



SIB 65 25 19

2021-02-16

## RECALL 19V-853: DRIVER'S FRONT AIR BAG (NADI) INFLATOR

This Service Information Bulletin (Revision 10) replaces SI B65 25 19 **dated October 2020**.

### What's New (Specific text highlighted):

- Parts & Correction - Standard air bag unit **without** multifunction controls is now available
- Procedure – MRS III vehicles with dual stage gas generator identification added; also hyperlink
- Warranty

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.

### MODEL

E-Series	Model Description	Production Date
E46	3 Series Sedan, Coupe, Sports Wagon	May 20, 1999 – 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 through 2001 BMW 3 Series vehicles that were produced between May 1999 and July 2000. Please see attached Recall Notice and Q&A for further information.

This recall campaign involves vehicles equipped with the single-stage Takata Non-Azide (NADI) Driver gas generator/Inflator. There are three separate recalls involving the NADI units.

Recall ID	SIB No.	DCs	Recall Description
19V-851	B65 23 19	32 34 90 03 00; or 00 32 97 02 00	Driver's Front Air Bag (NADI) Inflator-STOP DRIVE
19V-852	B65 24 19	32 34 90 03 00; or 00 32 98 02 00	Driver's Front Air Bag (NADI) Inflator
19V-853	B65 25 19	32 34 90 03 00; or 00 32 96 02 00	Driver's Front Air Bag (NADI) Inflator-Spare Parts

At this time we only have a limited supply of parts. Please refer to the weekly Parts Matrix for updates.

We will update this bulletin as soon as additional information is available.

### **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 gas generator will not correct the other fault code(s).

**CAUSE**

The single-stage Takata Non-Azide (NADI) Driver gas generator, also known as an air bag inflator, may have been produced with an insufficient seal that could allow moisture to enter the gas generator. The gas generator is a separately replaceable part of the air bag module.

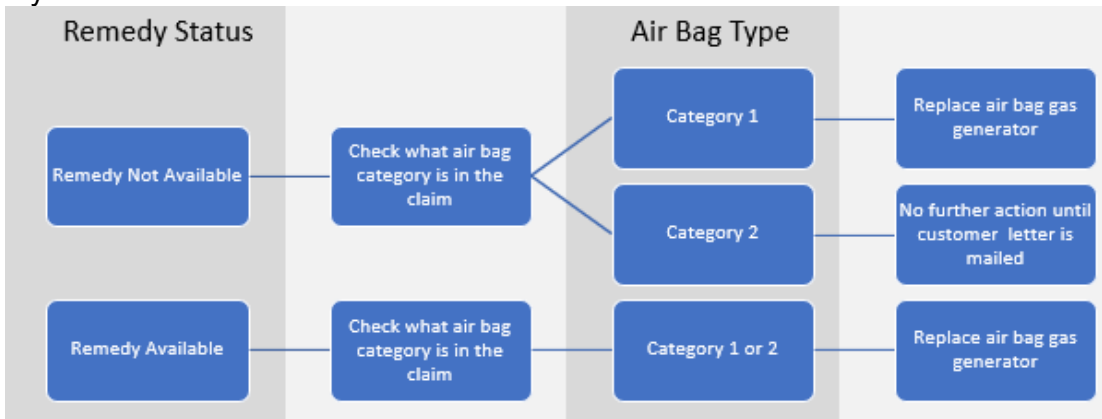
**CORRECTION**

The current installed air bag gas generator must be inspected.

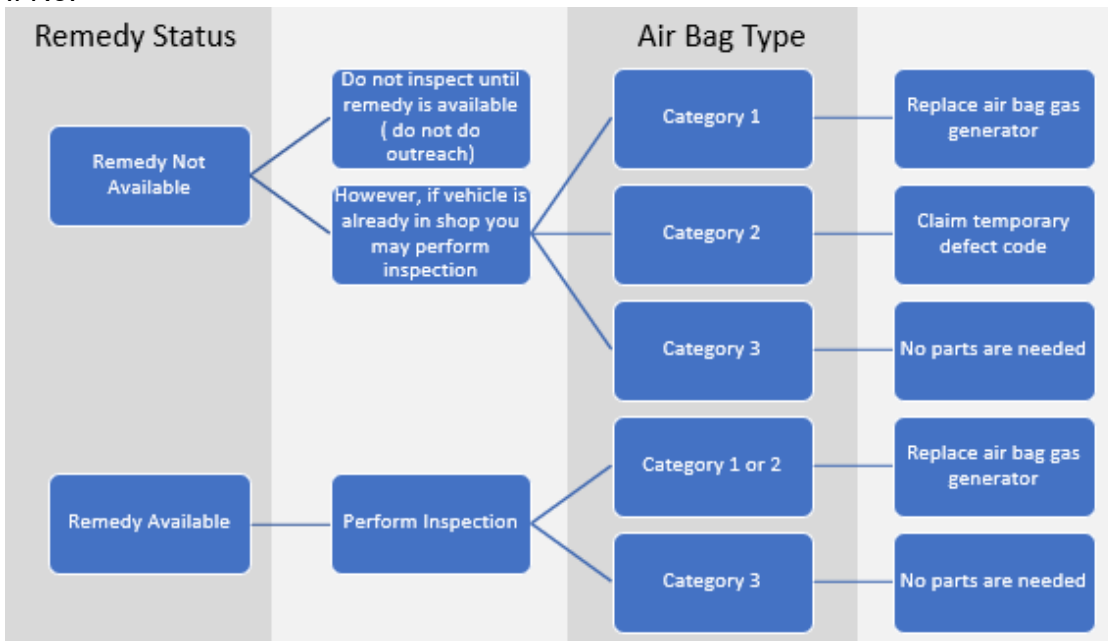
The serial number on the installed air bag gas generator must be compared to the serial number list in the procedure section to determine if the gas generator needs to be replaced.

**Note:** Before proceeding with the Recall airbag inspection procedure, please review the Repair History (Claims) section first in the DCSnet Warranty Inquiry for the affected vehicle to see if: **DC 32 34 90 03 00 (Preliminary Inspection Only - Later Replacement is Required) has already been claimed.**

If yes:



If No:



**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 (Sport steering wheel and standard air bag **WITH** multifunction switches) is required but parts are not available, please contact BMW Customer Relations at 1-800-525-7417 for further support.

## **PROCEDURE**

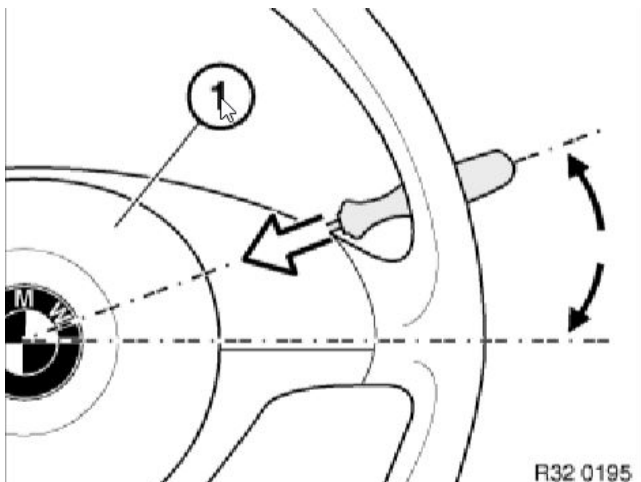


Follow all safety precautions when handling air bags.

