



SI B63 01 19
Lights

April 2019
Technical Service

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 **March 2019**.

What's New:

- F39 added

MODEL

F22 (2 Series Coupe)	F23 (2 Series Convertible)	F30 (3 Series Sedan)	F31 (3 Series Sports Wagon)
F34 (3 Series GT)	F39 (X2)	F80 (M3 Sedan)	F87 (M2 Coupe)
G12 (7 Series, including ALPINA)	G01 (x3)		

AFFECTED VEHICLES

This delivery stop involves 7,741 F22, F23, F30, F31, F34, F,39, 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.



Note: F22 and F23 tail lights are visually different than shown in the photos. The repair procedure remains the same and can be completed without removing the tail light.

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 lights which have passed inspection) for documentation must be sent to the following e-mail address:

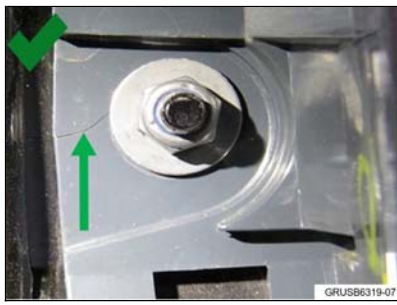
US_Body_Electrical_TS@bmwna.com

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

- VIN number

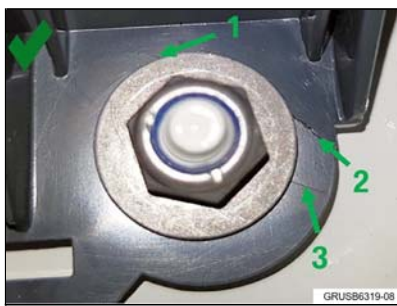
- Production date of vehicle
- And fault found
 - o Crack over a big area in tail light bracket left/right
 - o Broken rear light bracket left/right or eye loop left/right

Rear light OK left/right



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

Single cracks are acceptable.



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

	<p>acceptable cracking as shown in the step 3 examples?</p> <p>YES: No further correction is required, the vehicle can be reassembled.</p> <p>NO: Continue to step 7.</p>
	<p>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.</p> <p> 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.</p>
	<p>8. Immediately dispose of the removed tail light mounting nuts so that they cannot be reused.</p> <p> 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.</p>
	<p>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.</p> <p> 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.</p> <p>Ethanol can be locally sourced in the form of denatured alcohol. Using any other cleaning solution will cause damage to the vehicle.</p>
	<p>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.</p>
	<p>11. Completely reassemble the vehicle.</p>

UPDATE! **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
If required:		
64 50 9 123 157	Self-locking Hex-nut	2 or 4
Refer to ETK	Rear light in the side panel, left	1 if needed
And/Or:		
Refer to ETK	Rear light in the side panel, right	1 if needed
And:		
NPN	Denatured alcohol (Ethanol-Local Purchase)	As needed
For G12 only:		
Refer to ETK	Left rear molding for tail light	1
Refer to ETK	Right rear molding for tail light	1

WARRANTY INFORMATION

Reimbursement for this Delivery Stop Campaign will be via normal claim entry utilizing the following information:

Defect Code:	0063580100	F2x F3x F80 F87 G01 G12 Rework rear light
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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

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

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

Labor Operation:	Labor Allowance:	Description:
		Perform inspection of the rear tail lights, replace

00 67 793	Refer to AIR; 6 FRU (G12 ALPINA)	one tail light, and clean the vehicle body (Plus Work)
Or:		
00 67 794	Refer to AIR; 10 FRU (G12 ALPINA)	Perform inspection of the rear tail lights, replace both tail lights, and clean the vehicle body (Plus Work)
And:		
00 67 795	2 FRU (All)	Administrative time to email photos and vehicle information to US_Body_Electrical_TS@bmwna.com

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

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

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

Labor Operation:	Labor Allowance:	Description:
00 67 216	Refer to AIR; 7 FRU (G12 ALPINA)	Perform inspection of the rear tail lights, replace one tail light, and clean the vehicle body (Main Work)
Or:		
00 67 217	Refer to AIR; 11 FRU (G12 ALPINA)	Perform inspection of the rear tail lights, replace both tail lights, and clean the vehicle body (Main Work)
And:		
00 67 795	2 FRU (All)	Administrative time to email photos and vehicle information to US_Body_Electrical_TS@bmwna.com

And, as applicable:

Sublet – Bulk Materials

Sublet Code 4	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: Wednesday, April 24, 2019

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