



M7 Speed
Ultimate MINI Performance

Installation Guide

Splitter for R55-R57 MINI Cooper with Factory JCW (Aero) Front Bumper (Model years 2007-2010) PN 56-4M7102, 56-4M7602

M7 Speed 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) or a local automotive accessory installation center to perform this work.

CONTENTS:

Qty	M7 P/N	Description
2	95-2034-SS	M6x20mm lg Button Head Screws-SS
4	95-3004-SS	#10-32 x5/8" SHCS SS (installed in Support Rod)
7	95-4001	Expanding Retainer-Black Plastic (1 extra)
3	95-5001	#10-32 Expanding NutSert (Gold Zinc)
7	95-7001-SS	#10 x 3/4" OD Flat Washer SS
4	95-7026-SS	M6 Fender Washer-SS
2	95-8013-SS	#10-32 Standard Nyloc Nut SS
2	95-8051-SS	M6 Nyloc Nut SS
1	95-9005	AVK Insert Tool #10-32
7	95-9006-BZ	#12 Truss Head Self Tapping Screw (1 extra)
2	95-9012	Support Rod
1	96-1157	1" Delrin Spacer
1	96-2010-SS	#10-32 x 1-3/4" lg Button Head Screws-SS

TOOLS NEEDED:

- #2 Phillips screw driver (power nut driver recommended)
- Electric drill
- 1/8" drill bit
- 1/4" drill bit
- 3/8" drill bit
- 3/8" open end wrench
- 7mm open end wrench
- 8mm open end wrench
- 10mm open end wrench
- 5/32" Allen wrench
- 3mm Allen wrench
- Masking tape, tape measure and a sharpie
- A friend to help



M7 Speed
Ultimate MINI Performance



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. Place a piece of masking tape on your bumper nose at the point it wraps and goes underneath. Measure the grill opening and divide by 2 to determine the centerline of the bumper. (Grill width/2) Mark this point on the masking tape.
4. Place a piece of masking tape at the center of the splitter. Measure the overall width and divide by 2 to determine the centerline of the splitter. Mark this point on the masking tape.
5. Place the Splitter up to the bottom side of your bumper, aligning the back edge of the splitter with the rear vertical lip on your bumper and the centerline marks on the bumper and splitter. Position the splitter so there is no gap between the splitter and the back edge on the underside of your bumper. (A friend is very helpful at this point)
6. Using a ¼" drill bit or a silver Sharpie® and the splitter as a guide, mark the bottom of your bumper cover at the seven (7) locations shown below. See Figure #1. **Check three (3) times that the marks and the splitter are aligned correctly before drilling!**

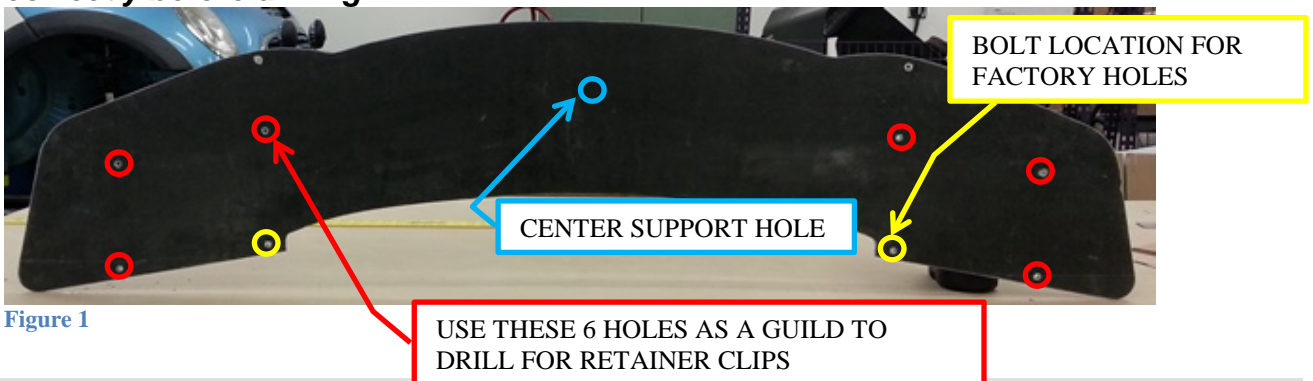


Figure 1



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

7. Remove the splitter and set it to the side.
8. Drill the six (6) **RED** holes with a 1/8" or 1/4" drill first. Then final drill using a 3/8" drill bit to enlarge the six (6) holes you just drilled. 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.

9. Locate the center hole highlighted in **BLUE** in Figure#1. Using 1/4" drill bit drill up through the black underside bumper cap. STOP as soon as the drill cuts through the first layer of plastic. **Do not make this hole any larger than 1/4"**.
10. Insert the six (6) plastic retainers into the 3/8" **RED** holes. Push the retainers into the holes until they snap in and 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".
11. Install one (1) gold #10-32 threaded insert into the 1/4" **BLUE** hole flush with the bumper cover. Follow the instructions included with the AVK tool and tighten to seat the insert into the hole.



