the car. ◀

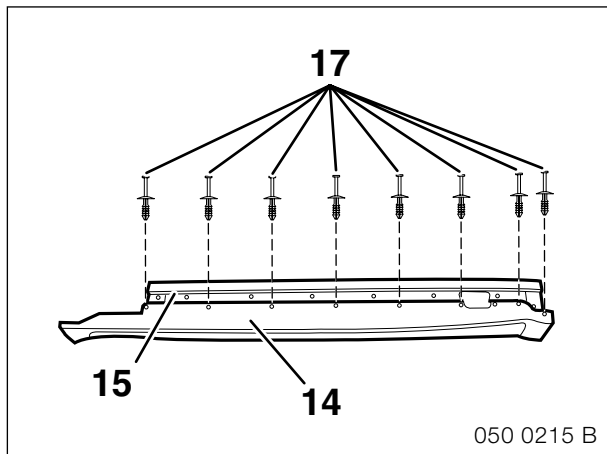
Push the expanding rivets (9) from the front through the existing holes (30) in the accessory front apron (1) and secure them to the mounting bracket behind it.

10. To fit the accessory radiator grille



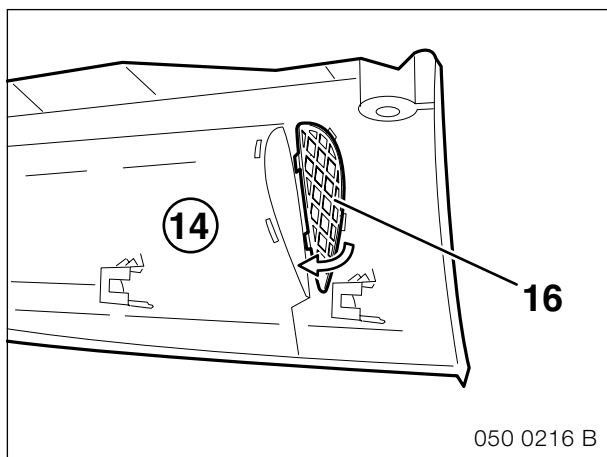
Secure the accessory radiator grille (5) to the bonnet (30) in the same way as the standard radiator grille.

11. To install the accessory side skirt



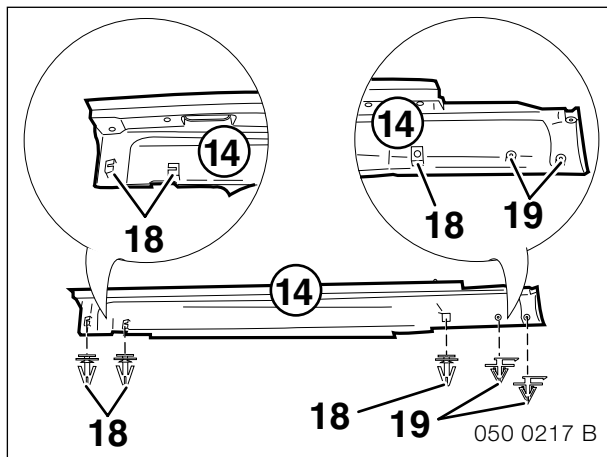
▶ The figure shows the underside of the accessory side skirt (14) and the side skirt mountings (15). ◀

Secure the accessory side skirt (14) and the side skirt mountings (15) together using expanding rivets (17).



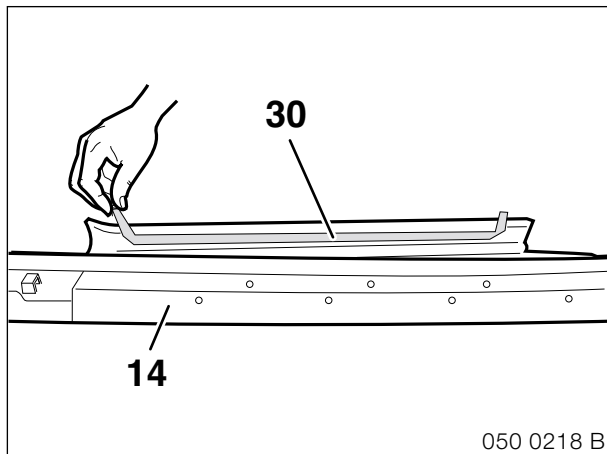
▶ The figure shows a section of the reverse of the accessory side skirt (14) at the rear. ◀

Clip the side skirt grille (16) into the accessory side skirt (14).



