



SIB 61 23 23

2023-10-12

**SERVICE ACTION: REPLACING THE CELL MODULE OF THE HIGH-VOLTAGE BATTERY**

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.

<input type="checkbox"/>	THIS REPAIR IS MOBILE FRIENDLY
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**MODEL**

E-Series	Model Description	Production Date
G26 BEV	i4 Gran Coupe	August 10, 2022 – September 2, 2022

**AFFECTED VEHICLES**

Vehicles which require this Service Action to be completed will show it as “Open” when checked either in AIR, the "Service Menu" of DCSnet (Dealer Communication System), ISPA Next or Warranty Vehicle Inquiry.

**SITUATION**

BMW AG has issued a Service Action on certain Model Year 2022 BMW i4 Gran Coupe vehicles that were produced between August 10, 2022 – September 2, 2022.

**CAUSE**

As part of the quality controls carried out on an ongoing basis at the BMW Group, it was found that, in very rare cases, the production process of cells of the high-voltage battery did not meet BMW standards.

**CORRECTION**

Removal and replacement of affected high-voltage cell modules.

**Note:** Only one of the vehicle’s high-voltage battery cells should be affected.

**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 HV 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.**

**\* 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”.**

**Up to Generation 4 Vehicles: 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.**

For Generation 5 Vehicles however, the specific vehicle training is required to diagnose, remove and service any HV component and it is NOT allowed for non HV certified technicians to work on the high voltage system.



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”).

And

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”.

BMW recommends NOT to drive the vehicle NOR charge the high-voltage battery until all repair work below to remedy the fault has been completed.

**Caution:**

Please create a TSARA case for ALL vehicles prior to any disassembly.

The steps below must be followed precisely:

1. Please perform the **cell module read out** test plan in ISTA to determine the serial numbers and locations of the high-voltage cell modules installed in the vehicle.

Diagnostic path:

Vehicle management > Service function > Electric drive > High-voltage battery unit >

**High-voltage battery unit: Read out stored serial numbers ABL.**

The “**High-voltage battery unit: Read out stored serial numbers**” test plan has been updated to identify the high-voltage cell modules affected by this campaign and their location in the high-voltage battery.

**Note:**

Once the Cell module read out test plan has been performed, please submit a TSARA case titled “B61 23 23 HV Battery cell module ID process” for assistance in identifying the affected modules (attach the module serial number read out to the case).

It is imperative that once the new replacement cell module arrives, you attach that module serial number to the TSARA case for approval.

Only when TSARA approves the replacement module you have clearance to install it in the HV battery and continue the repair.

Please do not start the repair or submit a TSARA case if the status of the service action is NOT Green, as there is not yet a “Remedy Available” for this vehicle.

2. The high-voltage battery must be discharged prior to removal to an average **cell voltage** of 3.51V

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are removed.

Diagnostic path:

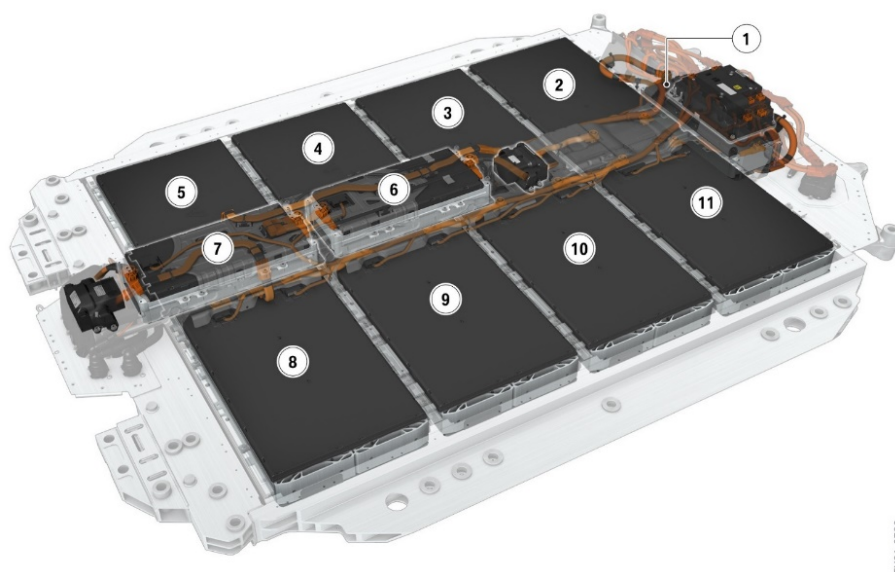
Vehicle management > Service function > Electric drive > High-voltage battery unit >  
**High-voltage battery unit discharged to a defined state of charge (SOC) ABL.**

**Note:**

**The High-voltage battery unit discharged to a defined state of charge (ABL) service function is ONLY available if the high-voltage battery temperature is between 59 to 95 °F (15°C and 35°C).**

3. Replace the defective high-voltage cell modules using repair instructions **61 27 703** to **61 27 877** depending on the affected cell module location.

