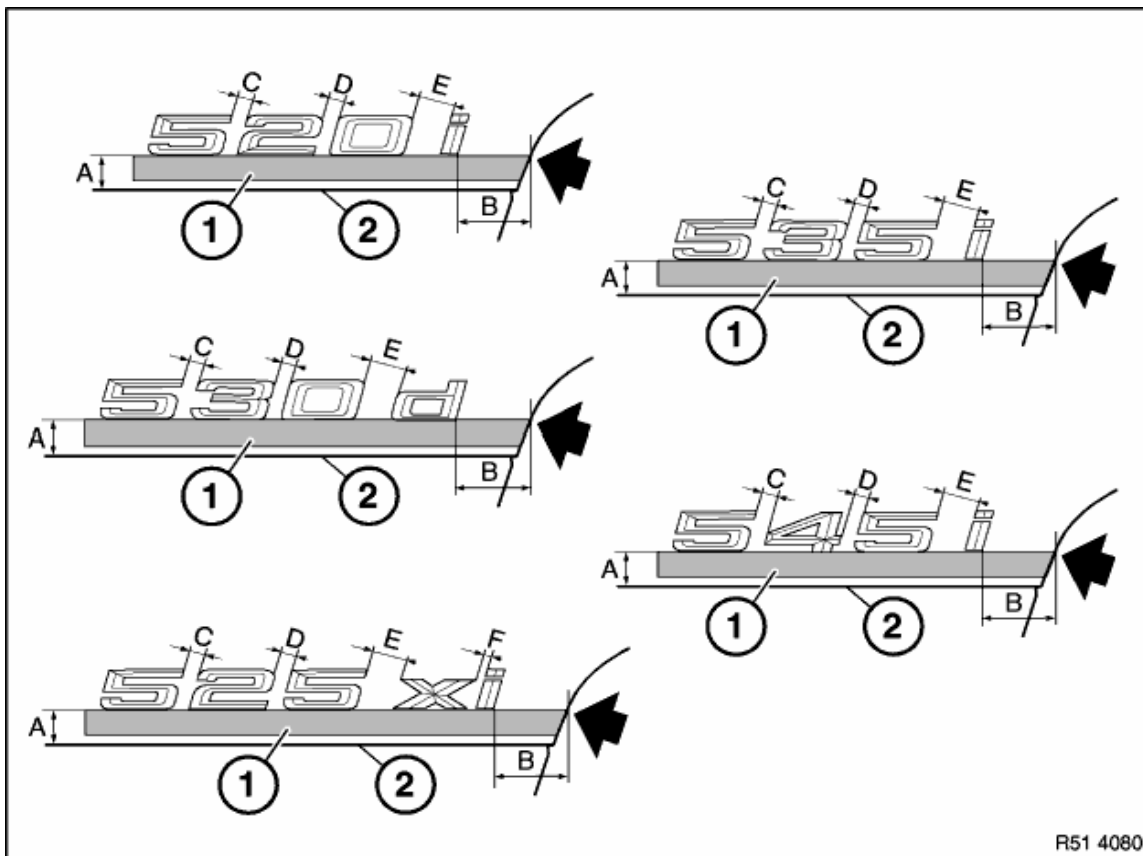


**Important!**

The "Instructions for number/letter combination cementing" serve as the basis for these repair instructions and must be followed without fail.

**Fitting dimensions (E60, E61):**

R51 4080

Stick on adhesive tape (1) between edge of rear lid (2) and top edge "A". Mark measurement "B" from top edge "A" to outer edge of rear lid on adhesive tape (1).

**Dimensions:**

E60	A = 18 mm	B = 40 mm
E61	A = 17 mm	B = 31.5 mm

**Note:**

Measurements C, D and E are for information purposes only, as determined by carrier film.

