



SIB 65 06 20

2020-05-06

**RECALL CAMPAIGNS 19V-852 AND 19V-853: INSPECTION
PERFORMED AND DRIVER'S FRONT**

Please perform the procedure outlined in this Service Information on all affected vehicles before customer delivery. In the event the customer has already taken delivery of the vehicle, please perform the procedure the next time the vehicle is in the shop.

This Service Information Bulletin (Revision 1) replaces SI B65 06 20 **dated February 2020.**

What's New (Specific text highlighted):

- Limited parts are now available
- Entire SIB updated except Model
- Attachments added

MODEL

E-Series	Model Description	Production Date
E46	3 Series	February 17 1998 – July 14, 2000

AFFECTED VEHICLES

Vehicles which require this Recall Campaign to be completed will show it as Open” when checked either in AIR, the Service Menu of DCSnet (Dealer Communication System), ISPA Next or Warranty Vehicle Inquiry.

SITUATION

BMW AG is conducting a Voluntary Safety Recall (effective December 4, 2019) on certain Model Year – 1999-2001 BMW vehicles that were produced between February 17, 1998 – July 14, 2000. These vehicles require a new air bag inflator to be installed.

This bulletin is for vehicles which already had the inspection process completed but due to a lack of parts availability, have not yet had a new air bag inflator installed.

OTHER AIR BAG-RELATED FAULTS AND REPAIRS

This Recall applies to an operational driver's front air bag. The issue addressed will not cause an air bag (SRS) malfunction light to illuminate. It will also not prevent the system from deploying in a front-end collision.

However, a recalled vehicle can arrive at your center with an air bag malfunction light illuminated.

It is important to notify the customer that diagnosing other air bag-related system issues may be required and this diagnosis and corresponding repair work, **if needed, is not covered by this Recall.**

In this case, replacing the driver's front air bag module will not correct the other fault code(s).

CAUSE

The single-stage Takata Non-Azide Driver Inflator (NADI) may have been produced with an insufficient seal that could allow moisture to enter the inflator.

CORRECTION

Replace the driver's front air bag inflator/gas generator.

In the following cases the inflator/gas generator replacement should not be done and instead the complete air bag assembly must be replaced:

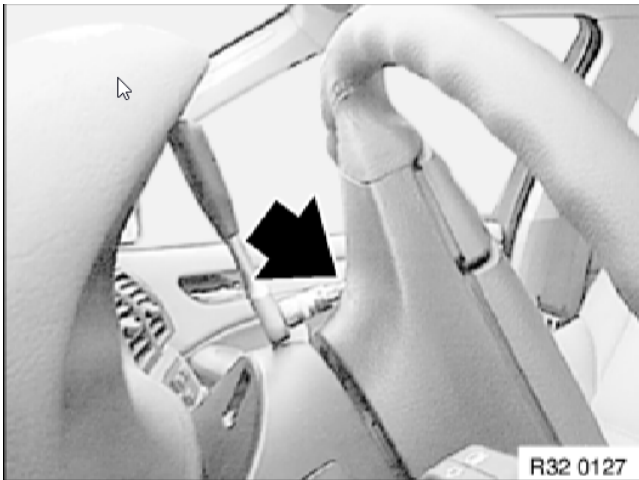
- Threaded bolts are damaged
- Threaded bolts are bent or corroded
- The generator cannot be removed from the air bag without excess force
- If the target tightening torque of the nuts cannot be achieved (5 Nm in a star pattern sequence)
- If there is a gap between the generator & air bag that is not closed-up when tightening the nuts
- If there is damage to the air bag cover that may impede deployment of the air bag

If an entire air bag assembly is required but parts are not available, please contact BMW Customer Relations at 1-800-525-7417 for further support.

Note: Before proceeding with the Recall air bag inspection procedure, please first review the Repair History (Claims) section in the DCSnet Warranty Inquiry for the affected vehicle to see what air bag category was claimed.

- If the vehicle has a category 2 air bag, no further action is needed until the replacement part becomes available
- If the vehicle has a category 1 air bag, you can proceed with repair.

