

# AC<sup>®</sup> SCHNITZER

**-Fitting Instructions-**

**Front Spoiler**

**– R1200R –**



**Part No.: S51120619603**

# General Notes!



## AC Schnitzer Front Spoiler - R 1200 R -

### Important Notes!

Read these Fitting Instructions carefully before starting installation work. AC Schnitzer bears no liability for damage caused by incorrect installation!

Check goods for completeness and accuracy before fitting. Later complaints cannot be accepted.

These Fitting Instructions are intended for use by an authorised AC Schnitzer dealer.

These Fitting Instructions are directed in each case to specialists trained in BMW vehicles, with corresponding professional knowledge.

The front spoiler must always be fitted to the vehicle individually before painting, and adapted or reworked if necessary.

### **Fitting**

For fitting, secure the vehicle adequately against rolling away or tipping.

For this we recommend the use of an original BMW fitting stand!

### **Fitting Time ( 1 unit = 5 Minutes )**

The fitting time is approx. **9 units**, which may differ depending on condition and equipment level of the vehicle.  
( This value is a recommendation only and is not binding! )

### **Painting Time ( 1 unit = 5 minutes )**

The painting time is approx. **18 units**, which may differ depending on composition of the component.

### **Tools Required**

BMW special tool ( fitting stand )  
Allen key 4mm  
Open-ended/ring spanner SW 10mm  
Open-ended/ring spanner SW 17 mm  
Socket SW 10 mm  
Socket SW 17  
Torx driver  
Pneumatic saw if required

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AC Schnitzer - Motorrad-Technik - Neuenhofstraße 160 - D - 51078 Aachen - Tel. 0241/5688 -300 Fax -135

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# Components Supplied



## AC Schnitzer Front Spoiler - R 1200 R -

( Images = Symbolic images! )



1 X



1 X



1 X



1 X



1 X



2 X



6 X



2 X 6x20 mm



1 X M10



8 X M6



6 X



1 X 10 x90 mm



10 X 6,5 mm



2 X 10,5 mm



2 X

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# Fitting Instructions



## AC Schnitzer Front Spoiler - R 1200 R -

### 2. Fitting the AC Schnitzer Front Spoiler

**Note:**

The front spoiler cannot be fitted in combination with the original BMW main stand. Remove main stand if required following BMW Instructions.

Jack up vehicle securely at the rear wheel using the BMW fitting stand or similar and secure against rolling or tipping with clamps.

Loosely attach front brackets ( No.1 ) to engine block using bolt M10 X 90mm, washer and M10 nut ( Fig.1 ).

**Note:**

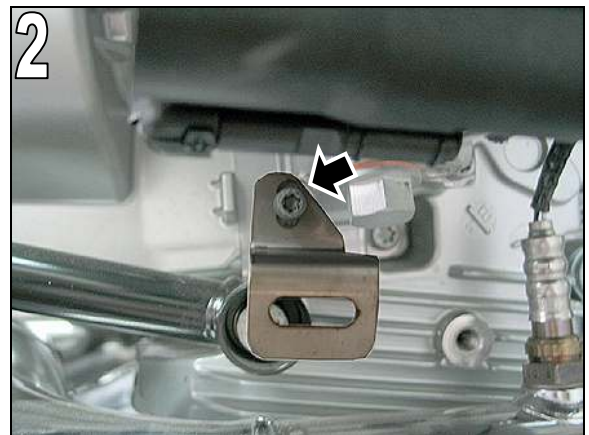
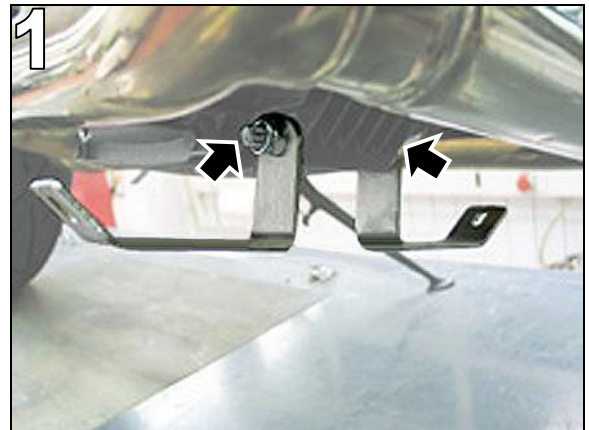
The brackets are asymmetrical, check fitting direction and reverse if necessary.

Mount bracket ( No.3 ) on right in direction of travel as shown; to do this, unscrew the standard Torx bolt and loosely screw on the bracket ( Fig.2 ).

Mount bracket ( no.5 ) on right in direction of travel as shown ( rear ), by attaching the rubberised pipe clamp supplied to the cross strut and attaching the bracket loosely using the M6x20mm bolt, 6.4mm washer and self-locking nut ( M6 ) supplied ( Fig. 3 ).

**Note: The rear right and rear left brackets are different; swap over if necessary!**

Mount bracket ( No.4 ) on left in direction of travel as shown ( rear ), by attaching the rubberised pipe clamp supplied to the cross strut and attaching the bracket loosely using the M6x20mm bolt, 6.4mm washer and self-locking nut ( M6 ) supplied ( Fig. 4 ).



# Fitting Instructions



## AC Schnitzer Front Spoiler - R 1200 R -

### 2. Fitting the Front Spoiler... ( cont'd. )

Mount bracket ( No.2 ) on left in direction of travel, unscrewing the standard bolt and loosely attaching the bracket with the bolt ( Fig. 5 ).

Place the front spoiler on the vehicle and attach using the countersunk head bolts, countersunk washers, 6.5mm washers and self-locking nuts supplied, align and fasten ( Fig. 6 ).