Remove **Basic Drivers air bag** as per

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

**OR**

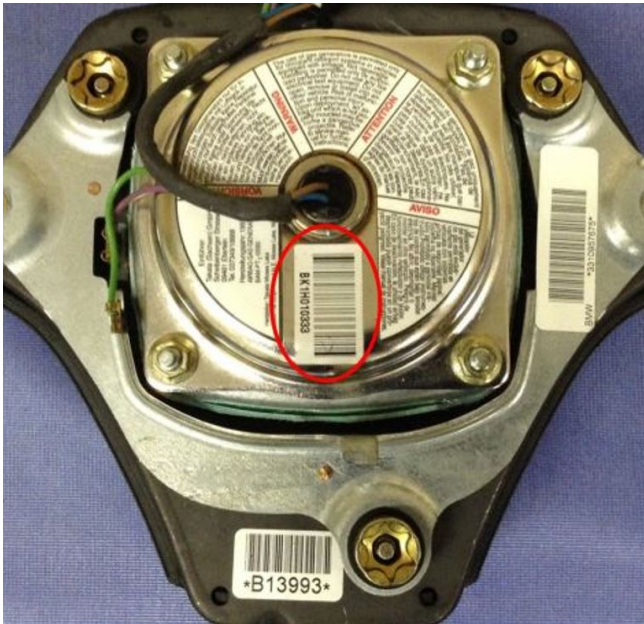
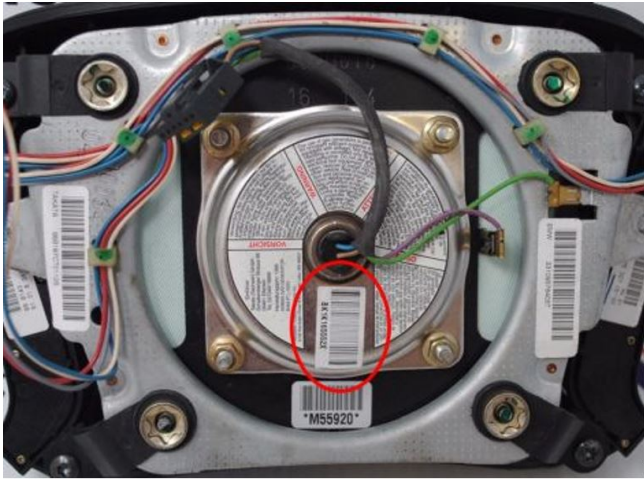


Remove **Sports Drivers air bag** as per

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

Once the air bag is removed and the wiring is disconnected, turn air bag over to read the parts label(s) on the gas generator on the back.

**Basic Driver's air bag**, showing the location of the parts label.



**Sport Driver's air bag**, showing the location of the parts label.

	<p><b>Gas generator serial number decoding:</b></p> <p>Digits 1-2 = Type of gas generator          Digit 3 = Production Line          Digit 4 = Production year          Digit 5-11* = Serial #</p> <p><b>*NOTE:</b> The serial number can have 10 or 11 characters. Only the first 10 characters counted from the left are relevant for the check. The 11th digit can be disregarded for the repair covered by this SIB</p>
	<p><b>EXAMPLE 1:</b> Gas Generator Parts Label</p> <p>All <b>BK1H</b> are <b>Category 2</b></p>



**EXAMPLE 2: Gas Generator Parts Label**

**BKCJ** may fall under two categories:

Up to 059642	<b>Category 1</b> – Drivers air bag gas generator must be replaced; the vehicle cannot be driven until repaired.
From 059659	<b>Category 2</b> – Drivers air bag gas generator must be replaced

This example is **1059652** which is a higher serial number than 059659 so this is **Category 2**

**\*NOTE: The serial number can have 10 or 11 characters. Only the first 10 characters counted from the left are relevant for the check. The 11th digit can be disregarded for the repair covered by this SIB, so ignore the last digit 2**



**EXAMPLE 3: Gas Generator Parts Label**

**BK1K** may fall under two categories:

Up to 088984	<b>Category 2</b> – Drivers air bag gas generator must be replaced
From 088992	<b>Category 3</b> – Drivers air bag gas generator is OK

This example is 11 digits and **386101S** is above 088992 so this is **Category 3**

**\*NOTE: The serial number can have 10 or 11 characters. Only the first 10 characters counted from the left are relevant for the check. The 11th digit can be disregarded for the repair covered by this SIB, so ignore the letter S**



If the serial number is not legible or the driver airbag gas-generator (not type BK) cannot be identified, submit a TSARA case for support. Title the TSARA case **NADI TAKATA RECALL 19V-853**.

Some vehicles may have air bag control unit



MRS III which was introduced in some models starting September 1999 and supports a dual stage gas generator.

Standard steering wheel gas generator pictured. Takata air bags with different chemical compositions (white label) are not affected by this recall and DO NOT need to be replaced. **Reinstall the driver's air bag.** This is **Category 3**.



Some vehicles may have air bag control unit MRS III which was introduced in some models starting September 1999 and supports a dual stage gas generator

Sport steering wheel gas generator pictured.

These gas generators are **Category 2** and must be replaced. See [SI B65 02 17](#) for parts information.

**Submit an INFO ONLY TSARA case to document this repair.**

To see the repair category of your air bag gas generator, refer to the table below.

Descriptions of each category are shown below the table.

Digits 1-3	Digit 4	Digit 5-10	Repair Category
BKC	H	ALL	<b>Category 1</b> – Drivers air bag gas generator must be replaced; the vehicle cannot be driven until repaired.
BKC	J	Up to 059642	<b>Category 1</b> - Drivers air bag gas generator

			must be replaced; the vehicle cannot be driven until repaired.
		<b>From 059659</b>	<b>Category 2</b> -Drivers air bag gas generator must be replaced
BK1	H	ALL	<b>Category 2</b> – Drivers air bag gas generator must be replaced
BK1	J	ALL	<b>Category 2</b> – Drivers air bag gas generator must be replaced
BK1	K	<b>Up to 088984</b>	<b>Category 2</b> – Drivers air bag gas generator must be replaced
		<b>From 088992</b>	<b>Category 3</b> – Drivers air bag gas generator is OK
BK1	L M N P Q R U V	ALL	<b>Category 3</b> – Drivers air bag gas generator is OK
BK5	-	ALL	<b>Category 3</b> – Drivers air bag gas generator is OK
BKV	-	ALL	<b>Category 3</b> – Drivers air bag gas generator is OK

