



SIB 41 05 23

2024-01-22

SERVICE ACTION: CHECKING THE GAPS ON THE TAILLAMPS

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
U11	X1 Sports Activity Vehicle	August 2, 2022 – August 31, 2023

SITUATION



Contact between the taillamps and the tailgate/side panel(s) can occur. This can cause paint abrasion, and over time corrosion can form on the body of the vehicle/tailgate.

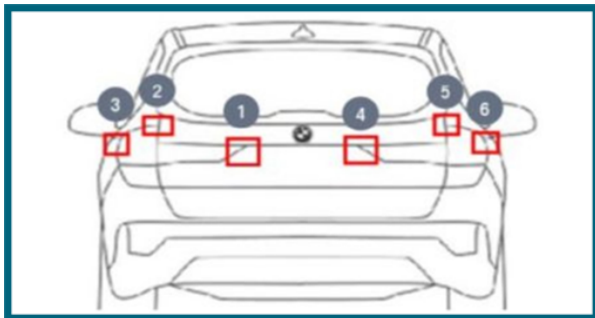
Note: This can occur on either one or both sides of the vehicle.

CORRECTION

Measure the gaps between the taillamps' housing and the tailgate/side panels. If the gap is too small, the taillamp(s) must be removed and the specific area of the tailgate/side panel(s) will need to be inspected for corrosion.

PROCEDURE

Note: When it is necessary to perform a consequential paint finish repair (Paint pen or CCRC/Auto Body Shop), it is mandatory to identify and record the area that required attention due to the issue described in the Service Information Bulletin.



For example:

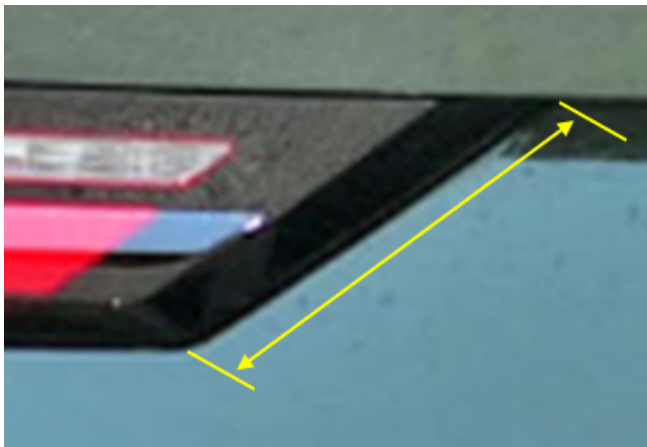
Chafe mark 1, or
Chafe marks 2, 3, or
Chafe marks 4, 5, 6

For these claim submissions, the applicable condition identifier information described above is to be provided in the technician's RO notes and in the claim comment section.

A. Measure the gap between the inner taillamps and the tailgate.



1. Inspect the inner taillamp(s) housing on the tailgate for correct gap.



The gap is to be checked at the diagonal area of the taillamps as shown in the photo.

Note: Check both inner taillamps' gap.



Attempt to insert a small strip of writing paper between the diagonal part of the taillamps housing and tailgate.

If the paper **CAN** be inserted in the gap between the inner taillamps housing and tailgate, the taillamp(s) is OK.

If the paper **CANNOT** be inserted in the gap between the inner taillamp(s) housing and tailgate, continue to step 2.

2. Remove the inner taillamp(s) that is contacting the tailgate following the repair instructions listed in ISTA/AIR 63 21 279/281 and/or 63 21 285.

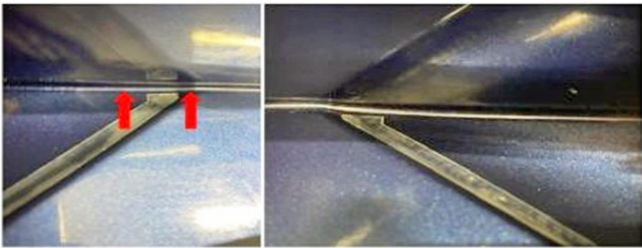


3. Clean off the tailgate paint using R2 cleaner. Inspect for any paint abrasion. The critical area is 5mm inward from the top edge as shown in the photo.

