

2025-05-28

This Service Information Bulletin (Revision 1) replaces SI B61 05 25 **dated March 24, 2025.**

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

**What’s New:**

- CAUSE added
- CORRECTION added
- PROCEDURE added
- PARTS INFORMATION added
- CLAIM INFORMATION added
- Attachment added for FRU worksheet

**MODEL**

E-Series	Model Description	Production Date
G45	X3 Sports Activity Vehicle	August 1, 2024 – February 12, 2025

**AFFECTED VEHICLES**

- Vehicles which require this campaign to be completed will show it as “Open” when checked either in AIR, AWP, Campaign Summary or Warranty Vehicle Inquiry.
- Please make sure you check your dealer inventory as soon as possible. As of March 22, 2025, you can see a list of affected vehicles in Inventory Campaign Details (ICD) under ROSS.

**SITUATION**

BMW AG has issued a Delivery Stop (effective March 21, 2025) on certain Model Year 2025 BMW vehicles that were produced between August 1, 2024, and February 12, 2025.

**Do not deliver to a customer, a New, Certified Pre-Owned or Used vehicle subject to a Delivery Stop, until the vehicle is repaired. Do not use or sell replacement equipment/parts subject to a Delivery Stop.**

**CAUSE**

The terminals of the 48V battery may have not been torqued properly. In the event of a loose connection, the vehicle’s electrical system might suffer numerous malfunctions. This is generally indicated by the corresponding Check Control messages (CCMs) that will display.

