



SIB 41 06 19

2019-11-06

DELIVERY STOP: CHECK BLIND PLUGS

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 (Revision 3) replaces SI B41 06 19 dated October 2019.

Whats New (Specific text highlighted):

- Procedure added for customer vehicles where the plugs are missing
- Warranty Information section updated

MODEL

E-Series	Model Description	Production Date
G20	330i, 330i xDrive Sedan NA	March 27, 2019 – August 21, 2019

AFFECTED VEHICLES

Vehicles which require this Recall Campaign to be completed will show it as "Open" when checked either in AIR, the "Service Menu" of DCSnet (Dealer Communication System), ISPA Next or Warranty Vehicle Inquiry. All other systems will show the stop sale starting tomorrow.

SITUATION

BMW of North America, LLC has issued a Delivery Stop (effective October 7, 2019) on a small number of Model Year 2019 and 2020 BMW 3 Series vehicles that were produced between March 27, 2019 and August 21, 2019.

CAUSE

During assembly, the blind plug in one or both rear wheel wells may have been knocked out of position when attaching the suspension to the vehicle body.

PROCEDURE



1. Inspect both sides of the vehicle body, just inboard of the rear shock absorber in the area shown.

Note: There is no vehicle disassembly required to inspect or install the blind plugs.

Is the body plug (circled) installed?

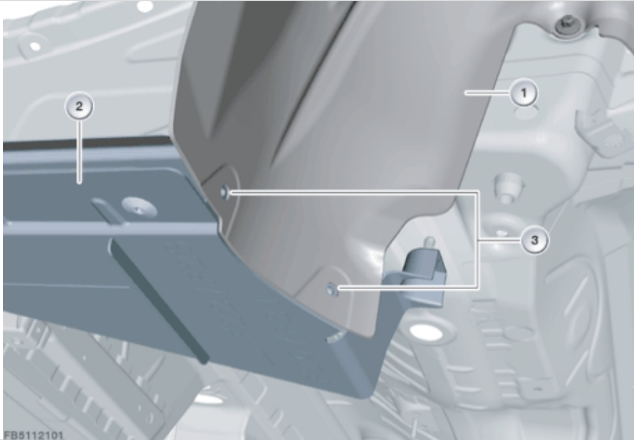
No: Continue to step 2.

Yes: No further correction needed.

2. Has the vehicle already been delivered to the customer?

No: Install a blind plug in one or both sides, depending on whether one or both blind plugs are missing. You are finished.

Yes: Proceed to the next step



3. Only for vehicles that have already been delivered to the customer:

- Remove the underbody panel covering the fuel tank and the rear wheel arch trim panel (1) (only from the side with the missing plug).



4. Looking from under the vehicle, locate the rear paint plug (1) and drill it out using a 10 mm drill bit.

5. If there is no moisture coming out of the hole, remove the mounting plug (2) and with a small light or borescope check for moisture.

Note: Perform this procedure on the other rear wheel well if the plug was missing from step 2.

6. Was there moisture present in either hole (1) or hole (2)?

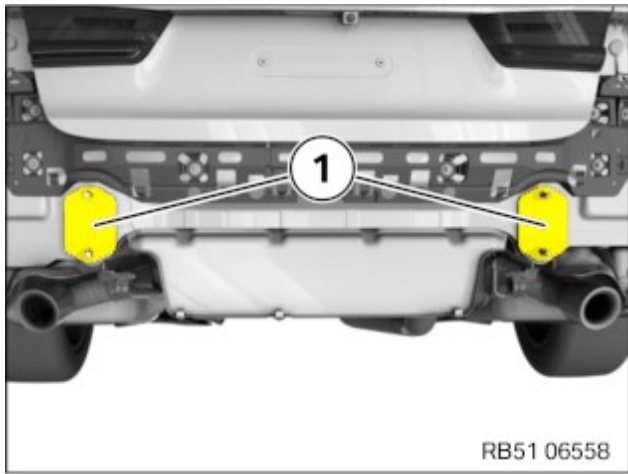
YES: Proceed to the next step

NO: Replace the missing plug(s) (07 14 7 127 540) from step 2.

Reinstall the mounting plug (2) removed in step 5.

Install a seal plug (07 14 7 127 539) into the drilled-out paint plug (1) in step 4. Repeat for other side if needed. You are finished.

7. Remove the rear bumper panel and support as per repair instructions "51 12 050 Removing



and installing/replacing support for rear bumper panel”.

