



SIB 11 03 24

2024-08-01

SERVICE ACTION: Replace Crankcase Screw

MODEL

Model	Model Description	Model Code	Production Dates
KA1	R 1300 GS	0M23	Aug 21, 2023, to June 3, 2024

The affected vehicles have been marked with campaign number **0011570000** in AIR.

In order to determine if a specific motorcycle is affected by this campaign, it will be necessary to verify the vehicle VIN in AIR (Aftersales Information Research). Based on the response of the system, either proceed with the repair or take no further action. Please note, open campaigns or vehicle stops may not appear in DCS Warranty Vehicle Inquiry or sales systems until 24-72 hours after they are announced, therefore AIR is always the recommended method for determining open campaigns and vehicle stops.

SITUATION

After quality inspection it has been found that the bolting torque process of the engine crankcase to frame was not adequate. As a result, there may be an effect on the rigidity of the general engine to frame combination.

PROCEDURE

For vehicles that have not yet been delivered, the service action must be completed before vehicle handover. If the service action cannot be completed due to a parts shortage, the service action then must be performed during the next possible workshop visit when parts become available. In such instances, it is essential to inform the customer of the situation.

In all instances in which the vehicles have already been handed over to customers, the customers must be made aware of the situation described above and asked to have the Technical Campaign carried out.

The crankcase to frame bolting must be replaced in accordance with repair instruction "00 60 446 – Replace crankcase bolting".

PARTS INFORMATION

NOTICE: There are limited parts and a minimal number of affected units. Please only order the part if you have an affected unit to avoid taking parts from another dealer that requires the part.

Obtain and confirm the part numbers for your specific vehicle by entering the chassis number in ETK which takes into account specific equipment and/or options.

Additional parts like gaskets, hardware and chemicals may be required for the complete repair.

Part Number

07 12 9 908 724	Cheese Head Screw M10x95-10.9	QTY 1
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CLAIM INFORMATION

Please submit claims via the normal claim process using the information below:

Defect code

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00 11 57 00 00	Replace crankcase bolting
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Labor Operation

00 60 446	Replace crankcase bolting	4 FRU
+00 60 946	Replace crankcase bolting	3 FRU

FRUs includes all repair procedures to complete the task with allowance for necessary ancillary tasks (e.g., visual inspection, lubrication, cleaning parts etc.) and administrative tasks.

Labor operation code 00 60 446 is a Main labor operation. If you are using a Main labor code for another repair, use the Plus code labor operation instead.

QUESTIONS REGARDING THIS BULLETIN

Technical inquiries	Contact the BMW Technical Support Group via TSARA
Warranty inquiries	Submit an IDS ticket to the Warranty Department
Parts inquiries	Submit an IDS ticket to the Motorrad Parts Department

Supporting Materials

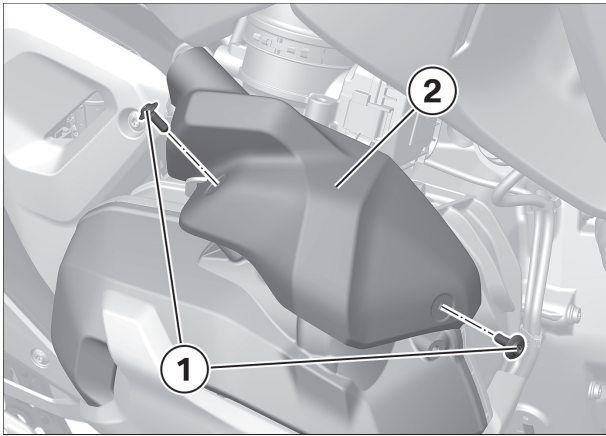
[picture_as_pdf RM_0060446_0M21_EN.pdf](#)

[picture_as_pdf 11 03 24 SA Replace Crankcase Screws.pdf](#)

0M21 - R 1300 GS

00 60 446 Replacing crankcase bolting

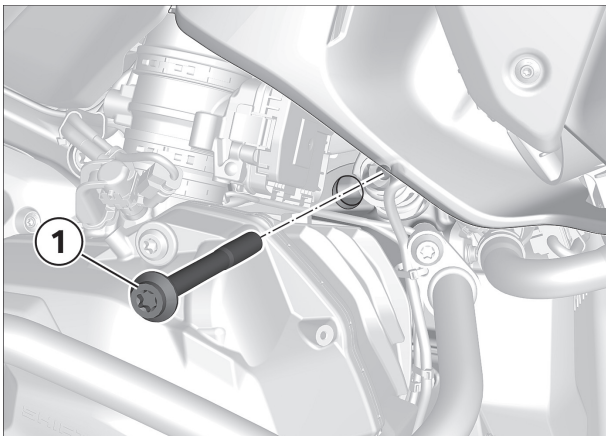
1



► **Removing right injection valve cover**


- Remove screws (1).
- Remove injection valve cover (2).

2

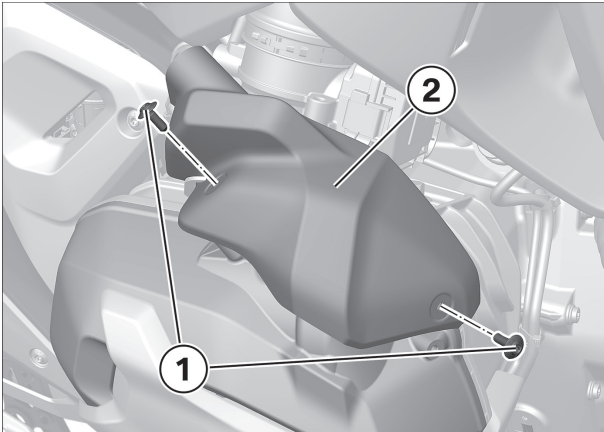


► **Replace crankcase bolting.**

- Remove screw (1).
- Install new screw (1).

 Tightening torques		
Assembly of crankcase		
M10 × 95	Tightening torque, 25 Nm	
	Additional angle of rotation, 90°	

3

▶ **Installing right injection-valve cover**

- Install injection valve cover (2).
- Install screws (1).

4

▶ **Final inspection of completed work**

- Ensure the following:
 - The objective of the completed work was achieved.
 - All operating fluids have been filled in and the fluids are at the correct fill level.
 - All loosened screw connections have been retightened correctly.
 - The fuel system is free of leaks.
 - The lighting and signal system is functional and the vehicle is roadworthy.
 - The brake pads of the front and rear wheel brakes are resting against the brake disks.

▷ **Function test, engine start suppression****Check**

- Set kill switch to centred position.
- Select neutral.
- Switch on the ignition.
 - » Neutral indicator light "N" lights up.
- Select a gear.
 - » Neutral indicator light "N" goes out.
- Press the starter button.
 - » Starter does **not** operate.
- Extend the side stand.
- Pull the clutch lever.
- Press the starter button.
 - » Starter does **not** operate.
- Retract the side stand.
- Press the starter button without releasing the clutch lever.
 - » Starter operates.

Result

Not all test steps completed successfully.

Measure

- Check corresponding components with BMW Motorrad diagnosis system.

