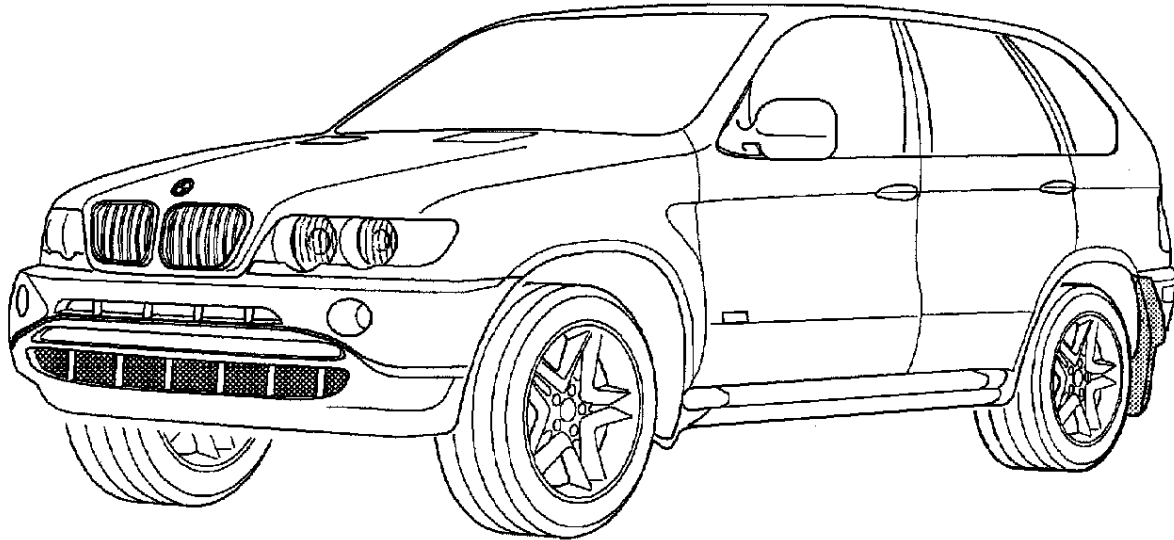




Parts and Accessories Installation Instructions



F 53 0609 B

BMW accessory mudflaps (rear) installation kit

BMW X5 (E53)

Not suitable for vehicles with accessory sports package

The installation time is approx. 1.5 hours, but this may vary depending on the condition of the car and the equipment in it.

Retrofit/Installation kit No. 82 16 0 017 252


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1. Important information for installing the mudflaps


Only for use within the BMW dealer organisation.


The mudflaps may only be installed by a specialist workshop that has the required special tools and skills.


 All the work is shown for the left-hand side of the car and must be completed using exactly the same procedures on the right-hand side. ◀


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

 The tools required for the adhesive work are standard workshop equipment for windscreen repairs. ◀

 Keep strictly to the drying times for the cleaners and primers you use. ◀

 The vehicle parts glued to the mudflaps must be at a temperature of at least 18°C. ◀

 The Sika Tack Ultrafest adhesive must be heated to 80°C before use. ◀

 The vehicle must not be moved for six hours after the last gluing operation. The adhesive bonds are strong enough to be taken through a car wash after 48 hours. ◀

Subject to technical modifications.

Tools required

Set of Philips screwdrivers
Pencil
Paintbrush
Abrasive paper (grain size 80)
Textile adhesive tape
Socket wrench (size 8)

Equipment required for the adhesive work

Manufacturer of the equipment

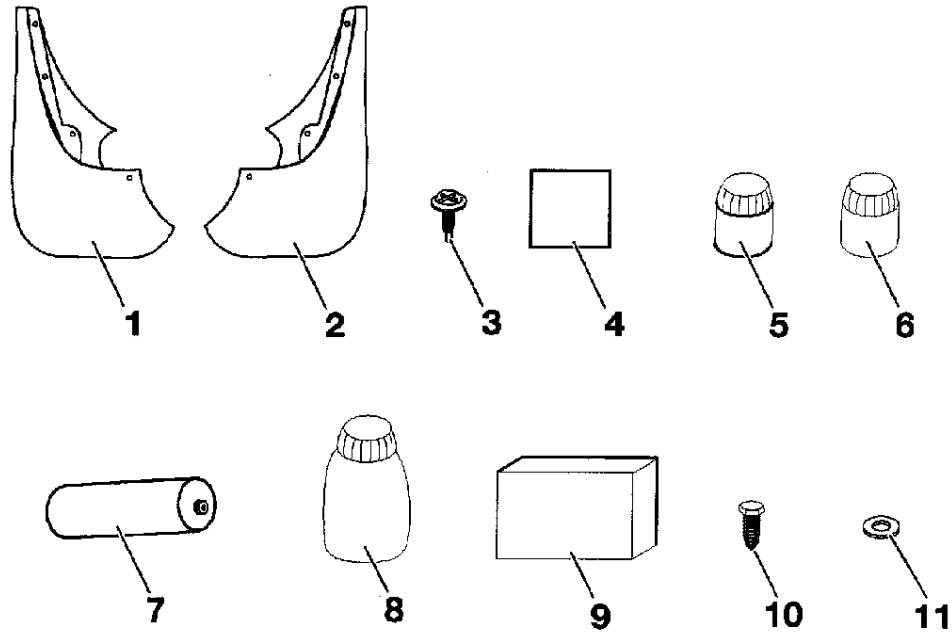
Sika Automotive GmbH
Kornwestheimerstr. 107
70439 Stuttgart