Category	Part	Defect Code*	Steps
1	Air Bag Gas Generator	Final Repair: 00 32 96 02 00	<ul style="list-style-type: none"> <li>The serial number of the checked gas-generator AND the new gas-generator must both be stated on the repair order and in the comments section of the warranty claim.</li> <li>Refer to <a href="#">SI B65 03 20</a> for details on how to replace a gas generator. And its attached Checklist for gas generator replacement.</li> </ul>
	Complete Air Bag Assembly Needed	Temporary: 32 34 90 03 00	<ul style="list-style-type: none"> <li>Parts are not available</li> <li>The serial number of the checked gas-generator must be stated on the repair order and in the comments section of the warranty claim.</li> <li>Contact BMW Customer Relations at 1-800-525-7417 for further support. This vehicle is now part of the <b>Stop Drive</b></li> </ul>
Category	Part/Remedy	Defect Code	Steps
2	If Remedy is not available	Temporary: 32 34 90 03 00	The serial number of the checked gas generator must be stated on the repair order and in the comments section of the warranty claim.
	Air Bag Gas Generator	Final Repair: 00 32 96 02 00	<ul style="list-style-type: none"> <li>The serial number of the checked gas-generator AND the new gas-generator must both be stated on the repair order and in the comments section of the warranty claim.</li> <li>Refer to <a href="#">SI B65 03 20</a> for details on how to replace a gas generator and its attached Checklist for gas generator replacement.</li> </ul>
	Complete Air Bag Assembly Needed	Temporary: 32 34 90 03 00	<ul style="list-style-type: none"> <li>Parts are not available</li> <li>The serial number of the checked gas-generator must be stated on the repair order and in the comments section of the warranty claim.</li> <li>Contact BMW Customer Relations at 1-800-525-7417 for further support. This vehicle is now part of the <b>Stop Drive</b></li> </ul>

Category	Part	Defect Code	Steps
3	No part needed	Final Repair: 00 32 96 02 00	<ul style="list-style-type: none"> <li>The air bag is OK and it can be reinstalled.</li> <li>The serial number of the checked gas-generator must be stated on the repair order and in the comments section of the warranty claim.</li> </ul>

\* It is very important to claim on the correct defect code so we know which vehicles still need a part when parts become available.

## **PARTS INFORMATION**

Please refer to the Parts Matrix for the 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
32 34 5 A1B DB4	Standard air bag unit <b>WITHOUT</b> multifunction switches	1 (if required)
32 34 5 A1B DB5	Standard air bag unit <b>WITH</b> multifunction switches	1 (if required)
32 34 5 A1B DB3 ETA is April	Air bag unit, sports steering wheel. Not available until April	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](mailto: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.

<b>Plus work</b>	Vehicle is already in the workshop for another repair
<b>Main work</b>	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 and 2 vehicles - Inspect the air bag and the gas generator is replaced (Recall is CLOSED)**

<b>Defect Code:</b>	<b>0032960200</b>	<b>E46 Driver's airbag (NADI - part II)</b>	
:			
<b>Work Pkg</b>	<b>Labor Operation</b>	<b>Description</b>	<b>Labor Allowance</b>
# 1	00 68 975	Checking the driver's air bag and <b>replacing the gas generator (category 1 and 2)</b> (Plus work)	7 FRU
Or:			
# 2	00 68 357	Checking the driver's air bag and <b>replacing the gas generator (category 1 and 2)</b> (Main work)	8 FRU

### **Category 3 vehicles - Inspection the air bag ONLY, no replacement is required (Recall is CLOSED)**

<b>Defect Code:</b>	<b>0032960200</b>	<b>E46 Driver's airbag (NADI - part II)</b>	
:			
<b>Work Pkg</b>	<b>Labor Operation</b>	<b>Description</b>	<b>Labor Allowance</b>
# 3	00 68 808	Only checking the driver's air bag, air bag is OK ( <b>category 3</b> ), no replacement is necessary (Plus work)	3 FRU
Or:			
# 4	00 68 224	Only checking the driver's air bag, air bag is OK ( <b>category 3</b> ), no replacement is necessary (Main work)	5 FRU

### **Category 2 vehicles – The gas generator repair is wait listed (Recall remains OPEN)**

<b>Defect Code:</b>	<b>3234900300</b>	<b>E46 Driver's air bag NADI - test result</b>	
:			
<b>Work Pkg</b>	<b>Labor Operation</b>	<b>Description</b>	<b>Labor Allowance</b>
# 5	00 68 807	Check, <b>the necessary gas generator repair is wait listed (category 2)</b> (Plus work)	3 FRU
Or:			
# 6	00 68 223	Check, <b>the necessary gas generator</b>	5 FRU

		<b>repair is wait listed (category 2) (Main work)</b>	
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**Category 1 and 2 vehicles – The gas generator repair cannot be performed, future air bag module replacement is required (Recall remains OPEN)**

<b>Defect Code:</b>	<b>3234900300</b>	<b>E46 Driver's airbag NADI - test result</b>	
:			
<b>Work Pkg</b>	<b>Labor Operation</b>	<b>Description</b>	<b>Labor Allowance</b>
# 7	00 68 806	Check, the necessary gas generator repair cannot be performed, future driver's air bag module replacement required (category 1 and 2) (Plus work)	3 FRU
Or:			
# 8	00 68 222	Check, the necessary gas generator repair cannot be performed, future driver's air bag module replacement required (category 1 and 2) (Main work)	5 FRU

**Category 1 and 2 vehicles - As applicable below, the air bag module complete is replaced (Recall is CLOSED)-**

<b>Defect Code:</b>	<b>0032960200</b>	<b>E46 Driver's air bag (NADI - part II)</b>	
:			
<b>Work Pkg</b>	<b>Labor Operation</b>	<b>Description</b>	<b>Labor Allowance</b>
# 9	00 69 564	Replace the driver air bag (module complete, replacement part is available) after abandoning the replacement of the gas generator (category 1 and 2) (Plus work)	4 FRU
Or:			
# 10	00 69 060	Replace the driver air bag (module complete, replacement part is available) after abandoning the replacement of the gas generator (category 1 and 2) (Main work)	5 FRU
Or:			
# 11	00 70 639	Replacing the driver's air bag module (complete, replacement part is available) (category 1 and 2) (Follow-up work after WP # 3 or # 4 was performed and claimed prior/DC 32 34 90 03 00) (Plus work)	3 FRU
Or:			
# 12	00 70 122	Replacing the driver's air bag module (complete, replacement part is available) (category 1 and 2) (Follow-up work after WP # 3 or # 4 was performed and claimed prior/DC 32 34 90 03 00) (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 25 19 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 their 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.

### QUESTIONS REGARDING THIS BULLETIN

Technical inquiries	Submit feedback at the top of this bulletin
Warranty inquiries	Submit an IDS ticket to the Warranty Department or use the chat available in the Warranty Documentation Portal.
Parts inquiries	Submit an IDS ticket to the Parts Department

### Supporting Materials

[picture\\_as\\_pdf B652519 19V-853\\_E46 DAB QA\\_4Dec2019.pdf](#)

[picture\\_as\\_pdf B65 25 19 REP 32 34 020 R I airbag sport.pdf](#)

[picture\\_as\\_pdf B652519 Parts Bulk Ship Return.pdf](#)

[picture\\_as\\_pdf B652519 Recall Notice.pdf](#)

[picture\\_as\\_pdf B652519 REP.pdf](#)

[picture\\_as\\_pdf B652519 Parts Return Program Instructions.pdf](#)

[picture\\_as\\_pdf B65 25 19 REP 32 34 020 R I airbag unit.pdf](#)

## **SAFETY RECALL NOTICE**

To: All Center Operators, Sales Managers, Service Manager, Parts Manager and Warranty Processor

RE: Recall 19V-853: Driver's Front Air Bag (NADI) Inflator – B65 25 19

BMW AG has issued a Voluntary Safety Recall (effective December 4, 2019) on certain Model Year 1999 through 2001 BMW 3 Series vehicles that were produced between May 1999 and July 2000.

