



SI B63 01 19  
Lights

May 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 April 2019.



### What's New:

- Repair procedure changed for F30 & F80
- Parts information added for F30 & F80
- Warranty information added for F30 & F80



### MODEL

F22 (2 Series Coupe)	F23 (2 Series Convertible)	F30 (3 Series Sedan)	F31 (3 Series Sports Wagon)
F34 (3 Series Gran Turismo)	F39 (X2)	F80 (M3 Sedan)	F87 (M2 Coupe)
G01 (X3 Sports Activity Vehicle)	G12 (7 Series Sedan, including ALPINA)		



### AFFECTED VEHICLES

This delivery stop involves 11,792 F22, F23, F30, F31, F34, F39, F80, F87, G01, and G12s produced from October, 2018 to February, 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 or repair and cleaning of the vehicle body.

**Effective immediately – Taking Photos and emailing them to BMW is no longer required.**



**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.**



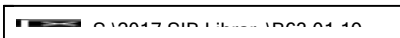
2. Visually inspect the mounting area of the tail light as shown to the left.

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 inspection procedure remains the same and can be completed without removing the tail light.

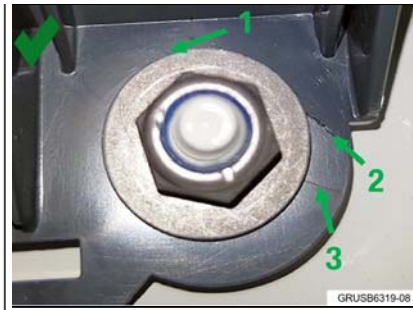


3. Reference the photos shown to the left, which demonstrate **acceptable** cracking and which require no further correction.

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



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

Holder broken



Eye broken off

5. 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:FOR F30/F80-** Reference the attachment "[B63 01 19](#) Repair procedure"

**FOR ALL OTHER VEHICLES-** Continue to step 6.

6. 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 or repair. Do not remove a tail light that does not fail the visual inspection procedure.

	<p>7. 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 <b>NOT</b> be reused. Reusing a contaminated mounting nut will cause the new tail light to fail.</p>
	<p>8. With the damaged rear light removed from the vehicle, the tail light mounting studs and vehicle body <b>MUST</b> be cleaned to remove residual manufacturing oil.</p> <p>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 <b>NOT</b> 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>9. Once the vehicle body has completely dried, install a new or repaired tail light on the affected side(s). <b>Replace all of the tail light mounting nuts with new nuts.</b> The tail light mounting nuts <b>MUST BE REPLACED</b> if they were removed to replace or repair a tail light.</p>
	<p>10. Completely reassemble the vehicle.</p>

### **UPDATE!** PARTS INFORMATION

Only replace or repair the tail light assemblies if required after inspection.

Not all vehicles require tail light replacement or repair. 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)	Sublet as needed
<b>For G12 only:</b>		
Refer to ETK	Left rear molding for tail light	1
Refer to ETK	Right rear molding for tail light	1
<b>For F30/F80 only if applicable:</b>		
63 21 2 472 169	Repair kit for tail light F30/F80 (Enough for 1 complete vehicle/both sides) (Kit includes 4 self-locking hex nuts)	1 if needed
83 19 2 211 217	Solvent cleaner R1 (100 ml) (for use with the Adhesive set)	Sublet as needed
83 19 2 317 925	Adhesive set K6 (use the Adhesive 11 ml and two nozzles only)	Sublet as needed
83 19 2 336 502	Replacement mixing nozzles K6 adhesive set (10 pack)	Sublet as needed up to 2 nozzles per vehicle



## WARRANTY INFORMATION

Refer to Attachment.

