

## R53 Splitter for Standard Bumper (Carbon Fiber or Tegrise®)

### Installation Guide

M7 Tuning engineers and manufactures the highest quality MINI accessories and performance parts available anywhere on the planet! Please read these instructions completely BEFORE attempting to install this product. If you are not confident you can do the work described or do not have the tools necessary please contact a local M7 dealer (listed on or website [www.m7tuning.com](http://www.m7tuning.com)) or a local accessory installation center to perform this work.

**Qty-1 M7 R53 Carbon Fiber or Tegrise® Splitter for R53 Standard Bumper**

#### **HARDWARE KIT CONTENTS: #90-1003**

| Qty | M7 P/N     | Description                                 |
|-----|------------|---|
| 12  | 95-9006    | #12 Truss Head Self Tapping Screw (1 extra) |
| 5   | 95-4001    | Expanding Retainer-Black Plastic (1 extra)  |
| 1   | 95-9005    | AVK Insert Tool #10-32                      |
| 2   | 95-5002    | #10-32 Expanding NutSert                    |
| 2   | 95-9007    | APR Strut Rod                               |
| 4   | 95-3005-SS | #10-32 x 3/4" SHCS SS                       |
| 6   | 95-7001-SS | #10 x 3/4" OD Flat fender washer-SS         |
| 2   | 95-8019    | #10-32 Half Height Nyloc Nut                |
| 1   |            | Installation Guide                          |
| 1   | 99-1000    | Sticker Pack                                |

#### **TOOLS NEEDED:**

|                                   |                         |
|-----------------------------------|-------------------------|
| • #2 Phillips screw driver        | • 3/8" open end wrench  |
| • Electric drill                  | • 9/16" open end wrench |
| • 1/4" drill bit (0.250") [6.3mm] | • 7mm open end wrench   |
| • 9/32 drill bit (0.281") [7.1mm] | • 8mm open end wrench   |
| • 3/8" drill bit (0.375") [9.5mm] | • 5/32" Allen wrench    |
| • Masking tape                    | • Pen or Marker         |
| • A friend to help                | • Tape measure or ruler |



**CAUTION:**

**WHEN WORKING UNDER YOUR CAR ALWAYS USE THE RIGHT EQUIPMENT FOR THE JOB. DON'T BE TEMPTED TO TAKE SHORT CUTS OR USE INAPPROPRIATE ITEMS. NEVER WORK UNDERNEATH A VEHICLE THAT IS ONLY SUPPORTED BY A JACK; USE AXLE STANDS OR CAR RAMPS THAT ARE IN GOOD CONDITION AND PROPERLY RATED FOR YOUR VEHICLE'S WEIGHT.**

**INSTALLATION:**

1. Raise your car onto axle-stands or ramps that so you can easily work under the front bumper of your vehicle.
2. Clean the underside of the bumper to remove any loose dirt or damaged hanging plastic bits caused by run-ins with parking lot curbs. A smooth surface is desired.
3. Remove the seven (7) Phillips drive screws holding the underside of the bumper to the splash panel.
4. Place the M7 Carbon Fiber Splitter up to the bottom side of your bumper, align the seven (7) rear-most holes on the splitter with the seven (7) factory holes you removed the screws from and hold in place (A friend is very helpful at this point)
5. Using a ¼" drill bit and the pre drilled splitter as a guide, drill through the bottom of your bumper cover at the four (4) locations shown below. **Be certain the rear holes are aligned correctly with the factory holes before drilling!**



USE THESE 4 HOLES AS A GUID TO DRILL FOR RETAINER CLIPS



**CAUTION: STOP AS SOON AS THE DRILL BREAKS THROUGH. THERE IS LIMITED CLEARANCE ABOVE THE BUMPER COVER.**

6. Remove the splitter and set it to the side.
7. Using a 3/8" drill bit enlarge the four (4) 1/4" holes you just drilled to 3/8" diameter. Do not make the holes any larger than 3/8". Clean away any remaining burrs.



**CAUTION: STOP AS SOON AS THE DRILL BREAKS THROUGH. THERE IS LIMITED CLEARANCE ABOVE THE BUMPER COVER.**

8. Insert the four (4) plastic retainers into the just drilled 3/8" diameter holes. Push the retainers into the holes until they are flush with the bottom side of the bumper. It is a tight fit by design. Do not make the holes any larger than 3/8".

