




## DELIVERY STOP: REWORK TAIL LIGHTS

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 B63 01 19 **dated February 2019**.

### What's New:

- Procedure updated
- Warranty information updated
- Parts information updated

### MODEL

F22 (2 Series Coupe)	F23 (2 Series Convertible)	F30 (3 series)	F31 (3 Series Sports Wagon)
F34 (3 Series GT)	F80 (M3)	F87 (M2)	G01 (x3)
G12 (7 Series)			

### AFFECTED VEHICLES

This delivery stop involves 7,741 F22, F23, F30, F31, F34, F80, F87, G01, and G12s produced from 10/2018 to 2/2019.

Vehicles which require this campaign 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

The tail light mounting brackets may be cracked or broken.

### CAUSE

During assembly, oil may have contaminated the plastic housing of the rear tail lamps, causing damage to the mounting points of the tail light assembly.

### CORRECTION

Inspect the rear tail light assemblies for signs of oil or cracking. Vehicles that pass the visual inspection process require no further correction.

Vehicles that do not pass the visual inspection will require tail light replacement and cleaning of the vehicle

body.

**Photographs and vehicle information showing the tail light condition MUST be forwarded to the email provided below.**

**UPDATE!** **PROCEDURE**

1. Reference the specific repair instructions for your model on how to remove the tail light trim panel to inspect the mounting nuts of the tail light.



Note: Both tail lights require inspection.



**Warning: DO NOT YET REMOVE THE MOUNTING NUTS OF THE TAIL LIGHT. THE TAIL LIGHTS**

**WILL BE INSPECTED VISUALLY WITHOUT REMOVAL OF THE MOUNTING NUTS.**



2. Visually inspect the mounting area of the tail light as shown to the left.

Different models may appear slightly different, but all models will be inspected in the same general location of the mounting tabs.

3. Take 2 clear photographs of the mounting points of both tail lights. 1 photo per light is required. The photos and additional information outlined below must be emailed to:

US\_Body\_Electrical\_TS@bmwna.com

**Documentation of ALL tail lights:**

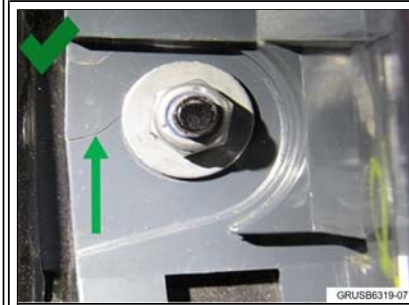
Pictures of rear lights which show the condition of the holder before a repair or handing the vehicle over to the customer (with OK lights) for documentation must be sent to the following e-mail address:

US\_Body\_Electrical\_TS@bmwna.com

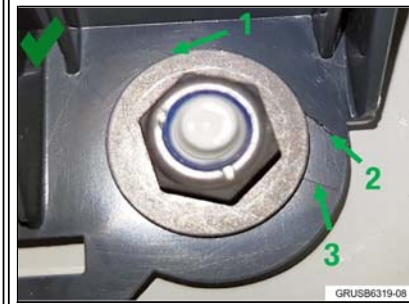
**Information to be reported back (please include the information below along with the pictures and send to the email address above):**

- VIN number
- Production date of vehicle
- And fault found
  - o Crack over a big area in tail light bracket left/right
  - o Broken rear light bracket left/right or eye loop left/right

Rear light OK left/right



4. Reference the photos shown to the left, which demonstrate **acceptable** cracking and which require no further correction.



Description of picture:

1 – small crack, not circulating, no net of cracks, **OK**

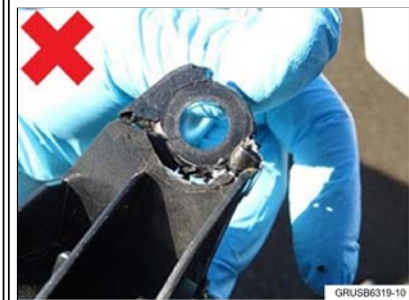
2 – small crack, not circulating, no net of cracks, **OK**

3 – weld line, **OK Attention:** the position of the weld line can vary from model to model



5. Reference the photos to the left showing examples of cracks that are **NOT** acceptable and which require tail light replacement.

Holder broken  
Eye broken off



6. Does the vehicle pass the inspection, showing only acceptable cracking as shown in the step 3 examples?

**YES:** No further correction is required, the vehicle can be reassembled.

**NO:** Continue to step 7.

7. Remove one or both rear lights, depending on whether one or both lights are found to be damaged following the ISTA repair instructions for the applicable model.



Note: It is possible that only one light may be damaged and require replacement. Do not remove a tail

light that does not fail the visual inspection procedure.