<b>Defect Code:</b>	<b>0063580100</b>	
<b>Note: Claims with repair dates on or after April 29, 2019 that contain the additional labor operation (00 67 795) for taking photos and emailing them to BMW will not be accepted.</b>		

Supporting Materials

B63 01 19 Repair procedure

B63 01 19 Warranty Information

Posted: Thursday, May 23, 2019

## ATTACHMENTS

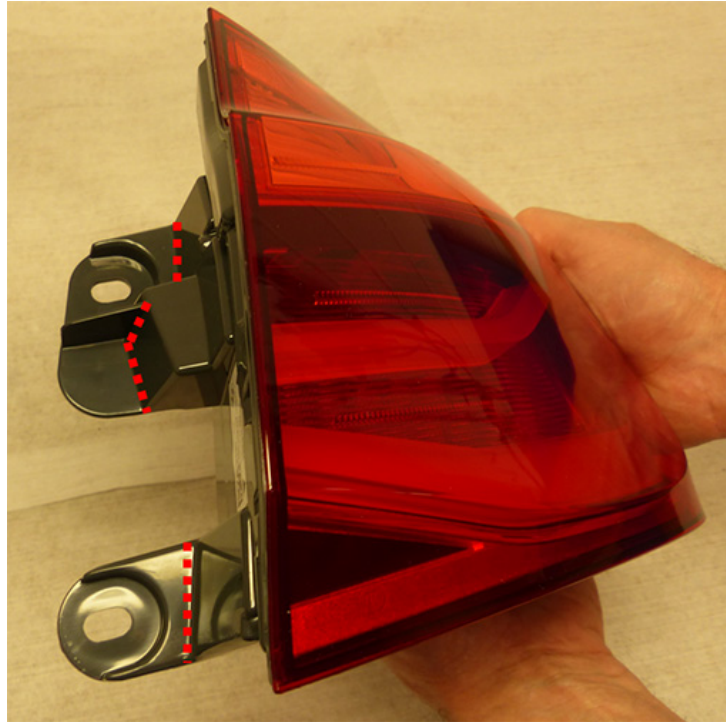
View PDF attachment [B63 01 19 Repair procedure.](#)

View PDF attachment [B630119 Attachment Warranty Information.](#)

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## B63 01 19 Repair procedure

1. After removal of damaged tail lights, ensure that the damage does not extend beyond the dotted lines shown below. If cracking extends closer to the tail light housing than the dotted line, or if the mounting tab is completely broken off of the tail light housing beyond the dotted line, the tail light will require replacement following the instructions within the SI B.

