



SIB 64 04 23

2023-04-14

NOISE FROM THE FRONT LEFT OF ENGINE COMPARTMENT

 THIS REPAIR IS MOBILE FRIENDLY

## MODEL

E-Series	Model Description	Production Date
G70	i7 xDrive60 BEV (Battery Electric Vehicle / All-Wheel Drive)	Vehicles produced up to March 31, 2023

## SITUATION

A noise can briefly be heard from the front left of the engine compartment near the air conditioning refrigerant line. The noise can be heard in the passenger compartment with the hood closed. A video of the noise is hyperlinked to this bulletin, per [BV640323 Noise LF G70.MOV](#)

## CAUSE

Vibrations within the air conditioning system are being heard. Interaction between a body support bracket and the air conditioning refrigerant line causes an amplification of these vibrations, making them briefly audible.

## CORRECTION

Apply felt tape to the body support bracket to insulate it from the movement of the air conditioning refrigerant line preventing transmitted noise.

## PROCEDURE

### Important Warning for Working on the High-Voltage (HV) systems on BMW Group vehicles:

**Only properly trained personnel, who passed all applicable HV Technical Training Courses, should perform repairs which require disconnecting, or removal of High Voltage battery components on any Hybrid or Electric Vehicle. Work performed on High Voltage systems by unqualified persons may result in severe injury or damage to the vehicle. Additional safety information is found in Repair Instruction 61 00... "Observe safety instructions when handling electric vehicles".**

**Prior to disconnecting, or the removal of any HV component, the HV system needs to be disabled and secured (by means of the HV Service Disconnect Switch and lock out) by a properly trained technician, who has a minimum HV Qualification level after completing the Technical Training Course "ST2324 High Voltage Drivetrain Systems" which as of 1/2023\* includes ST1824 Alternative Drive Part 1.**

**Once the vehicle's HV system is disabled (the "Blitz" - lightning bolt icon is displayed in instrument cluster, see below), a technician without HV Certification may remove a HV component (e.g., EH Heater, EKK Compressor, EME Control Unit, et.), except for the High Voltage Battery.**

**\* Note: As of January 2023, the HV component portion of the "ST2205 Generation 5 High-voltage class" (except for the High Voltage Battery) has been merged into "ST2324 High Voltage Drivetrain Systems".**

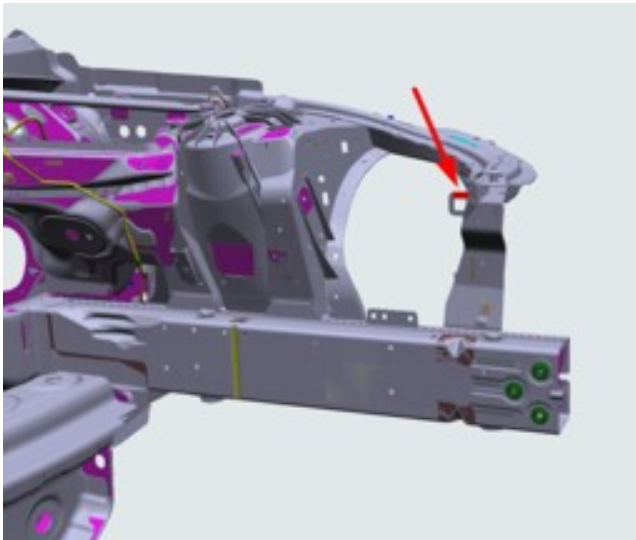
**High Voltage Battery removal and rework can ONLY be performed by a High-voltage Certified Technician with a HV Battery Certification level corresponding to a specific Electric or Hybrid vehicle, for example:**

To repair GEN4 HV battery of G05 PHEV a certification from Technical Training Course “ST2006 – SP44 HV Battery” or equivalent ST1825 – Alternative Drive Part 2 is required (or as of 1/2023 the equivalent “ST 2325 for High Voltage Battery Systems”).

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To repair A GEN5 HV battery the Technical Training Course “ST2205 Generation 5 High-voltage class” is required or as of 1/2023\* the equivalent “ST 2325 for High Voltage Battery Systems”.

\*Note: As of January 2023, the “ST2205 Generation 5 High-voltage stand-alone class” has been merged into “ST2324 for High Voltage Drivetrain Systems” and “ST2325 for High Voltage Battery Systems”



The body support bracket is located here on the vehicle frame in the left front of the engine compartment.



Unclip the refrigerant line holder from the carrier holder.

**The line only needs to be unclipped to gain access to the body support bracket.**

Complete removal of the line is not required.



Apply felt tape to the upper edge of the square eye of the body support bracket (*photo shows a bare body shell for clarity*).

Then clip the air conditioning refrigerant line back into the carrier holder.

## PARTS INFORMATION

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

Part Number	Description	Quantity
51 45 2 353 024	Set Felt strip self-adhesive Tape	Sublet as needed

## CLAIM INFORMATION

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

Defect Code:	6450900200	---
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The vehicle is already in the workshop

Work Pkg	Labor Operation	Description (Plus work)	Labor Allowance
# 1	00 73 948	Reworking the front refrigerant line holder	3 FRU

Or:

The vehicle arrives at your center for this work, no other Main work will be performed or claimed during this workshop visit

Work Pkg	Labor Operation	Description (Main work)	Labor Allowance
# 2	00 73 352	Reworking the front refrigerant line holder	5 FRU

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

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

<b>Sublet Code 4</b>	Up to \$2.50	Reimbursement for the repair-related bulk material (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 proportional 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.

**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: B64 04 23 WP 1), unless otherwise required by State law.

**FEEDBACK REGARDING THIS BULLETIN**

Technical 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

Supporting Materials

Videos

[64 03 23](#)

