



SIB 41 01 25

2025-02-25

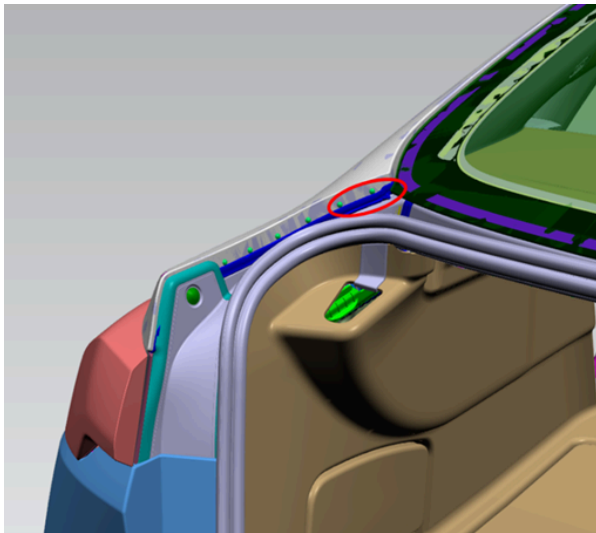
SERVICE ACTION: LEFT REAR SIDE PANEL WATER CHANNEL INSPECTION

THIS REPAIR IS MOBILE FRIENDLY

**MODEL**

E-Series	Model Description	Production Date
F74	2 Series Gran Coupe	January 9, 2025 – January 15, 2024

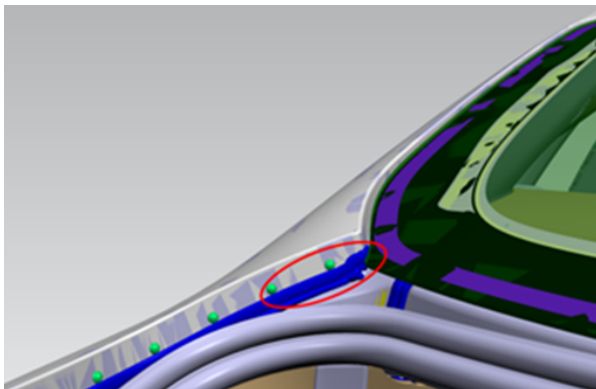
**SITUATION**



A crack may have formed in the upper left corner of the trunk opening (circled in red), where the quarter panel contacts the left lower corner of the rear window and trunk water channel.

Illustration of the inward-facing metal shows the general location of the possible crack, though the area to be checked in the Procedure is on the “back side”/outward-facing surface.

The PVC seam sealant applied to the water channel may not sufficiently seal the channel in the presence of the crack, resulting in a small water leak into the trunks interior.



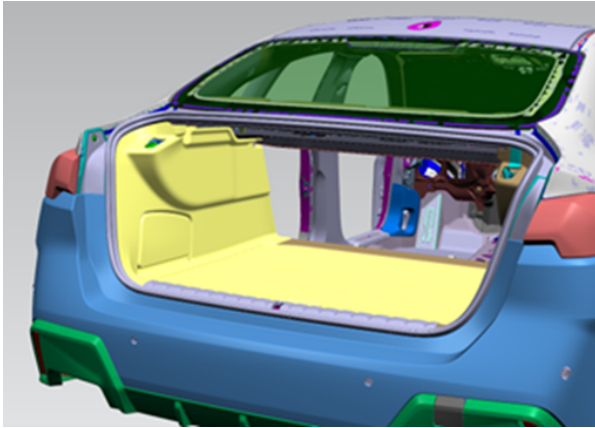
The green dots represent the location of spot welds.

**CORRECTION**

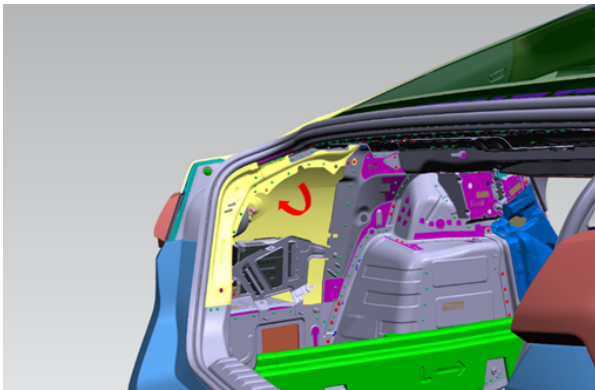
1. Check the inner surface of the trunk metal/water channel for the presence of a crack or metal tear.

