



SI B51 23 18  
Body Equipment

November 2018  
Technical Service

## SERVICE ACTION: RESEAL UNDERBODY BAFFLES

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

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.

This Service Information bulletin replaces SI B51 23 18 **dated November 2018**

### What's New:

- Minor procedure change for clarification

## MODEL

G05 (X5)
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Produced from 7/9/2018-9/27/2018

## AFFECTED VEHICLES

This Service Action involves 1,279 G05 X5 vehicles produced from 7/9/2018-9/27/2018.

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

Under certain conditions when driving through water, the underbody baffles may not completely prevent water ingress.

## CAUSE

Incorrect sealer application during production.

## CORRECTION

Reseal the underbody baffles to prevent water ingress, as outlined in the procedure section.

## PROCEDURE

**Note:** The repair procedure described in this Service Information bulletin can only be performed and completed by a technician in an authorized BMW center workshop.

**Please do not forward an affected vehicle to a CCRC or affiliated body shop to have them perform this repair.**



Follow the attached repair procedure “G05 Baffle sealing B51 23 18”

Heavy-duty drill PN 83 19 2 359 262 bit is one-time use and is claimable. The 12mm drill bit is not claimable.

If any technical issues or concerns arise before and during this repair, please submit a PuMA case for assistance.

## PARTS INFORMATION

Please refer to the Parts Matrix for parts ordering.

The four part numbers listed in the chart below are to be ordered with an IDS Ticket, VIN-specific with a recent key read (5 days or less).

Part Number	Description	Quantity
07 14 9 321 690	Fillister-head screw	8
07 14 7 127 539	Blind Plug	8
83 42 9 410 694	Cavity Foam (Spray 400 ml)	1
83 19 2 359 262	Drill bit, heavy-duty (6.8mm x 79 mm)	1

### Bulk Materials in Sublet

Part Number	Description	Quantity
83 42 0 428 190 <b>OR</b> 83 42 2 457 337**	Cavity protection spray (400 ml)	Qty as needed*
83 42 2 409 985	Seam sealant (300 ml)	1 in sublet

\*One (1) can of PN 83 42 0 428 190/83 42 2 457 337 Cavity protection spray (400ml) will treat up to “ten (10) vehicles.” It is unlikely that that your center will require more than 1 can of this item to complete the procedure on all vehicles at your dealership that require this service action.

\*\*PN 83 42 0 428 190 and 83 42 2 457 337 are interchangeable. Please use PN 83 42 0 428 190 FIRST to deplete stock. If PN 83 42 0 428 190 is no longer available, begin using PN 83 42 2 457 337.

## WARRANTY INFORMATION

Reimbursement for this BMW center workshop completed service action will be via normal claim entry utilizing the following information:

<b>Defect Code:</b>	<b>0051440400</b>	
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Completion “before” vehicle delivery to the customer or the vehicle is already in the workshop

Labor Operation:	Labor Allowance:	Description:
00 67 520	61 FRU	Sealing shaped parts in side sill on left and right (Plus work)

Or:

**Completion after vehicle delivery to the customer (with no other Main work claimed)**

Labor Operation:	Labor Allowance:	Description:
00 67 011	62 FRU	Sealing shaped parts in side sill on left and right (Main work)

And:

**Sublet – Bulk Materials**

<b>Sublet Code 4</b>	Up to \$100.00	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 83 42 2 457 337 and 83 42 2 409 985) 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.

And, as applicable:

**Alternative Mobility Solution (AMS) for Vehicle Owners**

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 [B01 29 16](#) for additional information.

Posted: Monday, November 5, 2018

## ATTACHMENTS

View PDF attachment [G05 Baffle sealing B51 23 18](#).