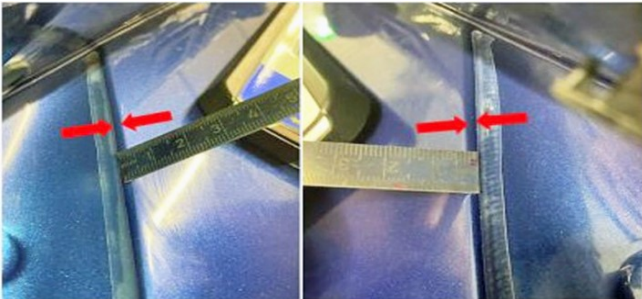
4. (A). If there is NO abrasion of the clear coat or the base color, or if there is only minor abrasion which dulls the clear coat, NO paint touch-up is needed. Continue to step 5.

(B). If the clear coat or base color is abraded so that the primer is visible: Touch up the area with the matching touch-up paint stick. Continue to step 5 afterwards.

(C). If the paint is not only damaged/abraded but there is bubble formation under the paint (lifting) or even rust formation, the damaged area must be repaired, and the entire tailgate repainted. After the repainting, continue to step 5.



5. Apply a strip of the clear abrasion tape along the edge pressing, between the transition of the tailgate upper section to the lower section.



Position the tape so that it is 3mm inward of the edge pressing. Once the tape is in position, press along the tape surface fully and firmly for maximum adhesion.



Extend the tape so that it is parallel to the edge pressing, and that the lower end wraps along the radius of the edge where it changes horizontal.

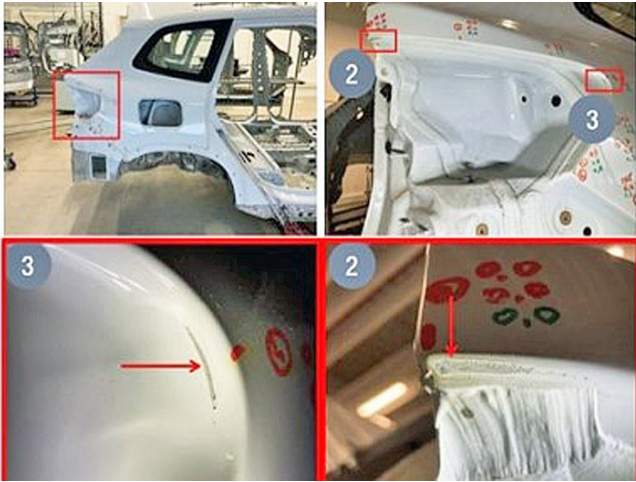
Repeat steps 1-5 on the other inner taillamp.

6. Install inner taillamps.



7. Check the outer taillamps in the areas shown in the photo.

8. Check each indicated sections of the outer taillamp gaps to the side panels using the paper strip method as performed in step 1.



9. The right side shown with the body partially stripped for clarity. The specific areas to be checked are in the red boxes as shown in the photo.

If the paper **CAN** be inserted in the gap between the outer taillamps housing and the side panel(s), the taillamp is OK.

If the paper **CANNOT** be inserted in the gap between the outer taillamps housing and the side panel(s), continue to step 10.

10. Remove the outer taillamp(s) that is contacting the side panel(s) following the repair instructions listed in ISTA/AIR 63 21 275/277 and/or 63 21 283

11. Clean the side panel(s) paint where the outer taillamp sits using R2 cleaner. Inspect for any paint abrasion.

- (A). If there is NO abrasion of the clear coat or the base color, or if there is only minor abrasion which dulls the clear coat, no paint touch-up is needed.
- (B). If the clear coat or base color is abraded so that the primer is visible: Touch up the area with the matching touch-up paint stick. Continue to step 12.
- (C). If the paint is not only damaged/abraded but there is bubble formation under the paint (lifting) or even rust formation, the damaged area must be repaired, and the entire side panel repainted.