G26 BEV SE27 HB Battery module locations shown below-



TH21-0786

## **PARTS INFORMATION**

**Only use and invoice the applicable part listed number below.**

<b>Part Number</b>	<b>Description</b>	<b>Quantity</b>
61 27 8863448	Cell module, high-voltage battery	Up to 3
61 27 8863438	Double module for high-voltage battery	Up to 4
61 27 9454253	Multi-purpose bolt (M12x1.5x45)	14
61 25 8833851	Hexagon bolt (M12x5x130)	2
61 25 8833846	Hexagon bolt (5x105)	6
07 14 6884435	ASA Multi-purpose bolt (M10x35)	4
33 32 6760340	Torx bolt with washer (M12x127-10.9)	4
33 30 6861221	Torx bolt (ISA M12x35- 10.9)	10
61 27 9884703	Gasket	1
07 14 8860492	Screw (M5)	82
07 14 8838288	Sealing screw (M8x28)	20
61 27 9454854	Screw	as needed (max 63)
61 27 8677639	Screw (M6x18)	as needed (max. 22)
39 10 6865725	Multi-purpose bolt	4
07 14 8835104	Multi-purpose bolt (M12x1.5x72-10.9)	4

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61 27 8855826	High-voltage battery upper housing section	1 (If required)
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Additionally, other small parts that are not specified above, such as one-time use screws, nuts, O-rings and seals, which must be replaced according to the ISTA repair instructions/ETK, must be selected from the Electronic Parts Catalog according to the respective vehicle type and invoiced under the special defect code.

### Part Retention

**Parts that are removed from BMW vehicles cannot be used for resale! The parts are the property of BMW NA.**

Your center is responsible for the proper identification, storage, and documentation of these parts. They must be held in a secure retention area until notification of claim payment is made by BMW NA through DCSnet.

**Please DO NOT return these recalled High Voltage (HV) battery modules directly to the WPRC. You must use the Gen 5 HV battery Recall return process.**

The Gen 5 high-voltage cell module return process is different than the Gen 4, for the Gen 5 battery cell module return process, refer to aftersales bulletin:

- **Bulletin #: C-2-0323-0606 Gen 5 HV Battery Recall Return Process.pdf**

For more information refer to CenterNet: "Menu>BMW>Aftersales>Business Development & Marketing Portal>Batteries>Bulletins".

### HV Battery Return Packaging - Bulk Payment

For this Service Action, to help offset the time to properly package the lithium-ion batteries for return, a bulk payment of \$20.00 per battery module will be made through monthly miscellaneous billing credit.

Payments will be identified as "Parts-\$20 credit/HV battery recall returns to ITAP".

Payment will not be issued for any lithium-ion batteries that were improperly packaged or shipped.

Hazardous materials or dangerous goods are defined as substances and articles that when offered for transportation in commerce pose an unreasonable risk to health, safety, property, and the environment.

Therefore, BMW of North America would like to remind you all applicable regulatory requirements must be followed when transporting hazardous materials. Your center is responsible for ensuring that your procedures are in compliance with all current D.O.T. regulations.

### CLAIM INFORMATION

Reimbursement for this Service Action will be via normal claim entry utilizing the relevant work package (WP 1 or WP 2), the additional work labor operation code (00 75 565) for the applicable total FRU allowance, and the part numbers listed above that apply.

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

<b>Defect Code:</b>	<b>0061080800</b>	<b>G26 BEV Replacing high-voltage battery cell module</b>
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A.  
for this action.

**Below are the special flat rate labor operation code choices**

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Work Pkg	Labor Operation	Description	Labor Allowance
#1	00 75 564	Removing and installing high-voltage battery unit ( <b>Plusposition work</b> )	86 FRU
Or:			
#2	00 75 048	Removing and installing high-voltage battery unit ( <b>Main work</b> )	87 FRU

Only one Main work flat rate labor operation code can be claimed per workshop visit.

**Note for 00 75 565: Claim labor operation code 00 75 565 one-time only for the applicable total FRU allowance that applies. Itemize the total work time (WT) FRU allowed claimed on the RO and in the claim comments.**

Work time labor operation code 00 75 565 is not considered a Main labor operation.

1. <b>Additional Work with Labor Operation 00 75 564 (WP 1) or 00 75 048 (WP 2)</b>		<b>00 75 565:</b>	<b>Labor Allowance</b>
<b>00 75 565</b>	Perform the cell module read out test plan in ISTA to determine the serial numbers and locations of the high-voltage cell modules affected by this Service Action (Includes 00 00 556/61 21 528), run the HV battery discharge procedure, and submit a TSARA case titled "Gen 5 HV Battery cell module ID process" for the final confirmation of the high-voltage cell location.		5 FRU

**Note:** The following HV cell module replacement procedure includes completing and attaching the required Battery Condition Certification form for each HV cell module replaced.