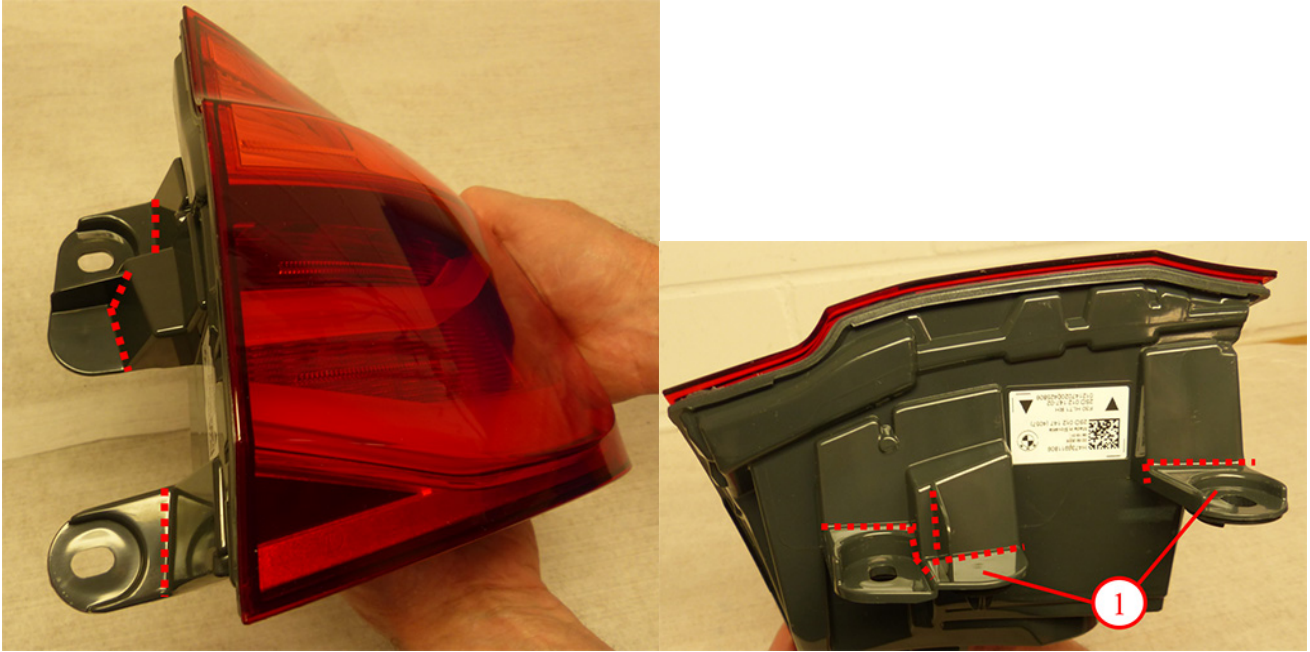


2. Place the tail light on a soft, clean piece of material to ensure the light is not scratched or damaged during the repair. If repairing both tail lights, mark each tail light as “left” or “right” to assist with future steps.



## B63 01 19 Repair procedure

- Using a suitable saw, such as a handheld hacksaw, oscillating saw, or jigsaw, cut the tabs at the dotted lines shown below:



Note: The aid of a second person may be needed to hold the taillight while cutting.

4. Reference the photos below for a correctly cut taillight:



5. De-burr all of the plastic edges from cutting during the previous steps. Using compressed air, ensure that all of the plastic debris is removed. The tail light must be completely free of any cutting remains.

