SIB 54 04 17 2019-10-02

CREAKING OR RATTLING NOISE FROM SUNROOF AREA

This Service Information Bulletin (Revision 4) replaces SI B54 04 17 **dated May 2018**.

What's New (Specific text highlighted):

- Model (remove production dates)
- Situation
- Procedure

MODEL

E-Series	Model Description
G12	7 Series Sedan

SITUATION

Creaking and/or rattling noise from the sunroof area, especially when driving on uneven road surfaces. This can already take place as of low speeds.

CAUSE

Incorrect torque applied to the mounting screws during production, allowing flexing/movement around the sunroof cassette/glass unit.

And/or

Improperly installed (loose) threaded bushings in the roof panel.

CORRECTION

Reinforce the bushing installation for the front and rear glass assemblies; and torque all screws precisely.

PROCEDURE

For conditions that are similar to the situation described:

1. Test drive vehicle to verify the creaking or rattling noise is coming from the glass roof unit attachment screws.

2. Refer to the attached procedure to reinforce the threaded bushings and re-torque the sunroof cassette bolts. Follow the procedure completely to avoid a recurrence of this issue.

Note: For vehicles which return for this complaint after the procedure has been completed, verify that the noise is being caused by the situation described above, and verify the procedure was correctly completed on the initial repair attempt. If so, submit a TSARA case for additional assistance.

PARTS INFORMATION

Obtain and confirm the part numbers for your specific vehicle by entering the chassis number in either ETK or AIR which takes into account specific equipment and/or options.

Part Number:	Description:	Quantity:
07 14 7 226 126	M6 x 14 Hex Bolt	12 or 14
54 10 7 153 589	Plastic Washer	12 or 14

Bulk Materials - Sublet

Part Number:	Description:	Quantity:

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83 19 0 417 324	Cleaner, R2	As Needed
83 19 2 211 217	Cleaner, R1	As Needed
83 19 2 158 654	Body Adhesive, K5a	As Needed
83 19 2 210 339	Screw-locking adhesive, Med Strength	As Needed

WARRANTY INFORMATION

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

Defect Code:	**5412213900**	
Labor Operation:	**Description:**	**Labor Allowance:**
54 13 250	Removing and installing/replacing rear glass slide/tilt sunroof panel (Main work)	Refer to AIR
Or:		
54 13 750	Removing and installing/replacing rear glass slide/tilt sunroof panel (Plus work)	Refer to AIR
And:		
54 99 000	Work time to perform repairs to threaded bushings	17 FRU

If you are using a Main labor code for another repair, use the Plus code labor operation 54 13 750 instead of 54 13 250.

And, as needed:

Sublet – Bulk Materials

Sublet Code 4	See the sublet reimbursement calculations below	Reimbursement for the repair-related bulk materials (Do not use part numbers for claim submission)

Sublet reimbursement calculation for claiming the applicable repair-related bulk materials (BMW part numbers) is a 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.
Supporting Materials
picture_as_pdf B540417_Repair Instructions for G12 Sunroof Noise.pdf

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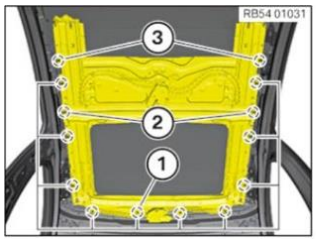
REPAIR INSTRUCTIONS FOR G12 SUNROOF NOISE

Special Tools/Fluids Required:

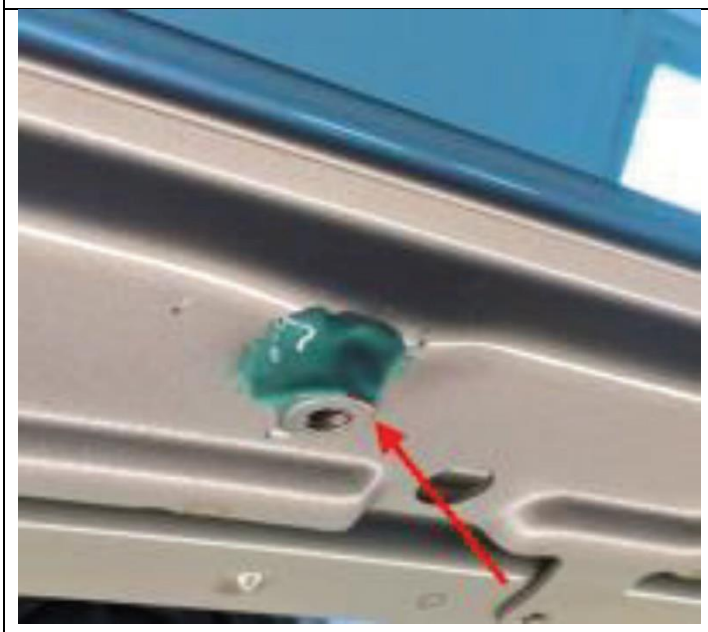
- Heat gun with adjustable temperature (locally available)
- Non-contact infra-red thermometer
- R2 Cleaner (83 19 0 417 324)
- R1 Cleaner (83 19 2 211 217)
- Body adhesive K5a (83 19 2 158 654)
- Body adhesive cartridge gun (83 19 2 149 522)
- Infra-red Thermometer (locally available)
- Thread lock adhesive (83 19 2 210 339)