And for access to perform the repair as instructed by the above (B):

1. <b>Removing/installing lid for high-voltage battery unit</b>		
<b>00 75 565</b>	Removing/installing lid for high-voltage battery unit (Includes 61 27 900 - High-voltage battery unit final test, draining and topping up the coolant circuit)	27 FRU

With B and C, together with the repair item below that applies:

1. <b>Single Cell Modules 6 or/and 7</b>		<b>00 75 565 – Replacing</b>	<b>Labor Allowance</b>
Replacing cell module 6			14 FRU
Or/and:			
Replacing cell module 7			14 FRU
<b>Total</b>			<b>28 FRU</b>

**Additional Work (E) FRU Allowance is included as noted below in the F to K Work Procedures.**

1. <b>Preliminary Access (Cell Module 1, 2/11, 3/10, 4/9, 5/8)</b>		<b>for</b>	<b>Labor Allowance</b>
Remove and install intermediate level (For access to cell module 1, minus Labor operation codes 61 27 010/501 and 61 27 900 that is included in item C)			11 FRU

1.	<b>00 75 565 – Replacing Single Cell</b>	<b>Labor Allowance</b>
<b>Module 1</b>		
Replacing cell module 1		12 FRU
Total with E (11 FRU included)		23 FRU

Or:

1.	<b>00 75 565 – Replacing Single Cell</b>	<b>Labor Allowance</b>
<b>Modules (6 and/or 7 and 1)</b>		
D (14 FRU), E (11 FRU included) and F for 2 cell modules (6 or 7 and 1)		37 FRU
D (28 FRU), E (11 FRU included) and F for 3 cell modules (6 and 7 and 1)		51 FRU

Or:

1.	<b>00 75 565 – Replacing Dual-Cell Modules</b>	
<b>2/11, 3/10, 4/9, 5/8 (Includes cell modules 6 and 7)</b>		
<b>Only One (1) Dual-Cell Module (with F when applicable)</b>	<b>Labor Allowance with E (11 FRU included in the below)</b>	<b>Total with Cell Module 1 (F)</b>
Replacing dual-cell module 2 (Includes cell 11)	26 FRU	38 FRU
Or:		
Replacing dual-cell module 3 (Includes cell 10)	24 FRU	36 FRU
Or:		
Replacing dual-cell module 4 (Includes cell 9)	24 FRU	36 FRU
Or:		
Replacing dual-cell module 5 (Includes cell 8)	22 FRU	34 FRU

Or:

I.	<b>Only Two (2) Dual-Cell Modules (with F when applicable)</b>					
<b>Dual-cell modules</b>	<b>2/3 (2)</b>	<b>2/4 (2)</b>	<b>2/5 (2)</b>	<b>3/4 (2)</b>	<b>3/5 (2)</b>	<b>4/5 (2)</b>
Pre-work (E)	11 FRU	11 FRU	11 FRU	11 FRU	11 FRU	11 FRU
2 (Includes cell 11)	15 FRU	15 FRU	15 FRU			
3 (Includes cell 10)	13 FRU			13 FRU	13 FRU	
4 (Includes cell 9)		13 FRU		13 FRU		13 FRU
5 (Includes cell 8)			11 FRU		11 FRU	11 FRU
<b>Totals</b>	<b>39 FRU</b>	<b>39 FRU</b>	<b>37 FRU</b>	<b>37 FRU</b>	<b>35 FRU</b>	<b>35 FRU</b>
Cell module 1 (F)	12 FRU	12 FRU	12 FRU	12 FRU	12 FRU	12 FRU
<b>Totals</b>	<b>51 FRU</b>	<b>51 FRU</b>	<b>49 FRU</b>	<b>49 FRU</b>	<b>47 FRU</b>	<b>47 FRU</b>

Or:

1.	<b>Only Three (3) Dual-Cell Modules (with F when applicable)</b>				
<b>Dual-cell modules</b>	<b>2/3/4 (3)</b>	<b>2/3/5 (3)</b>	<b>3/4/5 (3)</b>	<b>2/4/5 (3)</b>	<b>All (4)</b>
Pre-work (E)	11 FRU	11 FRU	11 FRU	11 FRU	11 FRU
2 (Includes cell 11)	15 FRU	15 FRU		15 FRU	15 FRU
3 (Includes cell 10)	13 FRU	13 FRU	13 FRU		13 FRU
4 (Includes cell 9)	13 FRU		13 FRU	13 FRU	13 FRU
5 (Includes cell 8)		11 FRU	11 FRU	11 FRU	11 FRU
<b>Totals</b>	<b>52 FRU</b>	<b>50 FRU</b>	<b>48 FRU</b>	<b>50 FRU</b>	<b>63 FRU</b>
Cell module 1 (F)	12 FRU	12 FRU	12 FRU	12 FRU	12 FRU

Or:

1. <b>Cell (3) and Dual-Cell (4) Modules</b>	<b>00 75 565 – All Single</b>	<b>Labor Allowance</b>
Replacing all cell modules		99 FRU

And, with any of the above:

Labor Description	Labor Allowance
Additional work with pressure test cooling system high-voltage battery unit Associated work (coolant drained) (to high-voltage battery unit)	4 FRU

**Claim Repair Comments**

Only reference this SIB number, the work package (Pkg) number performed, and cell modules replaced by their reference number in the RO technician notes and the claim comments (For example: B61 23 23 WP 1, Cell module 4), unless otherwise required by State law.

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

<b>Sublet Code 4</b>	Up to \$100.00	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 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.

**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 topics 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