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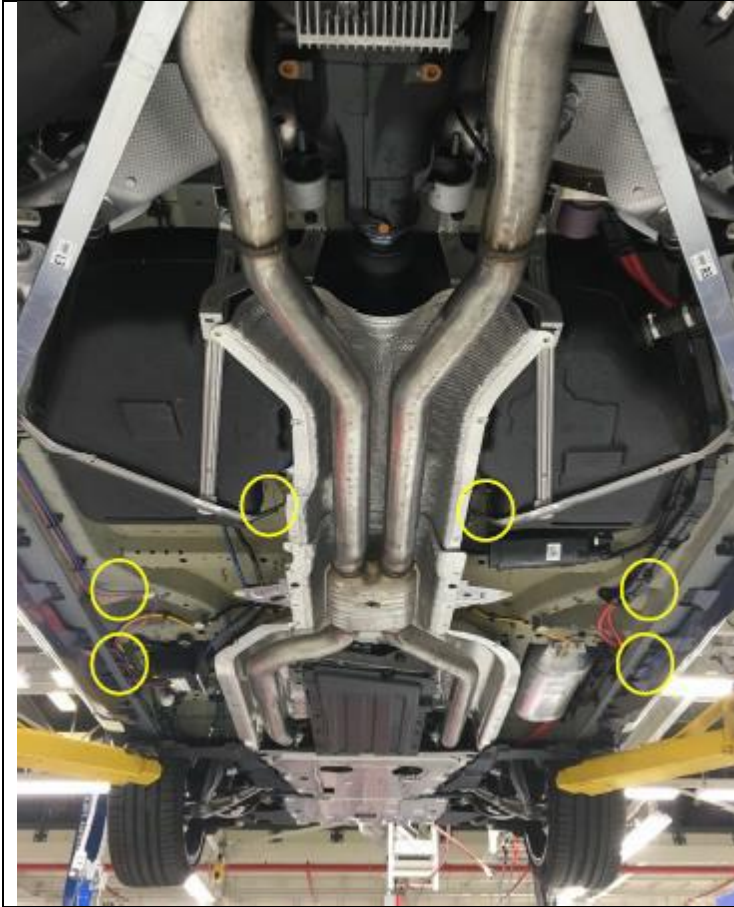
Steps 1-14 are performed outside and underneath of the vehicle.  
Steps 15-24 are performed from inside the vehicle.



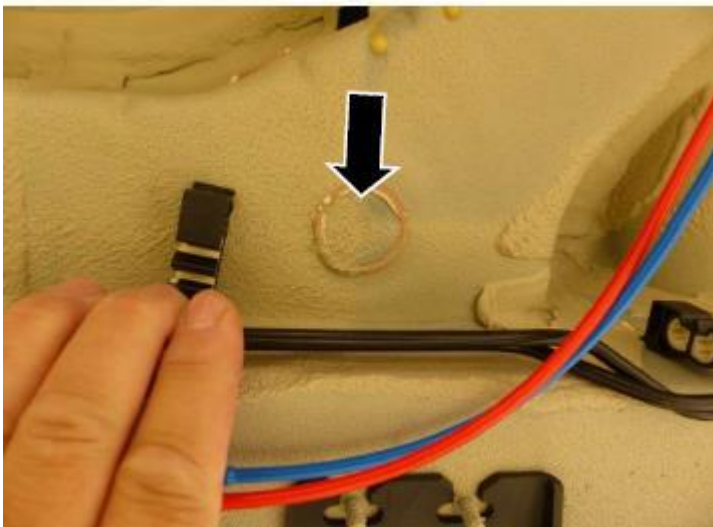
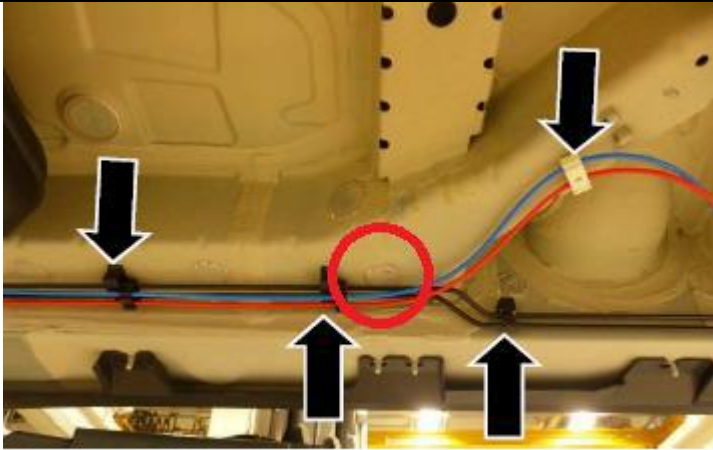
1. Remove the underbody panels (1 & 2) from both sides of the vehicle, following repair instructions **REP 51 71 017 “Remove and install/replace left underbody paneling”**. The rear underbody cover can be removed in a similar manner by removing the screws.