**Please be reminded that it is a violation of federal law (The Safety Act) for you to sell, lease or deliver any new motor vehicle covered by this notification until the recall repair has been performed. This means that centers may not legally deliver new motor vehicles to consumers until they are fixed or use/sell replacement equipment/parts subject to this recall. Note also that substantial civil penalties apply to violations of the Safety Act.**

**Also, you should not sell, lease or deliver any Certified Pre-Owned or used vehicles subject to a safety recall until the repair is completed.**

**Please follow any special instructions that we provide to you for the return or disposition of recall parts.**

We appreciate all your assistance with this Recall.

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!

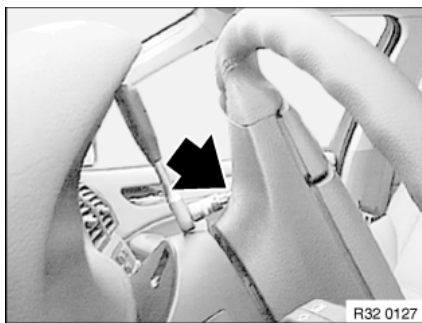
Steering wheel must be replaced if airbag unit has been triggered!

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.

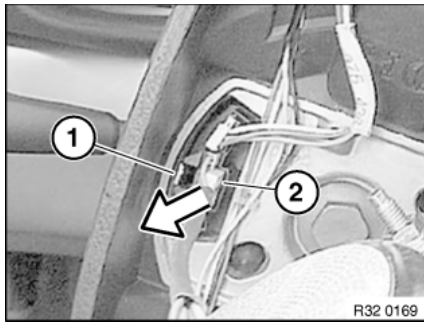
Tightening torque 32 34 1AZ.



#### 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 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!

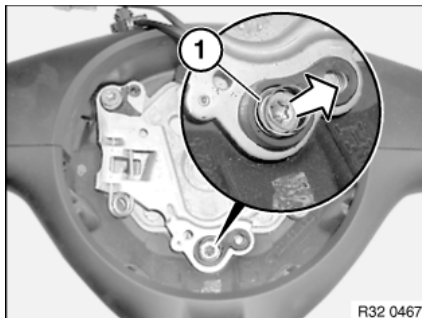
Steering wheel must be replaced if airbag unit has been triggered!

Follow procedure after airbag deployment.



#### Necessary preliminary work:

- Disconnect battery earth lead



#### Installation note:

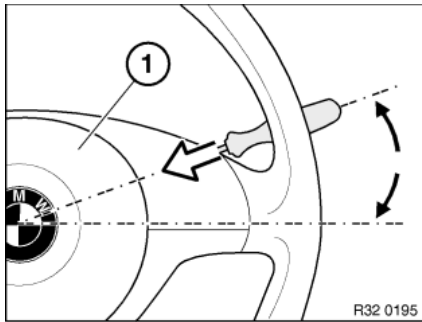
When installing a new airbag unit (see table below), the available ground spring (1) must be removed from the base plate of the steering wheel.

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:

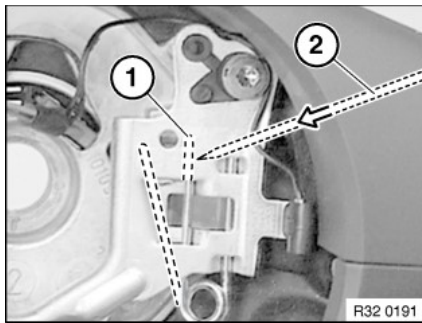
E46:	01/2002
E53:	02/2003
E39:	03/2002



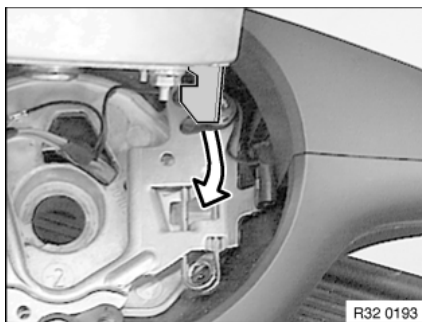
Insert a screwdriver through the opening on the rear side of the steering wheel and press on the lock. In the event of a spring resistance, press the lock up to the limit position and simultaneously pull away the airbag unit (1) from the steering wheel.

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.

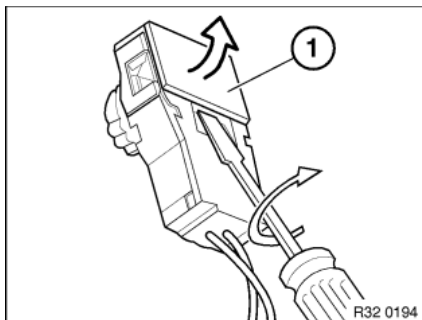
Insert the airbag unit into the locks with the hooks and press it into the steering wheel.



**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.

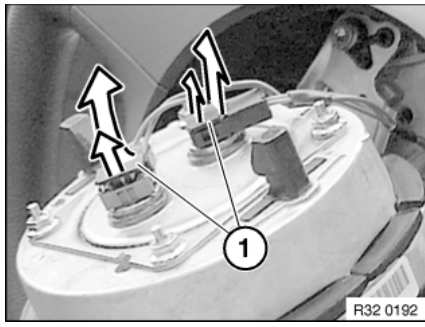
Open the locks (1) and pull off the connector.

Remove airbag unit.

***Installation note:***

Connect plugs to connections of same colour on airbag unit.





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Replacing the gas generator for the driver's airbag »

 **WARNING**

Pyrotechnic components.

**Danger! Immobilization period-threatening injuries!**

- All work on pyrotechnic parts may be carried out by technically experienced and appropriately trained personnel only.
- Replace any damaged part or ones that have been dropped.
- For additional information see: 72 00 Safety regulations on handling components with gas generators.

 **RISK OF DAMAGE**



Electrostatic discharge.

Damage to or destruction of electrical components.

- Leave electrical components in original packaging until just before they are installed. Use the original packaging only for any return shipments. Always package removed components straight away.
- Read and comply with user information on using the associated special tool 12 7 060.
- Only tap the housings of electrical components. Do not tap pins or multi-pin connectors directly.
- Wear electrically conductive clothing and antistatic shoes (with ESD symbol).
- For additional information see: 61 35 ... Notes on ESD (electrostatic discharge) protection  
61 35 ... Notes on ESD protection (Electro Static Discharge)

**i TECHNICAL INFORMATION**

The work surface must be clean, even, skid-proof and tilt-proof.

** NOTE**

Only **one vehicle** may be processed at a time.

Execute repair **without interruption**.

Interruptions of any kind are not permitted (such as by telephone calls).

The person performing the procedure must not be distracted.

** NOTE**

The person performing the repair must have a second person available **for the entire duration** of the repair.

The second person has the following tasks:

Fill in the checklist.

