SI B63 04 15
Lights

May 2015
Technical Service

SUBJECT
Traces of Condensation Appear in Rear Tailgate Lights

MODEL
I01 (i3, i3 REx)

SITUATION

	The rear tailgate lights on one or both sides show traces of condensation in the clear lens.

CAUSE
Excessive moisture can escape into the tail light, creating condensation. There is not enough heat from the LED tail light to evaporate the condensation during short trips.

CORRECTION

- Check for any external leaks on the affected rear light.
- Check that all trim pieces attached to the tailgate are not loose or missing.

The rear light is part of the rear tailgate and cannot be replaced separately. To dry out the rear light, follow the preliminary work per the following ISTA Repair Instructions:

- REP 51 49 015 Removing and installing/replacing the cover for the rear window frame at top
- REP 51 49 003 Removing and installing/replacing cover for rear window frame on left or right
- REP 51 49 000 Removing and installing or replacing trim for rear lid
- REP 63 21 800 Removing and installing/replacing left rear light printed circuit board

	After removing the rear circuit board, dry out the lens area with an adjustable temperature heat gun. **It is important that the temperature not be higher than 140 F, to avoid damage to the lens and LED.**

	If you have moisture on the other side, perform the same procedure.

Note: Lens damage due to repair procedure-related overheating is NOT covered.

	After drying, all condensation will have evaporated. If there is no further damage: • Reinstall the circuit board. • Reinstall the trim for the rear lid. • Reinstall all covers for the frame. Road test and check for rattles.

NOTE: If there is damage to the lens, submit a TC PuMA case for the rear LED light to collect parts for analysis.

WARRANTY INFORMATION

Covered under the terms of the BMW New Vehicle Limited Warranty for Passenger Cars and Light Trucks.

Defect Code:	**63 21 15 48 00**	Rear light, rear lid leaking

Repairing One Side

Labor Operation:	**Labor Allowance:**	**Description:**
63 21 300	Refer to KSD	Replacing PCB in left or right rear light (For access only)
And:		
63 99 000	4 FRU	Work time for drying the light on one side and leak checking

Or:

Repairing Both Sides

Labor Operation:	Labor Allowance:	Description:
63 21 300	Refer to KSD	Replacing PCB in left or right rear light (For access only)
And:		
63 99 000	10 FRU	Work time for removing and installing the other PCB, drying the lights and leak checking both sides

If you are using a Main labor code for another repair, use the Plus code labor operation 63 21 800 instead.

Work time labor operation code 63 99 000 is not considered a Main labor operation. Also, since the “work time” FRU allowance to be claimed is specified, a separate punch time is not required.

Other Repairs

If the leak checking results in other eligible and covered work, claim this work with the applicable defect code and/or labor operations listed in KSD2.

Overlapping Labor – Associated and/or Other Repairs

If invoicing KSD2 flat rate labor operation codes for the additional repair work results in overlapping labor being claim, invoice work time labor operation 00 50 000 for the additional time (FRU) minus the overlap instead.

On the repair order and in the claim comment section, please identify the labor operations labor operation code 00 50 000 replaces and itemize claimed FRU amount.

Work time labor operation code 00 50 000 is not considered a Main labor operation.

Associated Repairs: When work time labor operation 00 50 000 is used as an extension of the repair outlined in this bulletin, a separate defect code and punch time(s) are not required.

Other Repairs: When work time labor operation 00 50 000 is used for work that will be claimed under different defect codes, separate punch time(s) are required.

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