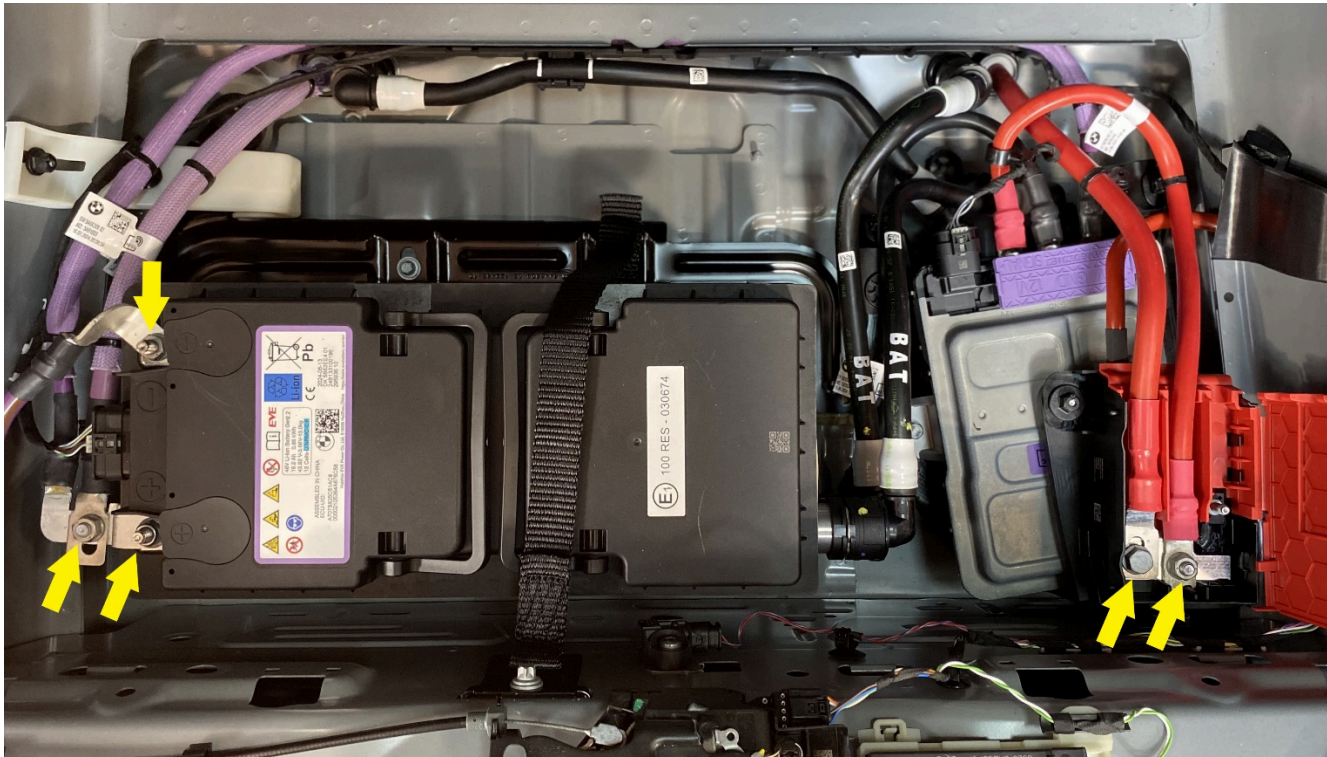
**CORRECTION**

Inspect the threaded connections of the battery cables of the 48V battery, and rework if necessary.

**PROCEDURE**

1. Visual inspect the (5) threaded connection points below marked by yellow arrows. If a loose threaded connections is detected, unfasten the nut and check the connection point (cable shoe, nut, bolt) for damage.

**Threaded connection points to be tested  
(Power distribution, base Z83\*1B, Z83\*2B and 48-volt battery G14\*2B and G14\*3B)**



2. When consequential damage is visible: renew the associated cable, nut, 48V battery, distributor, or Power Control Unit (PCU) if necessary. Select and follow the appropriate repair instructions in AIR based on the extent of damage that has occurred.
3. If no consequential damage is visible or found, reassemble the threaded connection points in accordance with specifications.
4. Retorque the threaded connections to **19 Nm** and reassemble the vehicle.

#### Guidelines:

In most cases, incorrect threaded connections lead to component damage. Please, observe the steps below:

- When renewing or disconnecting any battery, the procedure in the repair instructions **must** be followed
- **Do not** use force when disconnecting terminal covers from the battery
- **Do not** pull on the ground cables
- **Do not** place any tools under the terminal clip to lever off the terminal cover
- Use a torque wrench and set the tightening torque in accordance with repair instructions
- Use the battery size (capacity) installed standard upon battery replacement
- Delete fault code entries associated with battery replacement
- **Clean the contact surfaces** and have them checked by a second person
- Screws or nuts of the threaded connections **must** always be tightened to the specified torque. If possible, have a second person check the torque.
- Always update software on newly installed 48V vehicle batteries
- Perform battery registrations when installing a new battery; make sure to perform **pre-diagnosis to determine the cause of the battery failure**

**Note:** 48 V screw connections form **REH-HIN-P-0001-48VOLT - V.2** can be found in AIR/ISTA.

**Important:** Follow repair instructions and ensure all battery cables are fastened with the correct nut to the specified torque.

**Note:** Damage to the 48V Battery electronics can occur if it is disconnected from the on-board electrical system while active!

Only activate the 48V electrical system when the 48V battery is fully installed (connected).

## **PARTS INFORMATION**

When applicable for WP #3, consequential replacement of cables, nuts, 48V battery, distributor, and/or the PCU as required.

To determine the part numbers that apply to a 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.

### **Sublet - Bulk Supply Material**

Part Number	Description	Quantity
83 19 5A32851	HT-12 Antifreeze RTU (Bulk Drum DN = 1/10 Liter) (Pre-mix)	As needed
Or:		
83 19 2468442	BMW Antifreeze/Coolant (DN = 1 Gallon Concentrate) - HT-12	As needed

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**

Reimbursement for this Action will be via normal claim entry utilizing the applicable work package information below, and for WP # 3, including the BMW part numbers that were needed for the consequential repair work as noted above.

<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 of the flat rate labor operation codes below can be used for claim submission and reimbursement. Also, only one Main work flat rate labor operation code can be claimed per workshop visit.

