



WINDOW FRAME TRIM OF FRONT DOOR IS DISPLACED

MODEL

F10 (5 Series)

SITUATION

- Noise detected upon closing door
- Damage to one or both window frame trims (front and rear door).

CAUSE

Front window frame trim is offset toward "B" pillar (as shown).



Frame trim damage may be caused by trim overlap.



CORRECTION

Replace one or both window frame trim panels, if damaged.

PROCEDURE

For conditions that are similar to the situation described:



Note: Apply adhesive tape to prevent damage to the window frame panels.

1. Remove window frame according to repair instructions "51 32 390 Removing and installing/replacing frame trim on front left or right side window frame"
2. Clean the window frame surface at the three rear clamp positions as depicted in picture.



3. Apply adhesive tape on the window frame (83 19 0411397 – Fabric tape, Tesa 4657) at the 3 positions shown.



4. Re-install the window trim and any other removed parts according to appropriate repair instructions



Note: Be careful when separating the layers to minimize any marring of the surfaces.

PARTS INFORMATION

Part Number	Description	Quantity
83 19 0 411 397	Fabric Tape, Tesa 4657 (L=50m, W=12mm)	As needed

WARRANTY INFORMATION

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

Defect Code:	5133194100	
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Repairing One Side

Labor Operation:	Labor Allowance:	Description:
51 32 390	Refer to KSD2	Removing and installing or replacing ornamental frame on window frame of left or right front door (Main work)
Or:		
51 32 890	Refer to KSD2	Removing and installing or replacing ornamental frame on window frame of left or right front door (Plus work)
And:		
51 99 000	2 FRU	Cleaning and applying fabric tape to window frame panel (one side)

If you are using a Main labor code for another repair, use the Plus code labor operation 51 32 890 instead.

Or

Repairing Both Sides

Labor Operation:	Labor Allowance:	Description:
51 32 391	Refer to KSD2	Removing and installing or replacing ornamental frame on window frame on both front doors
(Main work)		
Or:		
51 32 891	Refer to KSD2	Removing and installing or replacing ornamental frame on window frame on both front doors
(Plus work)		
And:		
51 99 000	4 FRU	Cleaning and applying fabric tape to window frame panel (both sides)

If you are using a Main labor code for another repair, use the Plus code labor operation 51 32 891 instead.

Refer to KSD2 for the corresponding flat rate unit (FRU) allowances.

Work time labor operation code 51 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.

And:

Sublet – Bulk Materials

Sublet Code 4	See sublet reimbursement calculation below	Reimbursement for the repair-related bulk material (BMW part number, please do not use the part numbers for claim submission)
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Sublet reimbursement calculation for claiming the “used quantities” of repair-related bulk material (BMW part number) is at dealer net plus your center’s handling.

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

Overlapping Labor Procedure – Other Repairs

If invoicing the KSD2 flat rate labor operation codes for other repair work results in overlapping labor, for those flat rate labor operations that are affected, you can now:

- Replace the stated KSD2 “FRU allowance” with a “reduced FRU value” to eliminate the overlapping labor.

For help in identifying the overlapping labor, please refer to the AIR FRU Plausibility Check (Overlapping Labor Tool) that is located in the AIR Client.

Eligible other repair work being claimed under a different defect code will require separate punch times.

On the repair order and in the claim comment section, please identify and itemize those labor operations being claimed with a “reduced FRU value.”

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