



## GROANING NOISE FROM DOORS

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

This Service Information bulletin replaces SI B51 10 16 **dated June 2017**

### What's New:

- Affected models clarified
- Warranty information added

### **MODEL**

F30 (3 Series Sedan)	F31 (3 Series Sport Wagon)	F80 (M3 Sedan)	
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The affected vehicles must meet the following criteria for production date and manufacturing plant:

F30/F80 up to 11/5/2015	Regensburg (Identified by a "P" or "J" in the 11th position of the VIN)
F30/F31 up to 11/16/2015	Munich (Identified by a "F" or "K" in the 11th position of the VIN)
F30 up to 1/15/2016	Rossllyn (Identified by a "N" in the 11th position of the VIN)

If a vehicle does not meeting the criteria for model, production date, and manufacturing plant, this bulletin does not apply.

## SITUATION

A groaning noise is heard from any of the doors when driving over rough road surfaces.

## CAUSE

Excessive friction between window guide and door opening. Situation is worsened by:

- Option SA 760 high-gloss shadow line
- High ambient temperature
- Uneven driving surface

### **CORRECTION**




Replace window guides on affected doors if they are not the updated versions.

### **PROCEDURE**

For conditions that are similar to the situation described:

Follow the attached procedure detailed in Window Guide Noise Elimination procedure.

## PARTS INFORMATION

Part Number	Description	Quantity
<b>F30, F31, F80 Front</b>		
51 33 7 414 531	Window guide, front left	As needed
51 33 7 414 532	Window guide, front right	As needed
<b>F30, F80 Rear</b>		
51 35 7 414 533	Window guide, rear left	As needed
51 35 7 414 534	Window guide, rear right	As needed
<b>F31 Rear</b>		
51 35 7 414 535	Window guide, rear left	As needed
51 35 7 414 536	Window guide, rear right	As needed
<b>Bulk Materials (Sublet)</b>		
<b>83 19 9 407 798</b>	 Teflon tape (W=15mm,L=33m)	As needed
<b>51 91 0 033 068</b>	 BMW Anti-static cleaner (5000ml)	As needed
<b>83 19 2 157 321</b>	 Lubricant (20g)	As needed

## WARRANTY INFORMATION

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



Note: Only one "Main Work" labor operation can be claimed per repair visit with a claim submission.

<b>Defect Code:</b>	<b>5133093900</b>	<b>Front window guide</b>
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### Replacing one front side seal

Labor Operation:	Labor Allowance:	Description:
51 32 211	Refer to KSD2	Replacing rubber guide for left or right front door window (Main Work)
Or:		
51 32 711	Refer to KSD2	Replacing rubber guide for left or right front door window (Plus work- vehicle already in workshop)

Or:

**Replacing both front side seals**

<b>Labor Operation:</b>	<b>Labor Allowance:</b>	<b>Description:</b>
51 32 212	Refer to KSD2	Replacing rubber guide for both front door windows (Main work)
Or:		
51 32 712	Refer to KSD2	Replacing rubber guide for both front door windows (Plus work- vehicle already in workshop)

And/Or:

<b>Defect Code:</b>	<b>5134043900</b>	<b>Rear window guide</b>

**Replacing one rear side seal**

<b>Labor Operation:</b>	<b>Labor Allowance:</b>	<b>Description:</b>
51 34 211	Refer to KSD2	Replacing rubber guide for left or right rear door window (Main work)
Or:		
51 34 711	Refer to KSD2	Replacing rubber guide for left or right rear door window (Plus work- vehicle already in workshop)

Or:

**Replacing both rear side seals**

<b>Labor Operation:</b>	<b>Labor Allowance:</b>	<b>Description:</b>
51 34 212	Refer to KSD2	Replacing rubber guide for both rear door windows (Main work)
Or:		
51 34 712	Refer to KSD2	Replacing rubber guide for both rear door windows (Plus work)

And/or:

<b>Labor Operation:</b>	<b>Labor Allowance:</b>	<b>Description:</b>
51 99 000	6 FRU	Work time to clean <b>one seal</b> and apply Teflon tape to <b>one door seal</b> (Main work)
Or:		

51 99 000	4 FRU	Work time to clean <b>one seal</b> and apply Teflon tape to <b>one door seal</b> (Plus work)
Or:		
51 99 000	10 FRU	Work time to clean <b>two seals</b> and apply Teflon tape to <b>two door seals</b> (Main work)
Or:		
51 99 000	8 FRU	Work time to clean <b>two seals</b> and apply Teflon tape to <b>two door seals</b> (Plus work)
Or:		
51 99 000	14FRU	Work time to clean <b>three seals</b> and apply Teflon tape to <b>three door seals</b> (Main work)
Or:		
51 99 000	12 FRU	Work time to clean <b>three seals</b> and apply Teflon tape to <b>three door seals</b> (Plus work)
Or:		
51 99 000	18 FRU	Work time to clean <b>four seals</b> and apply Teflon tape to <b>four door seals</b> (Main work)
Or:		
51 99 000	16 FRU	Work time to clean <b>four seals</b> and apply Teflon tape to <b>four door seals</b> (Plus work)

When the “51 99 000” work time labor operation code repair-related procedure (as described above) is performed and claimed without a corresponding window guide seal replacement being performed during the same workshop visit (stand-alone Main or Plus work time labor operation), a separate punch time is required.

