SIB 51 15 25

RECALL 25V-556: WINDSHIELD BONDING INSPECTION

2025-11-25

This Service Information Bulletin (Revision 6) replaces SI B51 15 25 **dated November 2025.**

What's New:

- Parts Information updated
- Claim Information updated for third-party windshield sealing repair

☐	THIS REPAIR IS MOBILE FRIENDLY
☐	THIS REPAIR IS REMOTE SOFTWARE UPGRADE (RSU) FRIENDLY

MODEL

E-Series	Model Description	Production Date
F95	X5 M Sports Activity Vehicle	August 5, 2025 – August 11, 2025
G05	X5 Sports Activity Vehicle	August 5, 2025 – August 11, 2025
G07	X7 Sports Activity Vehicle	August 5, 2025 – August 11, 2025

AFFECTED VEHICLES

Vehicles which require this campaign to be completed will show it as "Open" when checked either in AIR, AWP, Campaign Summary or Warranty Vehicle Inquiry.

Please make sure you check your dealer inventory as soon as possible. As of August 21, 2025, you can see a list of affected vehicles in Inventory Campaign Details (ICD) under ROSS.

SITUATION

BMW AG has issued a Delivery Stop (effective August 20, 2025) on certain Model Year 2026 BMW vehicles that were produced between August 5, 2025, and August 11, 2025.

As of August 27, 2025, this Delivery Stop has been upgraded to a Safety Recall.

This safety recall involves the sealing of the windshield to the vehicle which may not have been performed according to specifications. It could be possible for water to enter the vehicle and contact certain electronic components. In rare cases, this could lead to a short circuit and, in an extreme case, a thermal event, even if the ignition was off, which could increase the risk of injury.

The Recall Notice and FAQ have been attached for further information.

Do not deliver to a customer, a New, Certified Pre-Owned or Used vehicle subject to a Delivery Stop, until the vehicle is repaired. Do not use or sell replacement equipment/parts subject to a Delivery Stop.

CORRECTION

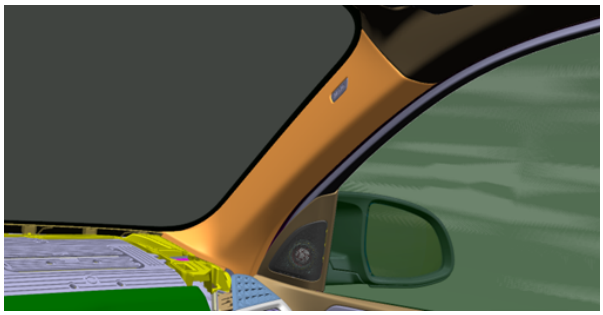
Inspect the front windshield adhesive bead on the passenger side bottom A-pillar.

PROCEDURE

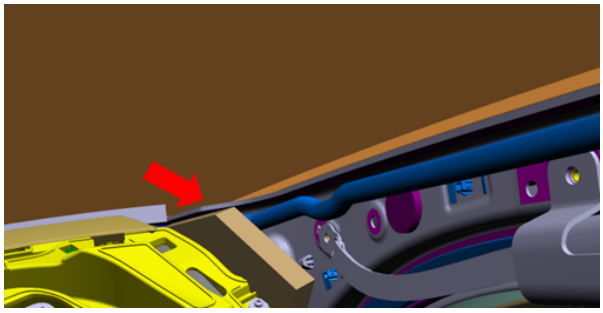
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1. Remove the right-side (passenger side) drip molding **(highlighted in orange)** following the repair instructions listed in ISTA/AIR 51 31 030.

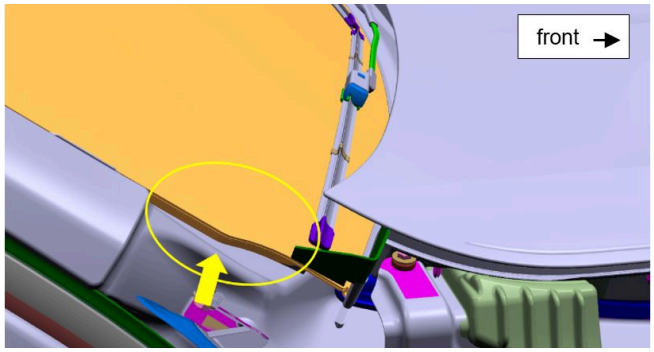


2. Remove the right-side A-pillar interior trim panel **(highlighted in orange)** following the repair instructions listed in ISTA/AIR 51 43 201.



3. Two technicians are momentarily required for this step.

Technician 1: Apply compressed air (24-34 PSI) from the inside of the windshield **(red arrow pointing to the area)** using a long-nozzle compressed air gun tool.



