



SIB 51 22 20

2020-07-21

SERVICE ACTION: TIGHTEN UNDERFLOOR BRACING

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.

For centers that qualify, this Recall repair is eligible to be performed via Mobile Assistance.

MODEL

E-Series	Model Description	Production Date
F95	X5 M Sports Activity Vehicle	December 2019 to February 2020
F96	X6 M Sports Activity Coupe	December 2019 to February 2020

AFFECTED VEHICLES

This Service Action involves 127 F95 and F96 produced from December 2019 to February 2020.

Vehicles which require this Service Action to be completed will show it as "Open" when checked either in AIR, or the "Service Menu" of DCSnet

SITUATION

The underfloor bracing was not correctly tightened by the additional 90° required to meet the torque specification during production.

CAUSE

Improper tightening of the underfloor bracing.

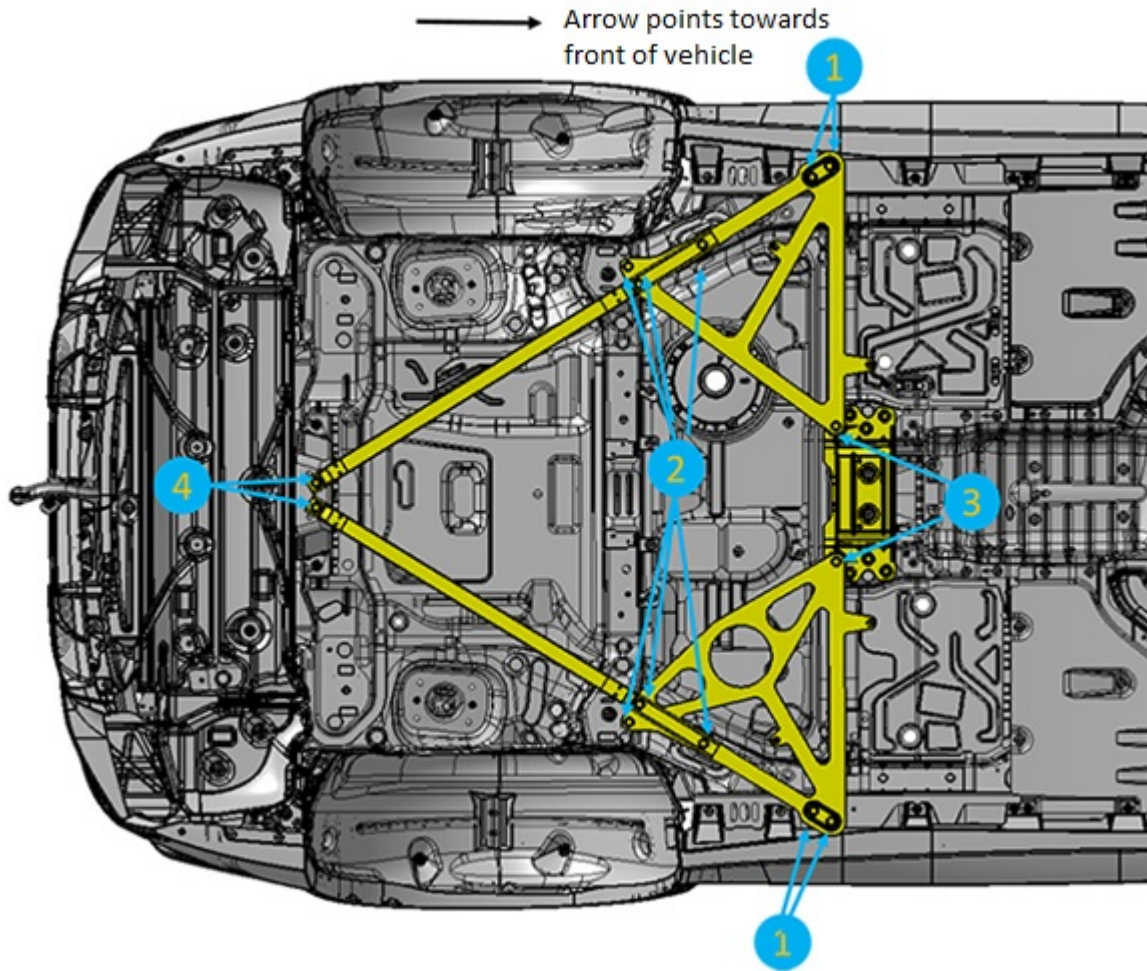
CORRECTION

Correctly tighten the 14 underfloor bracing bolts.