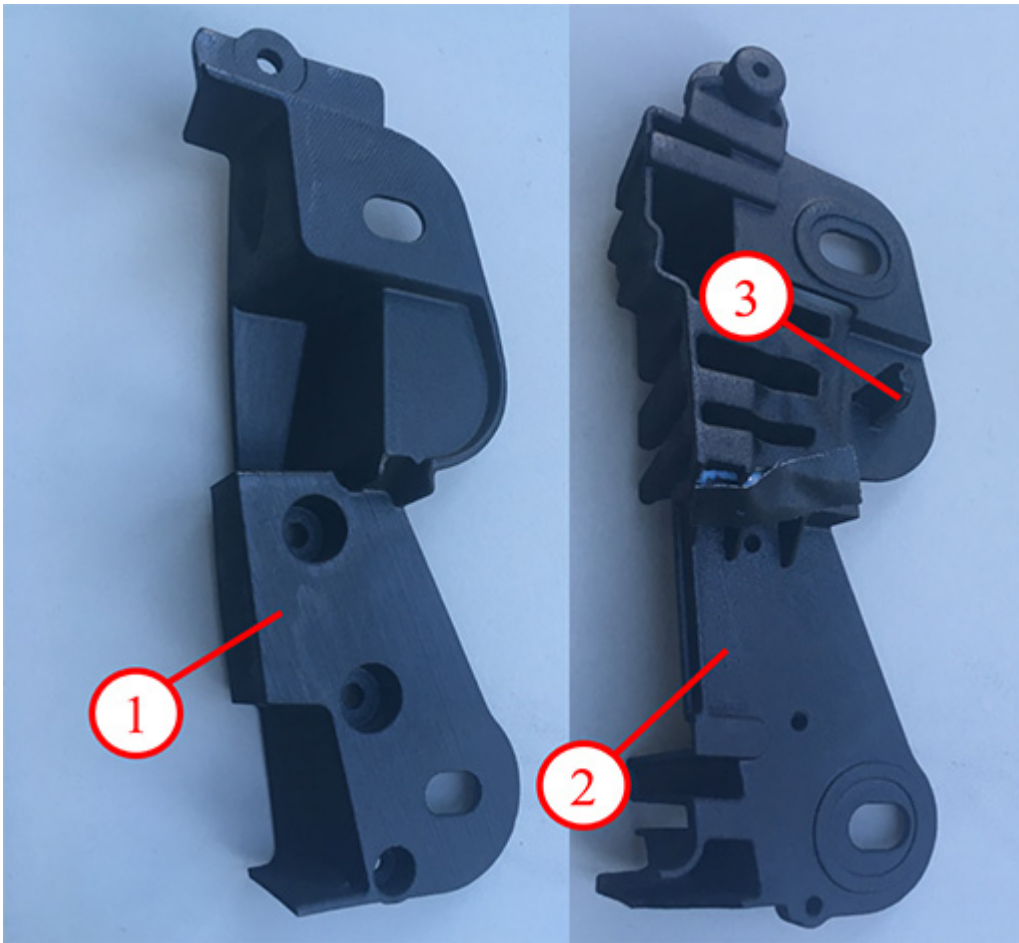


## B63 01 19 Repair procedure

6. Remove the holders from the repair kit. Each side of the repair kit will have an inner holder and an outer holder. Familiarize yourself with which component is the outer, and which is the inner. Label the holders if necessary to aid in future steps. **Note: The repair sets (inner and outer) are side specific and are labeled L & R to be matched to the corresponding tail light.**

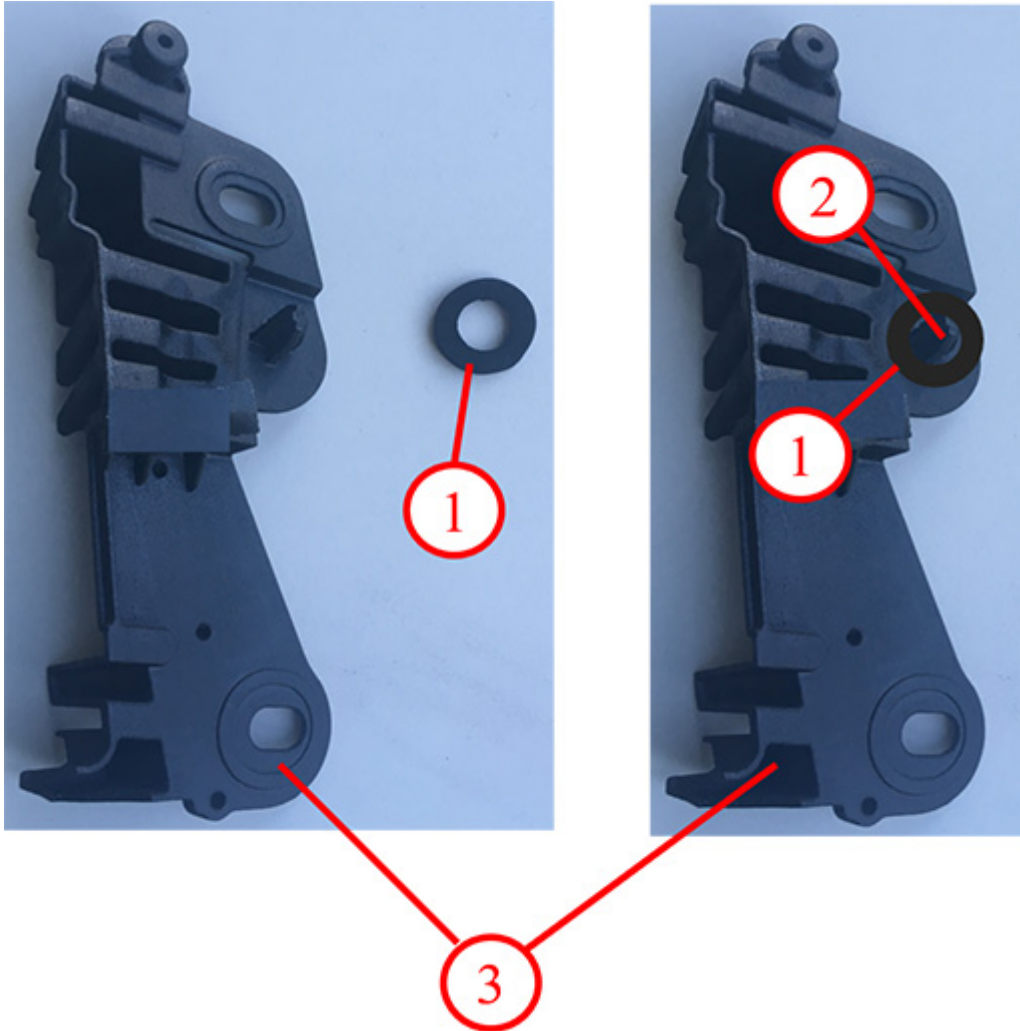
The inner holder (2) can be identified by the pin (3) shown below:

The outer holder (1) can be identified using the photo below:



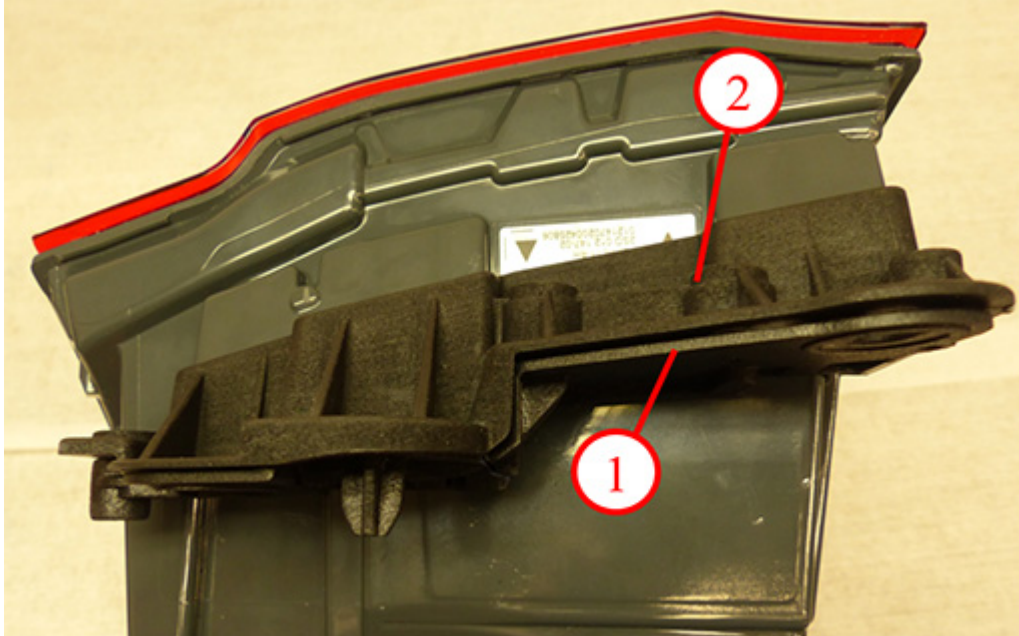
B63 01 19 Repair procedure

7. Remove the foam gasket (1) from the repair kit. Remove the adhesive backing, and install the foam gasket over the pin (2) on the inner holder (3).

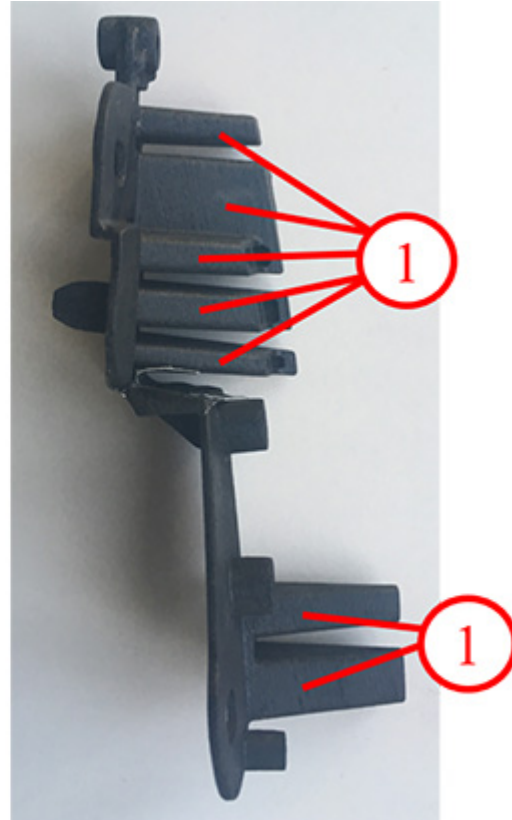
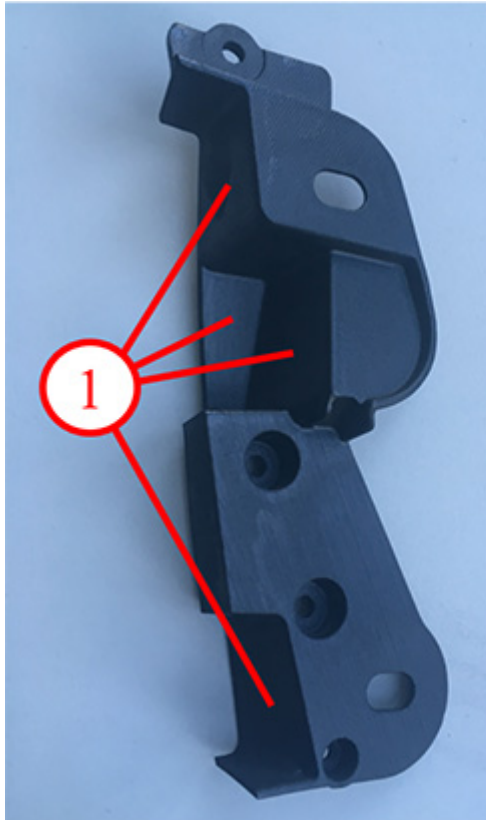