PROCEDURE

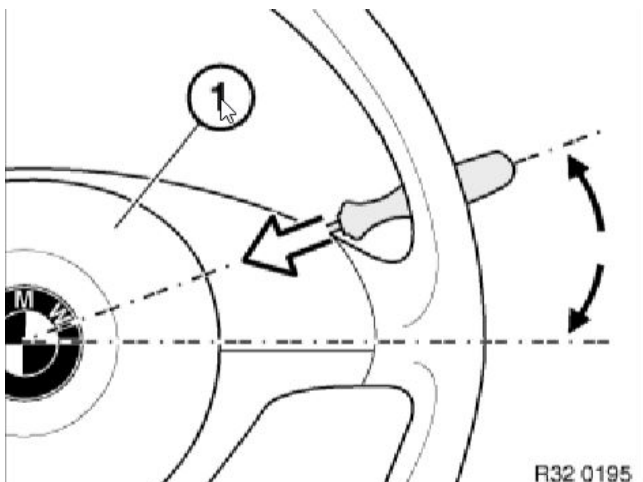


Follow all safety precautions when handling air bags.

Remove **Basic Drivers air bag** as per

REP 32 34 020 "Removing and installing/replacing airbag unit"

OR



Remove **Sports Drivers air bag** as per

REP 32 34 020 "Removing and installing/replacing the airbag unit (sports steering wheel, inserted airbag unit)"

The serial number of the removed gas-generator AND the new gas-generator must both be stated on the repair order and in the comments section of the warranty claim.

- Refer to [SI B65 03 20](#) for details on how to replace a gas generator.
- See the attached Checklist for gas generator replacement.

PARTS INFORMATION

Please monitor the Parts Matrix for ordering procedure.

Only use and invoice the part numbers below that apply.

Performing a part number look-up in ETK (EPC) by VIN or model in place of using/invoicing the following part numbers may result with the wrong part numbers being invoiced and installed. This could delay the payment of claim.

Part Number	Description	Quantity
32 30 5 A1B D99	Gas Generator repair kit	1
TBD	Air Bag	1 (if required)

PARTS RETENTION AND RETURN

Recalled parts that are removed from BMW vehicles cannot be used for resale!

The parts replaced to perform and submit for this Recall repair procedure are the property of BMW NA.

Your center is responsible for the proper identification, storage and documentation of these parts. They must be held in a secure retention area until notification of claim payment is made by BMW NA through DCSnet.

Upon claim payment and based on the replacement front air bag component part number claimed, a DCSnet part return tag will be generated with special handling instructions.

Please DO NOT return these recalled air bag components to the Warranty Parts Return Center (WPRC).

Inflatable air bags are classified as dangerous goods by the Department of Transportation (DOT) and require special preparation, packing and labeling for transport.

Your center is responsible for following all rules and regulations that apply to shipping dangerous goods as described in the attachment.

A shipping procedure has been created for returning the replaced air bag modules directly to Takata. There is also a procedure available for Bulk Shipping 15 or more air bag modules at one time to Takata.

These procedures are contained in the Part Return Program Instructions and Bulk Ship PDF attachments to this bulletin; please read both of them. Effective immediately, please use the following email address when scheduling bulk shipment returns to Takata:

Scfieldaction.14305@xpo.com

The parts are to be packaged in the same packaging that the new part arrived in for shipment back to Takata.

The returns pickup schedule has been changed from weekly to every two weeks (bi-weekly).

WARRANTY INFORMATION

Reimbursement for this Service Action will be via normal claim entry utilizing the applicable work package information below, and when applicable, the part number listed above that applies.

Plus work	Vehicle is already in the workshop for another repair
Main work	The vehicle arrives at your center and this Recall Campaign shows open (No other Main work will be performed/claimed during this workshop visit)

Category 1 vehicles - Inspect the air bag and the gas generator is replaced (Recall can be CLOSED)-

Defect Code:	0032110300	E46 Rework driver's airbag	
Work Pkg	Labor Operation	Description	Labor Allowance
# 1	00 69 589	Checking the driver's airbag and replacing the gas generator (category 1) (Plus work)	7 FRU
Or:			
# 2	00 69 084	Checking the driver's airbag and replacing the gas generator (category 1) (Main work)	8 FRU

