



SIB 63 06 23

2023-05-16

SERVICE ACTION: HEADLAMP (HL) GAP

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.

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THIS REPAIR IS MOBILE FRIENDLY

MODEL

E-Series	Model Description	Production Date
U11	X1 Sports Activity Vehicle	July 12, 2021 – February 20, 2023

SITUATION



Contact between the headlamp housing and the front fender can occur, causing paint abrasion.

Note: This can occur on either one or both sides of the vehicle.



Close-up of general affected area; driver's side shown.

CAUSE

During vehicle assembly, the headlamp(s) may have not been correctly installed.

CORRECTION

Inspect both headlamps (HL) for sufficient gap between the housing and fender. Rework if necessary.

PROCEDURE

1. Using a piece of paper, slide the paper between the headlamp housing and fender. This

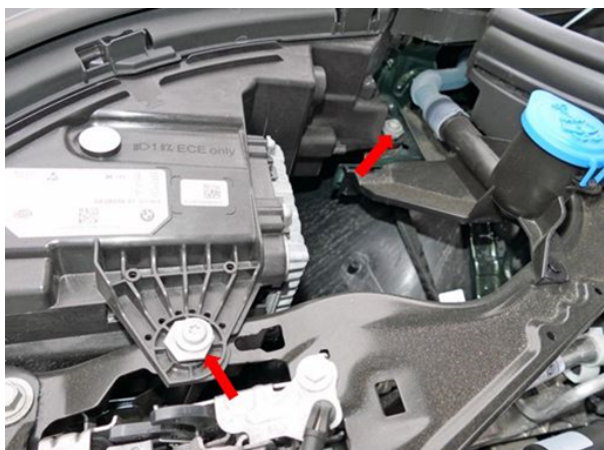


needs to be performed on both sides of the vehicle.

- If the paper passes freely between the headlamp and fender, no repair is needed
- If the paper does not pass between the headlamp and fender, continue to step 2



General photo showing the location of the four bolts (arrows) that secure the headlamps to the vehicle.



2. Loosen the bolts approx. 2-3 full turns.

General photo showing that the bolt does not need to be removed, only loosened. A space (arrows) between the bolt head and the large adjustment nut is all that is required.



3. LOOSEN the large adjustment nut at the **inner support brace** 1-2 turns.



4. TIGHTEN the large adjustment nut at the **fender-well** 1-2 turns.



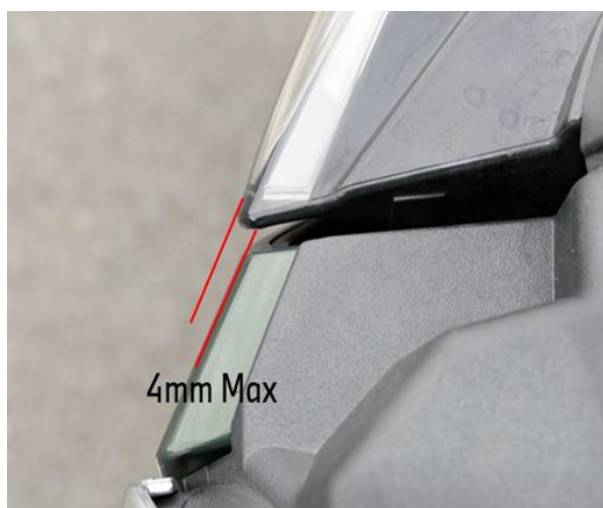
5. Pull the headlamp assembly frontwards away from the fender to create a gap (circled) between the headlamp and fender.

- Gap size: 1 to 3.5 mm.



The headlamp can protrude a maximum of 4 mm beyond the kidney grill.

6. Tighten both adjustment bolts.



7. Measure the gap between the headlamp housing and the front fender.

- Gap size: 1mm





8. Inspect the paint at the front edge of the fender, in the area where the headlamp was originally contacting the fender.

- A. If there is no paint damage, or only mild scuffing of the clear coat; no paint repair is needed. Go to step 9 to aim the headlamps.
- B. If either the clear coat or the base color has been damaged so that either the base color or primer is visible, remove the headlamp following the repair instructions listed in ISTA/AIR (63 12 021).

- Repair the damaged paint using a matching touch-up stick (aka paint pen)
- Adjust the headlamp following the repair instructions listed in ISTA/AIR (63 10 004)

C. If the primer is damaged and either paint or rust/corrosion are visible, remove the fender completely following the repair instructions listed in ISTA/AIR (Left 41 35 101) and/or (Right 41 35 101).

D. Repaint the entire fender.

9. After a headlamp assembly has been correctly refitted, including those that require a corresponding paint finish repair; aim/align the headlamps by following the repair instructions listed in ISTA/AIR (63 10 004).

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
83 19 0417324	Cleanser R2 (500 ml, WP# 7 to WP # 12)	Sublet
As applicable	Touch-up paint stick (aka paint pen. 1 stick repairs up to 10 vehicles, WP# 7 to WP # 12)	Sublet

CLAIM INFORMATION

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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.