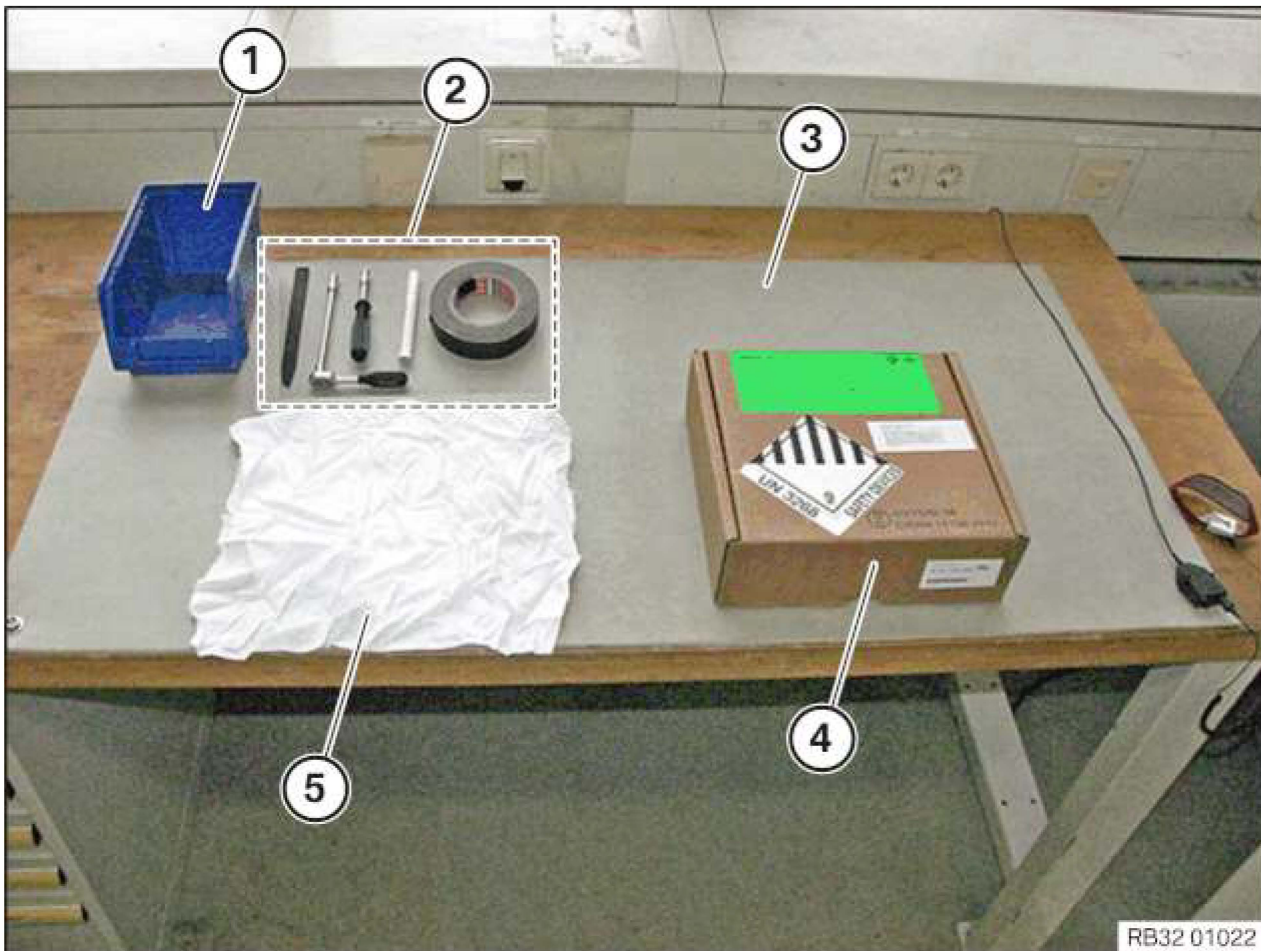
Attach the component(s).

Inspection of work performed.

## Preliminary work

### Preparing the workplace

Workplace for replacement of the gas generator (E46)



- 1 Collection container for disposal of the nuts
- 2 Tools required for the exchange
- 3 Antistatic mat
- 4 New, packaged gas generator
- 5 Scratch-resistant cotton underlay

- Print out the checklist.

## 3234

- Prepare the antistatic mat and cotton pad:
- Have the following tools ready:
  - Felt pen
  - Adhesive tape (width min. 25 mm)
  - Wedge 0 490 539 (00 9 322)
  - 1/4" reversible ratchet
  - 1/4" reversible ratchet



1/4" reversible ratchet  
with Extension 1/4 inch  
Extension 1/4 inch



Extension 1/4 inch  
and Socket wrench for hexagon  
Socket wrench for hexagon



Socket wrench for hexagon  
8 mm

Torque wrench with Socket wrench for hexagon  
Socket wrench for hexagon



Socket wrench for hexagon  
8 mm

### Tightening torques

#### Gas generator to airbag unit

Nut  
Renew nut.

