



SIB 52 06 23

2023-04-13

DELIVERY STOP: FRONT REAR SEAT CROSSMEMBER

This Service Information Bulletin (Revision 1) replaces SI B52 06 23 **dated March 2023**.

What's New:

- Title
- Model (G09 deleted)
- Situation
- Cause
- Correction
- Procedure
- Parts Information
- Claim Information

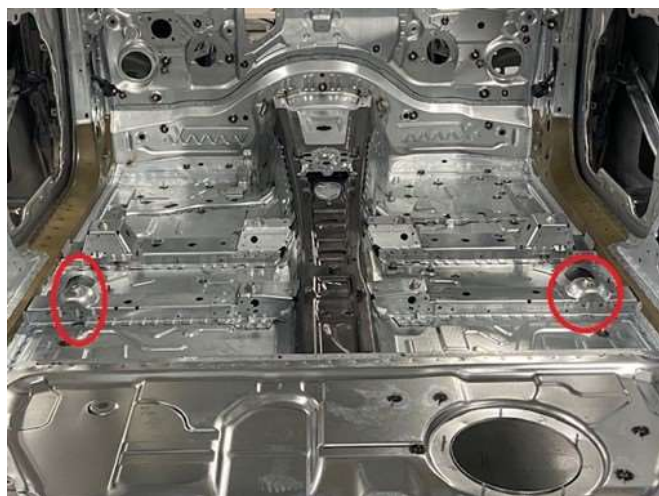
MODEL

E-Series	Model Description	Production Date
G06	X6 Sports Activity Coupe	March 1, 2023 – March 7, 2023

AFFECTED VEHICLES

- Vehicles which require this campaign to be completed will show it as “Open” when checked either in AIR, AWP, Campaign Summary, or Warranty Vehicle Inquiry
- Please make sure you check your dealer inventory as soon as possible. You can see a list of affected vehicles in Inventory Campaign Details (ICD) under ROSS
- For centers that qualify, this recall repair is eligible to be performed via Mobile Assistance

SITUATION



looking frontwards) can form.

BMW AG has issued a Delivery Stop (effective March 13, 2023) on certain Model Year 2023 BMW X6 SAC vehicles that were produced between March 1, 2023, and March 7, 2023.

Do not deliver to a customer, a New, Certified Pre-Owned or Used vehicle subject to a Delivery Stop, until the vehicle is repaired. Do not use or sell replacement equipment/parts subject to a Delivery Stop.

It was discovered that an indentation or crack on the driver and/or passenger seat crossmember rear outer dome (circled; viewed

Note: The rear inner dome on both the driver and passenger seat crossmembers are not affected.

CAUSE

A metal stamping error during production, on a small amount of the affected vehicles.

CORRECTION

Inspect the driver's seat left rear (L/R) mounting dome as well as the front passenger's seat right rear (R/R) mounting dome for evidence of a metal crack or indentation as shown in the photos.

PROCEDURE

Note: The seats DO NOT have to be removed to perform the inspection of the seat mounting domes.

1. Inspection of the driver seat L/R mounting dome and the passenger seat R/R mounting dome needs to be performed by removing the seat bolts on both seats and tilting the seat back.
 - o The seat does not need to be removed from the vehicle; this saves unplugging the harness

The bass speaker screws and cover need to be removed. The carpet can then be folded back to access the L/R (driver's) and R/R (passenger's) seat mounting domes. Refer to the repair instructions listed in ISTA/AIR 51 47 440 "Removing and installing rear carpet".

- Do not remove the center console, the console rear trim, nor the console armrest Do not
- remove the front seats. Once the mounting bolts are removed, tilt the seat back.

Note: If an indentation or crack cannot be felt or seen, no further action is needed.

Not OK: Indent.

Go to Step 2.



Not OK: Cracked/torn

Go to Step 2.





A "good" dome does not show any indications of an indent, nor of a crack/tear.

If both rear outer domes resemble this photo, go to Step 9.

2. If an indentation or a crack is found on the driver and/or passenger side L/R and R/R outer domes, disassemble the vehicle per the repair instructions listed in ISTA/AIR (51 47 440).

Note: Cover the vehicle interior with welding blankets once the vehicle is disassembled.



