



SI B54 04 17
Special Roofs

January 2018
Technical Service

CREAKING OR RATTLING NOISE FROM SUNROOF AREA

New information provided by this revision is preceded by this symbol .

This Service Information bulletin supersedes SI B54 04 17 dated **October 2017**.

What's New:

- Video added showing noise and loose bushing.

MODEL

G12 (7 Series)			
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Production through 11/4/2016

SITUATION

Creaking and/or rattling noise from the vicinity of the sunroof, especially when driving on uneven road surface.

CAUSE

Incorrect torque applied to mounting screws during production allowing flexing/movement around the sunroof cassette/glass unit.

And/or

 Video link of noise and loose bushing attached: <https://tinyurl.com/B540417>

CORRECTION

Reinforce bushing installation and torque all screws precisely.

PROCEDURE

For conditions that are similar to the situation described:

1. Test drive vehicle to verify the creaking or rattling noise is coming from the glass roof unit attachment screws.
2. Refer to the attached procedure to reinforce the threaded bushings and re-torque the sunroof cassette bolts. Follow the procedure completely to avoid a recurrence of the issue.

PARTS INFORMATION

Part Number	Description	Quantity
83 19 0 417 324	Cleaner, R2 (500 ml)	As Needed
83 19 2 211 217	Cleaner, R1 (100 ml)	As Needed
83 19 2 158 654	Body Adhesive, K5a (50 ml)	As Needed

83 19 2 210 339	Screw-locking adhesive, Med Strength (10 ml)	As Needed
07 14 7 226 126	M6 x 14 Hex Bolt	12 or 14
54 10 7 153 589	Plastic Washer	12 or 14

WARRANTY INFORMATION

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

Defect Code:	5412213900	
Labor Operation:	Labor Allowance:	Description:
54 12 211	Refer to KSD2	Removing and installing complete glass slide/tilt sunroof (Main work)
Or:		
54 12 711	Refer to KSD2	Removing and installing complete glass slide/tilt sunroof (Plus work)
And, as needed		
54 00 001	Work time	Locate slide/tilt sunroof complaint(s)
And:		
54 99 000	10 FRU	Working time to perform repairs to threaded bushings

If you are using a Main labor code for another repair, use the Plus code labor operation 54 12 711 instead of 54 12 211.

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

Work time labor operation code 54 00 001 is not considered a Main labor operation; however, it does require an individual punch time and an explanation on the repair order and in the claim comments section.

Work time labor operation code 54 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 materials (BMW part number(s), please do not use the part numbers for claim submission)
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Sublet reimbursement calculation for claiming repair-related bulk materials (BMW part numbers) is at dealer net price for the “used quantities” plus your center’s handling.

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

Posted: Friday, January 12, 2018

ATTACHMENTS

View PDF attachment [Repair Instructions for G12 Sunroof Noise.](#)

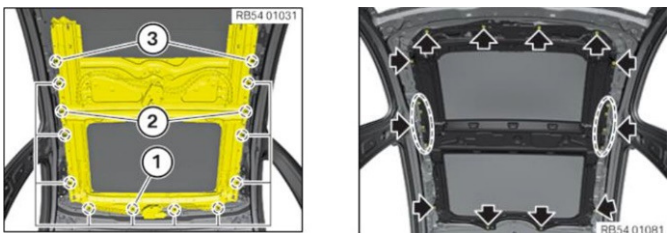
[Copyright ©2018 BMW of North America, Inc.]

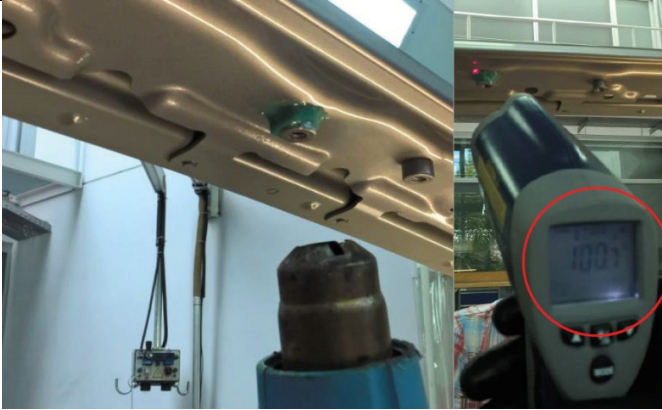
REPAIR INSTRUCTIONS FOR G12 SUNROOF NOISE

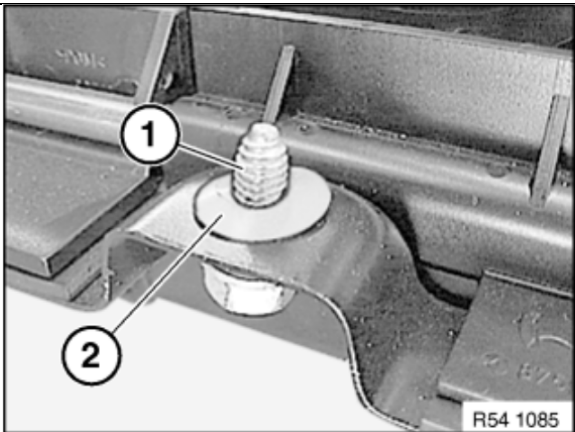
Special Tools/Fluids Required:

- Heat gun with adjustable temperature (locally available)
- Non-contact infra-red thermometer
- R2 Cleaner (83 19 0 417 324)
- R1 Cleaner (83 19 2 211 217)
- Body adhesive K5a (83 19 2 158 654)
- Body adhesive cartridge gun (83 19 2 149 522)
- Infra-red Thermometer (locally available)
- Thread lock adhesive (83 19 2 210 339)

PROCEDURE

	1. Following the procedure in REP 54 12 211 "Completely remove and reinstall glass slide/tilt sunroof" using new screws, remove and discard all screws used to connect glass unit to roof (Qty=12 or 14 depending on model).
	2. Prior to reinstalling sunroof, reinforce the threaded bushing connection by taking the following steps. A. Clean the surface area around each threaded bushing (from which screws were removed in Step 1) with R2 cleaner. Allow to air dry for 2 minutes. B. Clean the area around each threaded bushing with R1 cleaner. Allow to air dry for 2 minutes.

	C. Use a cartridge gun (83 19 2 149 522) to apply K5a body adhesive around the side of each bushing as shown.
	 Note: Keep all adhesive off the flat surface of the bushing.
	D. Heat the applied adhesive with a heat gun to an approximate temperature of 175 to 212 degree F (80-100° C). Check the temperature with an infra-red thermometer. E. Apply another layer of adhesive to the side of the bushing repeating Steps 2C and 2D, above. F. Allow the adhesive to cure for at least 12 hours.

	3. Reinstall the glass unit into the vehicle with new screws (1), be sure to install plastic washers (2) between the sunroof cassette and threaded bushing.
	4. Coat screw threads with medium-tight thread locking adhesive (Loctite 243) (BMW part # 83 19 2 210 339). Note: Tighten screws, with a torque wrench, to exactly 10 Nm. Over-tightening or under-tightening may lead to a loose connection and a repeat visit.
	5. Reassemble the balance of parts removed from the vehicle as per repair instructions. 6. Confirm the integrity of the repair by test-driving on an appropriate surface.

