

Service Information Bulletin

September 26, 2022

Fuel Systems

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.

RECALL 22V-683: REPLACING HIGH-VOLTAGE CELL MODULE

MODEL

E-Series	Model Description
G12 PHEV	745e xDrive

AFFECTED VEHICLES

Vehicles which require this 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 has issued a Recall on one Model Year 2021 BMW 745e xDrive vehicle that was produced on August 23, 2021.

It was found in very rare cases that faults could have occurred in the winding of cell-internal foils of the high-voltage cell module.

CAUSE

Faults could have occurred in the winding of cell-internal foils of the high-voltage cell modules.

CORRECTION

Replacement of the affected cell module.

PROCEDURE

Important Warning for Working on the High-Voltage (HV) systems on BMW Group vehicles:

Only properly trained personnel, who passed all applicable HV Technical Training Courses, should perform repairs which require disconnecting, or removal of High Voltage battery components on any Hybrid or Electric Vehicle. Work performed on High Voltage systems by unqualified persons may result in severe injury or damage to the vehicle. Additional safety information is found in Repair Instruction 61 00... "Observe safety instructions when handling electric vehicles".

Additional Information:

Scheduled Maintenance, or Quality Certification 1 (Pre-Delivery Inspection) on Electric or Hybrid vehicles does not require HV technical training.

Prior to disconnecting, or the removal of any HV component, the HV system needs to be disabled and secured (by means of the HV Disconnect Switch) by a properly trained technician, who has a minimum HV Qualification level after completing the Technical Training Course ST1824 (Alternative Drive Part 1). Once the vehicle's HV system is disabled (the "Blitz" - lightning bolt icon displayed in instrument cluster, see below), a technician without HV

Certification may remove a HV component (e.g., EH Heater, EKK Compressor, EME Control Unit, et.), except for the High Voltage Battery.



High Voltage Battery removal and rework can be performed **ONLY** by a HV Specialist Technician (certified by the Technical Training Course ST1825 – Alternative Drive Part 2), **AND** with a HV Battery Certification level corresponding to a specific Electric or Hybrid vehicle (e.g., to repair GEN4 battery of G05 PHEV, certification from Technical Training Course “ST2006 – SP44 HV Battery” is required).

Perform Service Function “High-voltage battery unit: Read out stored series numbers”, this can be found in the following location in ISTA: Service Function / Power train / Hybrid car / High-voltage battery unit: read serial numbers stored on SME / High-voltage battery unit: Read out stored series numbers

Once you have read the cell module serial numbers, replace the affected cell module with the Serial Number listed **below** per REP – “Replace cell module 1 (High-voltage battery unit removed) (high-voltage battery unit lid removed) (after vehicle diagnosis).”

Note: The repair instruction listed above is an example for cell module 1 but the repair instruction name is the same for all cell modules and only the cell number is different (i.e., 1-6). Use the required repair instruction for the cell module number that is being replaced.

Cell Module Serial Number	ISTA Cell Module ID Number
8658344136251527121071311015	5834413 62 11015 28/09/1951 10713

PARTS INFORMATION

Please enter a Recall IDS Ticket and the parts listed below will be ordered for you.

Part Number	Part Description	Quantity
61 27 8658344	Cell module of high-voltage battery (34AH NEG)	1 as required:
61 27 8658345	Cell module of high-voltage battery (34AH POS)	1 as required:
61 27 8 606 057	Torx socket	24
26 11 7 527 475	Hexagon bolt	3
26 12 7 536 563	Hexagon nut	3
18 30 5 A09 B63	V clip	1
07 11 9 904 024	Hexagon nut	4
18 30 9 909 376	Hexagon bolt	1
07 14 7 413 212	Combi-hexagon screw	6
07 12 9 908 570	Torx socket	4
61 27 8 620 917	Seal for high-voltage battery	1
61 27 8 677 638	Hexagon screw with internal Torx	49
61 25 8 632 010	Hexagon bolt	2
83 19 2 446 563	Refrigerant R1234yf	Qty if/as needed

Additionally, other small parts that are not specified above, such as one-time use screws, nuts, O-rings and seals, which must be replaced according to the ISTA repair instructions/ETK, must be

selected from the Electronic Parts Catalogue according to the respective vehicle type and invoiced under the special defect code.

Recalled Part Retention

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

Please DO NOT return these recalled High Voltage (HV) battery modules directly to the WPRC or through the current HV Battery return process.

Please refer to the following document for the procedure that applies to returning these Recalled HV Battery Modules:

- **Bulletin #: C-2-0407-0603_HV-Battery_Recall_Return_Process**

And, for the latest related training, refer to:

- **Bulletin #: B-2-0322-0301_HV-Battery_Recall_Training**

For more information refer to CenterNet: "Menu>BMW>Aftersales>Business Development & Marketing Portal>Batteries>HV Training Module".

