

AC SCHNITZER

-Installation instructions-

Engine spoiler - R12nineT -



S50122419603

General information!



AC Schnitzer engine spoiler - R12 nineT

Important notes !

These installation instructions must be read before starting installation work. AC Schnitzer accepts no liability for damage caused by incorrect installation! Check that the goods are complete and undamaged before starting work. Later complaints cannot be considered. These installation instructions are intended for use by authorised AC Schnitzer dealers.

The target group for these installation instructions is in all cases specialised personnel trained on BMW vehicles. Appropriate specialist knowledge of standards, tightening torques and material properties is assumed.

The engine spoiler must always be individually fitted to the vehicle before painting and, if necessary, adjusted or rework if necessary. Do not paint over existing part identification on the inside of the GRP part.

Assembly

Before mounting, the vehicle must be adequately secured against rolling away or tipping over.

We recommend the use of an original BMW assembly stand for the front wheel!

All work must be carried out in accordance with the applicable safety regulations.

After installation

A test drive must be carried out after installation. After the test drive, check that all screws are tight. Inform the customer of the changed ground clearance!

Installation time (1 AW = 5 minutes)

The installation time is **12 AW**

Painting time (1 AW = 5 minutes)

The painting time is **12 AW**

Tools required

- Mounting stand for the front wheel
- Various Allen keys
- Various spanners

Components supplied



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1x engine spoiler S50122419603



1x holder set 19603R12T-H



1x mounting kit 19603R12T-A 2x AC Schnitzer Vitro



Assembly instructions no.: S50122419603 / Date: 24/09/2024 / TSch

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Fitting the AC Schnitzer front spoiler

Note !

The front spoiler cannot be fitted in combination with a centre stand. If necessary, remove main stand according to BMW fitting instructions.

Tip !

Paint AC Schnitzer bracket black if necessary. Use medium-strength threadlocker.

Fig. 1

Secure vehicle securely to the front wheel with BMW mounting stand or similar to prevent it rolling away and falling over.

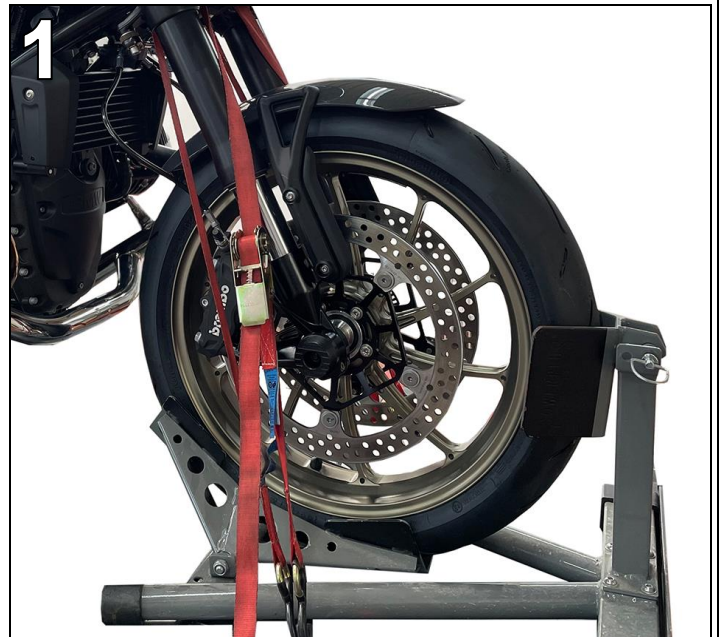


Fig. 2

Fit front bracket (**no. 2**) to front engine block with **M8x90mm** fixing bolt, washers **U8**, **4x16mm**, self-locking **M8** nut and tighten both.

Do not tighten the bracket.



Fig. 3

Fit the rear bracket (**no. 1**) to the rear engine block using the **M8x20mm** fixing screw, **U8** washers, **4x16mm** and tighten both screws.

Do not tighten the holder.



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Fitting the engine spoiler...

Fig. 4 Mount the side bracket (**no. 4**) on the engine block on the left with the **M10x20mm** fastening screw, washers **U10.4x20mm**, as shown and turn both screws.

Do not tighten the bracket.



Fig. 5 Mount the side bracket (**no. 3**) on the motor block on the right with the **M10x20mm** fastening screw, washers **U10.4x20mm**, as shown and screw on both sides.