Note: Lift arms may interfere with removal of the underbody panels. Take note of underbody panel mounting locations before lifting the vehicle to ease in removal.



2. Once removed, take note of the circled areas shown to the left. These will be the areas where re-working will occur.



3. In the areas shown to the left, relocate and secure any lines, wires, or hoses away from the work area of the body plugs to prepare the plugs to be drilled.



Note: The area shown in the photo to the left is in the area approximately below the driver and passenger seats.

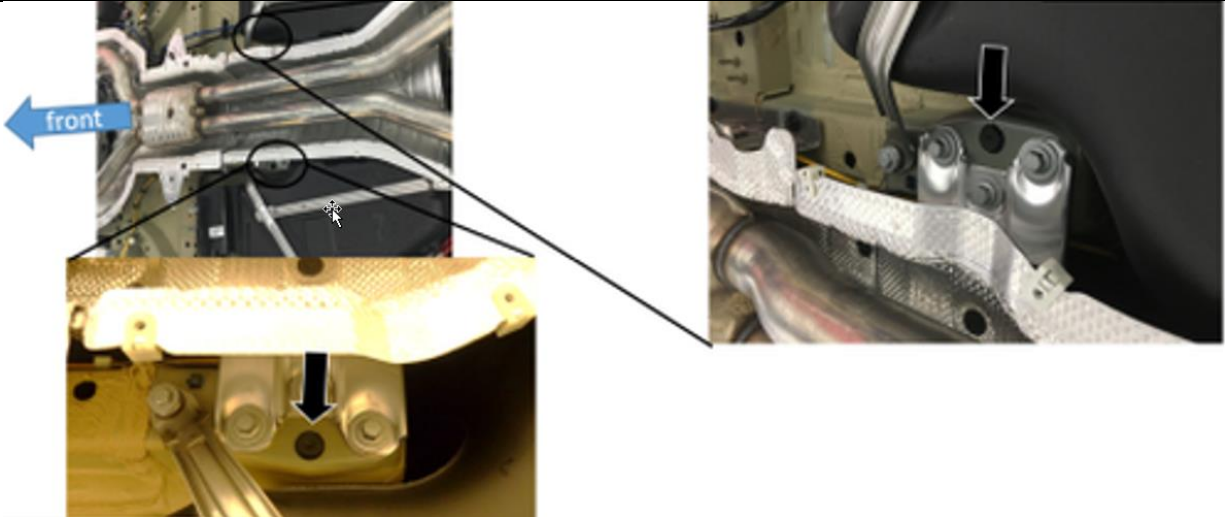
The plug to be drilled is circled in red, and can be found in the same location on both sides of the vehicle.



4. Using a 12mm drill bit or step bit, drill a hole through the plastic body plugs in the areas shown on the right and left sides of the vehicle.



5. Locate the two rubber plugs shown below in the area just in front of the fuel tank. Remove both rubber plugs and discard.



6. Familiarize yourself with the following 2 steps **before** beginning to inject cavity foam. The foam will dry rapidly in the nozzle, so these steps will need to be completed without pausing.



Follow all application instructions printed on the can of cavity foam.