▶ The figure shows the rear of the accessory side skirt (14). ◀

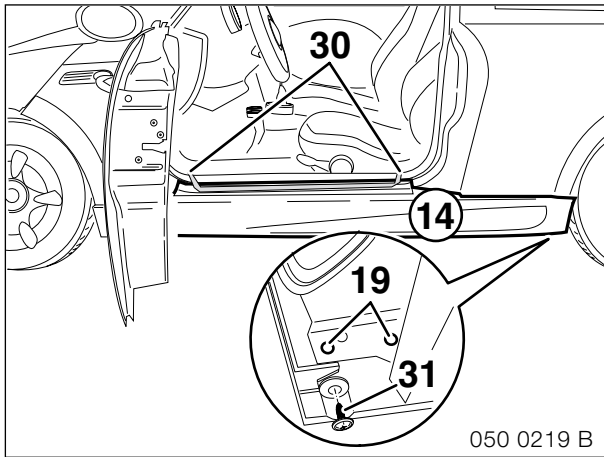
Secure the clips (18) and (19) in the positions shown in the figure.



▶ The figure shows the rear of the assembled accessory side skirt (14). ◀

Carefully remove the backing foil (30) of the adhesive tape on the rear of the accessory side skirt (14) by approx. 60 mm, as shown in the figure and fold it outwards.

11. To install the accessory side skirt

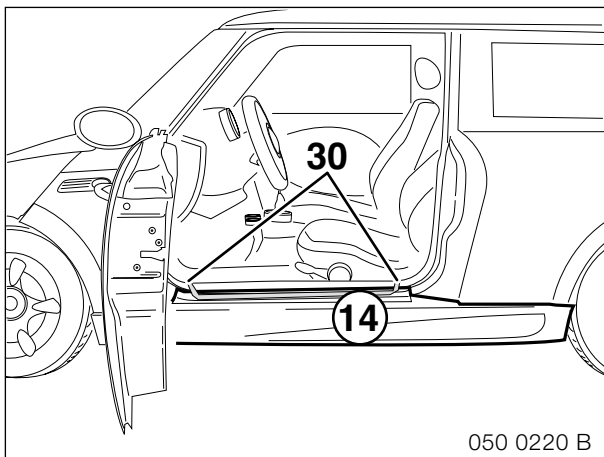


Carefully position the accessory side skirt (14) on the car.

- ▶ Do not yet remove the backing foil (30) from the adhesive tape. ◀

Secure the accessory side skirt (14) on the car in the same way as the standard side skirt using the existing clips.

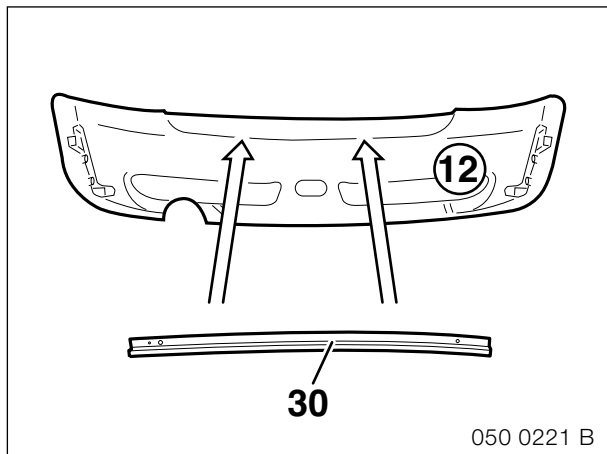
- ▶ The magnified section shows the fitted accessory rear skirt (14) at the rear. Secure the accessory side skirt (14) to the wheel arch trim using the existing Philips screw (31). ◀
- ▶ Check that the clips (19) are positioned correctly. ◀



Raise the accessory side skirt (14) off the body near the door sill and remove the backing foil (30) off the adhesive tape. Then align and affix the accessory side skirt (14).