<b>Repair Code:</b>	<b>0061180900</b>	<b>G45 Check and if necessary, rework threaded connection, battery cable 48V battery</b>
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Below are the special flat rate labor operation code choices for this action.

**Retorquing the Threaded Connections Only (No additional related consequential repair work WAS Not required)**

Work Package	Labor Operation	Description	Labor Allowance
# 1	00 78 648	Access, check and retorque the 48V battery cable threaded connections (No additional consequential repairs are needed) <b>(Plusposition)</b>	5 FRU
Or:			

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# 2	00 78 121	Access, check and retorque the 48V battery cable threaded connections (No additional consequential repairs are needed) <b>(Main work)</b>	7 FRU
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Or when the:

**Affected Vehicle arrives with 48V Battery Cable Threaded Connection related CCMs displayed (Additional diagnosis and related consequential repair work WAS required)**

Work Package	Labor Operation	Description	Labor Allowance
# 3	00 78 122*	Access, check 48V battery cable threaded connections and repair, including the related consequential work/part replacements (Procedure steps # 1 to #5 including the Guidelines that apply) <b>(Plusposition or Main work as applicable)</b>	Up to 125 FRU WT with the necessary time support <b>(Refer to the FRU worksheet below)</b>

**Please do not use Plus Code operation 00 78 649 for your WP # 3 claim submission.**

**Claim labor operation code 00 78 122 one time only for the supported total sum FRU allowance that applies to the additional related repairs performed.**

### **Labor Operation Code Reference Guide/FRU Allowance Worksheet for WP # 3**

For help in determining the FRU allowance amount that applies to this Action when consequential repair-related work is required to be performed, please refer and use the attached FRU allowance worksheet:

- B610525\_AT\_1 FRU Worksheet 05\_2025

**The AIR labor operation codes listed in the attachment are for reference use only, please do not use them to submit your claim**

If you are using a Main labor code for another repair, use the Plus code labor operation 00 00 556 as your reference instead of 00 00 006, or exclude them (including 61 21 528) when the Vehicle Test is included in another repair (For example, an open programming/encoding technical campaign will be performed after this repair is completed).

Work time labor operation codes 61 00 006, 61 00 009, and 61 99 000 are not considered Main labor operations.

### **Overlapping Labor Removal (AIR client's FRU Plausibility Check Tool)**

Depending on the scope of repairs, the reference AIR labor operations correspond to the work performed may contain overlapping inclusive labor tasks, please work together with your center's Warranty Manager, Warranty Administrator, and/or Booker to identify the overlapping labor contained in the flat rate labor operation codes listed above. As determined by the AIR Client's FRU Plausibility Check Tool; calculate, claim, and submit for the reduced FRU allowance that applies.

(\*) Based on which one applies to your center, please refer to **SI B01 01 20** or **B01 07 20** for the applicable procedure for documenting, and explaining, on the RO and in the claim comments, your diagnosis work time (WT), job/repair work time (WT), and the vehicle repairs your center performed, unless otherwise required by State law.

**Note:** Diagnosis Worktime Flat Rate 00 58 500 is not claimable with this Action.

### **Claim Repair Comments**



Reference the SIB number, the issue (briefly), and the work package (WP) number performed in the technician’s RO notes, and in the claim comments (For example: B61 05 25 Rework 48V Battery Cable Threaded Connection WP 1), unless otherwise required by State law.

For WP 3, please explain the additional work that was needed to be performed.

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

<b>Sublet Code 4</b>	Reimbursement for the repair-related bulk supply materials (Do not use the BMW part numbers for claim submission)	See the sublet reimbursement calculations below
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Sublet reimbursement calculation for claiming the applicable 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.

BMW Antifreeze/Coolant: Claim the corresponding sublet dollar amount for the quantity needed to replace what was drained. The one-gallon concentrate’s part number quantity as needed to obtain a 50/50 coolant/water solution.

Enter this material cost in sublet and itemize the amount on the repair order and in claim comment section.