Tightening torque  
5Nm

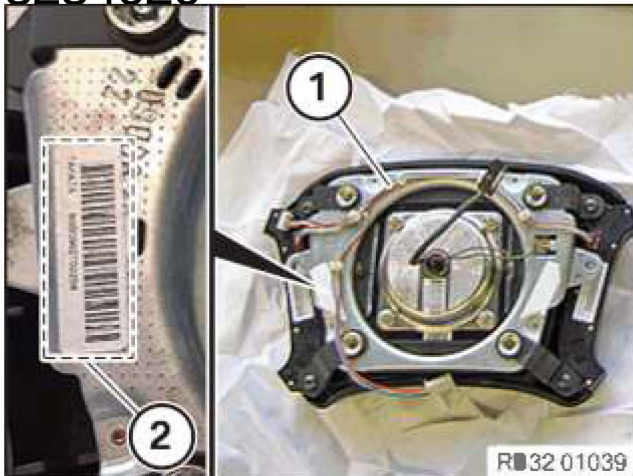
## Main Works

### Replacing the gas generator of airbag unit (standard steering wheel)

#### Prerequisite

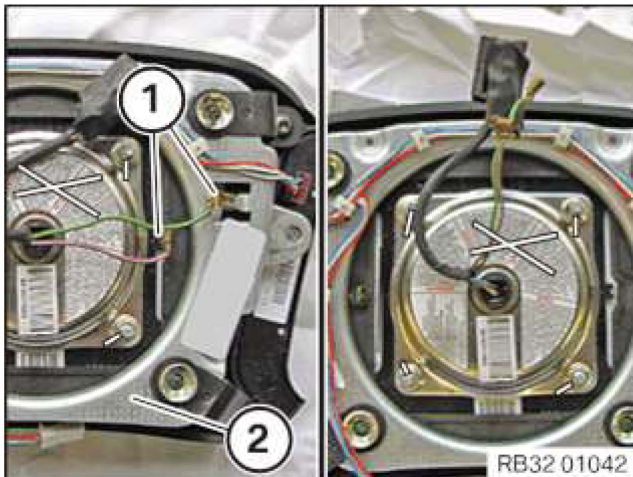
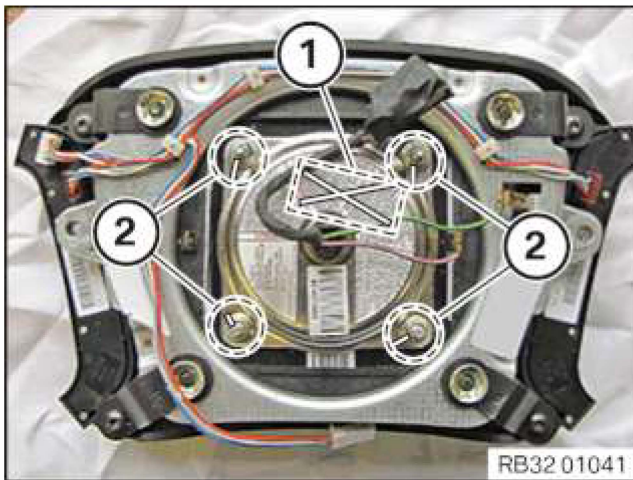
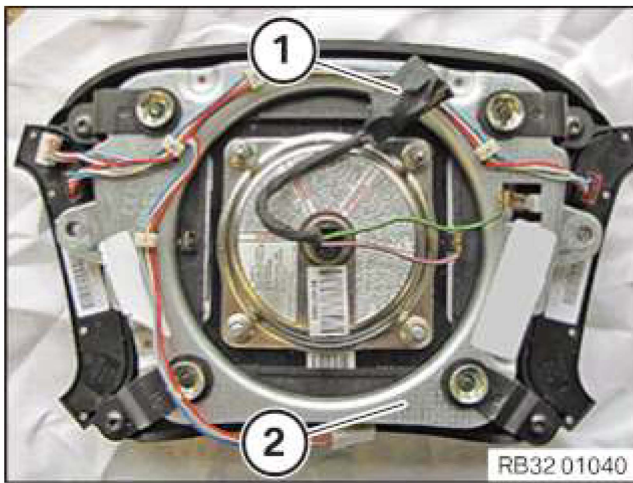
Airbag unit is removed.

## 3234020

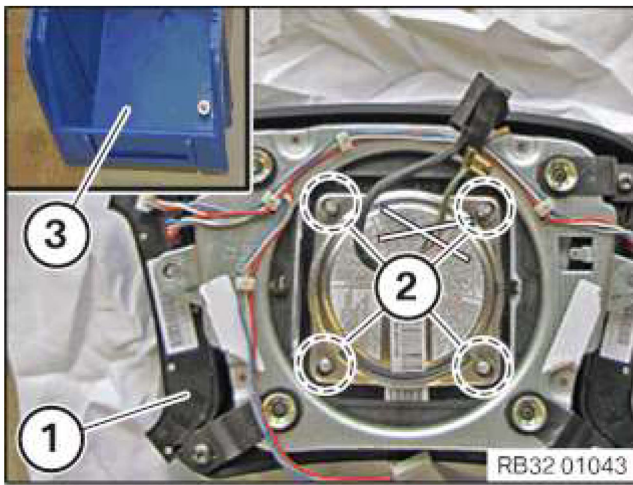


- Place the airbag unit (1) turned around as shown.
- Note the serial number (2) of the airbag unit (1) on the work order.

- Glue the connector (1) from the previous gas generator of the airbag unit (2) with the adhesive tape so that the contacts cannot be touched.



- Mark a cross (1) with the felt pen to avoid a mix-up with the new gas generator.
- Mark all the four nuts (2) with the felt pen to avoid a mix-up with the new nuts.
- Release both the connectors (1) on the airbag unit (2).
- **Auxiliary person:** Hold the airbag unit (1).
- Unscrew all the nuts (2) in any order and dispose of immediately in the collection container provided (3).
- Do not reuse the nuts (2).



### ► Preparing the new gas generator

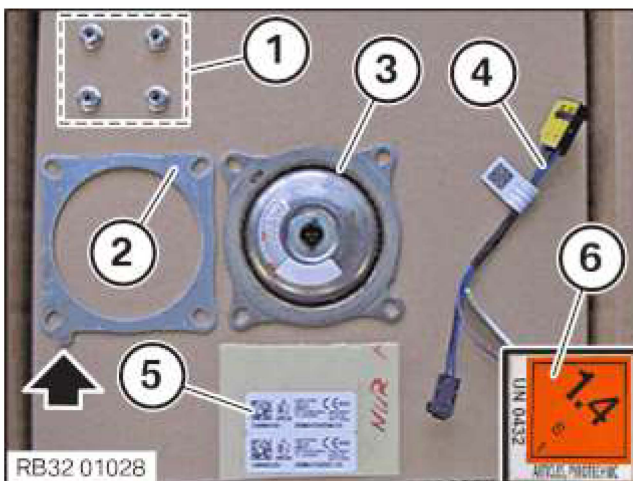


#### RISK OF DAMAGE

##### Damage to the gas generator.

A damaged gas generator due to, for example, a fall, can lead to malfunctions and must be replaced.

- Handle gas generator carefully.
- Do not use the gas generator after a fall, but replace it.



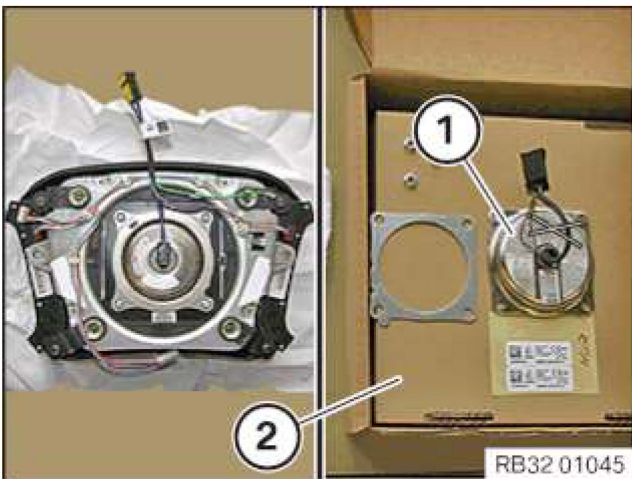
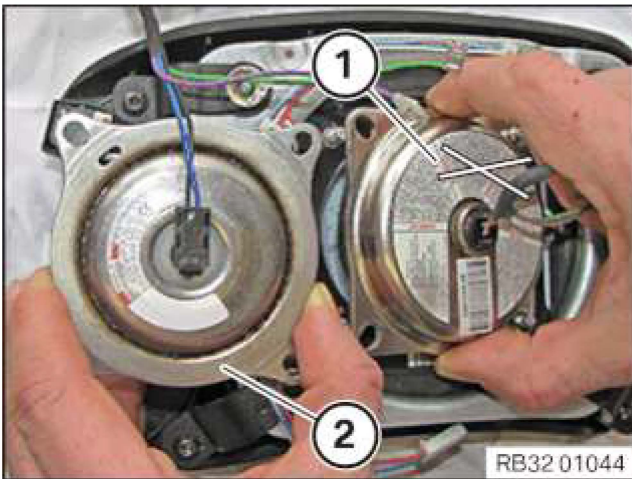
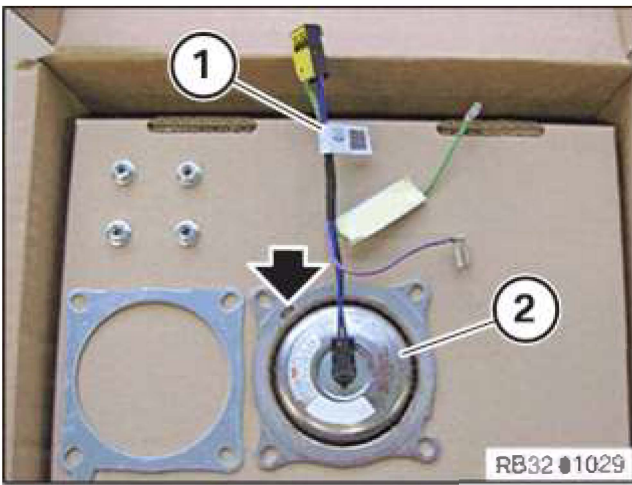
- Unpack the new nuts (1), reinforcement plate (2), new gas generator (3), cable (4) and sticker (5) and place it as shown.
- Make sure that the groove (arrow) of the reinforcement plate (2) is positioned correctly.
- USA only:  
Dispose of the hazard sticker (6).