Category 1 vehicles – The gas generator repair cannot be performed, future air bag module replacement is required (Recall remains OPEN)-

Defect Code:	3234900300	E46 Driver's airbag NADI - test result	
Work Pkg	Labor Operation	Description	Labor Allowance
# 3	00 68 814	Check, the necessary gas generator repair cannot be performed, future driver's airbag module replacement required (category 1) (Plus work)	3 FRU
Or:			
# 4	00 68 230	Check, the necessary gas generator repair cannot be performed, future driver's airbag module replacement required (category 1) (Main work)	5 FRU

Only one of the flat rate labor operation codes listed above can be used for claim submission/reimbursement purposes. Also, only one Main work flat rate labor operation code can be claimed per workshop visit.

Claim Repair Comments

Only reference the SIB number and the work package (Pkg) number performed in the RO technician notes and the claim comments (For example: B65 06 20 WP 1), unless otherwise required by State law.

Reimbursement of Prior Customer-Pay Repairs (TREAD Act)

With this Technical Campaign, a prior repair reimbursement is not likely. Typically, a customer would have the driver's front air bag module replaced as a result of an accident. In such a case, either an insurance company or the customer themselves paid for the replacement of the above mentioned air bag module in

conjunction with the accident repairs. Such cases are not covered by this campaign and are not entitled to reimbursement.

Supporting Materials

[picture_as_pdf B65 06 20 Checklist.pdf](#)

[picture_as_pdf B65 06 20 REP 32 34 020 R I airbag unit.pdf](#)

[picture_as_pdf B65 06 20 Parts Bulk Ship Return.pdf](#)

[picture_as_pdf B65 06 20 REP 32 34 020 R I airbag sport.pdf](#)

[picture_as_pdf B65 06 20 Parts Return Program Instructions.pdf](#)

Air Bag Generator Replacement E46

Conditions:

- The Generator replacement should always be carried out by the same Technician(s)
- Make sure your hands and clothes are clean and free of foreign objects
- Only one vehicle at a time should have this work performed
- This repair should be done from beginning to end without interruption
- Interruptions of any kind are not permitted

Safety:

- Notes on Electrostatic Discharge (ESD) must be observed. (see REP-RAGRP61-6135ESD)
- Do not measure or touch the electrical terminals on the Generator
- Handle Generator with caution
- If the Generator should fall or be damaged, it must be replaced
- Do not allow any foreign objects to enter the Air Bag cavity while the Generator is removed

Order Acceptance:

- The Air Bag cover & steering wheel should be inspected in the presence of the customer prior to repair
- Record the condition of the Air Bag on the Repair Order
- The Repair Order must be signed by both the 1st and 2nd Technician. Two technicians are required for the "4 eyes" inspections.

Working Position:

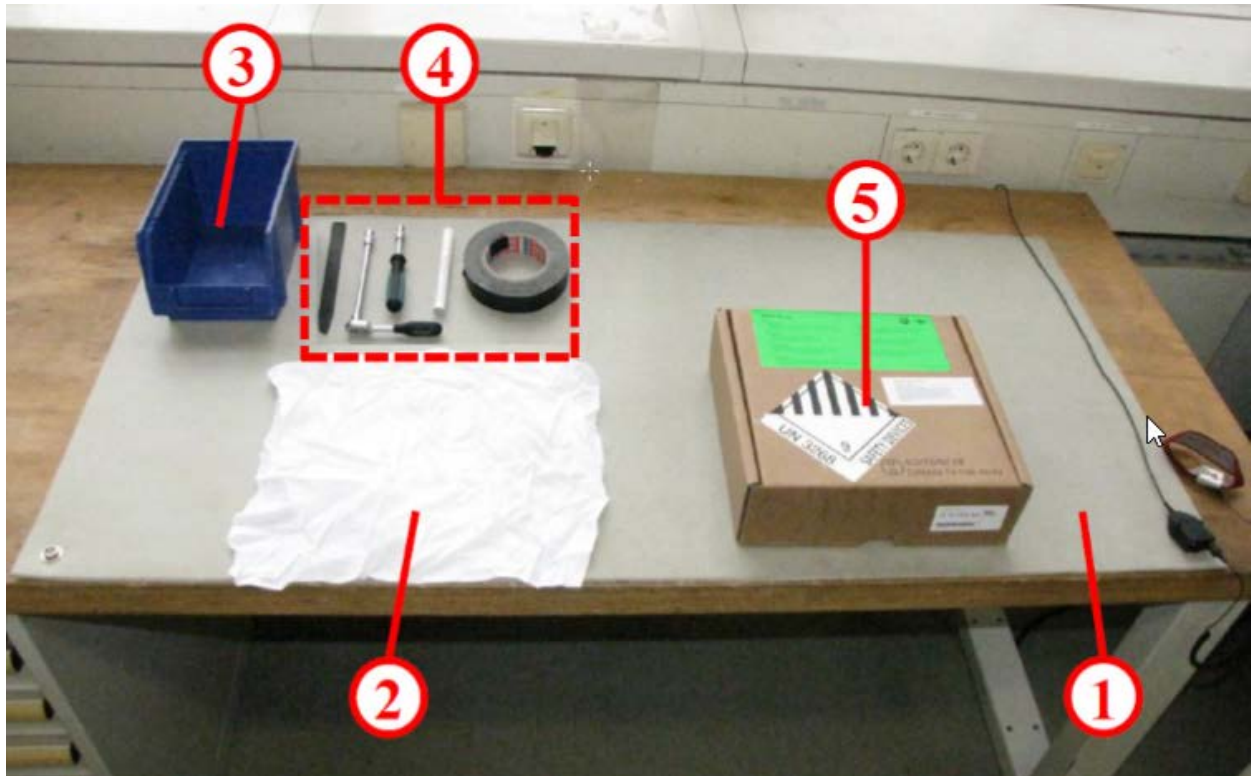
- Whenever possible do not place your body above the Air Bag

Working Location:

- It is recommended to do this work in a location away from other personnel and vehicles (for example in a separate room or the parts department)
- A clean workbench with ESD protection is necessary
- Position a soft blanket underneath the Air Bag to avoid damage to the cover
- The work area should be dust free
- Make sure there are no open cabinets above the workbench to avoid any foreign objects from falling into the Air Bag cavity.

Exclusion Criteria: In the following cases the complete Air Bag assembly must be replaced:

- Threaded bolts are damaged
- Threaded bolts are bent or corroded
- The Generator cannot be removed from the Air Bag without excess force
- If the target tightening torque of the nuts cannot be achieved
- If there is a gap between the Generator & Air Bag that is not closed up when tightening the nuts



The workbench should be prepared with the following items:

- Anti-Static mat (1) which must be grounded (See SWS 2 06 04 (128))
- A soft blanket or material (2) to prevent damaging the air bag cover
- A container (3) for disposal of the original Generator nuts
- A packaged new part (5)

Tools required (4) for the Generator exchange:

- Plastic bone tool (SWZ 0 490 539)
- Ratchet with extension and 8 mm socket
- Small torque wrench with 8 mm socket (5 NM)
- Duct tape (0.25 mm thick)

PROCEDURE:

Remove Air Bag from the vehicle:

- Remove Basic Drivers air bag as per REP 32 34 020 "Removing and installing/replacing air bag unit"
- Remove Sports Drivers air bag as per REP 32 34 020 "Removing and installing/replacing the air bag unit (sports steering wheel, inserted air bag unit)"
- Place air bag unit face down on the soft work surface

- Write the serial number of the original Air Bag unit on the work order
- Primary mechanic must place ground strap on his/her wrist



NOTE: – Picture above is an example and may not exactly match your Generator / air bag.

- Cover the connections on the old Generator with duct tape (1) so the contacts cannot be touched
- Mark orientation (2) of the Generator in the Air Bag with the felt tip marker
- Mark all four nuts (3) with the felt tip marker (to avoid mix up of old/new parts)
- Mark a large cross (4) with the felt tip marker (to avoid mix up of old/new parts)
- 2nd Technician should hold air bag steady for 1st Technician. Remove all four nuts (1) in any order and immediately place the used nuts into the provided container (2) for disposal. This is done to avoid mixing old parts and new parts.
- Remove the new Generator from the packaging
- Position the new Generator in the same orientation as the original
- Mark orientation (2) of the new Generator to match the original Generator markings with a felt tip marker
- Turn air bag over and gently wiggle the Generator to remove it from the air bag
- A plastic bone tool may be used to apply gentle pressure during removal

ATTENTION: Do not use hard, sharp tools!