#### **ATTACH THE SPLITTER:**

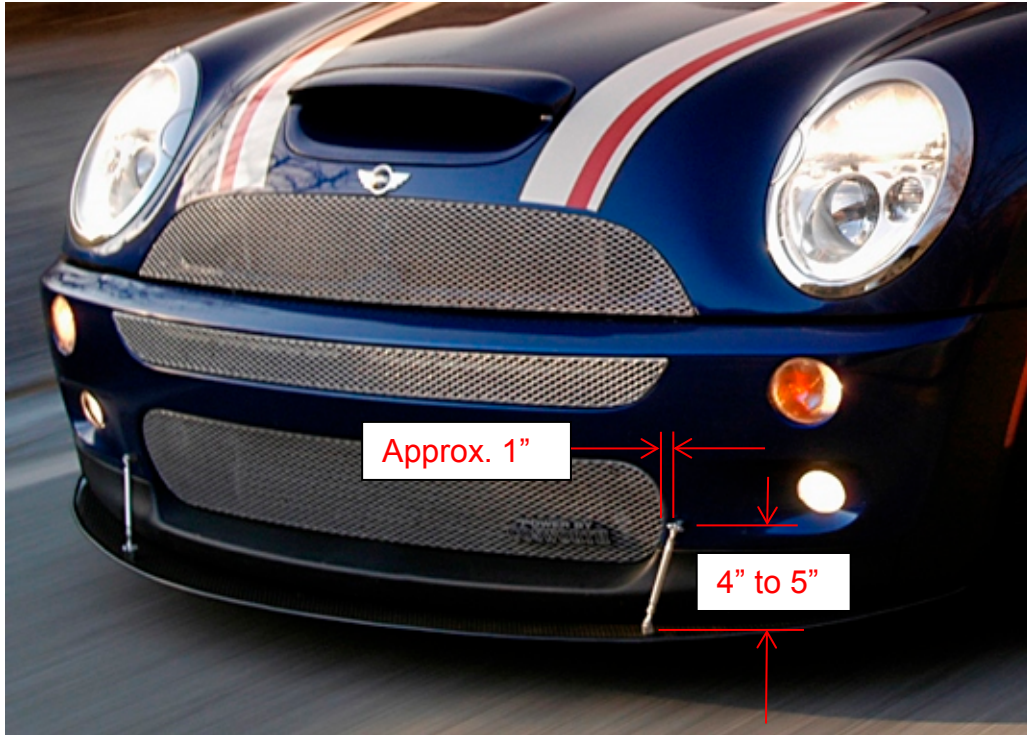
9. Remove the protective plastic layer and apply a coat of wax on the splitter.
10. Place the splitter to the underside of you bumper. Align all the holes and install the supplied Black Truss Head screws in the seven (7) factory holes and in the four (4) installed retaining clips. Be ure to capture all 3 panels when tightening the rear row of screws (Splitter, bumper lower lip & undercarriage splash panel)



**CAUTION: DO NOT OVER TIGHTEN. USE A HAND SCREW DRIVER TO FINAL TIGHTEN. REMEMBER-----YOUR ARE WORKING WITH PLASTIC MATERIALS!**

#### **STRUT ROD INSTALLATION:**

11. Plan where you want your adjustable rod links to connect to your bumper. General placement is approximately 1" either side of the lower grill, 4" to 5" up from the splitter. We advise you apply masking tape in the general area where your attachment points will be on bumper cover before drilling any holes. The strut rod holes are pre-drilled in the splitter for you.



12. Place one end of the strut rod into the pre-drilled hole in the splitter and locate where you want the top of the strut rod to attach to your bumper. Mark this spot on the masking tape. Before drilling any holes mock up the rod to make sure you have enough available strut rod length. Verify the clevis is screwed into each end of the rod at least  $\frac{3}{8}$ " so you have adjustment available when completed. Once everything is as you want it final mark the LS and RS hole locations. Keep the RS and LS symmetrical. **REMEMBER...MEASURE 3 TIMES.....DRILL ONCE**

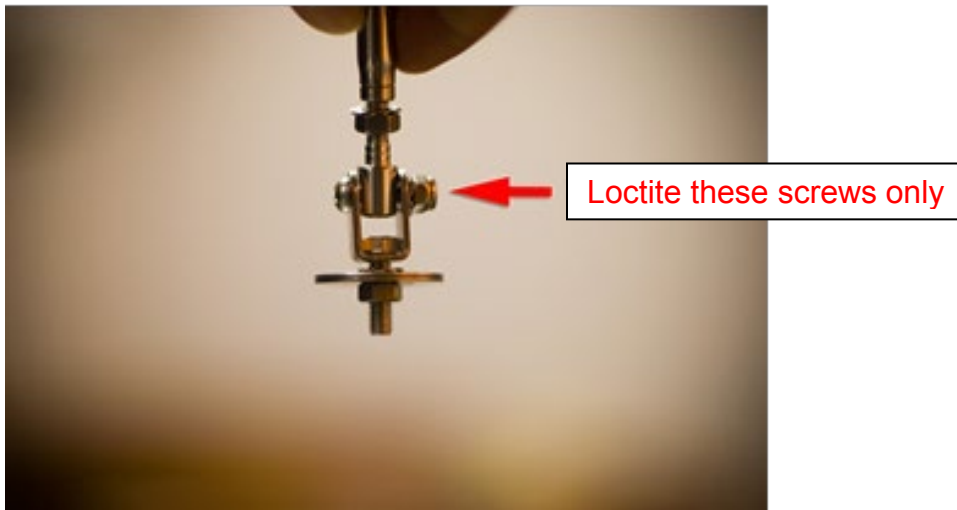
13. Using a  $\frac{9}{32}$ " (0.281") [7.1mm] drill bit, drill one single hole at each of the 2 spots you marked in the prior step. Do not make the holes any larger than the drill.



**CAUTION: STOP AS SOON AS THE DRILL BREAKS THROUGH. THERE IS LIMITED CLEARANCE ABOVE THE BUMPER COVER.**

14. Install the metal threaded insert into the drilled hole flush with the bumper cover. It is a tight fit by design-push until it "snaps" flush with the bumper cover. Follow the instructions included with the tool and tighten to seat the insert in each LS & RS hole. **DO NOT OVER TIGHTEN!**

15. Install the strut rods, align and tighten all hardware and jam nuts. On the splitter end of the strut rod, sandwich the splitter with one (1) flat washer on top and one (1) flat washer on the bottom. Tighter the screws holding the strut rod “U-brackets” to the bumper and splitter to 20 in-lbs (2.2Nm) MAX
16. It is advised you Loctite the four 5mm screws on the rotating joint nuts. If you Loctite any other nuts you will lose the ability to adjust or remove the strut rods in the future.



17. Final align the splitter by shortening or lengthening the strut rods so that it sits horizontal with the ground when your car is on a flat level surface.
18. Check all hardware for tightness and you are Done!

Enjoy the Ride and stay **M7 Tuned**.....

Thank you  
Team M7