Do not tighten the bracket.

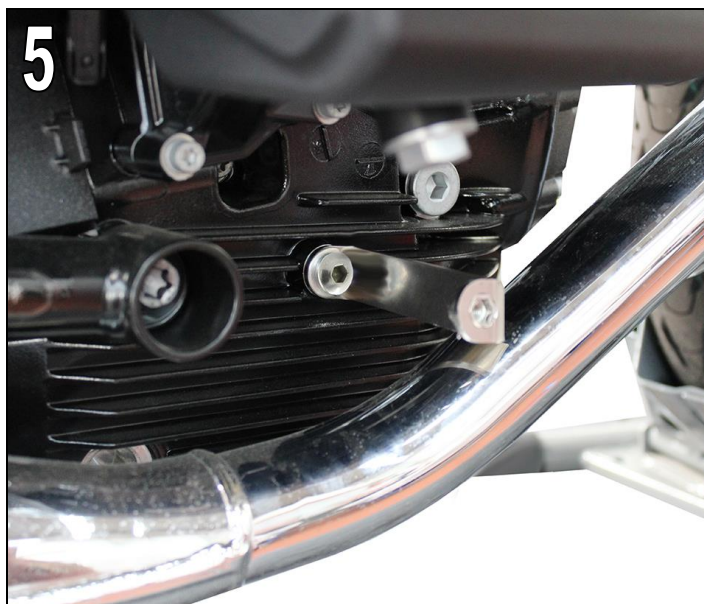


Fig. 6
Loosen the lower standard fastening screw of the starter cover.



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Fitting the engine spoiler...

Fig. 7 Pre-assemble the standard fastening screw with the supplied washer **U5, 4x10mm**, as shown.



Fig. 8 Mount the side bracket (**no. 5**) on the engine block on the left with the standard fastening screw, pre-assembled washers **U5, 4x10mm**, on the starter cowling as shown and screw on both sides.

Do not tighten the bracket.



Fig. 9 to 12

Position and align AC Schnitzer engine spoiler. Screw to the individual brackets using the **M6x20mm countersunk** fixing screws and the countersunk washers.

Do not tighten the fixing screws.



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Mounting engine spoiler...



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Fitting engine spoiler...

Align the AC Schnitzer bracket to the AC Schnitzer engine spoiler and tighten all fixing bolts of the AC Schnitzer bracket.

After alignment...

Tighten all fixing bolts of the AC Schnitzer engine spoiler. Use threadlocker.



Fig. 13 & 14

Glue AC Schnitzer Vitro into the recesses of the AC Schnitzer engine spoiler.

**Advise customer of reduced ground clearance!
Component must be registered!**

Subject to errors, modifications and further technical development
!

Painting instructions



Notes on painting AC Schnitzer components

Before painting, all AC Schnitzer body components on the vehicle must be checked for accuracy of fit (e.g. contact surfaces/contours).

Possible reworking (e.g. re-sanding contact surfaces/contours) should be carried out before painting!

The quality and durability of the paintwork on a component depends on the pre-treatment and external influences and is therefore not comparable with any other body part.

To avoid distortion / deformation during processing and drying, AC Schnitzer components must be placed on an appropriate fixture.

Note!

Please observe the paint manufacturer's painting instructions!

Painting steps:

- | | |
|----------------------|--|
| 1. cleaning: | Plastic cleaner / silicone remover |
| 2. tempering: | 30min. at max. 40° Celsius object temperature |
| 3. check: | Edges and seams of the surface (possibly pores), sand if necessary |
| 4. sanding: | 2K filler P220 - P280 (dry), complete component P400 - P600 (dry) |
| 5. masking: | Adhesive surfaces, TÜV labelling, type plates |
| 6. cleaning: | Silicone remover |
| 7. filling: | 2K HS filler |
| 8. drying: | 1h at max. 40° Celsius object temperature , component should remain in the drying chamber overnight |
| 9. removal: | Masking of type plates, adhesive surfaces and TÜV labelling |
| 10. sanding: | P800 (dry) |
| 11. cleaning: | Silicone remover |
| 12. masking: | Adhesive surfaces |
| 13. painting: | Observe the paint manufacturer's technical data and painting instructions |
| 14. drying: | 1 hour at max. 40° Celsius object temperature , component should remain in the drying chamber overnight |