4. Technician 2: At the same time while compressed air is being applied at the bottom right of the windshield from inside the vehicle by technician 1, using a spray bottle with soapy water, spray the bottom right of the windshield **(yellow arrow and circle)** from outside the vehicle.

- **WP 1 or 3:** If no soap bubbles form in the area between the vehicle's body and windshield, the adhesive bonding of the windshield is **OK**, and no further repairs are needed, and the campaign can be closed.

  For vehicles that pass the inspection procedure, the right-side front drip molding must still be replaced after its removal.

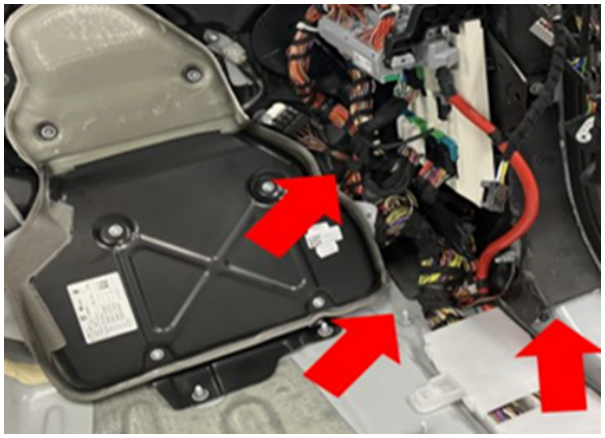
- **WP 2, 4, with added Work Pending:** If soap bubbles form in the area between the vehicle's body and windshield, the adhesive bonding of the windshield is **NOT OK**. Proceed to the next step.

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5. The interior of the vehicle needs to be checked for water ingress. Inspect the right front footwell (passenger's side, per dotted lines). Water can spread throughout the footwell (depending on the location where the vehicle is parked, such as on a slope), the front left footwell and, if necessary, the rear areas must also be checked.

6. Remove the footwell side trim panel on the right-hand A-pillar (arrow) in accordance with repair instructions 5143075 and the trims on the left and right of the front and rear door sill strips.



7. Fold back the floor carpet and check the area for any water ingress.

Check for water ingress directly on the floor panel and on the foam of the floor trim with a normal paper tissue.

Also check the bulkhead sound insulation and the foam in the lower area around the BCP and the main wiring harness (see photo).



8. Remove the windshield and reach with your hand between the bulkhead and foam insulation, and check for moisture in the bulkhead foam as shown.

9. If any water ingress is found in any of the steps 5-8, **reinstall and re bond the original windshield**. **Stop and do not proceed any further**. If a TSARA Info only case was previously submitted for this vehicle, update it with pictures and details of the water ingress. If a TSARA Info only case has not been previously submitted, then submit one with pictures of the water ingress

10. If there are no signs of water ingress in steps 5-8, **reinstall and re bond the windshield** per the Repair Instructions 5131000 Removing and installing windshield, along with the interior parts that were previously removed in order to perform the inspection. **The repair is complete and the car can be sold.**

Note: DO NOT sell or deliver any vehicle that did NOT pass the inspection.

PARTS INFORMATION

Use and invoice the part numbers below that apply.

To determine certain other part numbers that apply to the specific vehicle being repaired, enter the VIN / Chassis number into either ETK or AIR, this will consider the specific equipment and/or options that are fitted to the vehicle.

Work Package # 1 or # 3 (Reapplying Adhesive is not Required)

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Part Number	Description	Quantity
Refer to ETK/AIR	Drip molding, right (WP #1 - #3 only)	1
51 31 7 437 711	Clip, drip molding	1

Work Package WP #2, #4, #5, or #6 (Reapplying Adhesive is Required)

Part Number	Description	Quantity
Refer to ETK/AIR	Drip molding, right (From WP #1 - #3 only)	1
Refer to ETK/AIR	Drip moulding, left (WP #2, #4, #5 or #6 only)	1
51 31 7 437 711	Clip, drip molding	Up to 10
51 31 7 412 641	Upper windscreen cover	1
51 31 7 288 462	Buffer	4
Refer to ETK/AIR	Bulkhead sound insulation	As applicable
83 19 2 289 180	Windscreen adhesive kit (300 mL / 10.1 fluid ounces)	1
83 19 2 289 181	Window glass adhesive (300 mL / 10.1 fluid ounces extra)	1

Sublet - Reapplying Adhesive Bulk Supply Materials (Work Package WP #2, #4, #5, or #6)

Part Number	Description	Quantity
61 13 8351989	Fabric adhesive tape (DN = 1 meter, this rounds up to L = 50 m, W = 30mm)	Sublet – 5 meters
83 19 2 211 217	Cleaner R1 (DN = 100 mL / 3.4 Fl ounces)	Sublet

Additionally, other materials and small parts that are not specified above, such as fluids, lubricants (in sublet), one-time use screws, nuts, and seals, which must be replaced or installed (according to the ISTA repair instructions/ETK/AIR), are to be selected from the Electronic Parts Catalog, and/or other approved BMW Group's resources according to the respective vehicle type. Invoice these items separately under the Repair Code listed in this bulletin.