Cleaner (benzine or Sika adhesion promoter 205/5)
Sika 206 G+P primer
Sika Tack Ultrafest adhesive
Sika Tack cartridge oven
Sika Remover 208 cleaner

2. Preparations

Remove the rear wheels	TIS AW No. 36 10 300
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3. Parts overview

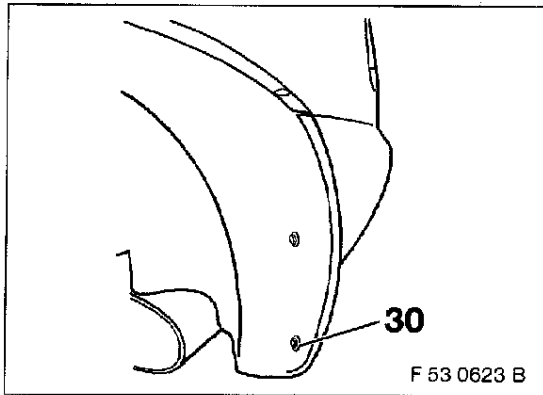


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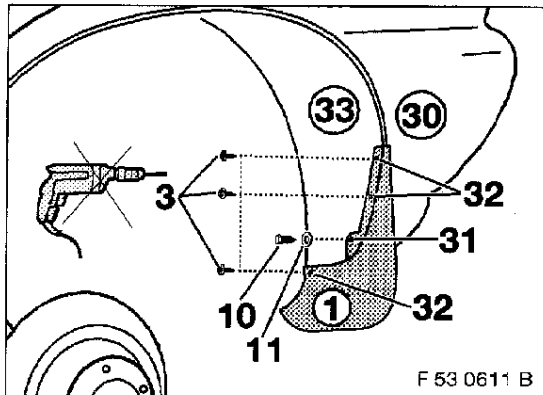
- 1 Mudflap (left)
- 2 Mudflap (right)
- 3 Philips screw (6x)
- 4 Abrasive paper (grain size 80)
- 5 Sika adhesion promoter 205/5 (250 ml can) *
- 6 Sika Primer 206 G+P *
- 7 Sika Tack Ultrafest adhesive *
- 8 Sika Remover 208 cleaner *
- 9 Installation aid (6x)
- 10 Hexagonal self-tapping screw M5 x 22 (2x)
- 11 Washer (2x)

* Workshop material from Sika for gluing windscreens


4. To install the mudflaps

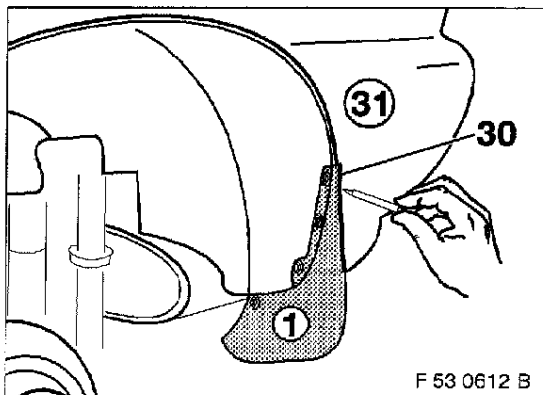


Remove the existing hexagonal self-tapping screw (30) with a socket wrench (size 8) (the hexagonal screw is no longer required).

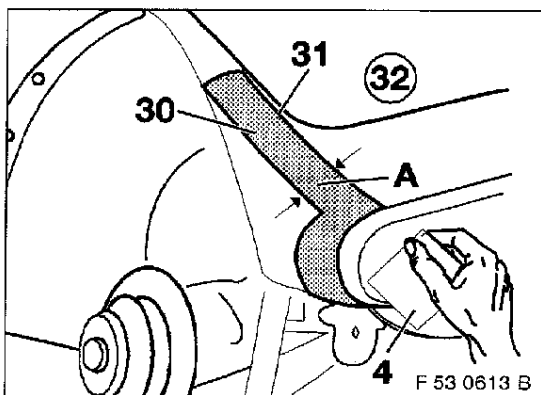


Screw the left mudflap (1) to the rear apron (30) using a 5 mm hexagonal self-tapping screw (11) through the opening (31) in the left mudflap (1). Then screw the three self-tapping Philips screws (3) into the wheelarch trim (33) through the opening (32) in the left mudflap (1).