ATTACH THE SPLITTER:

12. Remove the masking tape from the splitter and bumper. Place the splitter to the underside of your bumper.
13. Using the two (2) factory provided holes (hole locations are identified with a **YELLOW** circle in figure #1) install two (2) M6 x 20mm long button head screws in the two (2) rear holes of the splitter. Place one supplied stainless steel flat washer on the splitter side and one on the bumper side and install the nut through the factory provided hole. Install the screws from the bottom side up. Do not tighten.
14. Align all the holes and install the supplied Truss Head screws in six (6) hole locations identified with the **RED** circles and into the black plastic retaining clips.
15. Slide the 1" black plastic spacer between the splitter and the bottom of the bumper cover aligning the center hole in the splitter, the spacer and the bumper. Insert the #10-32 x 1- $\frac{3}{4}$ " long screw and one (1) flat washer from the bottom side up through the splitter and spacer and thread it into the gold threaded insert located in the bottom of the bumper cover. Tighten all the fasteners once you are satisfied with the splitter position.



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

STRUT ROD INSTALLATION:

16. 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 $\frac{3}{4}$ " up from the splitter. We advise you apply masking tape in the general area where your attachment points will be on bumper cover to mark this location before drilling any holes. The strut rod holes are pre-drilled in the splitter for you.

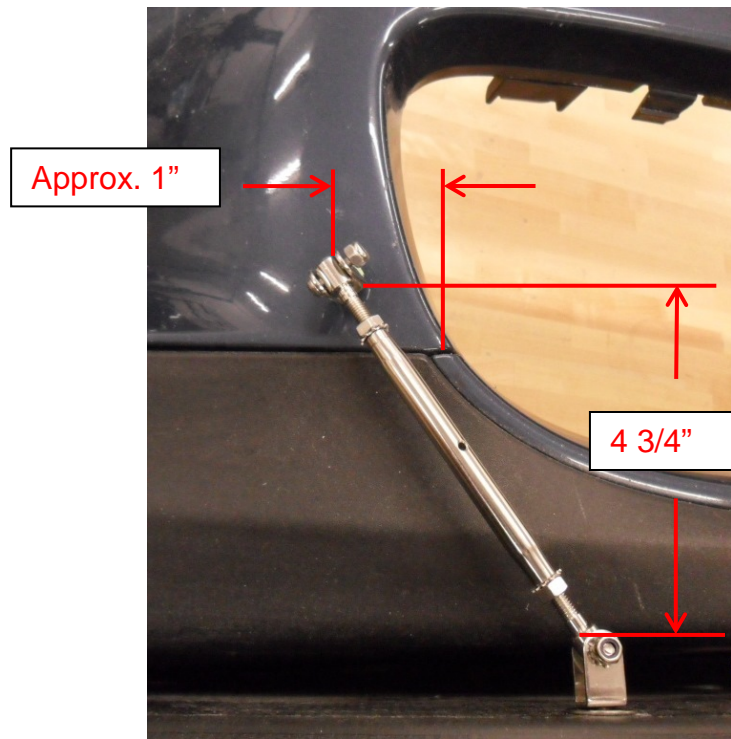


Figure 2

17. Place one end of the strut rod into the pre-drilled hole in the splitter and locate where the top of the strut rod will attach to your bumper. (1" & 4 3/4" dimensions) See Figure #2.

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 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**

18. Using a 1/4" drill bit, drill one single hole at each of the 2 spots you marked on the bumper in the prior step. Do not make the holes any larger than 1/4".



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

19. Install the threaded insert into the 1/4" hole flush with the bumper cover. Follow the instructions included with the tool and tighten to seat the insert in each LS & RS hole.

20. Install the strut rods. 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. On the bumper end use one (1) stainless steel flat washer between the strut rod u-bracket and the threaded insert you installed in the bumper. Once everything is aligned tighten all hardware and jam nuts. Tighten the screws holding the strut rod to the bumper and splitter to 20 in-lbs (2.2Nm) MAX
21. 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. See Figure #3

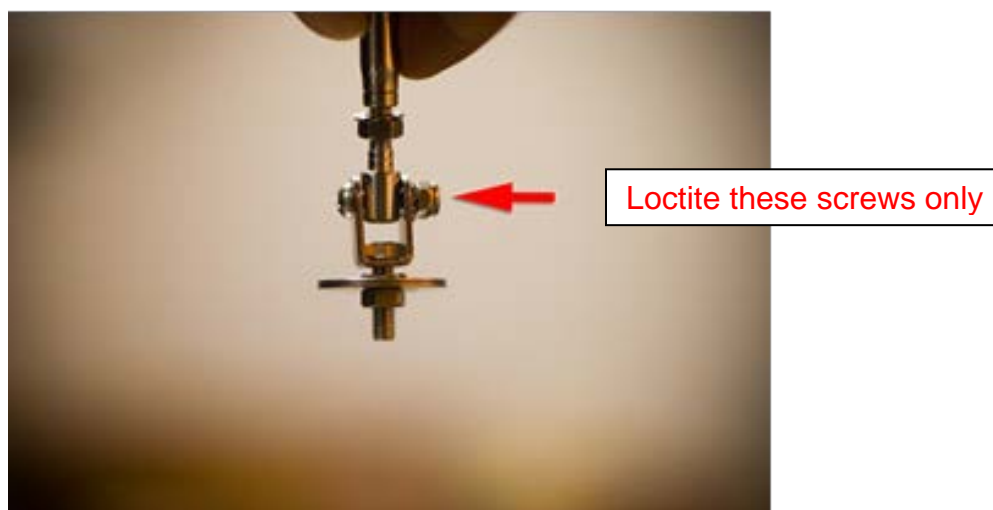


Figure 3

22. 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 and no free play is noticeable.
23. Check all hardware for tightness and you are Done!

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

Thank you
Team M7