



SIB 41 02 23

2023-05-09

SERVICE ACTION: RIGHT REAR WHEELWELL HUMP

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 REPAIR IS MOBILE FRIENDLY

MODEL

E-Series	Model Description	Production Date
G07	X7 Sport Activity Vehicle	February 15 – February 25, 2023

SITUATION

Due to prolonged, normal body flex acting on the vehicle during its service life, a small indentation and/or a crack can form in the body sheetmetal in the right rear wheelwell (aka wheel house). Potential water ingress and a risk of corrosion is possible.

CAUSE

A possible error in the metal stamping tool for the wheelwell.

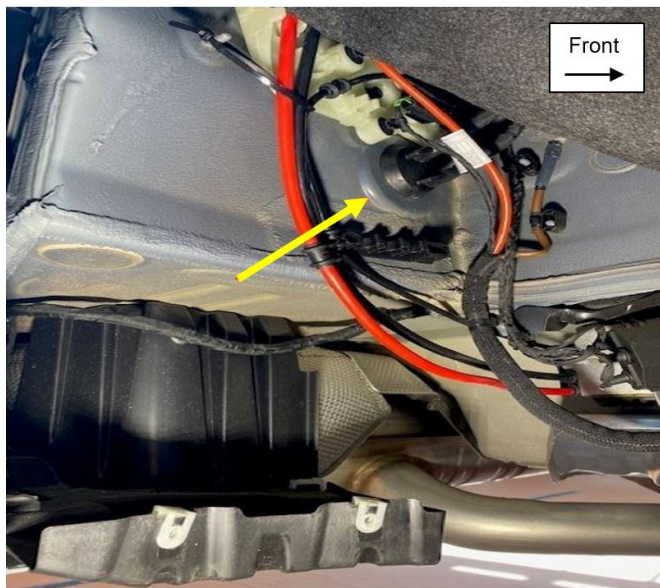
CORRECTION

Inspect the wheelwell hump and rework if necessary.

PROCEDURE



1. Remove the right rear wheelwell cover following the repair instruction listed in ISTA/AIR (51 71 041).



2. Inspect the circular pressed hump on right rear wheelwell for any cracks and/or indentations (arrow in photo).

Use a strong light to illuminate the area for the visual inspection. Touch the hump with a finger for a tactile inspection.

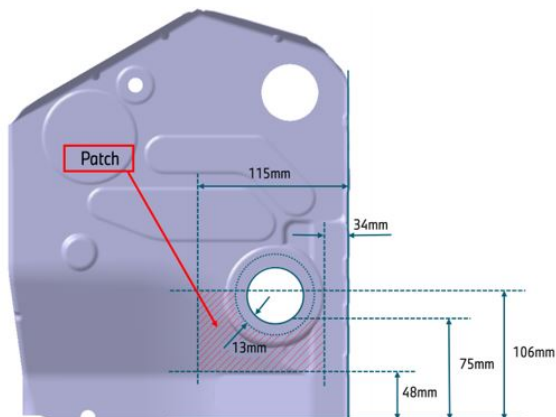
Note: Move the cables/wires aside to fully see the hump.

Note: If no cracks or indentations are seen or felt, no further action is needed. Reassemble the vehicle



Note: This photo indicates a hump that requires rework (no good). Continue to Step 3.

3. Remove the luggage compartment panels following the repair instructions listed in ISTA/AIR (51 47 220).



4. Using the attached document in this SIB, cut out the Parts replacement panel using the template and dimensions provided.

The vehicle's wheelwell panel does not need to be cut.



5. Place the cut panel onto the wheelwell hump. Using a marker, trace the panel edges (dotted line) onto the vehicle.



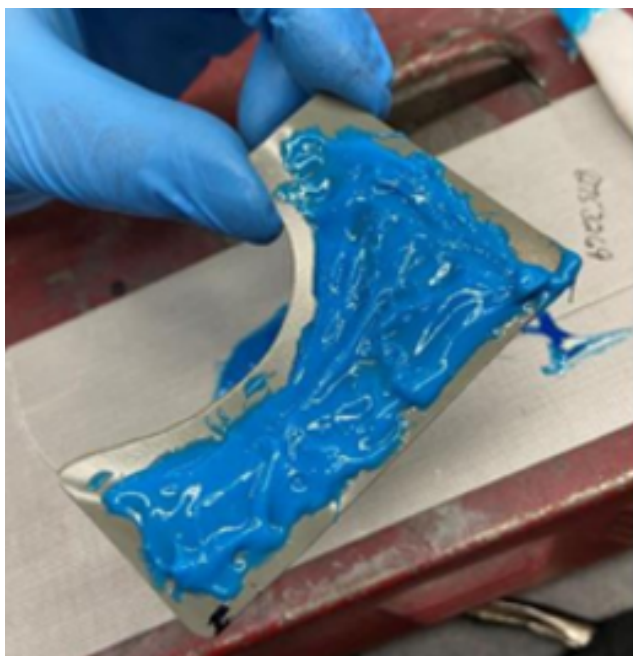
6. Clean the marked area of coating, wax, and body sealant.