- Clip in the cable (1) as shown in the new gas generator (2).

The cable (1) and the groove (arrow) of the new gas generator (2) point upwards.

The connector is encoded against incorrect assembly.





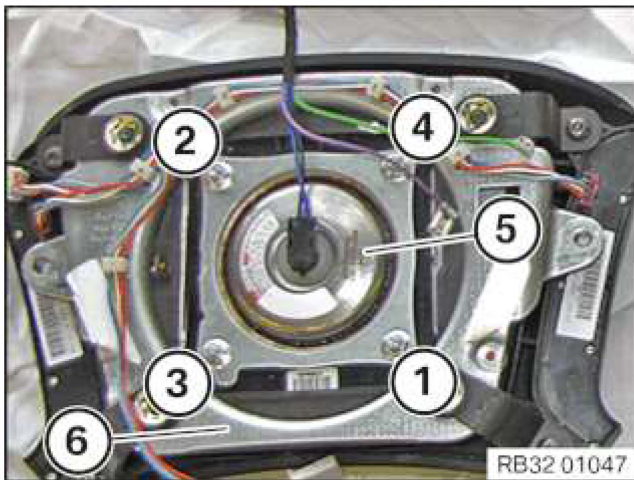
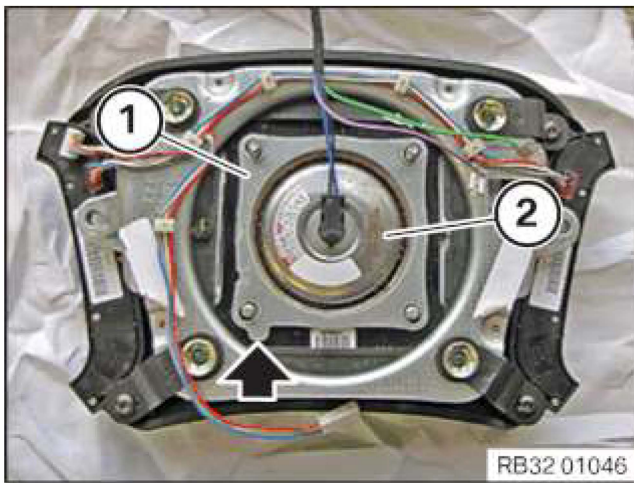
- Remove the previous gas generator (1) and subsequently directly place the new gas generator (2).

The cable and the groove of the new gas generator (2) point upwards.

- Insert the previous gas generator (1) in the packaging (2).

- Position the reinforcement plate (1) over the new gas generator (2).
- Make sure that the groove (arrow) of the reinforcement plate (1) is positioned correctly.

The groove (arrow) points downwards to the left.



- **Auxiliary person:**

Hold the airbag unit (6).

Check whether the nuts have been tightened correctly by the executing person.

The noise must be audible while retorquing.

- **Executing person:**

Lightly screw on the new gas generator (5) with the new nuts in the screwing sequence (1) to (4).

Tighten the nuts in the screwing sequence (1) to (4).

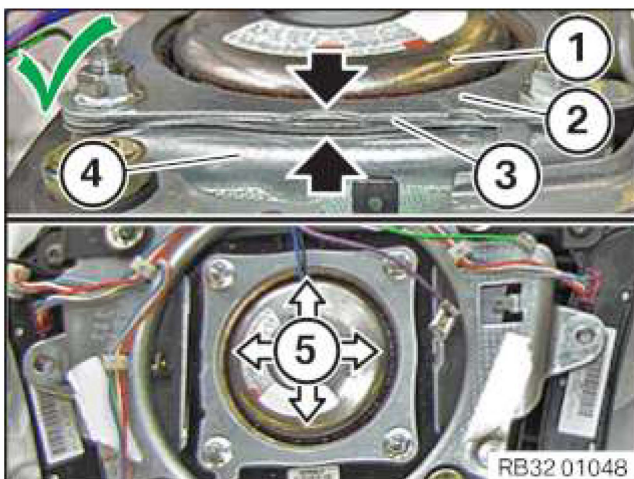
Retorque the nuts in screwing sequence (1) to (4).

### Tightening torques

#### Gas generator to airbag unit

Nut  
Renew nut.

Tightening torque  
5Nm



- **Executing person:**

Visually inspect the gap (3) between the new gas generator (1), reinforcement plate (2) and airbag unit (4) on all four sides (5).

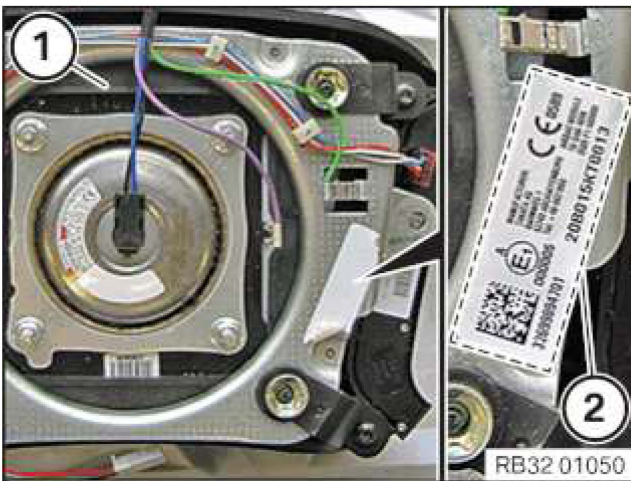
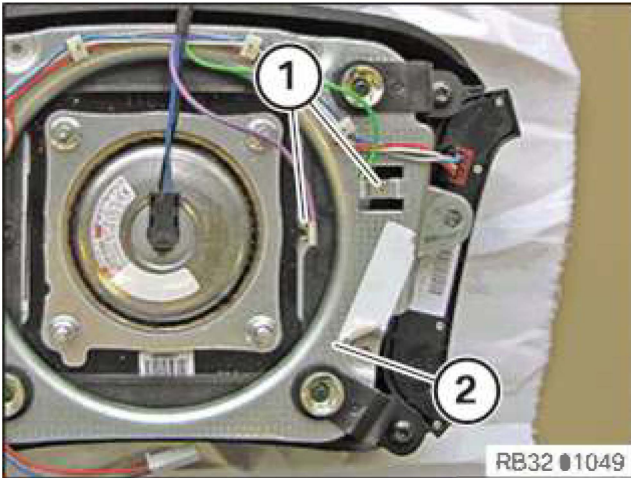
- **Auxiliary person:**

Visually inspect the gap (3) between the new gas generator (1), reinforcement plate (2) and airbag unit (4) on all four sides (5).