CLAIM INFORMATION

Reimbursement for this Recall will be via normal claim entry utilizing the applicable work package information, the additional work when required, and the part numbers above that apply.

Repair Code:	**0051290600**	**G05 G07 F95 Checking windscreen bonding, reworking if necessary**

Only one Main work flat rate labor operation code can be claimed per workshop visit.

Plusposition (+)	Completion before the first vehicle delivery to a customer (New in-stock/No in-service date), or the vehicle is already in the workshop for another reason and/or repair, identified by the **"(Plusposition)"** reference in the descriptions below.
Main work	The vehicle arrives for this Recall, no other Main work will be performed/claimed during this workshop visit, identified by the **"(Main work)"** reference in the descriptions below
Associated work	Additional/expanded job/work task(s) that are beyond the scope of the preliminary job/work task (Plusposition or Main)

Below are the special flat rate labor operation code choices for this action.

A. Reapplying Adhesive is not Required

Work Package	Labor Operation	Description	Labor Allowance
# 1	00 78 812	Check windscreen bonding with test result **OK (Plusposition)**	5 FRU

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# 3	00 78 262	Check windscreen bonding with test result **OK (Main work)**	6 FRU

Or:

B. Reapplying Adhesive is Required – Center Inspection and Windshield Repair

Work Package	Labor Operation	Description (Main work)	Labor Allowance
# 2	00 78 813	Check windscreen adhesive bond (leaking – **not OK**) and reapply adhesive **(Plusposition)**	26 FRU
Or:			
# 4	00 78 263	Check windscreen adhesive bond (leaking – **not OK**) and reapply adhesive **(Main work)**	28 FRU

And:

Sublet Code 4 – Center Repair: Reapplying Adhesive Bulk Supply Materials (RO and Claim Comments Required)

Sublet Code 4	Reimbursement for the supported amount of repair-related bulk supply materials (Do not use the BMW part numbers for claim submission)	Up to $30.00

Sublet reimbursement calculation for claiming the applicable repair-related bulk supply materials (BMW part numbers) is at the dealer net (DN) price for the full or proportional 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.

Additional Work - Required with WP #2 or #4

Expanded WP	Labor Operation	Description (Associated work)	Labor Allowance
A	00 78 814	Additional work/check vehicle interior front and rear on left and right for moisture **(OK)**	13 FRU (G07); 16 FRU
Or:			
B	00 78 815	Additional work/check vehicle interior front and rear on left and right for moisture **(not OK)**	13 FRU (G07); 16 FRU

Or:

C. Reapplying Adhesive is Required - Center Inspection with a Third-Party Windshield Repair

Work Package	Labor Operation	Description	Labor Allowance
# 5	00 78 812*	Check windscreen bonding with test result (leaking – **not OK**) **(Plusposition)**	5 FRU
Or:			

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# 6	00 78 262*	Check windscreen bonding with test result (leaking – **not OK**) **(Main work)**	6 FRU

(*) The same flat rate operation codes for WP #1 and #3 are also being used for this inspection/third-party repair procedure, WP #5 and WP #6 above.

And with:

Third-Party Reapplying Windshield Adhesive (Associated work)

Sublet Code 3	Third-party windshield remove and install to reapply adhesive (Sublet labor only at cost with no markup, the applicable BMW part numbers are to be billed out and claimed)	See below

And:

Labor Operation	Description	Labor Allowance
00 78 851	Additional work for the KAFAS camera **without** a programming and encoding procedure being performed for campaign or another repair	5 FRU
Or:		
00 78 852	Additional work for the KAFAS camera **with** a programming and encoding procedure being performed for campaign or another repair	1 FRU

And:

Additional Work - Required with WP #5 or #6

Expanded WP	Labor Operation	Description (Associated work)	Labor Allowance
A	00 78 814	Additional work/check vehicle interior front and rear on left and right for moisture **(OK)**	13 FRU (G07); 16 FRU
Or:			
B	00 78 815	Additional work/check vehicle interior front and rear on left and right for moisture **(not OK)**	13 FRU (G07); 16 FRU

Claim Repair Comments

Reference the SIB number, the issue (briefly), and the work package (WP) number performed in the technician's RO notes, and in the claim comments (For example: B51 15 25 Front windshield bonding WP 2), unless otherwise required by State law.

Also, explain the expanded work package task that was performed (OK, or not OK).