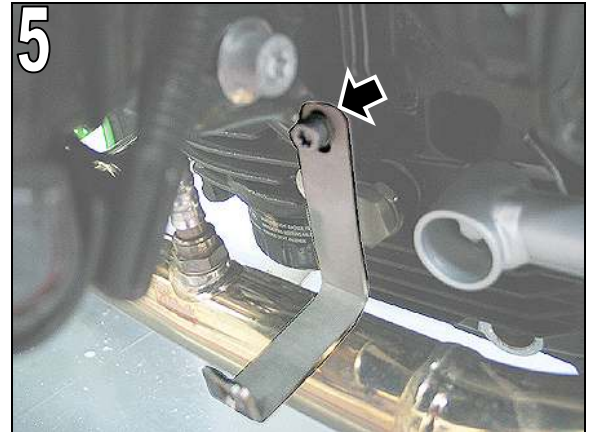
After aligning the front spoiler, definitively tighten all brackets on the vehicle. Ensure a sufficient clearance from all relevant parts. Then remove the front spoiler again and paint. See separate painting instructions.

For use on the race track or under high thermal loads, we recommend opening the front spoiler at the front to allow more cooling to the engine / silencer. For this, ideally before painting, cut out the front spoiler as shown on the front using a pneumatic saw or similar. Cover the opening with a suitable means [grille or similar ( not included in package! )]. ( Fig. 7 ).

After painting, place the dried front spoiler on the vehicle and attach fully. After a test ride, check for firm seat and adequate clearance.

**Draw your customer's attention to the modified ground clearance!!**

Subject to errors, technical refinements and modifications!



# Painting Instructions



## Notes on Painting AC Schnitzer Components

### General Preparations:

- Before starting work, temper the AC Schnitzer components; to do this, heat the components for 15 minutes at 40° to 50° Celsius, ensuring the components are placed on suitable jigs to prevent distortion!
- After cooling, clean the components thoroughly using Universal Cleaner (Glasurit No.: 541-30)!
- Dry sand the components with "Red Sanding Pad" (3M), smoothing down or removing seams and edges with 150 grade abrasive paper.
- Mask off contact surfaces, rating plates and TÜV markings on the components with masking tape or similar so that no filler residue remains on the surfaces concerned.
- Clean the components thoroughly again using Universal Cleaner (Glasurit No.: 541-30), rub down with a damp sponge (to prevent static charges) and allow to dry.

**Fillers:**                      **Mixing ratio for filler: 4 parts "filler", 1 part "hardener" and 1 part "thinner"**

**Filler (\*):**                      **Glasurit - HS Filler No.: 285-60**  
**Hardener:**                      **Glasurit - Filler Hardener – very short – No.: 929-28/2**  
**Thinner:**                      **Glasurit - Thinner No.: 352-91**  
**(\*) = for aluminium parts: Use Glasurit - EPOXY Filler No.: 8011552!**

- Mix the filler as specified above, and prefill broken and rounded edges and seams twice. Then fill the entire component twice (including edges and seams!).
- Heat components to 40° to max. 45° Celsius for one hour and leave to dry.
- Check components for pores (holes), if necessary puncture or cut away blisters, fill with plastic stopper (Glasurit Ratio No.: 83920) and leave to dry.
- Remove masking tape!

### Painting:

- Wet sand the entire component with 800 grade abrasive paper.
- Blow off component with compressed air, then clean with Universal Cleaner (Glasurit No.: 541-30).
- Rub down component with damp sponge (to prevent static charges) and allow to dry.
- Only now mask off the contact surfaces (not the rating plates and TÜV markings) with masking tape.
- In the spray booth, blow off component again lightly and rub down carefully with a dust cloth.

**Mixing ratio for base coat: 1 part "paint" and 1 part "thinner"!**

**Paint (produce to BMW number):**                      **Glasurit - Two Coat Cover, 55 line**  
**Thinner:**                      **Glasurit - Thinner No.: 352-91**

- Depending on shade, apply the prepared paint in two to four cross sweeps.
- Allow to flash off at 20° Celsius for approx. 15 minutes (base paint is then completely matt).

**Mixing ratio for clear: 2 parts "clear", 1 part "hardener" and 1 part "thinner"**

**Clear:**                      **Glasurit - MS Clear No.: 923-155**  
**Hardener:**                      **Glasurit - Hardener MS short no.: 929-71**  
**Thinner:**                      **Glasurit - Thinner No.: 352-91**

- Apply the mixed clear in 1½ cross sweeps!
- **Note: Do not use "adhesion agent" or "softface" (softener)!**

### Drying:

- AC Schnitzer recommends: Paint components the night before and leave to dry over night at room temperature or for at least 8 hours at max. 30° Celsius. If this is not possible, allow the components to dry for two hours at 40° to max. 45° Celsius (watch for component distortion!).
- After drying, wet sand any dust inclusions with 2000 grade abrasive paper and polish the entire component.

## Further AC Schnitzer Products



### AC Schnitzer Sports Silencer

With EC approval, suitable for standard cat / pre-silencer. The silencer is fitted with a removable sound insert

**Item number: S8102 101054L**

Not shown: AC Schnitzer High Performance Manifold without cat (not in combination with front spoiler)

**Item number: 0101 088206**

### AC Schnitzer Cardan Crashpad

If you come off: the AC Schnitzer crashpad protects the linkage and final drive from possible damage.

- Small part, big effect! -

**Item number: S50120661013**



### AC Schnitzer Mirror Enlargements

Expanded field of vision to observe traffic behind.

Available for almost all BMW models, exclusively from AC Schnitzer!

Further information is available by calling our Sales Centre.

**Item number: BK 02**