7. The two ends of the crack/indentation must be drilled using a 3 mm drill bit. This prevents the crack/indentation from expanding.

Note: Before drilling, care must be taken to not damage any internal parts or control devices located on the back surface (in luggage compartment wheelwell wall). If necessary, remove them before drilling.

Note: After drilling, the drill chips must be vacuumed out of the luggage compartment.



8. Apply K5 adhesive to the panel.

Note: Review notes on handling K5 adhesive (41 00 repair instructions).



9. Place and press the panel onto the wheelwell hump firmly. Coat the cut edges with K5 adhesive. If necessary, secure the panel using tape to prevent it from slipping off.

Note: Allow K5 adhesive to cure/harden for approx. 10 hours at room temperature (~68° F).

Note: Seal the area with D2 sealant.

10. Reassess the vehicle once repair is completed.

PARTS INFORMATION

Please monitor the weekly Parts Matrix for the cover panel ordering procedure.

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
41 00 7 947 142	Cover panel, wheel house, right	1

Bulk Materials – Center Workshop Repair (WP 3, 4, 5, 6)

83 19 5 A66 E25	Sealant D2	Sublet
83 19 2 158 654	Body adhesive K5	Sublet

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.

Plus work (+)	The vehicle new in-stock or is already in the workshop
Main work	The vehicle arrives for this Service Action, no other Main work will be performed/claimed during this workshop visit

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

Defect Code:	0041180200	G07 Rework the wheel arch end plate
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A. Center Workshop Inspection (No Repair is Necessary)

Work Pkg	Labor Operation	Description	Labor Allowance
# 1	00 73 955	Checking the rear right wheel arch end plate (No repair is necessary) (Plusposition)	3 FRU

# 2	00 73 358	Checking the rear right wheel arch end plate (No repair is necessary) (Main)	5 FRUs
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Or:

B. Center Workshop Inspection and Repair

Work Pkg	Labor Operation	Description	Labor Allowance
# 3	00 73 957	Checking and reworking the rear right wheel arch end plate (Plusposition)	23 FRU
Or:			
# 4	00 73 360	Checking and reworking the rear right wheel arch end plate (Main)	24 FRU

Or:

With ARS (Option Code SA2VS)

Work Pkg	Labor Operation	Description	Labor Allowance
# 5	00 73 956	Checking and reworking the rear right wheel arch end plate <u>with dual storage battery</u> . (Plusposition)	31 FRU
Or:			
# 6	00 73 359	Checking and reworking the rear right wheel arch end plate <u>with dual storage battery</u> . (Main)	32 FRU

And:

Sublet – Bulk Materials for WP 3, 4, 5, 6 (RO and Claim Comments Required)

Sublet Code 4	Up to \$25.00	Reimbursement for the repair-related bulk materials (Do not use the BMW part numbers for claim submission)
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Sublet reimbursement calculation for claiming the applicable repair-related bulk materials (BMW part numbers) is at the dealer net price amount for the proportional quantities 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.

Or:

C. Center Workshop Inspection with a Third-Party Rework Repair (CCRC or Approved Body Shop)

Work Pkg	Labor Operation	Description	Labor Allowance
# 7	00 74 674	Check rear right wheel arch end plate for external service (Plusposition)	1 FRU
Or:			
# 8	00 74 074	Check rear right wheel arch end plate for external service (Main)	3 FRU

And:

Third-Party	Description (Associated work for WP 7 and WP 8)	Sublet Allowance
Sublet Code 3	Reimbursement for third-party repair to rework right rear wheel arch end plate including the used quantities of approved bulk materials (excluding the Cover panel, wheel house, right and other repair related/required BMW part numbers to be invoiced on	Up to \$425.00

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Invoice the eligible rework labor/used bulk materials 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 repair-related rework 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 the claim comment section.

Claim Repair Comments

Reference the SIB number and the work package (Pkg) number performed in the RO technician notes and the claim comments (For example: B41 02 23 WP 1), unless otherwise required by State law.

Additionally for WP 3 through WP 8: As noted above, explain/itemize the claimed sublet amount.

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

[picture_as_pdf 41 02 23_Attachment 1.pdf](#)