 Do not predrill any openings since self-tapping Philips screws (3) are used. ◀




Draw round the outer contour (30) of the installed left mudflap (1) on the rear apron (31) with pencil. Then remove the left mudflap (1) again.

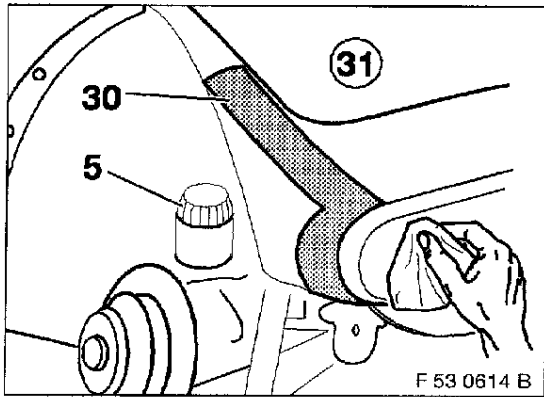


Abrade (roughen) the area marked grey (30) using abrasive paper (4), (grain size 80).

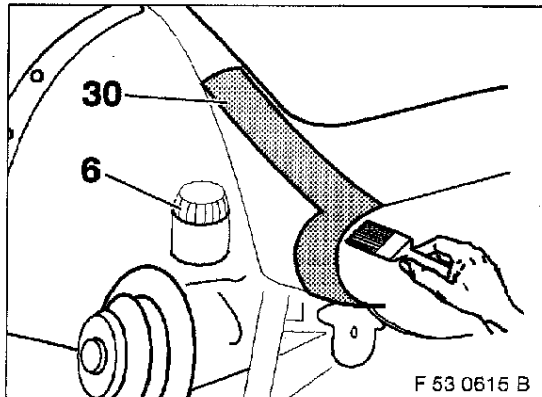
Dimensions A = 40 mm

 Ensure that you do not abrade over the drawn outer contour (31) in the visible area of the rear apron (32). ◀

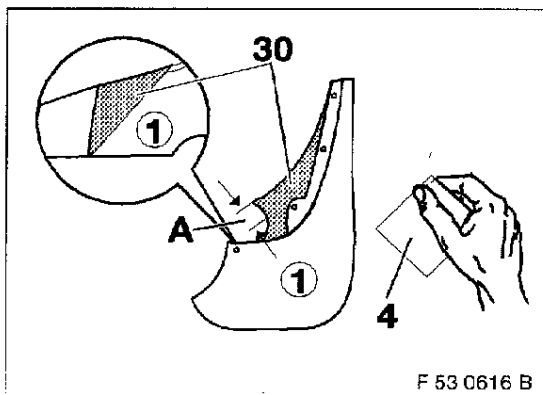
4. To install the mudflaps



Clean the area marked grey (30) on the rear apron (31) using **benzine** or **Sika adhesion promoter 205/5** (5) and leave to dry for **5 minutes**.

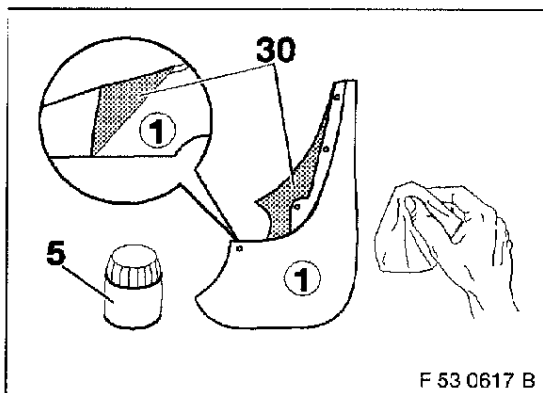


Apply **Sika Primer 206 G+P** (6) to the area marked grey (30) using a paintbrush and leave it to dry for **30 minutes**.



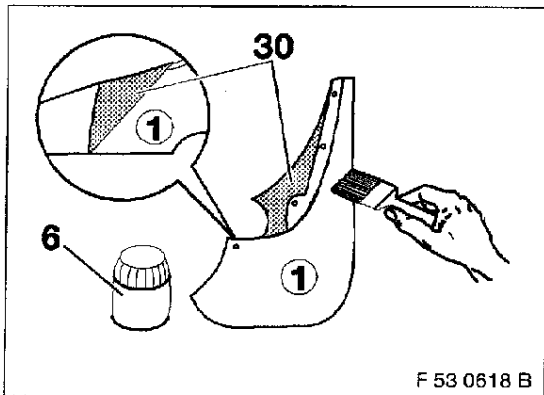
Abrade (roughen) the area marked grey (30) on the inside of the left mudflap (1) using abrasive paper (4), (grain size 80).