PROCEDURE

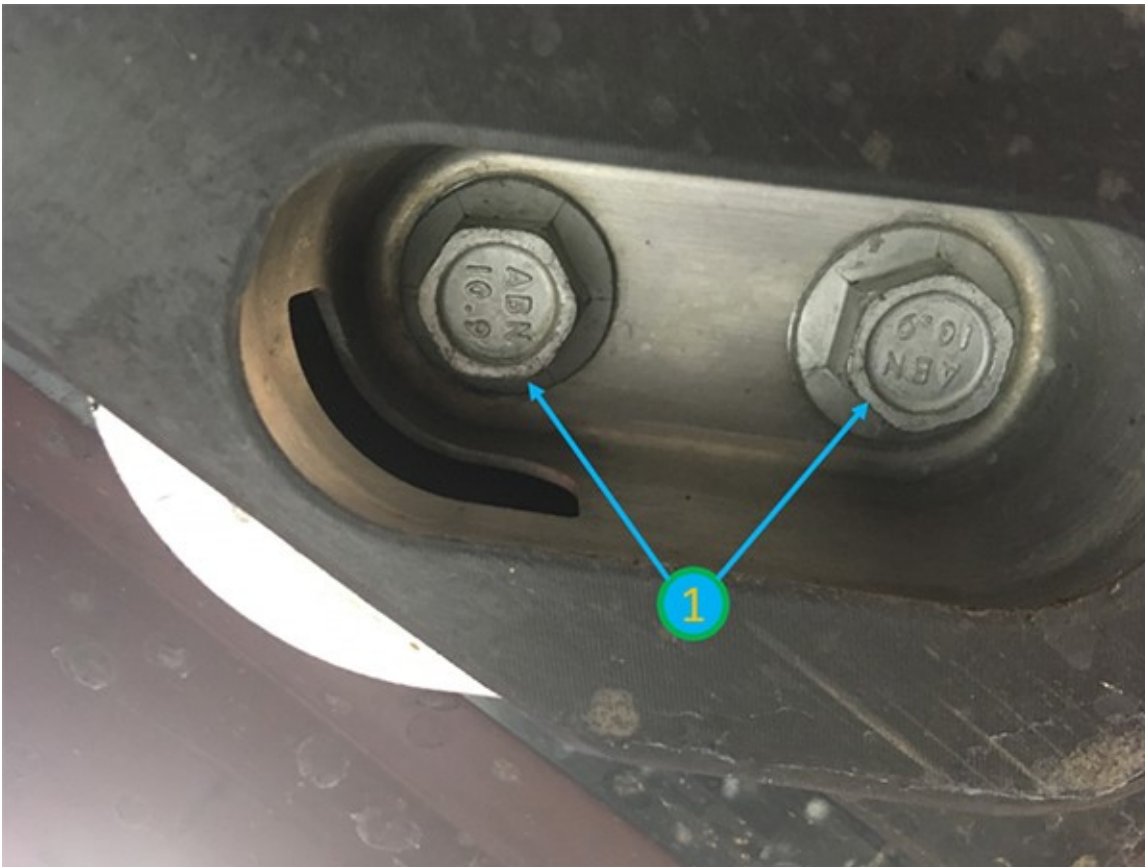
1. Safely secure the vehicle on a lift. Removal of the underbody shields are not required to complete this procedure. All the required bolts are accessible with the vehicle fully assembled.
2. Referencing the photo below, tighten the 14 bolts by 90°, as shown (arrows) in the tightening order of 1-4. Note: Ensure the torque wrench/angle gauge being used can support torque values of up to 250 Nm.
3. After angle torqueing each bolt, **mark the head of the bolt** to track and ensure each bolt has been correctly tightened.