NOTE: – Picture above is an example and may not exactly match your air bag

ATTENTION: In the area (1) above there must be no foreign objects!

Apply the “four eyes” principle and have this confirmed by two technicians.

- 1st Technician should perform a visual inspection of the air bag cavity for foreign objects.
- 2nd Technician should perform a visual inspection of the air bag cavity for foreign objects.

There may be a small amount of surface rust on the metal within the air bag. This is normal.

Insert the original gas generator into the new parts packaging for return.

Immediately after the visual inspection of the air bag cavity, the new Generator should be installed into the Air Bag.

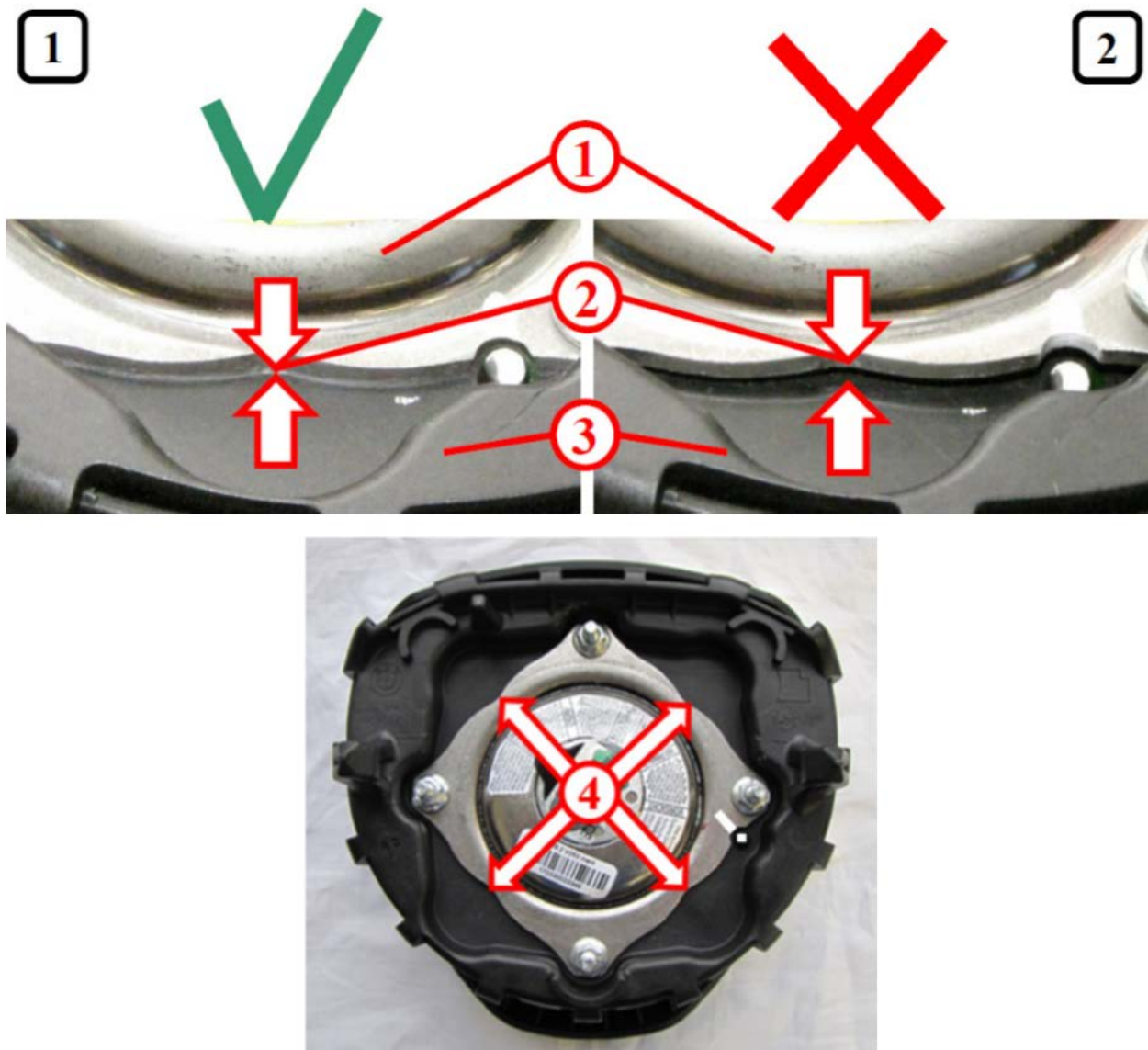


NOTE: – Picture above is an example and may not exactly match your Generator / air bag.

2nd Technician should hold air bag steady for 1st Technician.

Install the four new nuts (1,2,3,4) onto the studs and lightly tighten the nuts in the sequence shown (1,2,3,4).

Torque nuts in sequence (1,2,3,4,) to 5 Nm



Perform a visual inspection of the gap (2) between the Generator (1) and the Air Bag (3) on all four sides of the Generator (4).

Picture (1) shows a correctly installed Generator

Picture (2) shows an improperly installed Generator with an excessive gap (2).

Apply the “four eyes” principle and have this confirmed by two technicians.

- 1st Technician should perform a visual inspection of the air bag cavity for foreign objects.
- 2nd Technician should perform a visual inspection of the air bag cavity for foreign objects.

ATTENTION: If the gap cannot be closed up, cancel this procedure and replace the entire Air Bag assembly.

