



SIB 51 13 20  
REAR DOOR SEAL DETACHED

## MODEL

E-Series	Model Description
G05	X5 Sports Activity Vehicle
G07	X7 Sports Activity Vehicle

## SITUATION

One or both rear door seals are detached from the rear door(s).



**CAUSE**

Improper connection of the door seal to the door.

**CORRECTION**

Apply adhesive and reinstall the rear door seal(s).

**PROCEDURE**

1. Install a small dab (1 mm x 1 mm) of adhesive P/N 83 19 2 289 180 to the middle and bottom of the seal channel.
2. Re-install the seal by pressing it firmly into the channel. Use the window frame as a guide to ensure the seal is completely seated inside the channel.
3. Complete the procedure on the opposite side of the vehicle.

**PARTS INFORMATION**

Part Number	Description	Quantity
83 19 2 289 180	Windshield adhesive kit	See below

**WARRANTY INFORMATION**

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

<b>Defect Code:</b>	<b>5171013700</b>	<b>Seal, rear door Loose</b>
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**Repairing one rear door seal**

Labor Operation	Description	Labor Allowance
51 00 001	Work time to apply adhesive and re-install the seal on one rear door (Main work)	3 FRU
Or:		
51 00 001	Work time to apply adhesive and re-install the seal on one rear door (Plus work – Vehicle is already in the workshop)	2 FRU

Or:

**Repairing both rear door seals**

Labor Operation	Description	Labor Allowance
51 00 001	Work time to apply adhesive and re-install the seals on both rear doors (Main work)	5 FRU
Or:		
51 00 001	Work time to apply adhesive and re-install the seals on both rear doors (Plus work – Vehicle is already in the workshop)	4 FRU

And, as needed:

**Sublet – Bulk Materials (RO and Claim Comments Required)**

<b>Sublet Code</b> <b>4</b>	See the sublet reimbursement calculations below	Reimbursement for the repair-related bulk material
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Due to the limited shelf life of the adhesive, when two or more vehicles are being repaired during the same workshop visit, determine your center's reimbursement cost for PN 83 19 2 289 180 at a quantity of one (DN plus your center's handling). Divide this amount by the total number of vehicles being repaired, claim the applicable fractional amount in sublet as shown above.