2. If a crack/tear is observed, pour water into the water channel and observe if water passes through the crack/tear.
3. If water is observed passing through the crack/tear, rework the trunk corner and weld the crack/tear, then perform localized painting.

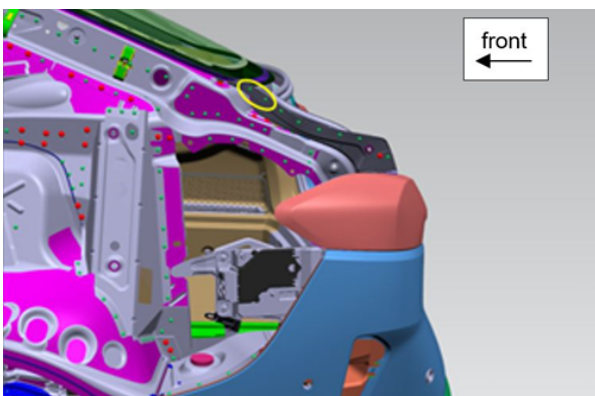
## PROCEDURE



1. Remove both panels highlighted in yellow following the repair instructions listed in ISTA/AIR 51 47 151.



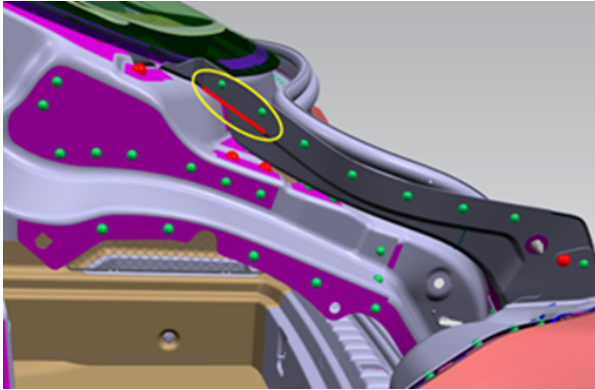
2. Using a borescope camera, insert the borescope head between both highlighted panels.



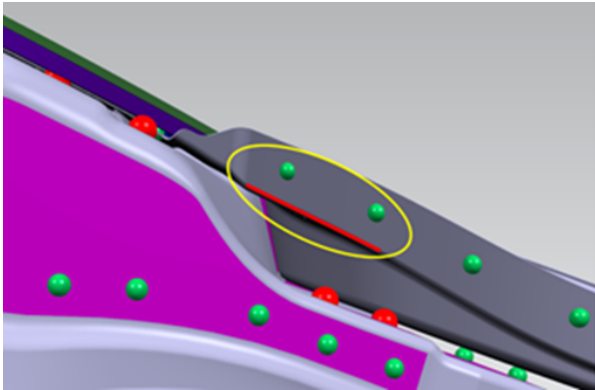
3. Using the borescope camera, inspect the area shown in the photo for a crack/tear where the panel curves/bends (see photos).

- If **NO** crack/tear is seen/found on the panel, the vehicle can be reassembled, and the campaign can be closed
- If **A** crack/tear is seen/found on the panel, continue to step 4

**Note: All three photos are showing the outer side panel removed for better visibility of the area**

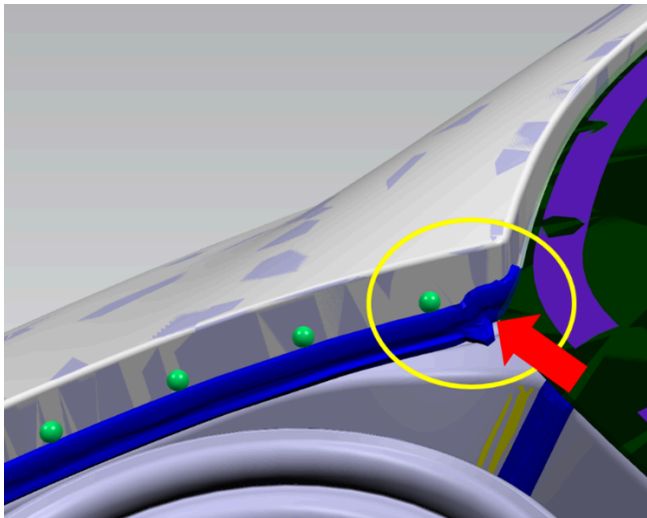


**Note: Red line demonstrates where the possible crack/tear would be located, on the “outboard facing” surface of the metal.**



4. With the borescope head still held in the cavity and pointing at the area in question (**photos in step 3**), use a plastic squeeze bottle filled with water to pour water onto the PVC seam on top of the water channel (**see photo below**).