Bolt replacement is not required.

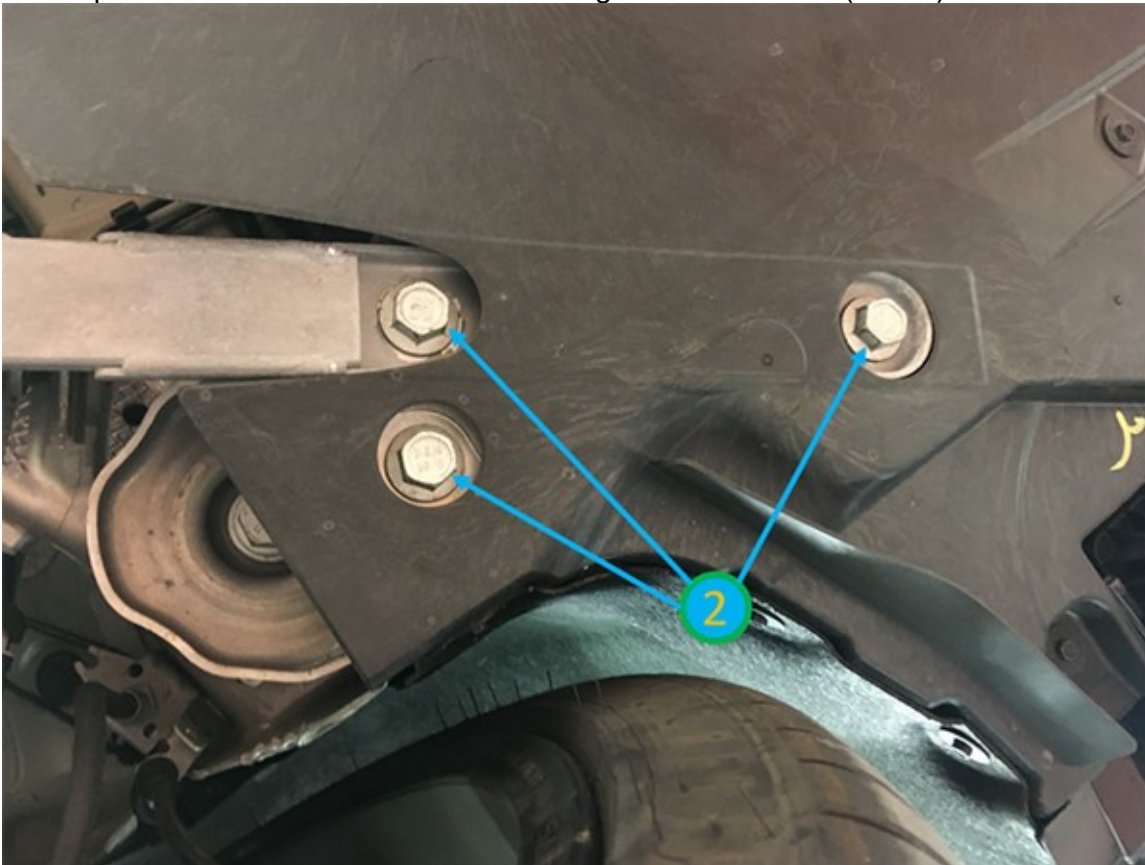


Additional bolt clarification photos are shown below for reference:

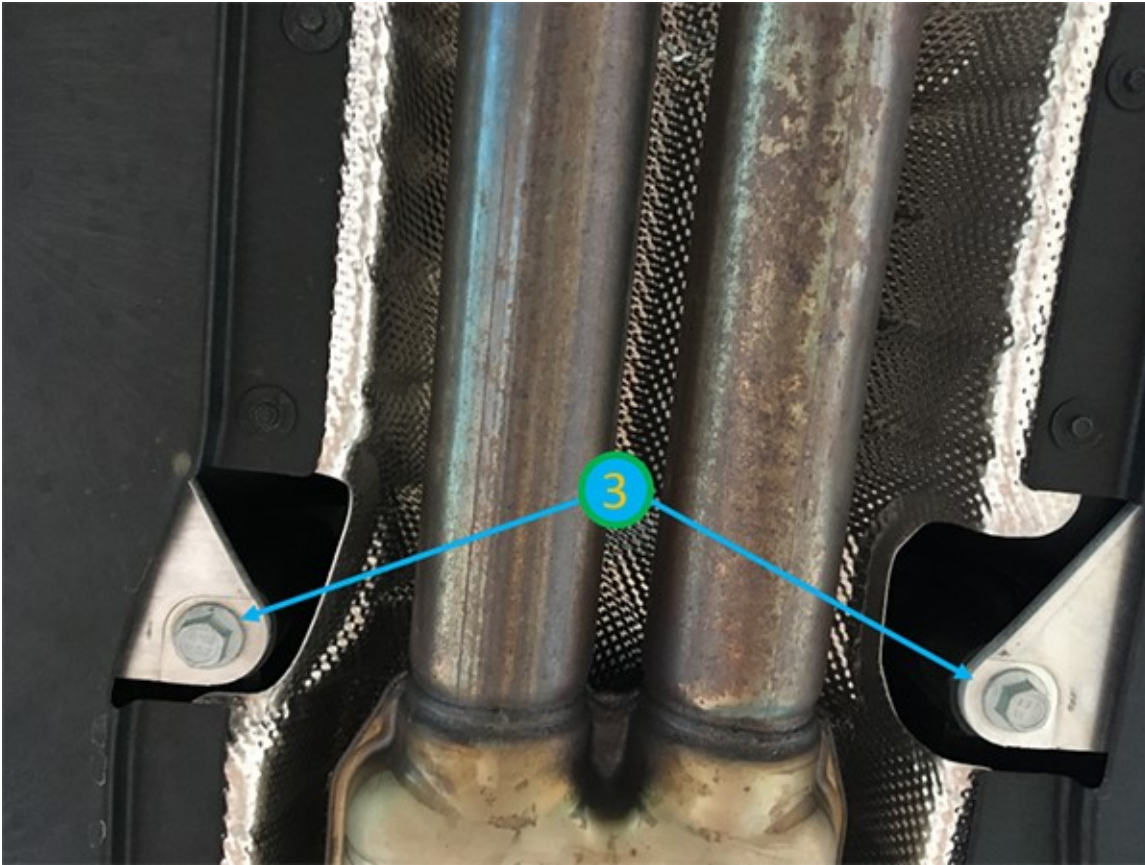
Screw point 1: 2x M12 each on the left and right side of vehicle (4 total):



Screw point 2: 3x M12 each on the left and right side of vehicle (6 total):



Screw point 3: 2x M12:



Screw point 4: 2x M12:



PARTS INFORMATION

Parts are not required. Bolt replacement is NOT required because angle torqueing was never achieved during production.

WARRANTY INFORMATION

Reimbursement for this Service Action will be via normal claim entry utilizing the work package information below that applies.

Defect Code:	0051950400	F95 F96 Retighten underfloor strut screw connection
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Completion before the first vehicle delivery to a customer or the vehicle is already in the workshop

Work Pkg	Labor Operation	Description (Plus work)	Labor Allowance
# 1	00 69 741	Retightening the screw connections by 90 degrees and mark it repaired with a colored dot	3 FRU

Or:

The vehicle arrives at your center and this Service Action shows open (No other main work will be performed or claimed during this workshop visit)

Work Pkg	Labor Operation	Description (Main work)	Labor Allowance
# 2	00 69 216	Retightening the screw connections by 90 degrees and mark it repaired with a colored dot	5 FRU

Only one of the flat rate labor operation codes listed above can be used for claim submission/reimbursement purposes. Also, only one Main work flat rate labor operation code can be claimed per workshop visit.

Claim Repair Comments

Only reference the SIB number and the work package (Pkg) number performed in the RO technician notes and the claim comments (For example: B51 22 20 WP 1), unless otherwise required by State law.

QUESTIONS REGARDING THIS BULLETIN

Technical inquiries	Submit feedback at the top of this bulletin
Warranty inquiries	Submit an IDS ticket to the Warranty Department
Parts inquiries	Submit an IDS ticket to the Parts Department