Cover stamped numbers with thick tape to protect during welding/grinding

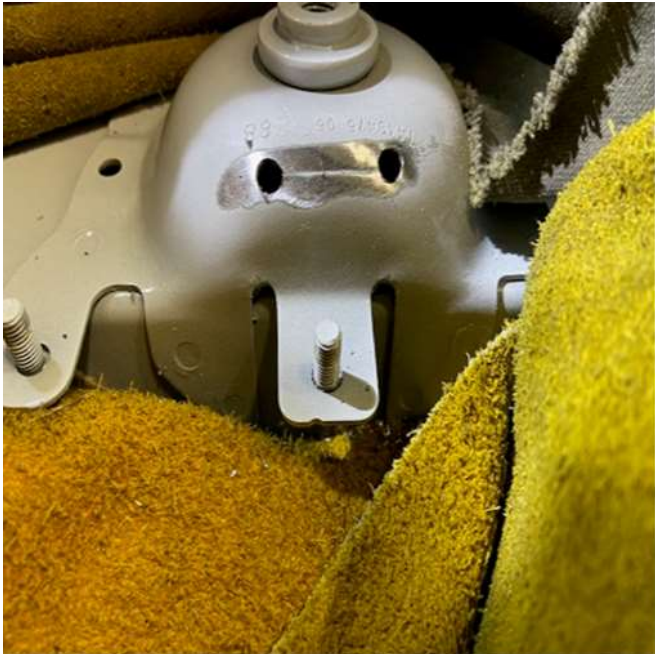
3. Place a thick piece of tape over the stamped numbers on the dome, for protection.

4. Grind the indentation or crack to determine

the end point.



5. Drill a 4.2 mm (approx. 5/32") hole at each



end of the indentation/crack to stop any crack propagation.

The protective tape from Step 3 is temporarily removed in this photo for clarity.

6. MIG weld the entire length of the defective

area including the drilled holes.

The protective tape from Step 3 is temporarily removed in this photo for clarity.



7. Using a small “finger” belt sander, carefully



grind down the MIG weld (80 grit sand belt).

Note: The weld seam must NOT be completely removed, as there is a risk that too much material will be removed.

The protective tape from Step 3 is temporarily removed in this photo for clarity.



8. Using 1K multi primer filler according to the vehicle color, repaint the affected area.

9. Reassemble the vehicle.

- Replace the 4 mounting bolts per seat, and torque per the AIR instructions.

PARTS INFORMATION

Repair-related small parts such as bolts or nuts, which need to be replaced based on the ISTA/AIR repair manual, must be selected from the ETK in accordance with the respective vehicle type or VIN and claimed under the special defect code of this service action.

Obtain and confirm these part numbers for the specific vehicle by entering the VIN either in ETK or AIR, which considers specific equipment and/or options.

Bulk Materials - Seat Mounting Dome Rework Repair

A list of materials for required chemicals will be released in a future revision of this bulletin.

CLAIM INFORMATION

Reimbursement for this Action will be via normal claim entry utilizing the applicable work package information below, and when applicable, including the third-party sublet repair.

Defect Code:	0041190200	---
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Center Inspection - Seat Mounting Dome Rework Repair is not Necessary

Work Pkg	Labor Operation	Description (Plus work)	Labor Allowance
# 1	00 73 942	Check left and right front seat console (No repair is necessary)	9 FRU
Or:			
# 2	00 73 346	Check left and right front seat console (No repair is necessary)	10 FRU

Or:

Center Inspection with a Third-Party Seat Mounting Dome Rework Repair Procedure (CCRC or Approved Body Shop)

Work Pkg	Labor Operation	Description (Combined work)	Labor Allowance
# 3	00 73 942	Check left and right front seat console (Repair is necessary)	9 FRU
Or:			
# 4	00 73 346	Check left and right front seat console (Repair is necessary)	10 FRU

And:

Seat Mounting Dome Rework Repair - One or Both Sides as Required

Third-Party	Description (Associated work)	Sublet Allowance
Sublet Code 3	Third-party seat mounting dome rework repair (one or both sides), welding, grinding, and apply interior sheet metal surface protection	Up to \$160.00

Note: Aftersales Area Manager (AAM) Field Authorization (FAS) is **not** required.

Invoice the eligible seat mounting dome repair (one or both sides) and the corresponding interior sheet metal surface protection in sublet on the repair order at the actual cost charged with no handling or markup. The sublet amount must also include any discounts or allowances.

The appropriate charge for the necessary seat mounting dome repair-related work procedures is determined by comparing the charged amount against the corresponding amount that is based on your warranty rates.

Prior to performing the repair, calculate your center's repair cost and then obtain outside repair estimate(s) for price comparison purposes.

It is your center's responsibility to review the repair cost estimate prior to the repair being performed. This will help ensure that the amount requested for the paint work is customary, fair, and reasonable. Also, it must not exceed the scope of the repair work described in this bulletin.

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

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: B52 06 23 WP 1), unless otherwise required by State law.

Additionally: For WP 3 and WP 4 for performing a repair, please also identify if the left, right or both seat mounting domes required repair.

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.

FEEDBACK REGARDING THIS BULLETIN

Technical Feedback feedback	To submit feedback for the technical topic of this bulletin: Submit your feedback in the rating box at the top of this bulletin
Warranty Feedback	To submit feedback for the CLAIMS section of this bulletin: Submit an IDS ticket to the Warranty Department, or use the chat available in the Warranty Documentation Portal
Parts Feedback	To submit feedback for the PARTS section of this bulletin: Submit an IDS ticket to the Parts Department