12. Install taillamp(s). Adjust the gap to the side panel to 1.1 mm.

PARTS INFORMATION

To determine the part number that applies to the specific vehicle being repaired, enter the VIN/chassis number into either ETK or AIR, this will consider the specific equipment and/or options that are fitted to the vehicle.

Part Number	Description	Quantity
41 00 9 644 448	Adhesive film kit v (1 kit can repair 7 vehicles)	1
83 19 0 417 324	Cleanser R2 (500 ml)	Sublet as needed
Refer to ETK	Touch-up paint stick (aka paint pen, depending on the repair performed, 1 stick can be used for multiple vehicles)	Sublet as needed

CLAIM INFORMATION

Reimbursement for this Action will be via normal claim entry utilizing the applicable work package
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codes, or when required, the corresponding third-party paint finish repair work in sublet.

Plusposition (+)	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

Below are the special flat rate labor operation code choices for this action. Only one Main work flat rate labor operation code can be claimed per workshop visit.

Repair Code:	0041250200	U11 Checking gap dimension of rear lights (tailgate, side panel) and reworking if necessary
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Workshop Inspection – No Repair is Necessary

Work Pkg	Labor Operation	Description (Workshop)	Labor Allowance
# 1	00 75 726	Check the gap dimension of all rear lights (not in combination with follow-up work)	3 FRU
Or:			
# 2	00 75 188	Check the gap dimension of all rear lights (not in combination with follow-up work)	5 FRU

Or:

Workshop Inspection – Repair is Necessary (Attachment 1 or 2 as Applicable)

Work Pkg	Labor Operation	Description (Workshop)	Labor Allowance
# 3	00 75 727	Check the gap dimension of all rear lights (always with follow-up work, refer to the applicable attachment 1 or 2)	1 FRU
Or:			
# 4	00 75 189	Check the gap dimension of all rear lights (always with follow-up work, refer to the applicable attachment 1 or 2)	3 FRU

And with the above:

Attachment 1: Additional Work - Workshop Repair Complete

Please refer to the following attachment for the additional Associated Work (AW) repair procedures, Options AW_A through AW_K as required, and for the corresponding special flat rate labor operation codes to select and use for the claim submission.

- B410523 Attachment 1 Workshop Repair Complete

Or:

Attachment 2: Additional Work - Consequential Third-Party Paint Finish Repair Work

Please refer to the following attachment for the additional associated CCRC/Approved Auto Body Shop paint finish repair work scopes, Options PW_A to PW_G as required.

- B410523 Attachment 2 CCRC_Auto Body Shop Repair

Claim Repair Comments and Sublet Explanations

Please refer to the attachment (1 or 2) that applies to the repair performed.

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

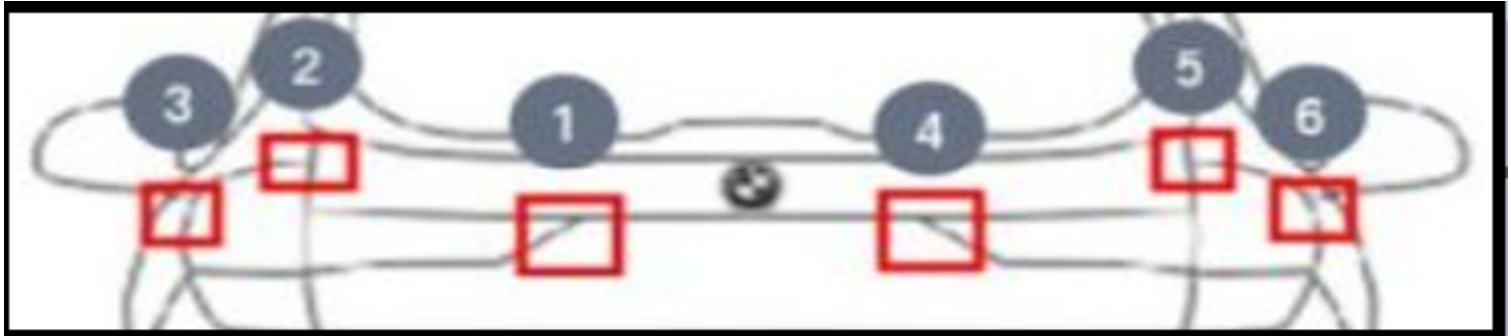
Supporting Materials

[picture_as_pdf B410523 Attachment 1 Workshop Repair Complete.pdf](#)