Note the serial number of the new Air Bag unit (1) on the Repair Order.

Install the Air Bag into the vehicle.

Check function after assembly is complete:

- Turn on ignition, does the Air Bag lamp briefly illuminate during the bulb self-check and then go out?
- Confirm that the horn is working

Seal the packaging with the original gas generator and prepare for shipment back to Takata.

BMW Group - AIR: 2019-12-03 / 11:13
Retailer: -/-
Model: 328i A
Development code: E46
Model code: AM63
Lead type: AM63

Repair instruction

Removing and installing/replacing the airbag unit (sports steering wheel, inserted airbag unit)

32 34 020 I REP-REP-RAE4632-3234020SMART - V.2

32 34 020 Removing and installing/replacing the airbag unit (sports steering wheel, inserted airbag unit)



Warning!

Observe the following instructions to avoid any risk of injury by the airbag unit.

- Comply with safety regulations for handling components with gas generators.
- Do not exert any force on the airbag unit.
- Use only specified release tool for the airbag unit.

Note: Incorrect handling may result in triggering of the airbag unit and thereby cause serious injury.



Attention!

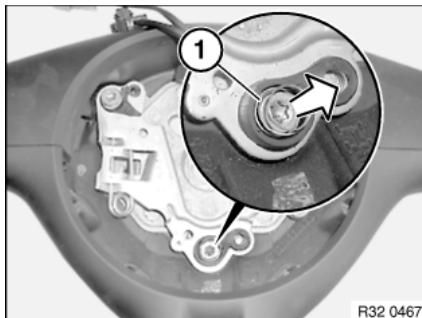
Steering wheel must be replaced if airbag unit has been triggered!

Follow procedure after airbag deployment.



Necessary preliminary work:

- Disconnect battery earth lead



Installation note:

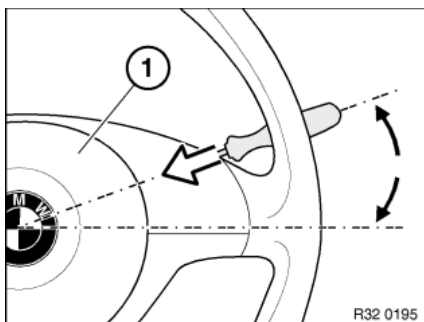
When installing a new airbag unit (see table below), the available ground spring (1) must be removed from the base plate of the steering wheel.

Pull off spring (1) from screw.

Omitting the ground spring (1) on new airbag units is not a safety hazard.

