

**SUBJECT****Tail Lamp Is Loose in the Trunk Lid****MODEL**

F30

Produced from November 2011

SITUATION

The customer may notice the tail lamp is either loose or protruding outward from the trunk lid.

CAUSE

The tail lamp is not attached to the trunk lid properly.

PROCEDURE

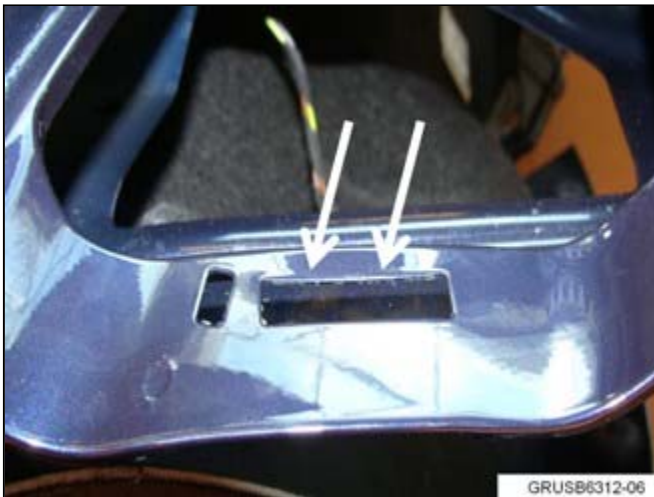
1. Check both rear trunk lid tail lamps for looseness or protrusion. If improper tail lamp fitment is noted, remove both left and right tail lamps. Refer to ISTA Repair Instruction 63 21 240 and 63 21 245.



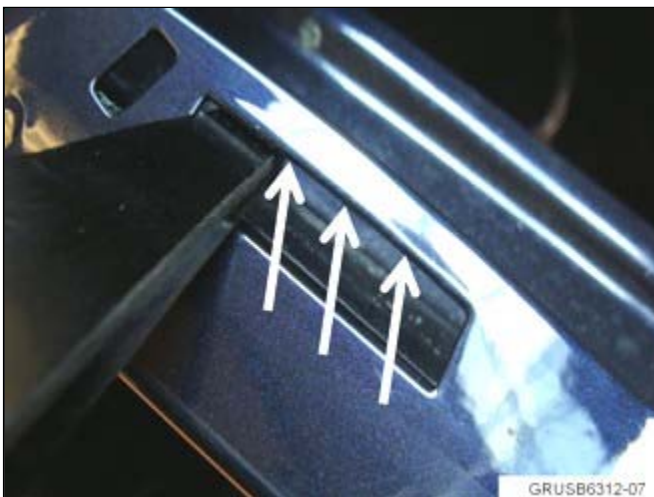
2. Place the tail light upside down on a clean work surface and locate the securing hook of the tail lamp.



3. Clean the securing hook and metal trunk lid contact areas thoroughly; then apply the cold windshield adhesive to the center area of the securing hook, as shown. The adhesive application must be 4 to 5mm thick.



4. Before installing the taillight, inspect the trunk lid where the taillight was removed. Check the sheet metal area where the taillight hook is inserted. In this case, you can see by the reflection (white arrows) the sheet metal has been bent down by the hook during installation. This will not allow the hook to fully seat properly under the metal lip and needs to be corrected.



5. To correct this, insert a plastic tool as shown and gently pry up the inside metal lip in multiple steps for the entire length of the opening. The metal lip must be even and parallel to the opening for the hook to secure underneath the lip properly.

6. Reinstall the tail lamp (with adhesive) into the trunk lid and ensure the hook is full seated under the metal tab, and then push the taillight inward before final tightening.

7. Repeat the same procedure to the opposite side tail lamp.

PARTS INFORMATION

Part Number	Description	Quantity
83 19 2 223 666	Windshield adhesive (cold 1 hour) 300ml	See sublet below

Note: The windshield adhesive tube can be used multiple times by allowing the adhesive in the nozzle tip to cure, then when needed again, simply unscrew the nozzle tip.

WARRANTY INFORMATION

Covered under the terms of the BMW New Vehicle/SAV Limited Warranty.

Defect Code:	63 21 15 37 00	
Labor Operation:	Labor Allowance:	Description:
63 21 250	Refer to KSD2	Removing and installing or replacing both tail lamp (on the luggage compartment lid)
and		
63 99 00	2 FRU	Work time to apply adhesive to both tail lamps
and		
Sublet Code		Reimbursement, up to the listed amount - sublet code 4, for the used quantity of Windshield Adhesive Cold 1 hour (P/N 83 19 2 223 666) required to perform this repair. Please do not use this part number for claim entry.
	\$1.00	

Labor operation code 63 21 250 is a Main labor operation. If you are using a Main labor code for another repair, use the Plus code labor operation 63 21 750 instead.

Refer to KSD2 for the corresponding flat rate unit (FRU) allowance. Enter the Chassis Number, which consists of the last 7 digits of the Vehicle Identification Number (VIN). Click on the "Search" button, and then enter the applicable flat rate labor operation in the FR code field.

Even though work time labor operation code 63 99 000 ends in "000," it is not considered a Main labor operation.