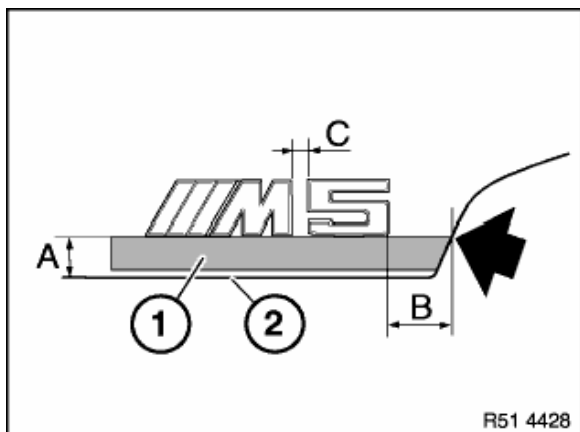
**520 i...540 i, 550 i:** C = 7 mm, D = 7 mm, E = 20 mm

545 i: C = 4 mm, D = 5 mm, E = 20 mm

520 d...535 d: C = 7 mm, D = 7 mm, E = 20 mm

525 xi...535 xi: C = 7 mm, D = 7 mm, E = 20 mm, F = 5 mm

525 xd...530 xd: C = 7 mm, D = 7 mm, E = 20 mm, F = 5 mm



### M5 only

Attach adhesive tape (1) between edge of rear lid (2) and top edge measurement "A".

Mark out measurement "B" from top edge "A" to outer edge of rear lid on adhesive tape (1).

### Measurements E60:

A = 24 mm

B = 33 mm

### E61 dimensions:

A = 22 mm

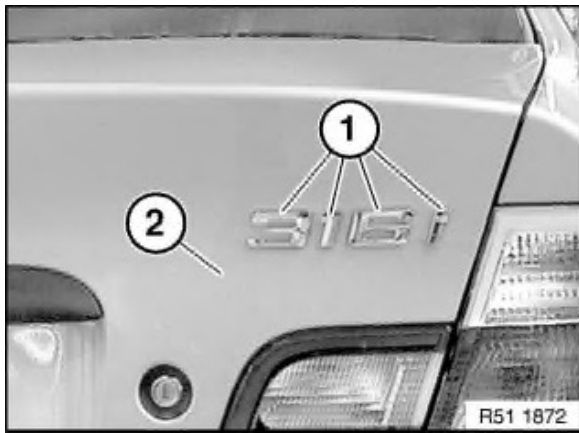
B = 20 mm

### Note:

Measurement C is for information purposes only, as it is determined by carrier film.

C = 9 mm

The following work steps are described using the "316 i" as the example.

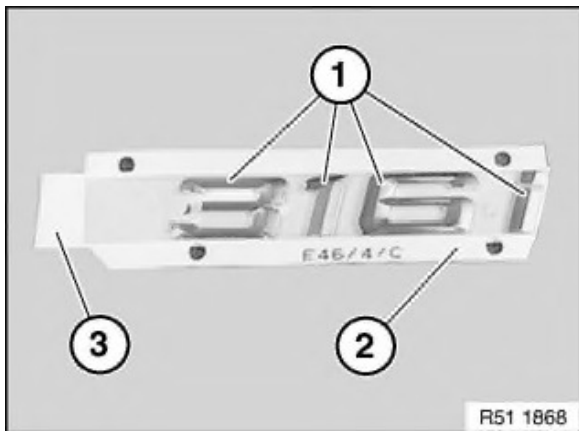


#### Removing:

Coat nylon string or strong yarn with tensides (e.g. washing-up liquid).

Cut through adhesive layer and remove model designation (1) from rear lid (2).

Remove remainder of adhesive layer with adhesive remover (sourcing reference: BMW Parts Service).



#### Assembly:

Number and letter combinations (1) of the model designation are not connected to each other and are supplied on a carrier film (2).

#### Important!

Adhesive areas must be dry and free of dust and grease.

Once it has been cleaned, do not touch the adhesive area with bare hands.

Remove liner (3) (protective strip for adhesive surface).

Press on model designation firmly.

Remove carrier film (2).