Introduction dates of new airbag units:

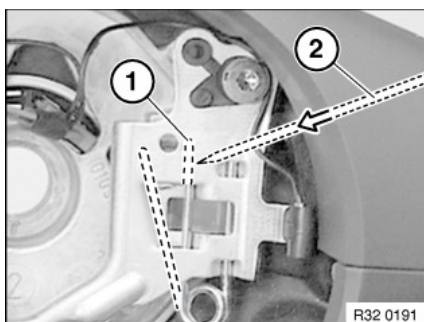
E46:	01/2002
E53:	02/2003
E39:	03/2002



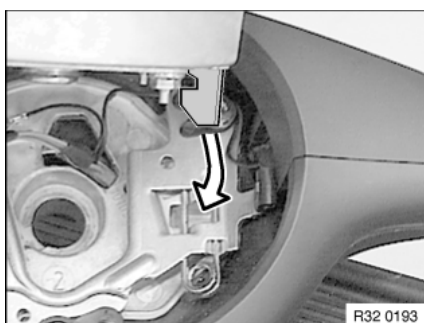
Insert a screwdriver through the opening on the rear side of the steering wheel and press on the lock. In the event of a spring resistance, press the lock up to the limit position and simultaneously pull away the airbag unit (1) from the steering wheel.

Repeat the process on the opposite side.

The process on the next image is illustrated without the airbag unit to make it clearer.



Use the screwdriver (2) to press on the lock (1).



Installation note:

Make sure electrical leads are correctly positioned.

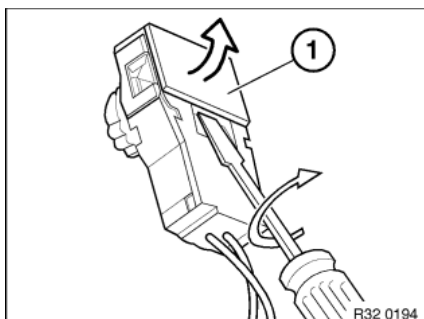
Insert the airbag unit into the locks with the hooks and press it into the steering wheel.



Warning!

Danger of injury!

Airbag unit may only be set down with the airbag itself facing upwards.



Unlocking the airbag plug connection:

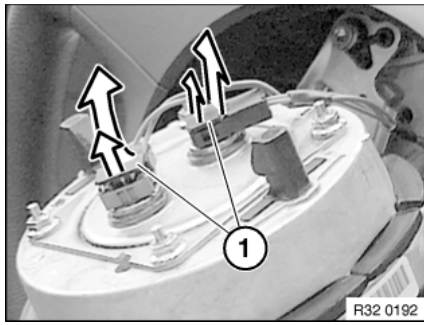
Lever out the lock (1) with a screwdriver.

Open the locks (1) and pull off the connector.

Remove airbag unit.

Installation note:

Connect plugs to connections of same colour on airbag unit.



BMW Group - AIR: 2019-12-03 / 11:12
Retailer: -/-
Model: 328i A
Development code: E46
Model code: AM63
Lead type: AM63

Repair instruction

Removing and installing/replacing airbag unit

32 34 020 I REP-REP-RAE4632-3234020 - V.1

32 34 020 Removing and installing/replacing airbag unit



Warning!

Observe the following instructions to avoid any risk of injury by the airbag unit.

- Comply with safety regulations for handling components with gas generators.
- Do not exert any force on the airbag unit.
- Use only specified tools for releasing the airbag unit.

Note: Incorrect handling may result in triggering of the airbag unit and thereby cause serious injury.



Important!

Steering wheel must be replaced if airbag unit has been triggered!

Follow procedure after airbag triggering.



Necessary preliminary tasks:

- Disconnect battery negative lead



Release screws (Torx T30) on both sides.

Installation:

Make sure electrical leads are correctly positioned.

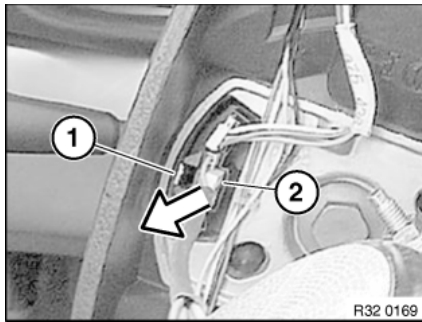
Tightening torque 32 34 1AZ.