Pluspostion (+)	The vehicle 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:	0063880100	U11 Check the gap dimension of the front light combination and adjust if necessary
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Center Inspection

Work Pkg	Labor Operation	Description (Plus work)	Labor Allowance
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# 1	00 74 532	Check the gap dimension of both side panels at the front: • No repair is necessary (Plusposition)	3 FRU
Or:			
# 2	00 74 010	Check the gap dimension of both side panels at the front: No repair is necessary (Main)	5 FRU

Or, for:

Center Inspection with the Workshop Repair that Applies (No Paint Repair is Needed)

Work Pkg	Labor Operation	Description (Plus work)	Labor Allowance
# 3	00 74 533	Check the gap dimension of both side panels at the front: • Adjust (correct fit) one headlight • With headlight setting (aim/align) (Plusposition)	4 FRU
# 4	00 74 011	Check the gap dimension of both side panels at the front: • Adjust (correct fit) one headlight • With headlight setting (aim/align) (Main)	6 FRU
Or:		-	
# 5	00 74 534	Check the gap dimension of both side panels at the front: • Adjust (correct fit) both headlights • With headlight setting (aim/align) (Plusposition)	5 FRU
# 6	00 74 012	Check the gap dimension of both side panels at the front: • Adjust (correct fit) both headlights • With headlight setting (aim/align) (Main)	7 FRU

Or, for:

Center Inspection with the Workshop Repair that Applies (Paint Repair with Paint Pen)

Work Pkg	Labor Operation	Description (Plus work)	Labor Allowance
# 7	00 74 535	Check the gap dimension of both side panels at the front: • Rework one side panel using paint pen (with correct headlight fit) • With headlight setting (aim/align) (Plusposition)	Refer to AIR

# 8	00 74 013	Check the gap dimension of both side panels at the front: • Rework one side panel using paint pen (with correct headlight fit) • With headlight setting (aim/align) (Main)	Refer to AIR
Or:			
# 9	00 74 536	Check the gap dimension of both side panels at the front: • Adjust (correct fit) one headlight, and • Rework one (other) side panel with paint pen (with correct headlight fit) • With headlight setting (aim/align) (Plusposition)	Refer to AIR
# 10	00 74 014	Check the gap dimension of both side panels at the front: • Adjust (correct fit) one headlight, and • Rework one (other) side panel with paint pen (with correct headlight fit) • With headlight setting (aim/align) (Main)	• Refer to AIR
Or:			
# 11	00 74 537	Check the gap dimension of both side panels at the front: • Rework both side panels with paint pen (with correct headlight fit) • With headlight setting (aim/align) (Plusposition)	Refer to AIR
# 12	00 74 015	Check the gap dimension of both side panels at the front: • Rework both side panels with paint pen (with correct headlight fit) • With headlight setting (aim/align) (Main)	Refer to AIR

And:

Sublet (WP # 7 to WP # 12 – Bulk Materials (RO and Claim Comments Required))

Sublet Code 4	Up to \$15.00	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, for:

Center Inspection with a Third-Party Front Side Panel (Fender) Paint Repair that Applies (CCRC or Approved Body Shop)

Work Pkg	Labor Operation	Description (Plus work)	Labor Allowance
# 15	00 74 532	Check the gap dimension of both side panels at the front: Third-party front fender paint refinish repair and headlight refit/adjustment repair performed (A, B, C, or D below) (Plusposition)	3 FRU
Or:			
# 16	00 74 010	Check the gap dimension of both side panels at the front: Third-party front fender paint refinish repair and headlight refit/adjustment repair performed (A, B, C, or D below) (Main work)	5 FRU

And, with the above:

Sublet (with WP #15/WP #16) - Front Side Panel (Fender) Paint Repair (As needed, see below)

Third-Party	Repair	Description (Associated work)	Sublet Allowance
Sublet Code 3	A	Paint one side panel (with correct headlight fit) With headlight setting (aim/align)	Up to \$865.00
	B	Adjust (correct fit) one (side) headlight, and Paint one (other) side panel (with correct headlight fit) With headlight setting (aim/align)	Up to \$880.00
	C	Rework one side panel with paint pen. and Paint one (other) side panel (with correct headlight fit) With headlight setting (aim/align)	Up to \$910.00
	D	Paint both side panels (with correct headlight fit) With headlight setting (aim/align)	Up to \$1120.00

And, when applicable:

Labor Operation	Description	Labor Allowance
00 74 706	Additional work with PDC (Removing and installing all ultrasonic sensors with vehicle wiring harness at front)	2 FRU
00 74 707	Additional work for start-up of close-range sensor	9 FRU

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: B63 06 23 WP 1 or B63 06 23 WP 15A), unless otherwise required by State law and except as noted below.

Sublet – Consequential Paint Repair (WP 15 and 16: A, B, C or D)

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

Invoice the eligible consequential paint repair in sublet (excluding those BMW part numbers that are to be invoiced on the RO and claimed in conjunction with the sublet) 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 paint work procedures is determined by comparing the

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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.

Alternative Mobility Solution (AMS) for Vehicle Owners (RO and Claim Comments Required)

This Service 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	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