7. Using the holes that were drilled in step 4, insert the cavity foam nozzle **PN 83 42 9 410 694** as far into the rail cavity as possible, facing towards the front center area of the vehicle as indicated by the blue arrow. Inject cavity foam for 3 seconds per hole. Immediately install a 12mm blind plug **PN 07 14 7 127 539** into each hole.

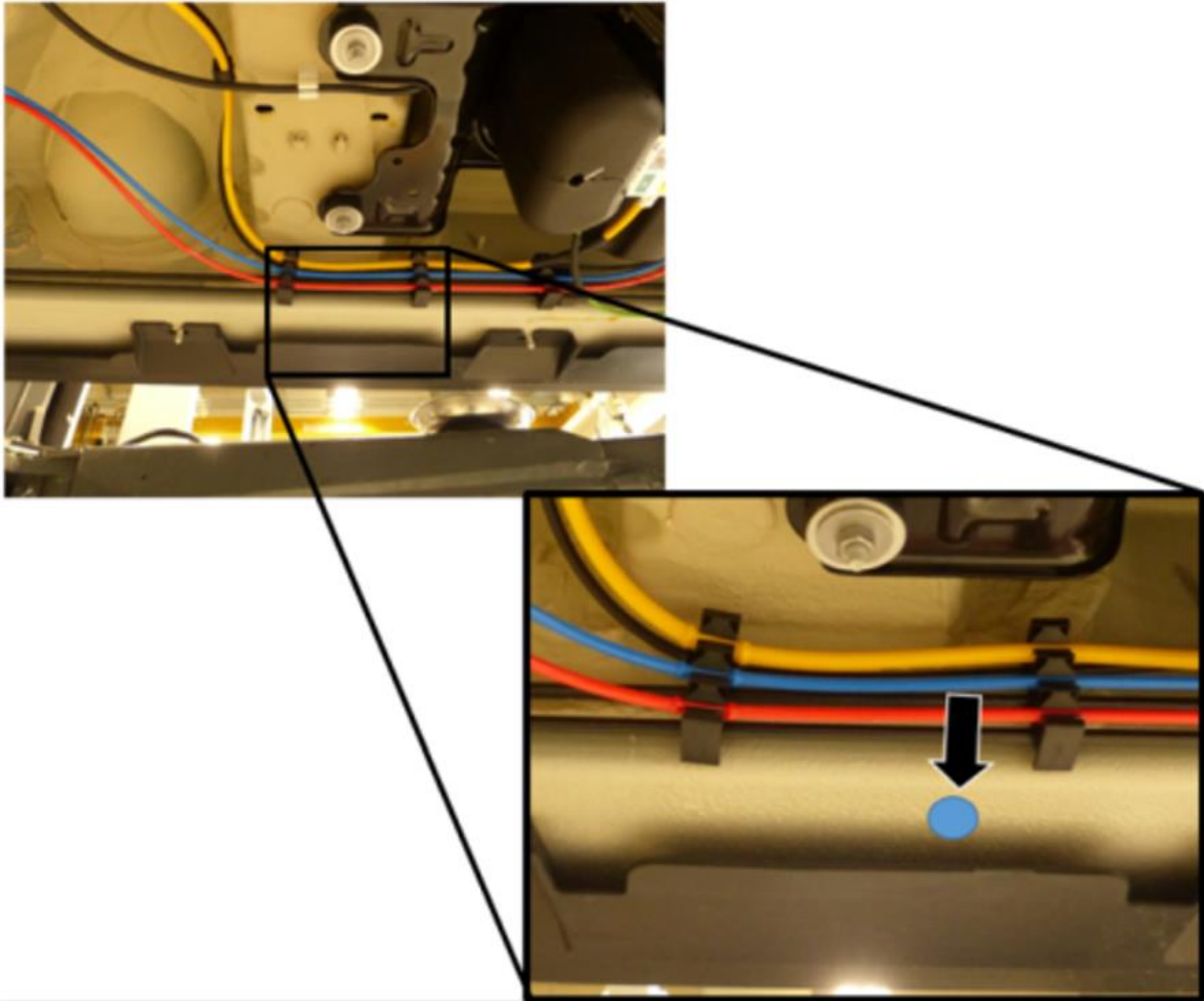


Note: You will be filling this rail cavity with foam in future steps, do not begin yet.