8. Test fit both holders by sliding them onto the tail light, fitting the tabs of the inner holder into the recesses of the tail light mounting tabs cut in step 3.

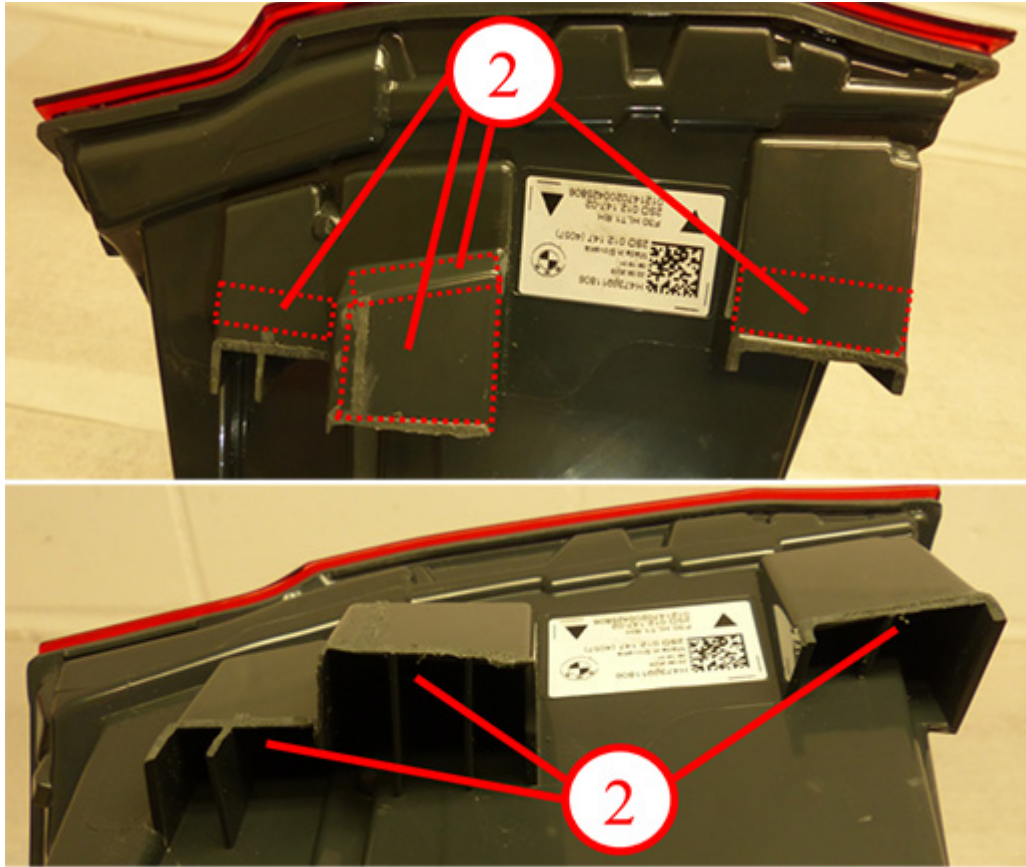
9. Ensure that the tail light repair kits fit tight against each other and the tail light as shown below. If necessary, re-trim the tail light mounting tabs to allow for a better fit.