- Check the borescope display to see whether water is entering the vehicle through the crack/tear.
- Submit a **TSARA info only case** titled “F74 water channel inspection” with photos of the crack/tear and a video of water **entering/not entering** the vehicle through the crack/tear for further instructions/procedures.



**PARTS INFORMATION**

To determine the part number(s) 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
83 19 2 158 654	K5 body adhesive 50 mL	1 If needed
83 30 5 A78 8C6	Cartridge gun, 2-comp. 50 mL	1 If needed
83 42 2 457 337	Cavity protection spray 400 mL	1 If needed
83 42 5 A66 E25	BMW Group Seam Sealant (D2) 300 mL	1 If needed

Additionally, other materials and small parts that are not specified above, such as fluids, lubricants, one-time  
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use screws, nuts, and seals, which must be replaced or installed (according to the ISTA repair instructions/ETK/AIR), are to be selected from the Electronic Parts Catalog, and/or other approved BMW Group’s resources according to the respective vehicle type. Invoiced these items separately under the Repair Code listed in this bulletin.

**CLAIM INFORMATION**

Reimbursement for this Service Action will be via normal claim entry utilizing the applicable work package information below, and the Expanded Work Package information that applies.

<b>Plusposition (+)</b>	Completion before the first vehicle delivery to a customer (New in-stock/No in-service date), or the vehicle is already in the workshop for another reason and/or repair, identified by the “ <b>(Plusposition)</b> ” reference in the descriptions below.
<b>Main work</b>	The vehicle arrives for this Recall, no other Main work will be performed/claimed during this workshop visit, identified by the “ <b>(Main work)</b> ” reference in the descriptions below

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

Repair Code:	0041430200	<b>F74 Check water channel on rear side panel and rework if necessary</b>
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Below are the special flat rate labor operation code choices for this action.

Work Pkg (WP)	Labor Operation	Description (Plus work)	Labor Allowance
# 1	00 78 520	Check the rear left side panel for cracks, using a leakage test and adhesive bond <b>(Plusposition)</b>	10 FRU
Or:			
# 2	00 78 017	Check the rear left side panel for cracks, using a leakage test and adhesive bond <b>(Main work)</b>	12 FRU

And:

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

Expanded WP A	Description (Associated work)	Sublet Allowance
Sublet Code 4	Reimbursement for the inspection repair-related bulk supply materials (Do not use the BMW part numbers for claim submission)	See the sublet reimbursement calculations below

Sublet reimbursement calculation for claiming the applicable inspection repair-related bulk supply materials (BMW part numbers) is at the dealer net (DN) price for the full or proportional quantities used plus your center’s handling.

Or:

Work Pkg (WP)	Labor Operation	Description (Main work)	Labor Allowance
# 3	00 78 519	Check rear left side panel for cracks <b>(Plusposition)</b>	6 FRU
Or:			
# 4	00 78 016	Check rear left side panel for cracks <b>(Main work)</b>	7 FRU

And:

**Sublet - Water Channel Sheet Metal Repair and Paint Refinish (Third Party CCRC/Approved Auto Body Shop)**

Expanded WP B	Description (Associated work)	Sublet Allowance
Sublet Code 3	Left rear side panel water channel sheet metal repair and paint refinish (Third-party sublet invoice)	See the sublet reimbursement calculations below

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

Invoice the water channel sheet metal repair and paint refinish work 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 paint finish work procedure 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 finish work is consistent with what is normally recognized as customary, fair, and reasonable. Also, it must not exceed the scope of the repair work that is described in this bulletin.**

**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: B41 01 25 WP 1, A), unless otherwise required by State law.

Additionally, 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
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[AM1]US part number

