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This Service Information bulletin supersedes SI 51 05 10 dated **January 2010**.

**PERFORM THE PROCEDURE OUTLINED IN THIS SERVICE INFORMATION ON ALL AFFECTED VEHICLES BEFORE CUSTOMER DELIVERY OR THE NEXT TIME THEY ARE IN THE SHOP FOR MAINTENANCE OR REPAIRS.**

**Under the National Traffic and Motor Vehicle Safety Act of 1966, as amended, if there has been a recall campaign, dealers must assure that all new vehicles and new items of replacement equipment are free of safety defects and comply with all applicable Federal Motor Vehicle Safety Standards at the time of delivery to the consumer. This means that dealers may not deliver new motor vehicles or new items of replacement equipment to consumers unless the safety defect or noncompliance has been remedied before delivery.**

**NEW** designates changes to this revision

#### SUBJECT

**NEW**

### Recall Campaign 10V-025: Remove and Install the Windshield

#### MODEL

E70 (X5)

E71 (X6)

#### SITUATION

The windshield may have been improperly bonded into the vehicle during assembly. As a result, the rigidity of the body in this area may not be sufficient.

#### AFFECTED VEHICLES

**NEW** This Recall involves E70 and E71 which were produced on December 14-16, 2009.

In order to determine whether a specific vehicle has had this Recall completed or is affected by this Recall first check the B-pillar label for code number **556**. If code number **556** has been punched out, the campaign has already been performed. If code number **556** has not been punched out, it will be necessary to utilize the "Service Menu" of DCSnet (Dealer Communication System) or the Key Reader. Based on the response of the system, either proceed with the corrective action or take no further action.

#### CORRECTION

Remove and install the existing windshield.

#### PROCEDURE

- Carefully remove and reinstall the windshield per Repair Instruction REP 51 31 000.
- The windshield must be removed using the "Roll Out 2000" wire cutting system, per Repair

Instruction REP 51 31...

## NOTES:

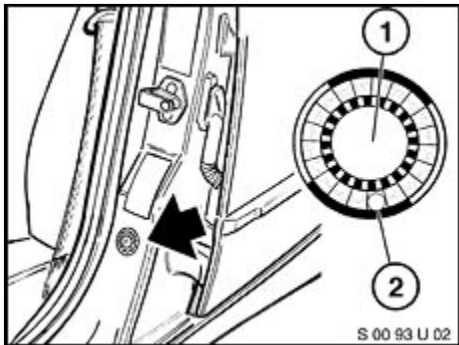
- **NEW** The windshield and associated trim should not be damaged during removal, and should be reused. No parts should be replaced under this Recall.
- For additional information on the Roll Out 2000 system, refer to [SI B04 26 03](#).
- If tape is used on the windshield flange during installation, it must be positioned such that it does not overlap the adhesive bead, or interfere with the bond between the glass and adhesive bead.
- For affected vehicles retailed prior to the center receiving this SIB, a customer letter will be sent out.

## PARTS INFORMATION

Part Number	Description	Quantity
83 19 0 444 141	Windshield replacement kit – 1 hour	1
83 19 0 444 144	Windshield adhesive cartridge – 1 hour	1*

\*NOTE: Since approximately 1.5 cartridges of adhesive are required, 1 of each part number listed above should be used. Only if the individual adhesive cartridge is unavailable in the US, a second replacement kit may be ordered.

## LABEL INSTRUCTIONS



This Recall has been assigned code number **556**. After the vehicle has been checked and corrected, if necessary, obtain a label (SD 92-366) and:

- Emboss your BMW dealer warranty number in the middle of the label (1);
- Punch out code number **556** printed on the label; and
- Affix the label to the **B**-pillar as shown.

If the vehicle already has a label from a previous Service Action/Recall Campaign, affix the new label next to the old one. Do not affix one label on top of another one, because a number from an underlying label could appear in the punched-out hole of the new label.

## WARRANTY INFORMATION

**NEW** The repair described in this bulletin is covered under warranty regardless of time or mileage. Reimbursement for this Recall will be via normal claim entry utilizing the following information:

**Defect Code:**                    **00 51 63 02 00**

**Labor Operation:**            **Labor Allowance:**            **Description:**

00 58 308*	35 FRU	Remove and reinstall the windshield
+ 00 58 988	33 FRU	Remove and reinstall the windshield

\*Main Work - use this labor operation number when this is the only repair being performed, or if this is the main repair when performed along with other repairs at the same time. If this is not the main repair, refer to KSD for the associated (+) labor operation code.

Sublet Code 4**	Actual amount	** Reimbursement of up to the amount listed may be charged to sublet code 4 for the windshield adhesive kit and additional adhesive cartridge (P/N 83 19 0 444 141/144) required to perform this repair. Claiming this part number outside of sublet code 4 will result in a delayed or denied claim payment.
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