Sublet Code 3 – Third-Party Reapplying Adhesive (RO and Claim Comments Required)

Invoice the corresponding third-party reapply adhesive work (Labor portion only) on the repair order at the actual cost charged with no handling or markup. The sublet must also include any discounts or allowances.

Appropriate charges are determined by comparing them to the corresponding warranty rates. Prior to

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required for price comparison purposes.

It is your center's responsibility to review the repair cost estimate prior to the repair being performed. This will help ensure that the amount requested is consistent with what is normally recognized as customary, fair, and reasonable. Also, it must not exceed the scope of the repair work that is described in this bulletin.

Itemize the claimed sublet amount on the repair order and in claim comment section.

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

This Recalls' 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.

BMW Group's AIR Application Resource for Flat Rate Labor Operation Codes

To obtain the corresponding flat rate unit (FRU) allowance information from the BMW Group AIR application resource, start by entering the Chassis Number (last seven (7) characters of the VIN), and click on the "Search" icon. If the "Vehicle Selection" window displays two or more model possible vehicle choices, select the applicable Model, or enter the full VIN (17 characters) instead to proceed. Click on the "Flat Rate Units" button and enter a flat rate labor operation code number "without spaces" in the field to the right, click on the "Search" icon to display the corresponding listing of "Flat rate unit group details" that are available and their corresponding FRU allowances.

Reimbursement of Prior Customer-Pay Repairs (TREAD Act)

Based on the issue, and the age of the Affected Vehicles being addressed by this Safety Recall Campaign, a reimbursement request for a qualifying prior customer-pay repair is not likely.

However, if you do receive a reimbursement request from a customer for a prior repair that may qualify, please contact the Warranty department (include a legible copy of the invoice) through IDS by selecting Coverage, Policy, Coding Questions and Mileage Corrections. The Warranty department will review and respond to your inquiry accordingly.

FEEDBACK REGARDING THIS BULLETIN

Technical Feedback	To submit feedback for the technical topic 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

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Supporting Materials
picture_as_pdf B511525 Recall Notice.pdf
picture_as_pdf B511525 V-556-WindshieldSeal-FAQ-(27Aug2025).pdf

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SAFETY RECALL NOTICE

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

RE: Recall 25V-556: Windscreen Bonding – B51 15 25

BMW AG has issued a Delivery Stop (effective August 20, 2025) on certain Model Year 2026 BMW vehicles that were produced between August 5, 2025, and August 11, 2025.

As of August 27, 2025, this Delivery Stop has been upgraded to a Safety Recall.

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.

Safety Recall
25V-556
Windshield Seal
Model Year 2026
BMW X5, X7
08/27/2025

Q1. Which BMW models in the US are potentially affected by this Safety Recall?
Certain Model Year 2026 BMW X5 and X7 models, in the US, are potentially affected.

Q2. What is the specific issue?
This safety recall involves the sealing of the windshield to the vehicle which may not have been performed according to specifications. It could be possible for water to enter the vehicle and contact certain electronic components. In rare cases, this could lead to a short circuit and, in an extreme case, a thermal event, even if the ignition was off, which could increase the risk of injury.

Q3. Why are other models / vehicles not included in this Safety Recall?
Other models have had the windshield sealed according to specifications.

Q4. Can I continue to drive my vehicle?
Yes. However, when you are notified by BMW of this Safety Recall that a remedy is available, please contact an authorized BMW center to schedule an appointment as soon as possible. For the latest updates to this Safety Recall, please visit bmwusa.com/recall. **If you are not the only driver of this vehicle, please advise all other drivers of this important information.**

Q5. How did BMW become aware of the issue?
BMW became aware of the issue through its quality control procedures.

Q6. How will I be informed of this Safety Recall?
Owners of potentially affected vehicles will be notified via First Class mail advising them of this Safety Recall and to schedule an appointment with an authorized BMW center as soon as possible to have the remedy performed. To locate your nearest authorized BMW center, please visit bmwusa.com/dealer.

To ensure BMW has the most up-to-date contact and vehicle information, owners should register their vehicle at bmwusa.com/myBMW. Registration is free and will give them access to other information specific for their BMW vehicle. Alternatively, owners can visit bmwusa.com/recall and click on "**Manage recall notices and contact information".**

Q7. How will my vehicle be remedied?
Potentially affected vehicles will have the windshield sealing checked and, if necessary, resealed, and any electronic components and wiring checked and, if necessary, replaced, at no charge to the owner, which could take up to several hours.

Q8. Do I have to wait for BMW to contact me to have the remedy performed?
Yes. BMW is currently in the process of ensuring that the necessary tools, parts, and procedures are available prior to contacting you to schedule an appointment with an authorized BMW center. For the latest updates to this Safety Recall, please visit bmwusa.com/recall.