#### OMB Control No.: 2127-0004

### Part 573 Safety Recall Report

Manufacturer Name :BMW of North America, LLCSubmission Date :SEP 24, 2021NHTSA Recall No. :20V-601Manufacturer Recall No. :NR

#### Manufacturer Information :

**Vehicle Information :** 

Manufacturer Name : BMW of North America, LLC Address : P.O. Box 1227 Westwood NJ 07675-1227 Company phone : 18005257417

#### N

Population :

Number of potentially involved : 4,801Estimated percentage with defect : 1%

Vehicle 1:	2020-2021 MINI Cooper Count	ryman All4 SE	
Vehicle Type :	LIGHT VEHICLES		
Body Style :	SUV		
Power Train :	HYBRID ELECTRIC		
Descriptive Information :	Approximately 35 vehicles we not have been produced accord		high voltage battery that may
	Basis for recall population determine the potential population determine the potentially af	tion and supplier prod	
	Recall component difference to One or more battery cells many according to specifications.	-	: er may not have been produced
Production Dates :	MAR 12, 2020 - AUG 19, 2020		
VIN Range 1:	Begin : NR	End: NR	Not sequential

The information contained in this report was submitted pursuant to 49 CFR §573



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Vehicle 2 :	2020-2021 B	MW X3 xDrive	30e	
Vehicle Type :	LIGHT VEHIC	CLES		
Body Style :				
Power Train :	HYBRID ELE	CTRIC		
Descriptive Information :			es were manufactured wit ed according to specificatio	n a high voltage battery that ns.
	Vehicle manu			iction records were reviewed n.
	One or more		e to non-recall component anufactured by the supplie	er may not have been produced
Production Dates :	JUN 03, 2020	- JAN 22, 2021		
VIN Range 1:	Begin :	NR	End: NR	Not sequential
Production Dates :	SUV HYBRID ELE Approximate may not have Basis for reca Vehicle many to determine Recall compo One or more according to JUN 06, 2020	CTRIC ely 1,331 vehicl been produce all population of facturing infor the potentially onent difference battery cells m specifications.	ed according to specification letermination: rmation and supplier produce affected vehicle population e to non-recall component nanufactured by the supplie	action records were reviewed n. er may not have been produced
VIN Range 1:1	Begin :	NR	End: NR	☐ Not sequential

<ul> <li>not have been produced according to specifications.</li> <li>Basis for recall population determination: Vehicle manufacturing information and supplier production records were reviewed to determine the potentially affected vehicle population.</li> <li>Recall component difference to non-recall component: One or more battery cells manufactured by the supplier may not have been produc according to specifications.</li> </ul>	Vehicle Type : Body Style :			
Vehicle manufacturing information and supplier production records were reviewed to determine the potentially affected vehicle population.Recall component difference to non-recall component: One or more battery cells manufactured by the supplier may not have been product according to specifications.Production Dates :MAR 02, 2020 - MAY 02, 2020 VIN Range 1 : Begin :Vehicle 5 :2021-2021 BMW 330e, 330e xDriveVehicle 5 :2021-2021 BMW 330e, 330e xDriveVehicle 5 :2021-2021 BMW 330e, 330e xDriveVehicle 7 :LIGHT VEHICLES Body Style :Body Style :4-DOOR Power Train :Power Train :HYBRID ELECTRICDescriptive Information : vehicle manufacturing information and supplier production records were reviewed to determine the potentially affected vehicle population.Basis for recall population determination: vehicle manufacturing information and supplier production records were reviewed to determine the potentially affected vehicle population.Recall component difference to non-recall component: One or more battery cells manufactured by the supplier may not have been product according to specifications.		Approximately 8 veh		high voltage battery that may
One or more battery cells manufactured by the supplier may not have been produc         according to specifications.         Production Dates :       MAR 02, 2020 - MAY 02, 2020         VIN Range 1 : Begin :       NR         End :       NR         Vehicle 5 :       2021-2021 BMW 330e, 330e xDrive         Vehicle Type :       LIGHT VEHICLES         Body Style :       4-DOOR         Power Train :       HYBRID ELECTRIC         Descriptive Information :       Approximately 692 vehicles were manufactured with a high voltage battery that mot have been produced according to specifications.         Basis for recall population determination:       Vehicle manufacturing information and supplier production records were reviewed to determine the potentially affected vehicle population.         Recall component difference to non-recall component:       One or more battery cells manufactured by the supplier may not have been produce according to specifications.		Vehicle manufacturin	ng information and supplier proc	
VIN Range 1: Begin:       NR       End: NR       Not sequential         Vehicle 5:       2021-2021 BMW 330e, 330e xDrive         Vehicle Type:       LIGHT VEHICLES         Body Style:       4-DOOR         Power Train:       HYBRID ELECTRIC         Descriptive Information:       Approximately 692 vehicles were manufactured with a high voltage battery that monot have been produced according to specifications.         Basis for recall population determination:       Vehicle manufacturing information and supplier production records were reviewed to determine the potentially affected vehicle population.         Recall component difference to non-recall component:       One or more battery cells manufactured by the supplier may not have been produce according to specifications.		One or more battery	cells manufactured by the suppli	
Vehicle 5:2021-2021 BMW 330e, 330e xDriveVehicle Type :LIGHT VEHICLESBody Style :4-DOORPower Train :HYBRID ELECTRICDescriptive Information :Approximately 692 vehicles were manufactured with a high voltage battery that most have been produced according to specifications.Basis for recall population determination: Vehicle manufacturing information and supplier production records were reviewed to determine the potentially affected vehicle population.Recall component difference to non-recall component: One or more battery cells manufactured by the supplier may not have been produc according to specifications.				🗌 Not sequential
		Approximately 692 v not have been produce Basis for recall popul Vehicle manufacturin to determine the pote	ced according to specifications. ation determination: ng information and supplier proc entially affected vehicle populati ference to non-recall componen cells manufactured by the suppli	luction records were reviewed on. t:
Production Dates :MAR 05, 2020 - SEP 24, 2020VIN Range 1 : Begin :NREnd :NRImage 1 : Begin :NR			ations.	