**Vehicle Programming and Encoding – Additional Work (RO and Claim Comments Required)**

This procedure automatically reprograms and encodes any vehicle control modules that do not have the latest software I-level.

If one or more control modules fail during the reprogramming procedure, claim the required consequential repair work procedures to address this issue (including performing the IRAP Control Unit Recovery first as required; refer to the SIB in AIR) under the Repair Code in this bulletin together with the corresponding labor operation codes and their flat rate unit (FRU) allowance(s), including the diagnosis\* that applies.

Please explain the additional work procedures that were performed (The why and the what) on the repair order and in the claim comments.

For covered repairs that address control module failures that occurred prior to performing this reprogramming procedure, claim this work with the applicable Repair Code listed in AIR together with the corresponding labor operation codes and their flat rate unit (FRU) allowance(s), including the diagnosis\* that applies.

**BMW Group’s AIR Application Resource for Flat Rate Labor Operation Codes**

To obtain the corresponding flat rate unit (FRU) allowance information from the BMW Group AIR application resource, start by entering the the Chassis Number (last seven (7) characters of the VIN), and click on the “Search” icon. If the “Vehicle Selection” window displays two or more model possible vehicle choices, select the applicable Model, or enter the full VIN (17 characters) instead to proceed. Click on the “Flat Rate Units” button and enter a flat rate labor operation code number “without spaces” in the field to the right, click on the “Search” icon to display the corresponding listing of “Flat rate unit group details” that are available and their corresponding FRU allowances.

**Alternative Mobility Solution (AMS) for Vehicle Owners (RO and Claim Comments Required)**

This Action’s repair qualifies for Alternative Mobility Solution (AMS) expense reimbursement, claim this item under the Repair 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 B610525\\_AT\\_1 FRU Worksheet.pdf](#)



<b>Repair Code:</b>	<b>0061180900</b>	<b>G45 Check and if necessary, rework threaded connection, battery cable 48V battery (Additional diagnosis and consequential repairs required)</b>
<b>Labor Operation Code Reference Guide/FRU Allowance Worksheet</b>		<b>FRU Allowances as Applicable</b>
<b>Labor Operation</b>	<b>Description</b>	<b>WP 3: 00 78 122</b>
00 00 556	Carrying out vehicle test <b>(Plusposition work)</b>	
	<b>Or:</b>	
00 00 006	Carrying out vehicle test <b>(Main work)</b>	
61 21 528	Supporting voltage of the vehicle electrical system	

**And, as needed**

61 00 006*	Carrying out vehicle diagnosis, ABL (Test Plan) (Work time - WT FRU)	
61 00 009*	Additional electrical/electronic troubleshooting performed to determine the scope of the consequential repair work (Work time - WT FRU)	

If you are using a Main labor code for another repair, select the Plus code labor operation 00 00 556 instead of 00 00 006, or exclude it (including 61 21 528) when the Vehicle Test is included in another repair.

**And the following as applicable / required (Includes accessing the 48V Battery area)**

61 14 540	Removing and installing/replacing rear positive battery cable power distribution	
61 21 523**	Replacing 48-V battery, registering with battery includes drain and top up the low-temperature coolant circuit	
61 42 601**	Replace 48V Power Control Unit (PCU 48)	

**When applicable, for vehicles without an open programming/encoding Technical Campaign (\*\*)**

61 00 730	Program/encode control unit(s), includes deleting the fault memory (After performing 61 21 523 / 61 42 601, or when otherwise required)	
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**Performed other work/job task(s) WITH a specified flat rate operation code/FRU allowance in AIR**


**AIR client's FRU Plausibility Check Tool – Use to review and identify overlapping labor for removal from the above.**

**Performed other work/job task(s) WITHOUT a specified flat rate operation code/FRU allowance in AIR (Explanation comments required for each)**

61 99 000*		

**The AIR labor operation codes listed above are for reference use only, please do not used them to submit your claim.**

**WP 3: 00 78 122**

Claim labor operation code 00 78 122 one time only for the <b>total FRU amount</b> that applies	
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