10. After test fitting, remove both the inner and outer holders. Using an abrasive pad or fine sandpaper (220-500 grit), roughen the bonding points shown below (1).



11. Roughen the surface of the tail light at the bonding points shown below (2).



12. Apply R1 cleaner, **PN 83 19 2 211 217**, to all of the bonding points that were roughened in steps 10 and 11. Allow the cleaner to dry for 2 minutes.



**Note:** Before continuing, familiarize yourself with the bonding points that were prepared in steps 10 and 11. These areas will be bonded with K6 adhesive, which dries rapidly. Be prepared to bond all required areas before the adhesive can dry. **Read the remainder of the installation instructions before mixing the K6 adhesive.**

13. Once familiar with the bonding points of the tail light and tail light repair holders, separate and mark the inner and outer holders so that they can be rapidly prepared with adhesive for installation without confusion. If needed, test fit the holders again to ensure the installation positions are completely understood.



## B63 01 19 Repair procedure

14. Install a mixing tip onto the tube of K6 adhesive. Apply a small amount of adhesive onto a disposable surface to ensure that the adhesive completely mixes inside the tip.

Apply adhesive to the inner holder at the bonding points (1) prepared in steps 10.

Apply adhesive to the rear light bonding points (2) of the inner holder prepared in step 11.

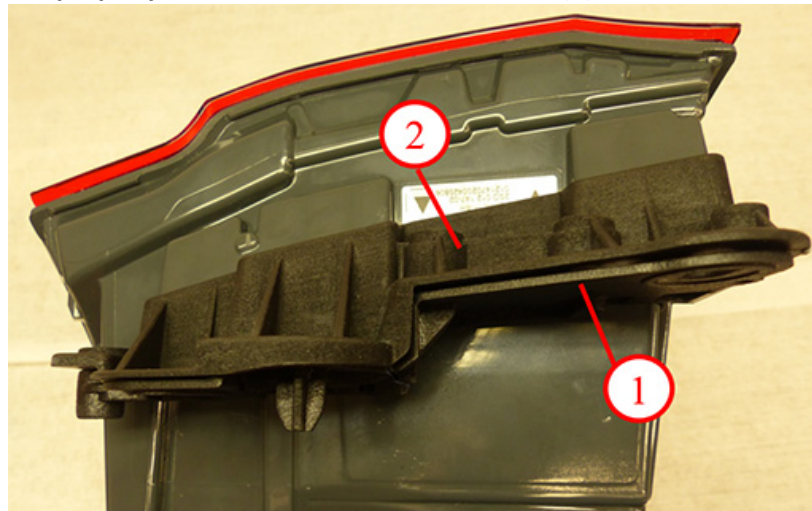
Install the inner holder onto the tail light, ensuring the holder is slid completely into the tail light.

15. Apply adhesive to the outer holder at the bonding points (1) prepared in steps 10.

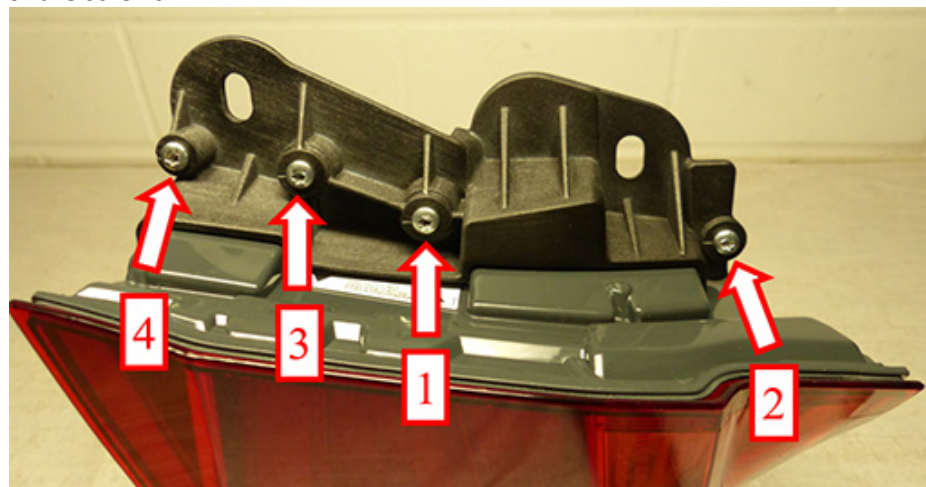
Apply adhesive to the rear light bonding points (2) of the outer holder prepared in step 11.