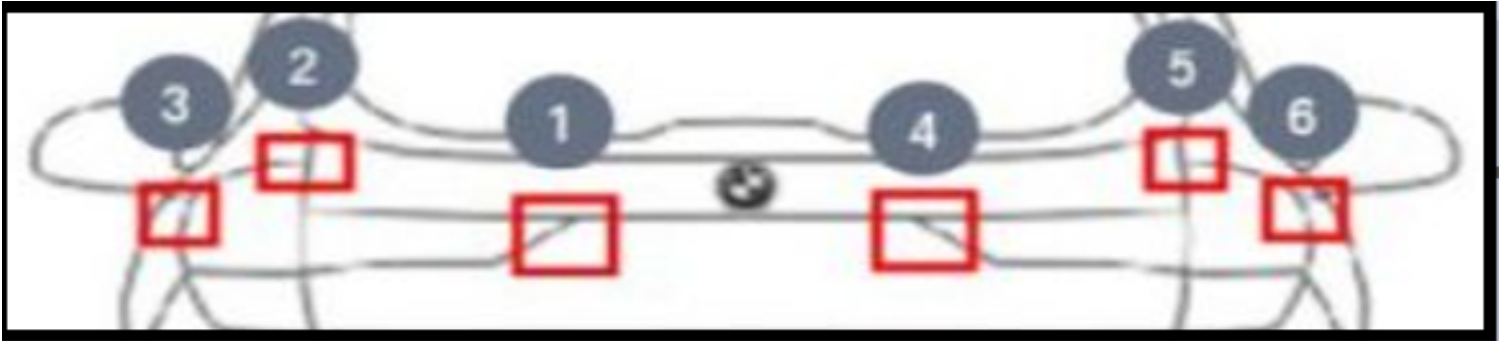
[picture_as_pdf B410523 Attachment 2 CCRC_Auto Body Shop Repair.pdf](#)

Select and claim the one (1) additional “Associated Work” (AW) repair procedure’s special labor operation codes below that apply to the required repair.

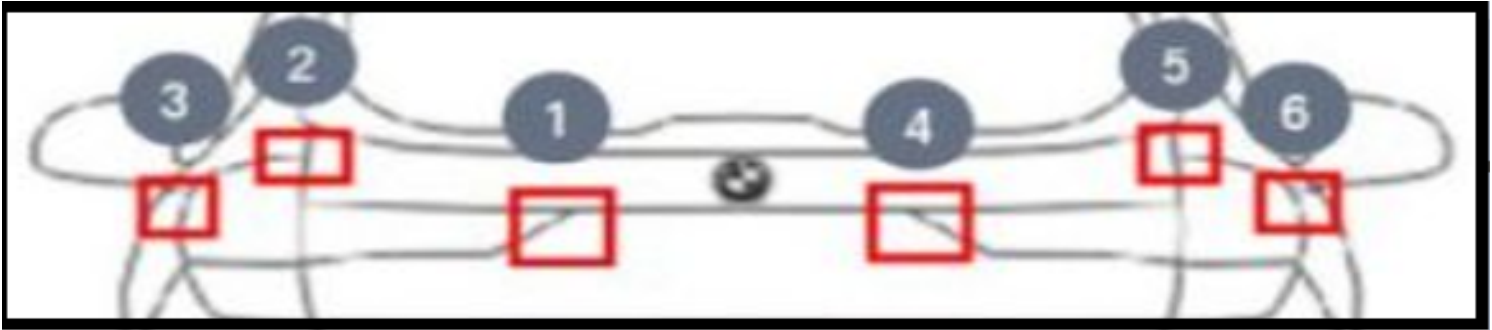
(* Note: “Additional work/rework (As applicable) with a paint pen” special labor operation codes are claimed only when the corresponding work procedures are required to be performed.