CLAIM INFORMATION

Reimbursement for this Recall will be via normal claim entry utilizing the applicable work package information below with the additional repair-relate FRU allowances and the part numbers listed above that apply:

Defect Code:	0061100700	Replacing high-voltage cell module(s)
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Plus work (+)	Completion before the first vehicle delivery to a customer or the vehicle is already in the workshop
Main work	The vehicle arrives at your center and this Recall shows open (No other Main work will be performed or claimed during this workshop visit)

6-Module Configuration G12

Work Pkg	Labor Operation	Description	Labor Allowance
# 1	00 73 573	Checking the vehicle and removing and installing the high-voltage battery (Plus)	49 FRU
# 2	00 73 035	Checking the vehicle and removing and installing the high-voltage battery (Main)	50 FRU

Add the following FRU allowance to the labor above that applies (00 73 573 or 00 73 035)

Description	Labor Allowance
Additional job/work to remove and attach the lid (includes High-voltage battery unit final test after repairing the high-voltage battery unit)	11 FRU

Then add FRU amount that applies to the cell module repair below that was performed (A, B, C, D or E)

Description	Labor Allowance
Job/repair work time for replacing one or more of the 6 cell modules (top and/or bottom	Additional FRU to claim (See below)

A. Front Modules (up to 2)

Labor Description	Cell(s)	FRU
Replacing a cell module (# 5 POS) (Front Left); Or:	1	4
Replacing a cell module (# 2 NEG) (Front Right) Or:	1	6
Replacing a cell module (Both) (Front Left and Right)	2	10 Total

Or:

B. Top Rear Modules (up to 2)

Labor Description	Cell(s)	FRU
Replacing a cell module (# 4 POS) (Top Rear Left) Or:	1	4
Replacing a cell module (# 3 NEG) (Top Rear Right) Or:	1	3
Replacing a cell module (Both) (Top Rear Left and Right)	2	7 Total

Or:

C. Front and Top Rear Modules (All 4, A - 10 FRU plus B - 7 FRU)

Labor Description	Cell(s)	FRU
Replacing a cell module (All) (Front and Rear Top)	4	17 Total

Or:

D. Rear Bottom Modules (up to 2) Including the rear Top Modules as required (up to 2, for a total of 4)

Labor Description	Cell(s)	FRU
Replacing a cell module (# 6 POS/ # 4 Pos) (Bottom/Top, Rear Left) Or:	1 up to 2	12
Replacing a cell module (# 1 NEG/ # 3 NEG) (Bottom/Top, Rear Right) Or:	1 up to 2	12
Replacing a cell module (Both) (Bottom/Top Rear, Left and Right)	2 up to 4	24 Total

Or:

E. Front (All 2), Rear Bottom (All 2)/Top Modules (0 to 2) or All 6 Modules

Labor Description	Cell(s)	FRU
Replacing a cell module (Front, Rear Bottom/Top)	4 to 6	32 Total

Claim Repair Comments

Only reference the Defect Code, work package (Pkg) number performed, and cell module replaced by their reference number in the RO technician notes and the claim comments (For example: 0061100700 WP 1, Cell modules 2, 4, 5), unless otherwise required by State law.

Sublet – Bulk Materials (RO and Claim Comments Required)

Sublet Code 4	Up to \$100.00	Reimbursement for the repair-related bulk materials (Do not use the BMW part numbers for claim submission)
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Sublet reimbursement calculation for claiming the applicable repair-related bulk materials (BMW part numbers) is at the dealer net price amount for the quantities used plus your center’s handling.

Enter this material cost in sublet and itemize the amount on the repair order and in claim comment section

And, if applicable:

Alternative Mobility Solution (AMS) for Vehicle Owners (RO and Claim Comments Required)

This Recall repair qualifies for Alternative Mobility Solution (AMS) expense reimbursement, claim this item under the Defect Code noted above as follows:

Sublet Code 2 - Itemize the AMS sublet amount on the repair order and in the claim comment section.

Please refer to SI B01 29 16 for additional information.

FEEDBACK REGARDING THIS BULLETIN

Technical Feedback	To submit feedback for the technical topics of this bulletin: Submit your feedback in the rating box at the top of this bulletin
Warranty Feedback	To submit feedback for the CLAIMS section of this bulletin: Submit an IDS ticket to the Warranty Department, or use the chat available in the Warranty Documentation Portal
Parts Feedback	To submit feedback for the PARTS section of this bulletin: Submit an IDS ticket to the Parts Department