Install the outer holder onto the tail light, ensuring the holder is slid completely into the tail light.

**Photo below shows properly bonded inner and outer holders (3):**



16. Install the 4 self-tapping screws into the inner and outer holders, following the tightening order shown below of 1-2-3-4. Ensure that both holders are held tightly against the tail light during installation of the screws.



17. Continue to Step 7 of SI B63 01 19.

**DELIVERY STOP: REWORK TAIL LIGHTS****WARRANTY INFORMATION**

Updated information highlighted in yellow.

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

<b>Defect Code:</b>	<b>0063580100</b>	<b>F2x F3x F80 F87 G01 G12 Rework rear light</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 (All)	Perform inspection of the rear tail lights <b>(No repair is necessary) (Plus Work)</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 or repair of one or both tail lights:**

<b>Labor Operation:</b>	<b>Labor Allowance:</b>	<b>Description:</b>
00 67 793	Refer to AIR; 6 FRU (G12 ALPINA)	Perform inspection of the rear tail lights, <b>replace one tail light, and clean the vehicle body (Plus Work)</b>
Or:		
00 67 794	Refer to AIR; 10 FRU (G12 ALPINA)	Perform inspection of the rear tail lights, <b>replace both tail lights, and clean the vehicle body (Plus Work)</b>
<b>Or for F30/F80 only:</b>		
<b>00 67 553</b>	<b>8 FRU (F30/F80)</b>	<b>Perform inspection of the rear tail lights, repair one tail light, and clean the vehicle body (Plus Work)</b>
Or:		
<b>00 67 554</b>	<b>15 FRU (F30/F80)</b>	<b>Perform inspection of the rear tail lights, repair both tail lights, and clean the vehicle body (Plus Work)</b>
Or:		
<b>00 67 555</b>	<b>10 FRU (F30/F80)</b>	<b>Perform inspection of the rear tail lights, repair one tail light, replace one tail light, and clean the vehicle body (Plus Work)</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>
<b>00 67 215</b>	<b>5 FRU (All)</b>	Perform inspection of the rear tail lights <b>(No repair is necessary) (Main Work)</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 or repair 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, <b>replace one tail light, and clean the vehicle body (Main Work)</b>
Or:		
00 67 217	Refer to AIR; 11 FRU (G12 ALPINA)	Perform inspection of the rear tail lights, <b>replace both tail lights, and clean the vehicle body (Main Work)</b>
<b>Or for F30/F80 only:</b>		
00 67 043	10 FRU (F30/F80)	Perform inspection of the rear tail lights, <b>repair tail light and clean the vehicle body on one side (Main Work)</b>
Or:		
00 67 044	16 FRU (F30/F80)	Perform inspection of the rear tail lights, <b>repair tail lights and clean the vehicle body on both sides (Main Work)</b>
Or:		
00 67 045	11 FRU (F30/F80)	Perform inspection of the rear tail lights, <b>repair one tail light, replace one tail light, and cleaning the vehicle body on both sides (Main Work)</b>

And, as applicable, when a corresponding repair is required:

**Sublet – Bulk Materials (All except F30 and F80)**

<b>Sublet Code 4</b>	Up to \$1.00	Reimbursement for the repair-related bulk material
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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.

Or:

**Sublet – Bulk Materials (F30 and F80)**

<b>Sublet Code 4</b>	Up to \$15.00 (only one side repaired); Up to \$31.00 (both sides repaired)	Reimbursement for the repair-related bulk materials
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Sublet reimbursement for the applicable repair-related bulk material (Denatured alcohol and the used portion of the Adhesive set K6).

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