PROCEDURE

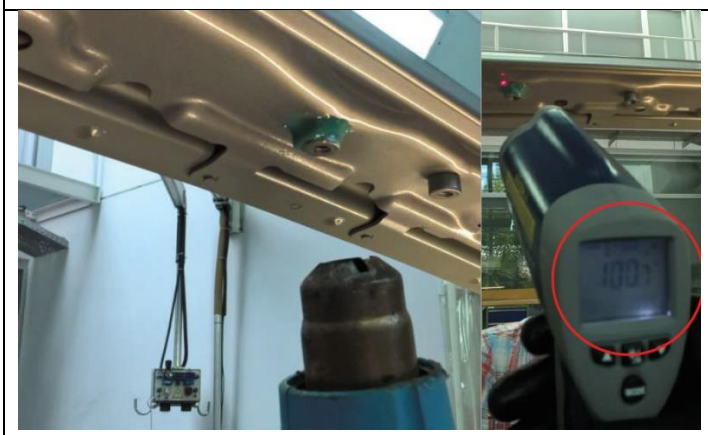
	1. Remove the rear sunroof glass panel following repair instructions **REP 54 13 250 "Removing and installing/replacing rear glass slide/tilt sunroof panel**". The front glass slide/tilt sunroof will be removed at the same time.
	2. With both glass panels removed from the vehicle, reinforce the threaded bushings by completing the following steps. A. Clean the surface area around each threaded bushing with R2 cleaner. Allow to air dry for 2 minutes. B. Clean the area around each threaded bushing with R1 cleaner. Allow to air dry for 2 minutes.

C. Use cartridge gun 83 19 2 149 522 to apply K5a body adhesive around the **side** of each bushing as shown.

Note: Apply adhesive on **all** of the threaded bushings on the roof for the front **and** rear glass panels.



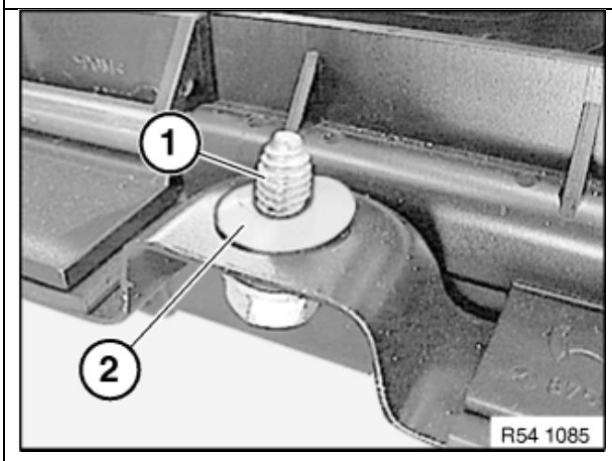
Note: Keep all adhesive off the flat surface of the bushing.



D. Heat the applied adhesive with a heat gun to an approximate temperature of 175 to 212 degree F (80-100° C). Check the temperature with an infra-red thermometer.

E. Apply another layer of adhesive to the side of the bushing repeating Steps 2C and 2D, above.

F. Allow the adhesive to cure for at least 12 hours.

	3. Reinstall the rear glass sunroof panel, following repair instructions. The original screws will be reused. Note: Tighten the rear glass panel mounting screws exactly to 10Nm using a torque wrench. **Coat the screw threads with medium-tight thread locking adhesive (Loctite 243)** (BMW part # 83 19 2 210 339)
	4. Reinstall the front glass unit into the vehicle, using **new** screws (1). Be sure to install plastic washers (2) between the sunroof cassette and the threaded bushing.

	5. Coat the front screw threads with medium–tight thread locking adhesive (Loctite 243) (BMW part # 83 19 2 210 339). Note: Tighten screws, with a torque wrench, to **exactly 10 Nm**. Over-tightening or under-tightening will lead to a loose connection and a repeat visit.
	6. Before completely assembling the vehicle, test drive and verify the roof noise is no longer present. 7. If the noise is no longer present after the repair, completely reassemble the vehicle.