Dimension A = 40 mm

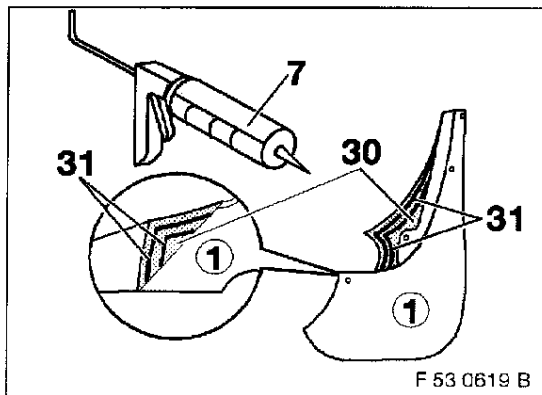


Clean the area marked grey (30) on the inside of the left mudflap (1) using **benzine** or **Sika adhesion promoter 205/5** (5) and leave to dry for **5 minutes**.

4. To install the mudflaps

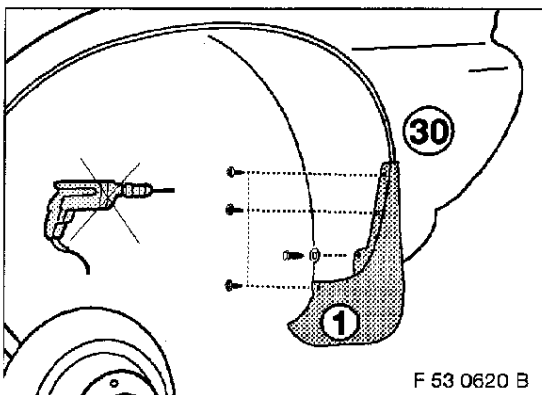


Apply **Sika Primer 206 G+P** (6) to the area marked grey (30) on the left mudflap (1) using a paintbrush and leave it to dry for **30 minutes**.

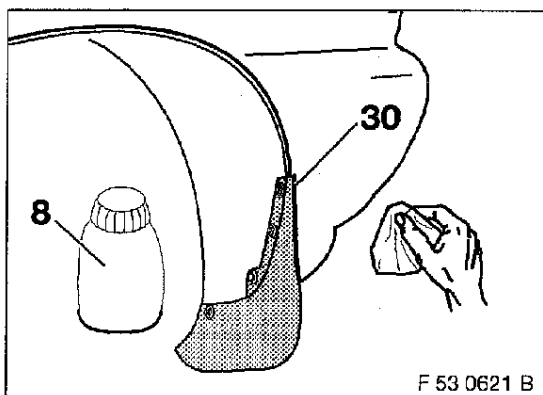


Apply two even beads (31) of **Sika Tack Ultrafest** (7) next to each other on to the prepared inside surface (30) of the left mudflap.

⚠ Sika Tack Ultrafest (7) must be at a temperature of **80°C** for proper application. The mudflaps must be fitted within **5 minutes** of applying the adhesive. ◀

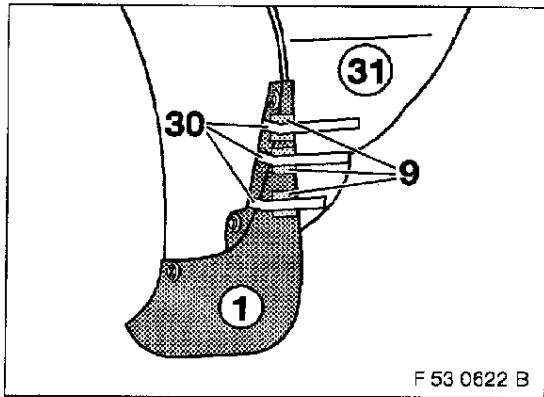


Affix the left mudflap (1) to the rear apron (30) and insert the screws.



⚠ Remove any excess adhesive (30) **immediately** using **Sika Remover 208** (8). ◀

4. To install the mudflaps



Secure three installation aids (9) as shown in the figure evenly spaced to the left rear mudflap (1) using adhesive tape (30) in such a way that the contact edge of the left mudflap is pressed against the surface of the rear apron (31).



Do not remove the installation aids (9) for **6 hours**. ◀



Remove any excess adhesive (30) **immediately** using **Sika Remover 208** (8). ◀

5. Concluding work

Install the rear mudflaps

Install the wheels.