	<p>8. Measure and mark the cavity foam spray nozzle at 55mm from the tip of the nozzle. Insert the cavity foam spray nozzle to the 55mm mark, facing towards the front of the vehicle, into the cavity shown to the left from step 5. Inject foam for 1 second per hole. Immediately install a 12mm blind plug after injecting the foam.</p> <div data-bbox="824 564 940 680"></div> <p>Note: You will be filling this rail cavity with foam in future steps, do not begin yet.</p>
	<p>9. Once familiar with the location and instructions for injecting the cavity foam, begin injecting the cavity foam following repair steps 7 and 8.</p>



10. Locate the area on the underside of both rocker panels shown below.

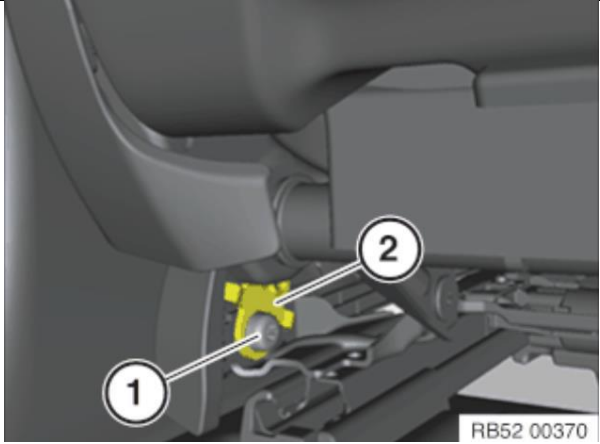



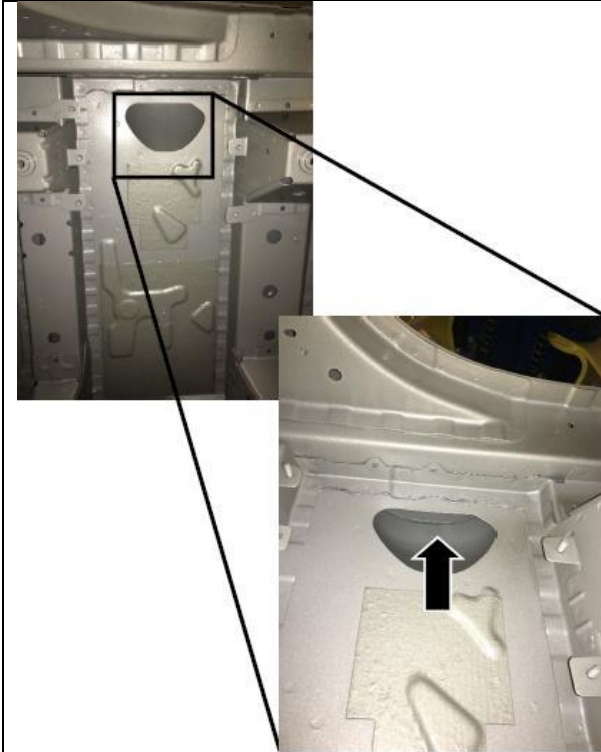
11. Using a 6.8 mm drill bit **PN 83 19 2 359 262** drill one hole in the rocker panel on the left, and one hole in the rocker panel on the right in the indicated location from above.

12. Clean and deburr the holes. Apply a suitable primer to prevent corrosion.

13. Once the primer has dried, apply cavity protection spray **PN 83 42 2 457 337** to the inside of the rocker panel through the holes that were drilled in step 11.