Warning!

Danger of injury!

Airbag unit may only be set down with the airbag itself facing upwards.



Press down lock (1) and disconnect plug (2).

Remove airbag unit.



Replacement:

Disconnect plug connections on airbag unit and remove connecting cable.

Installation:

Connect plugs to connections of same colour on airbag unit.

BMW / MINI BULK SHIPMENT PACKAGE REFERENCE GUIDE

NOTE: The information outlined in this document pertains to dealers within the Contiguous 48 States.

Dealers in Puerto Rico, the Hawaiian Islands, and Alaska **CANNOT** follow the shipping instructions outlined in this document; they **MUST** contact the following Takata USA representative(s) directly, **once a week**, for shipping instructions:

- Dealers in Puerto Rico, please contact: Juan.Armstrong@craneww.com
- Dealers in the Hawaiian Islands, please contact: Becky.Argyropoulos@craneww.com
 - Please make sure to include the required completed Hawaiian Hazardous Materials Shipping Certificate.
- Dealers in Alaska, please contact : SCTakataRestraints_International@xpo.com
 - Important: please be aware that there is an underscore (_) in the above Alaska email address, between the words "Restraints" and "International".
 - Or call the Alaskan Representative; Armando Gonzales at 210-250-5039.

1. Contact Takata:

- Dealers must contact Takata/XPO **Every Other week** to schedule **BULK** and **SINGLE** recall airbag component shipments.
 - o **Email:** SCFieldAction.14305@xpo.com
 - o **Phone:** 210-250-5079
- Takata/XPO will select the return type (bulk or single) based on the shipping quantities (LTL or FedEx PRP), and will supply the dealer with the proper shipping documentation.
 - o If Takata instructs you to return the recall airbag components as a **BULK SHIPMENT**, please follow the instructions outlined below.
 - o If Takata instructs you to return the recall airbag components as a **SINGLE SHIPMENT**, please follow the instructions provided by Takata.

2. Stacking:

Place the recall airbag components neatly on a pallet, and securely shrink-wrap them to the pallet.

Note: The total height of the pallet and boxes cannot exceed 60 inches.



3. Labeling:

Securely attach the following labels on each side of the shrink-wrapped pallet.

- o Class 9 Label
- o UN3268 Safety Device *
- o OVERPACK USED *

*You can print these labels on letter size white paper, using Microsoft Word.



4. Questions/Concerns:

For any other questions or concerns, please contact the WPRC: AirbagReturns@bmwna.com

Defect Code: 00 32 11 03 00

Safety Device Return Procedure for Airbag Recall

****ATTENTION****

DO NOT USE THE “1.4 LABEL” **AND DO NOT** FOLLOW ANY INSTRUCTIONS FOUND INSIDE THE REPLACEMENT AIRBAG MODULE'S BOX.

DISREGARD THOSE INSTRUCTIONS AND DO NOT RELABEL THE ORIGINAL BOX THAT WILL NOW BE USED FOR RETURNING THE RECALLED AIRBAG.

IMPORTANT

- As the shipper, your center is responsible for proper packaging and documentation completion.
- The person packaging the airbag(s) must have received the Hazardous Material training per 49CFR 172.702. Those training records must be on file at your center.
- The U.S. Department of Transportation (“DOT”) will impose substantial fines and/or penalties on the shipper if the packaging, labeling, or documentation is not properly prepared and the customer's (center) copy of the OP 900PRP form is not kept on file for a minimum of two (2) years.

CAMPAIGN DOF – CONTIGUOUS 48 STATE FEDEX GROUND SHIPMENT PREPARATION

As the shipper, you are responsible for proper packing and document completion. The person packaging the module must have received hazardous material training per 49CFR 172.702, and the training records must be on file at your dealership. The U.S. Department of Transportation will impose substantial fines and/or penalties on the shipper if the packaging, labeling, or documentation is not properly prepared and Customer Copy of OP 900PRP form is not kept on file for a minimum of 2 years.

IMPORTANT: Do not deploy the safety device. The person packing the used safety device must read and follow the provided instructions.

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