8. Immediately dispose of the removed tail light mounting nuts so that they cannot be reused.



Warning: The tail light mounting nuts are contaminated and can **NOT** be reused. Reusing a contaminated mounting nut will cause the new tail light to fail.



9. With the damaged rear light removed from the vehicle, the tail light mounting studs and vehicle body **MUST** be cleaned to remove residual manufacturing oil. Using an 80% ethanol/20% water mixture on a clean cloth, clean the mounting studs and body area shown to the left.



Warning: 80% Ethanol/ 20% water is the only suitable cleaning solution that is safe for the vehicle body and tail lights. Do **NOT** use any alternative cleaning solution.

Ethanol can be locally sourced in the form of denatured alcohol. Using any other cleaning solution will cause damage to the vehicle.

10. Once the vehicle body has completely dried, install a new tail light on the affected side(s). **Replace all of the tail light mounting nuts with new nuts.** The tail light mounting nuts **MUST BE REPLACED** if they were removed to replace a tail light.

11. Completely reassemble the vehicle.

## PARTS INFORMATION

Only replace the tail light assemblies if required after inspection. Not all vehicles require tail light replacement. Please refer to the Parts Matrix for the ordering procedure.

Part Number	Description	Quantity
64 50 9 123 157	Self-locking Hex-nut	2 or 4
If required:		
Refer to ETK/AIR	Rear light in the side panel, left	1 if needed
And/Or:		
Refer to ETK/AIR	Rear light in the side panel, right	1 if needed
And:		
NPN	Denatured alcohol (Ethanol-Local Purchase)	As needed

## WARRANTY INFORMATION

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

<b>Defect Code:</b>	<b>0063580100</b>	
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**Completion “before” the first vehicle delivery to a customer or the vehicle is already in the workshop –  
The vehicle PASSES the visual inspection**

<b>Labor Operation:</b>	<b>Labor Allowance:</b>	<b>Description:</b>
00 67 792	3 FRU	Perform inspection of the rear tail lights ( <b>No repair is necessary</b> ) ( <b>Plus Work</b> )
And:		
00 67 795	2 FRU	Administrative time to email photos and vehicle information to <b>US_Body_Electrical_TS@bmwna.com</b>

Or:

**Completion “before” the first vehicle delivery to a customer or the vehicle is already in the workshop –  
The vehicle DOES NOT PASS the visual inspection and requires replacement of one or both tail lights**

<b>Labor Operation:</b>	<b>Labor Allowance:</b>	<b>Description:</b>
00 67 793	3 FRU	Perform inspection of the rear tail lights, <b>replace one tail light, and clean the vehicle body</b> ( <b>Plus Work</b> )
Or:		
00 67 794	4 FRU	Perform inspection of the rear tail lights, <b>replace both tail lights, and clean the vehicle body</b> ( <b>Plus Work</b> )
And:		
00 67 795	2 FRU	Administrative time to email photos and vehicle information to <b>US_Body_Electrical_TS@bmwna.com</b>

Or:

**The vehicle arrives at your center for this campaign repair (No other Main work will be performed/claimed during this workshop visit) -The vehicle PASSES the visual inspection**

<b>Labor Operation:</b>	<b>Labor Allowance:</b>	<b>Description:</b>
00 67 215	5 FRU	Perform inspection of the rear tail lights (No repair is necessary) (Main Work)
And:		
00 67 795	2 FRU	Administrative time to email photos and vehicle information to <b>US_Body_Electrical_TS@bmwna.com</b>

Or:

**The vehicle arrives at your center for this campaign repair (No other Main work will be performed/claimed during this workshop visit) - The vehicle DOES NOT PASS the visual inspection and**

**requires replacement of one or both tail lights**

<b>Labor Operation:</b>	<b>Labor Allowance:</b>	<b>Description:</b>
00 67 216	5 FRU	Perform inspection of the rear tail lights, replace one tail light, and clean the vehicle body (Main Work)
Or:		
00 67 217	6 FRU	Perform inspection of the rear tail lights, replace both tail lights, and clean the vehicle body (Main Work)
And:		
00 67 795	2 FRU	Administrative time to email photos and vehicle information to US_Body_Electrical_TS@bmwna.com

And, as applicable:

**Sublet – Bulk Materials**

<b>Sublet Code 4</b>	Up to \$1.00	Reimbursement for the repair-related bulk material (Local Purchase)
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Sublet reimbursement for the applicable repair-related bulk material (Denatured alcohol).

Itemize the sublet amount on the repair order and in claim comment section.

Posted: Monday, February 25, 2019

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