8. Remove the seals (1). If not damaged, they can be reused at installation.



9. Set a hot air blower no higher than 122° F (50°C) at a distance of at least 4” from the two openings (circled). The hot air will dry any moisture and should be felt coming from the holes indicated in steps 4 and 5. The drying process can take up to 20 minutes depending on how much moisture is present.

10. Check for moisture again as in step 4 and 5. If moisture is still present, dry for an additional 10 minutes or until moisture is completely gone.



11. After all the moisture has been removed, cavity protection wax must be applied into the rear opening of the side member, the openings of the mounting plugs (2) and the opening of the drilled paint plug (1).

12. Replace the missing plug(s) (07 14 7 127 540) from step 2. Reinstall the mounting plug (2) removed in step 5. Install a seal plug (07 14 7 127 539) into the drilled-out paint plug (1) in step 4. Repeat for the other wheel well if needed.

13. Reinstall the rear seals.

14. Reinstall the rear bumper panel and support as per repair instructions “51 12 050 Removing and installing/replacing support for rear bumper panel”.

15. Reinstall the rear arch trim panel and underbody tank trim.

PARTS INFORMATION

Parts are only required if blind plugs are found to be missing. **Not all vehicles will require parts.**

Part Number:	Description:	Quantity:
07 14 7 127 540	Blind plug (15 mm)	1 or 2
07 14 7 127 539	Blind plug (12 mm)	1 or 2
83 42 2 457 337	Cavity Spray (400ml)	As needed

WARRANTY INFORMATION

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

Defect Code:	0041980100	
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Completion before the first vehicle delivery to a customer (New In-Stock Delivery Stop Vehicles)

Work Pkg	Labor Operation	Description (Plus work)	Labor Allowance
# 1	00 68 699	Checking whether plugs are present on the left and right (no repair is necessary)	3 FRU
Or:			
# 2	00 68 700	Checking whether plugs are present on the left and right, retrofitting one or both plugs	3 FRU

Or:

Vehicle is already in the workshop (Vehicle was previously delivered)

Work Pkg	Labor Operation	Description (Plus work)	Labor Allowance
# 3	00 68 699	Checking whether plugs are present on the left and right (no repair is necessary)	3 FRU
Or:			
# 4	00 68 703	Checking the plugs and retrofitting one, with a visual inspection of a trailing arm for moisture (none found)	8 FRU
Or:			
# 5	00 68 704	Check the left and right sides, retrofit both blind plugs and visual inspection of a trailing link for humidity (none found)	16 FRU
Or:			
# 6	00 68 705	Checking the plugs and retrofitting one, visually inspecting a trailing arm for moisture (found), drying and preserving one side	38 FRU
Or:			
# 7	00 68 706	Checking the plugs and retrofitting both, visually inspecting both trailing arms for moisture (found), drying and preserving both sides	48 FRU

Or:

The vehicle arrives at your center and this Campaign shows open (No other Main work will be performed/claimed during this workshop visit)

Work Pkg	Labor Operation	Description (Main work)	Labor Allowance

# 8	00 68 146	Checking whether plugs are present on the left and right (no repair is necessary)	5 FRU
Or:			
# 9	00 68 149	Checking the plugs and retrofitting one, with a visual inspection of a trailing arm for moisture (non-found)	10 FRU
Or:			
# 10	00 68 150	Check the left and right sides, retrofit both blind plugs and visual inspection of a trailing link for humidity (non-found)	17 FRU
Or:			
# 11	00 68 151	Checking the plugs and retrofitting one, visually inspecting a trailing arm for moisture (found), drying and preserving one side	39 FRU
Or:			
# 12	00 68 152	Checking the plugs and retrofitting both, visually inspecting both trailing arms for moisture (found), drying and preserving both sides	49 FRU

Claim Repair Comments

Only reference the SIB number and the work package (Pkg) number performed in the RO technician notes and in the claim comments (For example: B41 06 19 WP 1), unless otherwise required by State law.

And, as needed:

Sublet – Bulk Materials (RO and Claim Comments Required)

Sublet Code 4	Up to \$10.00	Reimbursement for the repair-related bulk materials (Do not use the BMW part number for claim submission)
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Sublet reimbursement calculation for claiming the applicable repair-related bulk material (BMW part number) is at the dealer net price amount for the quantity 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 (RO and Claim Comments Required)

This 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.