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	formation contain	ed in this report w	as submitted pursuant t	0.40 CED 8572
	2: NR			
Description of the Defe	specification	ns. During batte o enter one or m	ery cell production at	luced according to the supplier, debris may have a result, this could lead to
escription of Defect :	t. The birth are	14 h 44		luced according to
VIN Range 1:	Degin :	NR	End: NR	☐ Not sequential
Production Dates :			End ND	Not convertial
	-	ttery cells manu	non-recall component ifactured by the supp	nt: lier may not have been produced
	Vehicle manufa			oduction records were reviewed tion.
Descriptive Information :			manufactured with a ling to specifications.	ı high voltage battery that may
Power Train :	HYBRID ELECT		<b>A</b>	
Vehicle Type : Body Style :	LIGHT VEHICLI 4-DOOR	ES		
	2021-2021 BM			
VIN Range 1:		NR	End: NR	☐ Not sequential
Production Dates :	according to sp	ecifications.	nactared by the supp	
			non-recall component	nt: lier may not have been produced
	Vehicle manufa			oduction records were reviewed tion.
Descriptive Information :			ere manufactured wit ling to specifications.	h a high voltage battery that may
Power Train :	HYBRID ELECT			
Vehicle Type : Body Style :	LIGHT VEHICLI 4-DOOR	ES		
			Drive, 530e iPerforma	ance

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Description of the Safety Risk Description of the Cause	<ul> <li>In rare cases, the short-circuit could l increase the risk of an injury.</li> <li>NR</li> </ul>	ead to a thermal event which could	1
Identification of Any Warnin that can Occur			
Involved Components :			
Component Name 1:	High-Voltage Battery Module		
Component Description :	High-Voltage Battery Module		
Component Part Number :	BMW 3-5-7-X3 & MINI Countryman-86 X5-8678566-10/567-10; BMW I8-9452		
Supplier Identification :			
Component Manufacturer			
Name : Samsung			
Address: 150-20			

#### **Chronology** :

Country: Korea, Republic of

On August 4, 2020, BMW became aware of a field incident involving a Model Year 2021 BMW X5 SAV in which the vehicle experienced a thermal event. An analysis was initiated. Between early August and mid-September, BMW became aware of three additional field incidents.

Gongse-ro Giheung-gu Yongi-si, Gyeonggi-do Foreign States 17084

A review of supplier production and process change records indicated that for the incident vehicles, battery cell production at the supplier occurred during a specific and limited time period. Further reviews indicated that during this time period, a higher rate of impurities (debris) could have been allowed to enter one or more battery cells.

Vehicle assembly information and supplier production and process records were reviewed to determine the number, and production dates, of potentially affected vehicles.

On September 23, 2020, BMW decided to conduct a voluntary safety recall.

BMW Group has not received any reports, nor is BMW Group otherwise aware, of any accidents or injuries

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related to this issue.

Although the recall had been implemented, the field continued to be monitored. In May 2021, a field incident occurred involving a vehicle affected by 20V-601 but it did not require replacement of battery modules. Although efforts were made to retrieve and analyze the battery, the battery has only recently been provided to BMW for analysis. The root cause of the May 2021 incident has yet to be determined.

On Sept 17, 2021, BMW decided, in abundance of caution, to replace the affected battery module(s) on all potentially affected vehicles.

#### **Description of Remedy :**

Description of Remedy Program :	The affected battery modules will be replaced. Until the remedy is performed, drivers will be instructed to not charge their vehicles. Drivers will also be instructed to not drive in manual mode, sport mode, and to not use the shift paddles. Owners will be notified by First Class mail advising them of the recall and, if the remedy is available, to schedule an appointment with an authorized BMW dealer to have the remedy performed for free. If the remedy is not yet available, then when the remedy becomes available, owners will be notified by a follow-up letter advising them to contact an authorized BMW dealer for the remedy. If this condition were to occur to a potentially
	affected vehicle prior to this recall, the remedy would be covered by the BMW/MINI New Vehicle Limited Warranty program. Therefore, reimbursement for a pre-notification remedy re Part 573.13 and Part 577.11 is not necessary.
	Recall component: High Voltage Battery – p/n [Modules: (BMW (3-5-7-X3) and MINI Countryman – 8658344-11/345-11); (BMW X5 – 8678566-10/567-10); (BMW I8 – 9452661-04)].
Identify How/When Recall Condition was Corrected in Production :	NR
Recall Schedule :	
	Dealer notification is expected to begin and end on September 30, 2020.
	Owner notification is expected to begin and end on November 23, 2020.
Planned Dealer Notification Date :	SEP 30, 2020 - SEP 30, 2020

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Planned Owner Notification Date : NOV 23, 2020 - NOV 23, 2020

\* NR - Not Reported

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