When the “51 99 000” work time labor operation code repair-related procedure is performed and claimed in conjunction with a window guide replacement during the same workshop visit (Plus labor operation), a separate punch time is not required.

However, for both or the situations above, this work time labor operation still requires an explanation on the repair order and in the claim comments section.

And:

**Sublet – Bulk Materials**

<b>Sublet Code 4</b>	See the sublet reimbursement calculations below	Reimbursement for the repair-related bulk materials (Do not use part numbers for claim submission)
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Sublet reimbursement calculation for claiming the applicable repair-related bulk materials (BMW part numbers) is at the dealer net price for the “quantities used” plus your center’s handling.

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

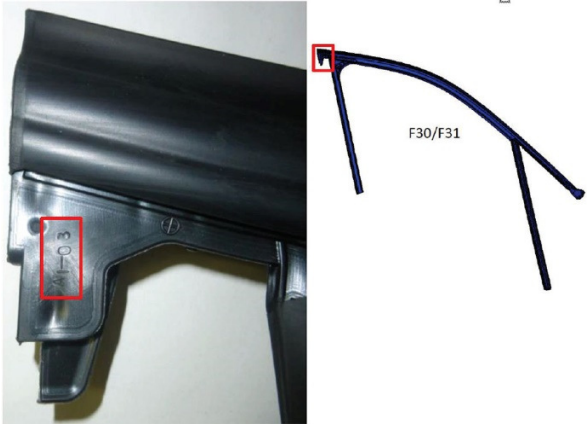
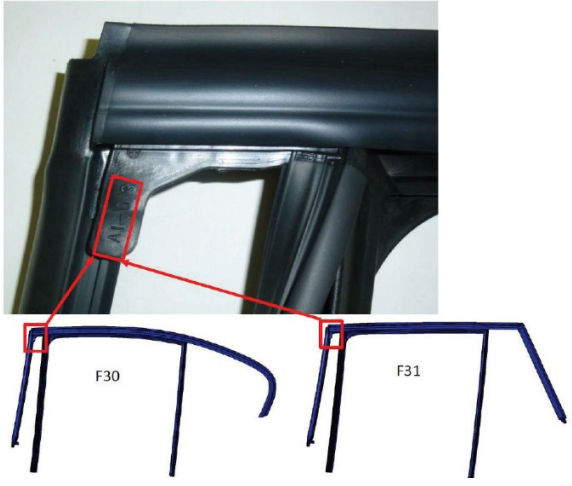
Posted: Friday, September 7, 2018







## ATTACHMENTS

View PDF attachment [Attachment A-Window Guide Noise Elimination B51 10 16](#).

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## Window Guide Noise-Elimination Procedure

<p>Front Window</p>  <p>The image shows a close-up of the front window assembly. A red box highlights the 'AI03' stamp on the metal frame. To the right, a blue window guide is shown with a red box at its top end and the label 'F30/F31'.</p> <p>Rear Window</p>  <p>The image shows a close-up of the rear window assembly. A red box highlights the 'AI03' stamp on the metal frame. Below, two blue window guides are shown: 'F30' on the left and 'F31' on the right. Red boxes highlight the top ends of both guides.</p>	<ol style="list-style-type: none"><li>1. Check revision index of window guide (see pictures for location). <b>Is revision AI03 or higher?</b> YES - do not replace, go to Step 2. NO- replace window guide as per repair instructions, then go to Step 2.</li></ol> <p>If the window guides need to be replaced, refer to repair instruction "REP 51 32 211 Replacing front left or right rubber guide for left or right door window" for front window and/or "REP 51 34 211 Replacing rear left or right rubber guide for left or right door window".</p>
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	<p> Note: The success of this repair is dependent upon the use of BMW-approved lubricants and cleaners. Substitution of alternative products will result in a return visit.</p> <p>2. Clean the contact surface (on which the door seal rests) on the body of the vehicle with anti-static cleaner (Part number (51 91 0 033 068) where shown.</p> <p> Note: Application of anti-static cleaner (silicone remover) onto the rubber window guide should be strictly avoided.</p>
	<p>3. Close vehicle door and apply masking tape abutting the contact point of the side door as shown.</p> <p>4. Heat the area adjacent to the masking tape with a heat gun in preparation for application of Teflon tape.</p>
	<p>5. Apply Teflon tape to the preheated area as shown.</p> <p> Note: Exact length of applied tape is not critical but be certain the bond is bubble-free over the complete length of the contacting surfaces.</p>