Wk Pkg	Labor Operation (1)	Description (Workshop)	Labor Allowance
# 3	00 75 727	Check the gap dimension of all rear lights (always with follow-up work) (Plusposition work)	1 FRU
Or:			
# 4	00 75 189	Check the gap dimension of all rear lights (always with follow-up work) (Main work)	3 FRU
AW	2/3 Left Side Panel (LSP)	1 Left Tailgate (LTG)	4 Right Tailgate (RTG)
A	2/3 (LSP – 00 75 735)		
B	2/3 (LSP – 00 75 735)	1 (LTG – 00 75 728)	
C	2/3 (LSP – 00 75 735)		4 (RTG – 00 75 729)
D	2/3 (LSP – 00 75 735)	1/4 (LTG/RTG – 00 75 730)	
LO Count	Labor Operations	Description (WP 3 or 4 with Associated Work A)	Labor Allowances
2	00 75 735	Remove and install the rear light on the left side panel /not in combination with painting the left side panel	6 FRU
3	00 75 738	(* Additional work/rework left side panel with a paint pen /not in combination with painting the left side	1 FRU
LO Count	Labor Operations	Description (WP 3 or 4 with Associated Work B)	Labor Allowances
4	00 75 728	Remove and install the left tailgate rear light /not in combination with painting the tailgate	7 FRU
5	00 75 731	Additional work/adhere the film to the tailgate, left	1 FRU
6	00 75 733	(* Additional work/rework tailgate on the left with a paint pen /not in combination with painting the tailgate	1 FRU
LO Count	Labor Operations	Description (WP 3 or 4 with Associated Work C)	Labor Allowances
4	00 75 729	Remove and install the right tailgate rear light /not in combination with painting the tailgate	7 FRU
5	00 75 732	Additional work/adhere the film to the tailgate, right	1 FRU
6	00 75 734	(* Additional work/rework tailgate on the right with a paint pen /not in combination with painting the tailgate	1 FRU
LO Count	Labor Operations	Description (WP 3 or 4 with Associated Work D)	Labor Allowances
2	00 75 730	Remove and install the left and right tailgate rear lights /not in combination with painting the tailgate	8 FRU
3	00 75 731	Additional work/adhere the film to the tailgate, left	1 FRU
4	00 75 732	Additional work/adhere the film to the tailgate, right	1 FRU
5	00 75 733	(* Additional work/rework tailgate on the left with a paint pen /not in combination with painting the tailgate	1 FRU
6	00 75 734	(* Additional work/rework tailgate on the right with a paint pen /not in combination with painting the tailgate	1 FRU



Wk Pkg	Labor Operation (1)	Description (Workshop)	Labor Allowance
# 3	00 75 727	Check the gap dimension of all rear lights (always with follow-up work) (Plusposition work)	1 FRU
Or:			
# 4	00 75 189	Check the gap dimension of all rear lights (always with follow-up work) (Main work)	3 FRU
AW	2/3 Left Side Panel (LSP)	1 Left Tailgate (LTG) 4 Right Tailgate (RTG)	5/6 Right Side Panel (RSP)
E			5/6 (RSP- 00 75 736)
F		1 (LTG - 00 75 728)	5/6 (RSP- 00 75 736)
G		4 (RTG - 00 75 729)	5/6 (RSP- 00 75 736)
H		1/4 (LTG/RTG - 00 75 730)	5/6 (RSP- 00 75 736)
LO Count	Labor Operations	Description WP 3 or 4 with Associated Work E)	Labor Allowances
2	00 75 736	Remove and install the rear light on the right-side panel /not in combination with painting the right-side panel	7 FRU
3	00 75 739	(* Additional work/rework right side panel with a paint pen /not in combination with painting the right-side panel	1 FRU
LO Count	Labor Operations	Description (WP 3 or 4 with Associated Work F)	Labor Allowances
4	00 75 728	Remove and install the left tailgate rear light /not in combination with painting the tailgate	7 FRU
5	00 75 731	Additional work/adhere the film to the tailgate, left	1 FRU
6	00 75 733	(* Additional work/rework tailgate on the left with a paint pen /not in combination with painting the tailgate	1 FRU
LO Count	Labor Operations	Description (WP 3 or 4 with Associated Work G)	Labor Allowances
4	00 75 729	Remove and install the right tailgate rear light /not in combination with painting the tailgate	7 FRU
5	00 75 732	Additional work/adhere the film to the tailgate, right	1 FRU
6	00 75 734	(* Additional work/rework tailgate on the right with a paint pen /not in combination with painting the tailgate	1 FRU
LO Count	Labor Operations	Description (WP 3 or 4 with Associated Work H)	Labor Allowances
2	00 75 730	Remove and install the left and right tailgate rear lights /not in combination with painting the tailgate	8 FRU
3	00 75 731	Additional work/adhere the film to the tailgate, left	1 FRU
4	00 75 732	Additional work/adhere the film to the tailgate, right	1 FRU
5	00 75 733	(* Additional work/rework tailgate on the left with a paint pen /not in combination with painting the tailgate	1 FRU
6	00 75 734	(* Additional work/rework tailgate on the right with a paint pen /not in combination with painting the tailgate	1 FRU