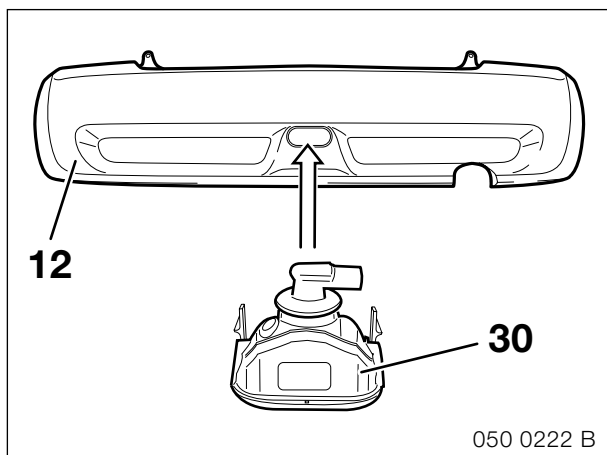
- ▶ As you secure the accessory side skirt ensure that the adhesive tape is affixed to the complete area with uniform pressure. ◀

12. To install the accessory rear apron

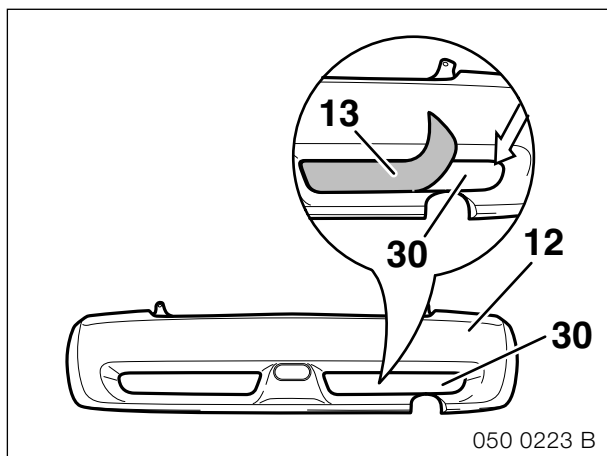


▶ The figure shows the reverse of the accessory rear apron (12). ◀

Remove the bracket (30) from the standard rear apron and install it in the same place on the accessory rear apron (12).



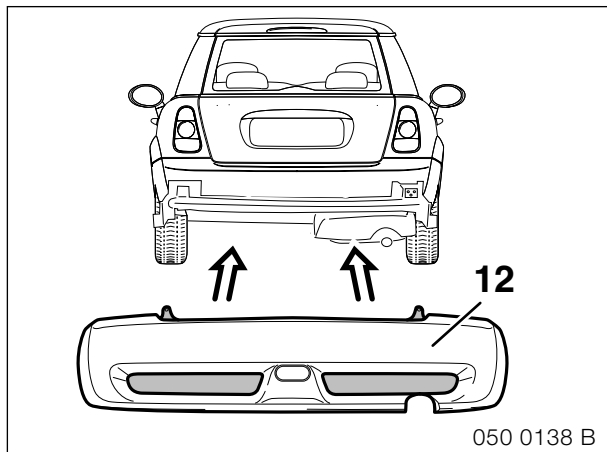
Clip the reversing light (30) into the accessory rear apron (12).



Only necessary for repairs or for the primed version of the accessory rear apron.

Clean the area (30) for gluing.
Affix the adhesive foil (13) on the accessory rear apron (12) as shown in the figure.

▶ Spray the foil (13) and the area for gluing (30) on the accessory rear apron (12) with soap suds, affix the foil (13) and then remove the excess soap suds with a rubber spatula. ◀



▶ Reconnect the reversing light. ◀

Clip the accessory rear apron (12) to the standard mounting points on the car and clip on the towing hitch cover from the standard rear apron.