14. Reinstall the underbody paneling.

<p>The remainder of the repair will be completed inside of the vehicle, on both the left and right sides.</p>	
	<p>15. Remove the lower B-Pillar trim panel on both sides following repair instructions <b>51 43 150 “Removing and installing/replacing the trim panel for the left or right door post (bottom)”</b>.</p> <p> Note: The screw listed in step 5 shown to the left does not need to be removed. This step can be omitted, as the seat can be tilted away from the work area, or placed outside the vehicle without removal of the upper seat belt.</p>
	<p>16. Remove the subwoofers from under both front seats following repair instructions 65 12 051 <b>“Remove and install/replace the central bass speak on the driver’s side”</b>.</p>

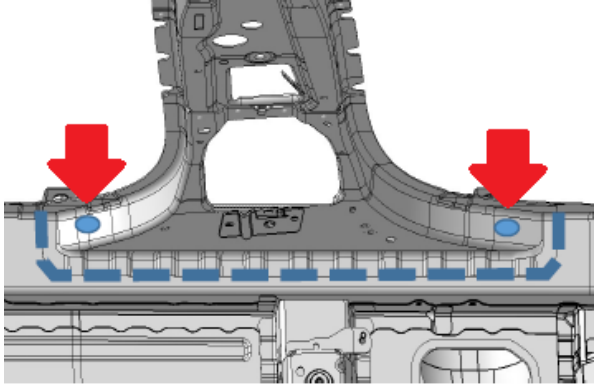
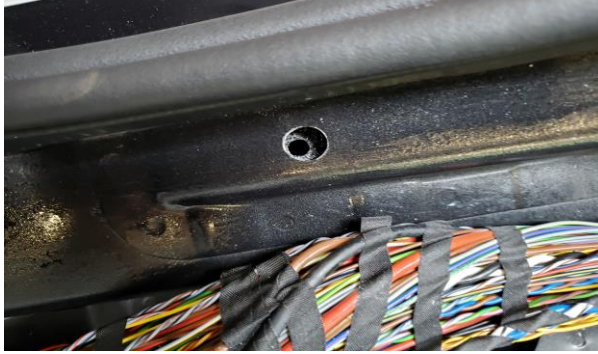




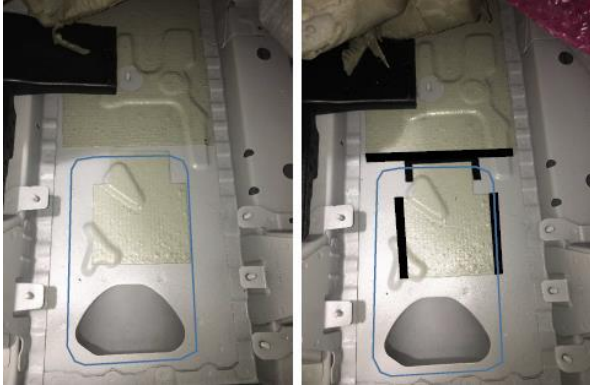
17. Coat the inside of the subwoofer cavity using cavity protection spray **PN 83 42 2 457 337**.



18. Secure the carpet away from the area around the base of the B-Pillar.

Detach and secure the wiring harness bracket away from the base of the B-Pillar as shown to the left.

	<p>19. Using drill bit <b>PN 83 19 2 359 262</b>, drill 2 holes in the base of the B-Pillar at the locations shown by the red arrows to the left.</p> <p>First drill through the B-Pillar, and then continue down through the rocker panel below the B-Pillar base in the area indicated to the left.</p>
	<p>20. When step 19 is complete, the top 2 outer-most holes need to be expanded using a 12mm drill bit.</p> <div data-bbox="919 743 1016 842" data-label="Image">  </div> <p>Note: During this step, only expand the holes of the outer sheet metal at the base of the B-Pillar. Do <b>NOT</b> drill into the rocker panel below.</p> <p>See to the left for an example of a correctly modified B-Pillar. Note that only the outer most hole is drilled to 12mm.</p> <p>Using a magnet and vacuum, deburr and remove any metal left behind from the drilling.</p>
	<p>21. Apply a suitable primer to exposed areas of metal where the holes were drilled.</p> <p>Once the primer has dried, install a blind plug <b>PN 07 14 7 127 539</b> in each of the holes.</p>
<div data-bbox="302 1587 358 1640" data-label="Image">  </div> <p>Warning: Before continuing to step 23, ensure both the driver and passenger side are disassembled and prepared for application of seam sealer. The seam sealer will begin drying rapidly, so both sides must be completed in quick succession.</p>	