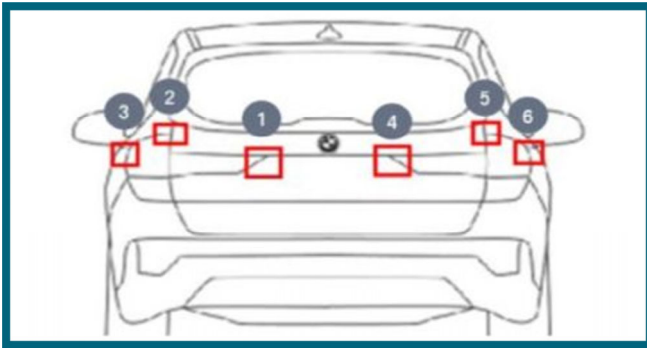
Wk Pkg	Labor Operation (1)	Description (Workshop)	Labor Allowances
# 3	00 75 727	Check the gap dimension of all rear lights (always with follow-up work) (Plusposition work)	1 FRU
Or:			
# 4	00 75 189	Check the gap dimension of all rear lights (always with follow-up work) (Main work)	3 FRU
AW	2/3 Left Side Panel (LSP)	1 Left Tailgate (LTG)	4 Right Tailgate (RTG)
I	2/3 LSP – (00 75 737)		5/6 Right Side Panel (RSP)
			5/6 RSP – (00 75 737)
LO Count	Labor Operations	Description (WP 3 or 4 with Associated Work I)	Labor Allowances
2	00 75 737	Remove and install the rear lights on both side panels /not in combination with painting the left or right-side panel (Claim once)	10 FRU
3	00 75 738	(* Additional work/rework left side panel with a paint pen /not in combination with painting the left side panel	1 FRU
4	00 75 739	(* Additional work/rework right side panel with a paint pen /not in combination with painting the right-side panel	1 FRU
AW	2/3 Left Side Panel (LSP)	1 Left Tailgate (LTG)	4 Right Tailgate (RTG)
J		1/4 (LTG/RTG – 00 75 730)	
LO Count	Labor Operations	Description (WP 3 or 4 with Associated work J)	Labor Allowances
2	00 75 730	Remove and install the left and right tailgate rear lights /not in combination with painting the tailgate	8 FRU
3	00 75 731	Additional work/adhere the film to the tailgate, left	1 FRU
4	00 75 732	Additional work/adhere the film to the tailgate, right	1 FRU
5	00 75 733	(* Additional work/rework tailgate on the left with a paint pen /not in combination with painting the tailgate	1 FRU
6	00 75 734	(* Additional work/rework tailgate on the right with a paint pen /not in combination with painting the tailgate	1 FRU
AW	2/3 Left Side Panel (LSP)	1 Left Tailgate (LTG)	4 Right Tailgate (RTG)
K	2/3 LSP – (00 75 737)		5/6 Right Side Panel (RSP)
		1/4 (LTG/RTG – 00 75 730)	
			5/6 RSP – (00 75 737)
LO Count	Labor Operations	Description (WP 3 or 4 with Associated Work K)	Labor Allowances
2	00 75 737	Remove and install the rear lights on both side panels /not in combination with painting the left or right-side panel (Claim once)	10 FRU
3	00 75 738	(* Additional work/rework left side panel with a paint pen /not in combination with painting the left side panel	1 FRU
4	00 75 739	(* Additional work/rework right side panel with a paint pen /not in combination with painting the right-side panel	1 FRU
5	00 75 730	Remove and install the left and right tailgate rear lights /not in combination with painting the tailgate	8 FRU
6	00 75 731	Additional work/adhere the film to the tailgate, left	1 FRU
7	00 75 732	Additional work/adhere the film to the tailgate, right	1 FRU
8	00 75 733	(* Additional work/rework tailgate on the left with a paint pen /not in combination with painting the tailgate	1 FRU
9	00 75 734	(* Additional work/rework tailgate on the right with a paint pen /not in combination with painting the tailgate	1 FRU