- **If the gap (3) is not OK:**

Release the screw connection and tighten again as described in the previous step. If the gap is still not OK, then cancel the repair. Install the new airbag unit in this case.

- Connect both the connectors (1) with the airbag unit (2).



- Glue on the first sticker on the airbag unit (1) with the new number on the position (2).
- Glue on the second sticker on the work order.

- Install the airbag unit and horn switch and if necessary, check the multifunction button for operability.

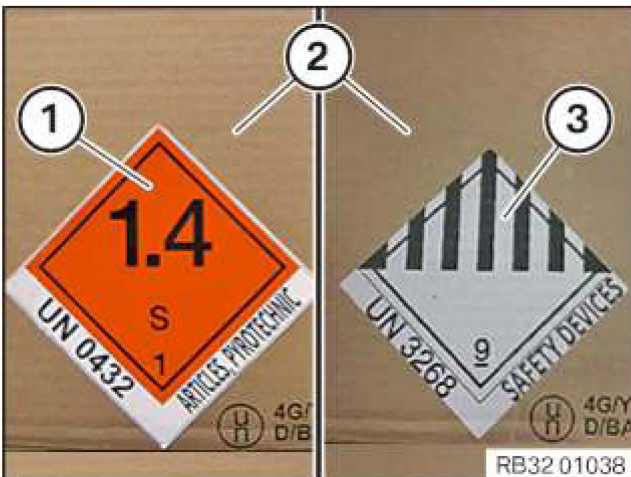
## 3234020

- All except USA:

Affix the hazard sticker (1) externally on the packaging (2).

- USA:

Do not affix any hazard sticker (3) externally on the packaging (2).



**Driver's Front Air Bag Inflator (NADI)  
Model Year 1999-2001 BMW 3 Series  
Safety Recall 19V-853  
Date Issued: 12/4/2019**

**Q1. Which models are included in this Safety Recall Campaign?**

Certain Model Year 1999 through 2001 3 Series Sedan, Coupe, and Sportswagon vehicles (E46), produced from May 1999 through July 2000, are potentially affected. Please refer to the table below for further information.

Series	Model Year	Model	Production Dates
E46	1999-2001	323i, 325i, 328i, 330i	May 1999 – Jul 2000
E46	2000-2001	323Ci, 325Ci, 328Ci, 330Ci	May 1999 – Jun 2000
E46	2000-2001	323iT, 325iT	Sep 1999 – May 2000

**Q2. Which inflator is affected?**

This recall campaign involves vehicles equipped with the single-stage Takata Non Azide Driver Inflator (NADI).

**Q3. What is the specific concern?**

A population of NADI inflators manufactured prior to March 15, 1999 may have been produced with an insufficient seal which could allow moisture to enter the inflator.

**Q4. What can happen as a result of this issue?**

In a crash where the driver air bag deploys, it may not deploy with sufficient restraint capability which could increase the risk of injury. It is also possible that the air bag housing may explode and could cause metal fragments to pass through the air bag cushion material, which may result in injury or death to the driver and/or other vehicle occupants.

**Q5. Can I continue to drive my vehicle?**

Yes. However, when you are notified that a remedy is available for your vehicle, please contact an authorized BMW center immediately to schedule an appointment to have this important **free repair** performed. If you are not the only driver of this vehicle, please advise all other drivers of this important information.

**Q6. Why are you recalling vehicles after March 1999?**

Vehicles produced after March of 1999 may have received an inflator that was produced during the affected period if the air bag module was replaced during a service visit.

**Q7. Why are other BMW models not included?**

Other vehicles have driver front air bags that were produced with different inflators.

**Q8. What is the fix?**

The remedy is currently being developed. When it is available, the driver air bag inflator will be inspected and, if necessary, replaced with a newly designed inflator.

**Q9. How will I be notified of this recall?**

Letters will be sent out in January 2020 via First Class mail, advising customers of this recall. To ensure BMW of North America, LLC has your most recent contact and vehicle information, please register your vehicle at <http://www.bmwusa.com/myBMW>. Registration is free, and will give you access to factory initiated campaigns and other information specific to your BMW vehicle.

**Driver's Front Air Bag Inflator (NADI)  
Model Year 1999-2001 BMW 3 Series  
Safety Recall 19V-853  
Date Issued: 12/4/2019**

**Q10. Do I have to wait for my letter in order to have my vehicle repaired?**

Yes. BMW is in the process of ensuring that the necessary tools, parts, and procedures are available prior to contacting you to schedule an appointment with your authorized BMW center to have this important Safety Recall performed. For the latest updates to this Safety Recall please visit [www.bmwusa.com/recall](http://www.bmwusa.com/recall).

**Q11. Is it possible to find out whether the problem exists in my car?**

No. There is no way to detect if your BMW might have an air bag inflator potentially at risk of rupturing upon deployment in an accident.

**Q12. How did BMW become aware of this issue?**

BMW became aware of this issue through its quality control procedures.

**Q13. I did not receive a letter from BMW regarding my vehicle. How can I find out if my BMW is included in this recall?**

You can enter your vehicle identification number (VIN) at [www.bmwusa.com/recall](http://www.bmwusa.com/recall) and download a sample owner notification letter and Q&A if your VIN is affected. Make sure to update your contact information by registering at <http://www.bmwusa.com/myBMW>.

**Q14. What if I am not the current owner of this vehicle?**

You can update your vehicle ownership information by registering at <http://www.bmwusa.com/myBMW>.

**Q15. Am I eligible for reimbursement under the TREAD Act if I previously replaced my driver's front air bag module?**

In this particular recall, reimbursement is likely not applicable, as you would typically have replaced your driver front air bag module as a result of an accident. In that situation, most likely your insurance company paid for the repair. However, in the very unusual (unlikely) scenario that you previously paid to replace the front air bag module "out-of-pocket" upon learning of this possible defect, you may be eligible for reimbursement. Additional information is provided when BMW mails the letter asking you to make an appointment with an authorized BMW center.

# 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](mailto:Juan.Armstrong@craneww.com)
- Dealers in the Hawaiian Islands, please contact: [Becky.Argyropoulos@craneww.com](mailto: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](mailto: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](mailto: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](mailto:AirbagReturns@bmwna.com)

Defect Code: 00 32 96 02 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.

- Dealers must contact Takata/XPO **Every Other Week** to schedule **BULK** and **SINGLE** recall airbag component shipments. 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.
  - Email: [scfieldaction.14305@xpo.com](mailto:scfieldaction.14305@xpo.com)
  - Phone: 210-250-5079

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- Dealers in the Hawaiian Islands, please contact: [Becky.Argyropoulos@craneww.com](mailto: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](mailto: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".
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For any other questions or concerns, please contact the WPRC: [AirbagReturns@bmwna.com](mailto:AirbagReturns@bmwna.com)