22. The seal at the base of the subwoofer may interfere with the sound absorbing pad attached to the floor, causing improper sealing of the subwoofer. The sharp edges of the sound absorbing pad should be smoothed to ensure proper sealing.

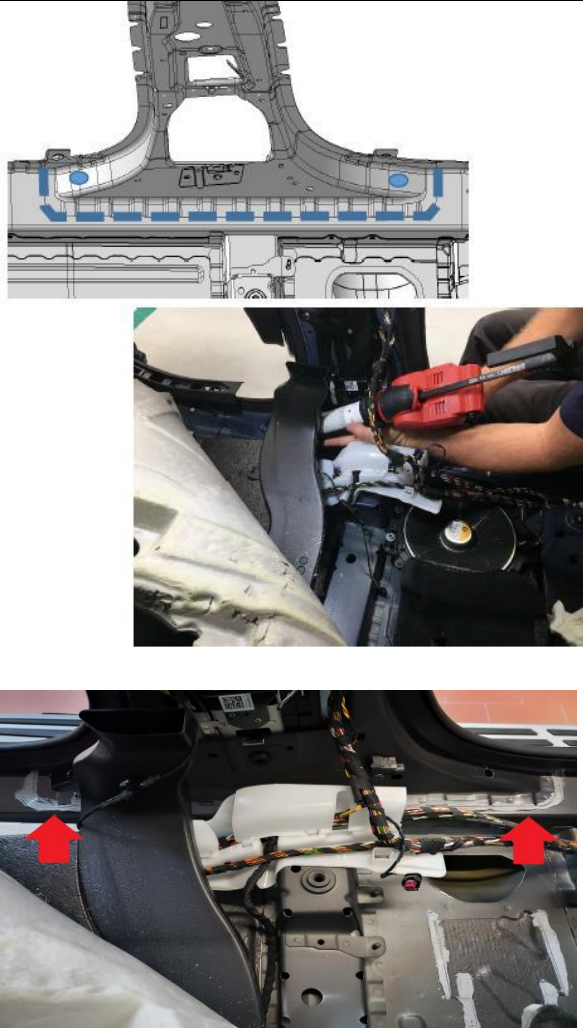

The photo to the left indicates the area of the sound absorbing pad that should be smoothed using body seam sealer.

Using Body seam sealant **PN 83 42 2 409 985**, smooth and taper the edges of the sound absorbing material to the floor. A photo to the left demonstrates the finished tapering.



Note: A flat bone tool can be used on an angle to create a smooth transition from absorbing pad to the floor.



 <p>The top image is a technical diagram of a vehicle's rear cross-section, showing the B-pillar and rocker panel. Blue arrows point to the seam where they meet, indicating the application of sealant. The bottom image is a photograph of the same area on a vehicle, showing a person using a red sealant applicator to apply the sealant to the seam. Two red arrows point to the sealed area.</p>	<p>23. Using seam sealer <b>PN 83 42 2 409 985</b>, seal around the base of the B-Pillar where the B-Pillar meets the rocker panel.</p> <p> Note: The dotted line shown to the left indicates the location where the sealer should be applied.</p> <p>The photo to the left shows a correctly sealed B-Pillar.</p>
	<p>24. Allow 2 hours for the seam sealer to completely dry. Once dry, the vehicle can be completely reassembled.</p>