Claim Repair Comments

Only reference the SIB number, the work package (Pkg) number that applies and the corresponding associated work procedure that were performed in the technician’s RO notes and in the claim comment section (For example: B41 05 23 WP 3 / AW_A), unless otherwise required by State law.

Additionally:

When it is necessary to perform a consequential paint finish repair (Paint pen or CCRC/Auto Body Shop), it is mandatory to identify and record the area that required attention due to the issue described in the Service Information Bulletin.



For example:

- Chafe mark 1, or
- Chafe marks 2, 3, or
- Chafe marks 4, 5, 6

For these claim submissions, the applicable condition identifier information described above is to be provided in the technician’s RO notes and in the claim comment section.

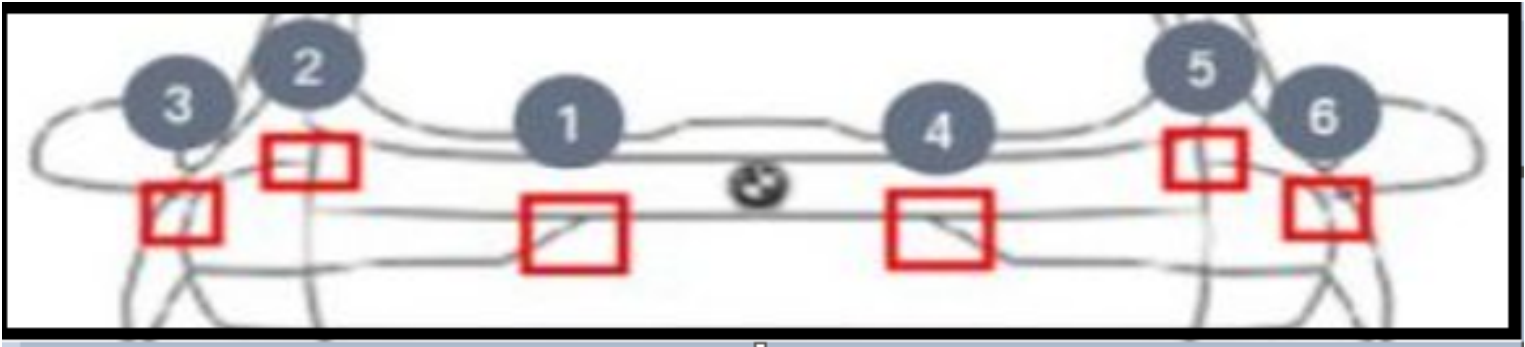
And as applicable with the above:

Sublet – Bulk Materials (RO and Claim Comments Required)

Sublet Code 4	See below	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.



Workshop Inspection with the Associated Third-Party (CCRC or Approved Auto Body Shop) Paint Finish Repair Work Scope procedure that applies.

