



SI M41 02 17
Body

December 2017
Technical Service

SERVICE ACTION: LEFT SIDE SILL INSPECTION-REPAIR

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.

MODEL

F57 (Cooper, Cooper S, JCW Convertible)			
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AFFECTED VEHICLES

This Service Action involves 173 Mini Convertibles produced from 9/29/2017 to 10/20/2017.

Vehicles which require this Service Action to be completed will show it as "Open" when checked either in AIR, the "Service Menu" of DCSnet (Dealer Communication System) or with the Key Reader.

SITUATION

A possible crack may cause water leakage into internal vehicle structures with subsequent corrosion.

CAUSE


A production issue during panel formation, has led to the possibility of cracks being created in the radius of the outer left side frame (below the side sill trim panel).

CORRECTION

Inspection of all affected vehicles and repair of those where the crack has formed.

PROCEDURE

For conditions that are similar to the situation described:

	<ol style="list-style-type: none"> 1. Remove the left side sill trim panel as detailed in REP 51 71 447 "Removing and installing/replacing the side sill trim panel on the left or right side."
	<ol style="list-style-type: none"> 2. Check for a crack in the side sill by shining a light into the opening for the clip as shown. <p>Does light shine through the crack near the inner radius of the side frame?</p>



YES- follow the attached repair procedure -
M410217_Attachment-Door Sill Crack Repair

NO – reassemble the vehicle and release.

3.

PARTS INFORMATION

Part Number	Description	Quantity
51 77 7 317 399	Left sill trim, Cooper	1
51 77 7 317 401	Left sill trim, Cooper S	1
51 77 7 403 242	Adhesive Tape (Use with trim above)	As needed
51 77 7 361 585	Left sill trim, Cooper JCW	1
51 77 7 403 245	Adhesive Tape (Use with trim ...361 585 above)	As needed
07 14 7 422 322	Expanding Rivet	As needed
07 13 1 480 419	Clip	As needed
51 71 1 496 621	Clip	As needed
51 43 7 001 491	Clip	As needed

WARRANTY INFORMATION

Reimbursement for this Service Action will be via normal claim entry utilizing the following information:

Defect Code:	0041830100	
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No Repair is Necessary

Labor Operation:	Labor Allowance:	Description:
00 65 887	6 FRU	Removing and installing the left side sill trim panel and checking for a crack in the workshop (No repair is necessary) (Completion “before” vehicle delivery to the customer or in conjunction with other Main/Plus work)
Or:		
00 65 238	7 FRU	Removing and installing the left side sill trim panel and checking for a crack in the workshop (No repair is necessary) (Main work)

Or:

Repair is Necessary

Labor Operation:	Labor Allowance:	Description:
41 99 000	3 FRU	Removing left side sill trim panel and checking for a crack in the workshop (Repair is necessary) (Plus work – Vehicle is already in the workshop)
Or:		
41 99 000	4 FRU	Removing left side sill trim panel and checking for a crack in the workshop (Repair is necessary) (Main work)

An individual punch time and an explanation on the repair order and in the claim comments section is required for the above.

And:

Sublet – Associated Repair and Paint Work

Sublet Code 3	Up to \$250.00 (including materials and excluding the sill trim part number)	Reimbursement for preparing and welding the crack, painting the side sill as described in this bulletin and applying cavity preservation
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Note: Aftersales Area Manager (AAM)/Area Manager (AM) “Field Authorization” (FAS) is not required.

Invoice eligible refinish and paint sublet work on the repair order at the actual cost charged with no handling or markup. The sublet amount must also include any discounts or allowances.

And, as applicable:

Alternative Mobility Solution (AMS)

This Service Action 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 [M01 01 17](#) for additional information.

ATTACHMENTS

View PDF attachment [Door Sill Crack Repair_M41 02 17](#).

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DOOR SILL CRACK REPAIR

Introduction or Preparatory Items:


This procedure assumes sill trim panel has been previously removed according to REP 51 71 447 Removing and installing/replacing the side sill trim panel on the left or right side.'






Warning: Before the start of this procedure, the vehicle must be prepared for welding:

- Disconnect the battery.
- Protect the vehicle with sufficient covers to prevent any incidental damage from the welding process.
- Follow all safety measures for welding, grinding and painting.

Repair Procedure:

	<p>1. Drill out both ends of the crack using a 3mm drill bit.</p>

	<p>2. Remove paint from the area of the crack.</p>
	<p>3. Weld the crack shut using inert gas welding equipment (MIG).</p>

 A close-up photograph of a metal door sill area. A weld seam is visible, and the surface appears to be in the process of being prepared for repair. There are some circular openings and a dark rectangular hole nearby.	<p>4. Grind the surface of the weld seam until it is even with the body surface</p>
 A photograph showing the door sill area after painting. The surface is now a light blue color. A large, irregularly shaped piece of white protective material is applied over the painted area, covering the weld and surrounding metal. The dark rectangular hole and circular openings are still visible.	<p>5. Prepare the vehicle for painting. 6. Prime the welded area and then paint. 7. After painting, apply body cavity protection through the openings in the sill.</p>
 A photograph showing the door sill area after the repair is complete. The white protective material has been removed, and the door sill is now a uniform light blue color. The dark rectangular hole and circular openings are visible, and the surface appears smooth and finished.	<p>8. Reassemble the vehicle.</p>