

2025-05-28

<input type="checkbox"/>	THIS REPAIR IS MOBILE FRIENDLY
<input type="checkbox"/>	THIS REPAIR IS REMOTE SOFTWARE UPGRADE (RSU) FRIENDLY

MODEL

E-Series	Model Description	Affected Option Code
G07	X7 Sports Activity Vehicle (SAV)	All with Third-Row Seat Option

SITUATION



While attempting to unbolt the third-row seat to perform, or to gain access to perform another required repair, one or more of the bolts may not easily loosen. Applying addition force to loosen the bolts may cause the seat anchor body-nuts to break free from their welds.

The bolts will then just spin, not allowing the seat to be removed.



You must cut the bolt to remove the seat.



For this situation, replacement of the body bracket with new anchor nuts will then need to be performed so that the third-row seat can be reinstalled and secured.

## **CAUSE**

Contamination of the third-row seat bolt and/or the anchor body-nut threads during production can cause excessive binding.

As a result, the force needed to remove the bolt(s) may exceed what the seat mounting(s) can support, which can cause the third-row seat anchor's body-nuts to break free from their welds.

## **CORRECTION**

Should this occur, as applicable, drill and replace the mounting bolts and/or replace the rear floor panel section(s) with the built-in third-row anchor nuts as required.

This can require a qualified body shop to weld the new bracket into the vehicle and properly paint the repair.

## **PROCEDURE**

It is recommended to first attempt to remove these bolts manually (do not use power tools).

A. **If these bolts cannot be easily removed manually, consider drilling and replacing the bolts to help avoid an unplanned CCRC/Approved auto body shop repair situation.**

Or:

B. If the third-row seat anchor body-nuts broke free from their welds, see [Attachment B52 06 25](#) for the repair procedure.

## **PARTS INFORMATION**

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

Part Number	Description	Quantity
Refer to ETK/AIR	Hexagon screw with flange	As needed

And, as needed:

See for example ETK page 41\_2980 Rear Wheelhouse parts

Part Number	Description	Quantity
41 00 7 947 147	Side member rear top left	1
And/or:		
41 00 7 947 148	Side member rear top right	1

**NOTE: These are structural body component part numbers with restricted ordering.**

To place an order for restricted parts, the collision center must visit [://BMW-partsrestrictions.dekagc.com](https://BMW-partsrestrictions.dekagc.com) and create or access their account where tooling training requirements are verified.

For BMW support, contact part [partrestrictions@bmwna.com](mailto:partrestrictions@bmwna.com)

When applicable, 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.

Additionally, other materials and small parts that are not specified above, such as fluids, lubricants, one-time 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

In conjunction with a covered repair that required the removal of the third-row rear seat under the terms of the BMW New Vehicle Limited Warranty (4/50) for Passenger Cars and Light Trucks as described below for all centers.

### Notes

- Diagnosis Worktime Flat Rate 00 58 500 is not claimable with these repairs.
- Generally, the labor for third-row rear seat removal and installation will be included in the original repair that was being performed.
- This repair procedure does the apply to Parts Warranty repairs, based on the issue being addressed, it would have then occurred when the first repair was performed.

<b>Repair Code:</b>	A. 5220323200	<b>Seat frame/carrier, rear seat Deformed / distorted / bent</b>
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And:

Labor Operation	Description	Labor Allowance
52 99 000	Drilling and replacing the bolt(s) for the third-row seat that will not loosen (One or both sides, work time)	FRU WT

And/or:

<b>Repair Code:</b>	B. 4112060100	<b>Floor panel, luggage (Rear) compartment Cracked / broken / torn off</b>
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Labor Operation	Description	Labor Allowance
52 99 000	Pre-work related to replacing the applicable side member rear top with mounting block for the third-row seat (One or both sides, work time)	FRU WT

And:

### Third-Row Seat Mounting Repair Work - One or Both Sides as Required

Third-Party	Description (Associated work)	Sublet Allowance
Sublet Code 3	Third-party third-row seat mounting repair work (one or both sides), welding, grinding, and applying interior sheet metal surface protection (including proportional amounts of approved bulk materials that were used) (Bill out the side member part numbers and claim with the sublet amount for the repair)	See below

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

Invoice the eligible third-row seat mounting repair work (one or both sides) and the used amount of approved interior sheet metal surface protection materials 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 third-row seat mounting repair-related 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 refinish/paint 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.**

Itemize the claimed sublet amount on the repair order and in claim comment section.

### Claim Repair Comments

Reference this SIB number and explain the issue and/or repair that required the removal of the third-row seat in the technician's RO notes, and in the claim comments

## 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 Attachment B52 06 25.pdf](#)



## **THIRD-ROW SEAT ANCHOR BODY-NUTS BREAK FREE WHILE ATTEMPTING TO REMOVE THE BOLTS**

### **Special Repair and Safety Equipment Required:**

- E-coated single part Assy Crossmember Upper Part
- MIG welder
- Drill with bits
- Grinder
- Weld Blankets
- Primer and Paint
- Hammer and chisel
- Wire brush

Prior to performing any welding disconnect negative battery cable and cover terminal.

Refer to ISTA, "1200...Instructions for welding work (overload protection of control units)"

Note: When reconnecting battery always observe proper tightening torque.

Cover the surrounding work area with protective weld blankets to prevent mutilation and burns of interior trim parts.

Cover the rear of the front seats with a welding blanket.

Cover rear luggage compartment floor with welding blanket or spark deflection paper (3M).


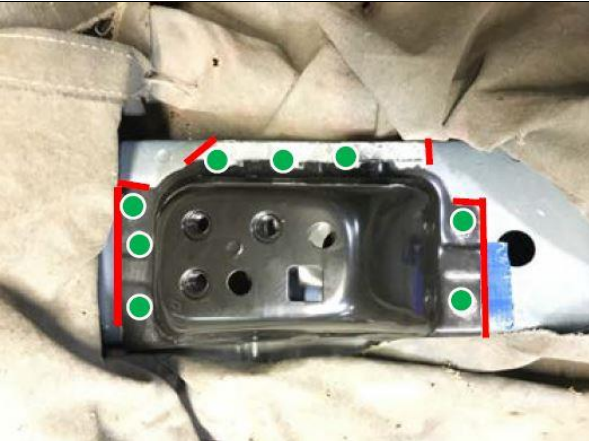

Protect roof liner from welding spatter.

It is imperative that the interior of the vehicle is NOT damaged by sparks or welding spatter during this process.

Ensure no vehicle wiring is exposed to welding spatter.



	<p>With chisel, scribe location of original part as the reference for locating the replacement part.</p>
	<p>Remove defective bracket by drilling the spot welds and chiseling the defective part from the rear support.</p> <p><b>NOTE:</b> DO NOT DRILL HOLES IN THE SUPPORT BEAM.</p>
<p>Procure E-coated part from parts and drill holes in the appropriate spot weld locations.</p> <p>Prepare the mounting surfaces of the body and surfaces of the single part by grinding the surface of the weld points to remove the excess drill filings, burrs and paint.</p>	

	<p>Properly locate new part on the rear support using the scribe lines as a guide and aligning the spot weld positions.</p> <p>Rear view</p>
	<p>Front view</p>
	<p>MIG weld the bracket to the support in the drilled holes at the identified spot weld locations.</p>





Prime the welded areas and paint with the appropriate color.