Wk Pkg	Labor Operation (1)	Description (Workshop)	Labor Allowance
# 3	00 75 727	Check the gap dimension of all rear lights (always with follow-up work) (Plusposition work)	1 FRU
Or:			
# 4	00 75 189	Check the gap dimension of all rear lights (always with follow-up work) (Main work)	3 FRU

And with the Work Package above that applies:

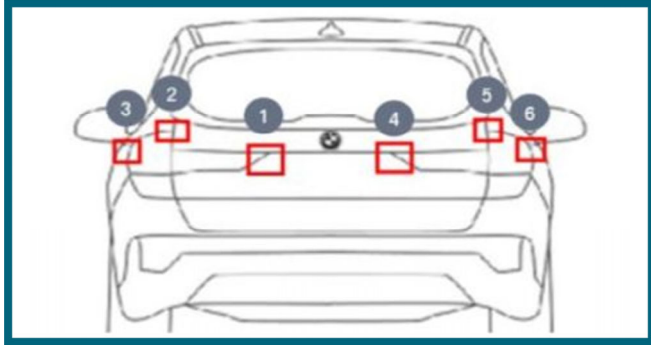
Sublet Code 3 – Third-Party Paint Finish Repair Work Scopes (Only one, as required)

Repair	Description (WP 3 or 4 with Associated Work PW_A to PW_G, One Only)	Sublet Allowance
PW_A	2/3 Left Side Panel 1 Left / 4 Right Tailgate (Complete)	5/6 Right Side Panel
	<ul style="list-style-type: none"> Dis and re assemble mechanical work for the rear left-side panel (for painting) Paint finish repair work for the rear left-side panel 	As applicable
PW_B	2/3 Left Side Panel 1 Left / 4 Right Tailgate (Complete)	5/6 Right Side Panel
	<ul style="list-style-type: none"> Dis and re assemble mechanical work for the rear right side panel (for painting) Paint finish repair work for the rear right side panel 	As applicable
PW_C	2/3 Left Side Panel 1 Left / 4 Right Tailgate (Complete)	5/6 Right Side Panel
	<ul style="list-style-type: none"> Dis and re assemble mechanical work for the rear left and right-side panels (for painting) Paint finish repair work for the rear left and right-side panels 	As applicable
PW_D	2/3 Left Side Panel 1 Left / 4 Right Tailgate (Complete)	5/6 Right Side Panel
	<ul style="list-style-type: none"> Dis and re assemble mechanical work for the tailgate (for painting) Paint finish repair work for the tailgate 	As applicable
PW_E	2/3 Left Side Panel 1 Left / 4 Right Tailgate (Complete)	5/6 Right Side Panel
	<ul style="list-style-type: none"> Dis and re assemble mechanical work for the rear left side-panel (for painting) Dis and re assemble mechanical work for the tailgate (for painting) Paint finish repair work for the rear left side-panel, and Paint finish repair work for the tailgate 	As applicable
PW_F	2/3 Left Side Panel 1 Left / 4 Right Tailgate (Complete)	5/6 Right Side Panel
	<ul style="list-style-type: none"> Dis and re assemble mechanical work for the rear right side-panel (for painting) Dis and re assemble mechanical work for the tailgate (for painting) Paint finish repair work for the rear right side-panel, and Paint finish repair work for the tailgate 	As applicable
PW_G	2/3 Left Side Panel 1 Left / 4 Right Tailgate (Complete)	5/6 Right Side Panel
	<ul style="list-style-type: none"> Dis and re assemble mechanical work for the rear left and rear right side-panels (for painting) Dis and re assemble mechanical work for the tailgate (for painting) Paint finish repair work for the rear left and rear right side-panels, and Paint finish repair work for the tailgate 	As applicable

Only reference the SIB number, the work package (Pkg) number and the corresponding additional associated third-party paint finish repair work scope that applies in the technician's RO notes and in the claim comment section (For example: B41 05 23 WP 3 / PW_A), unless otherwise required by State law.

Additionally:

When it is necessary to perform a consequential paint finish repair (Paint pen or CCRC/Auto Body Shop), it is mandatory to identify and record the area that required attention due to the issue described in the Service Information Bulletin.



For example:

- Chafe mark 1, or
- Chafe marks 2, 3, or
- Chafe marks 4, 5, 6

For these claim submissions, the applicable condition identifier information described above is to be provided in the technician's RO notes and in the claim comment section.

Sublet – Third-Party Consequential Paint Finish Repair (RO and Claim Comments Required)

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 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.