



SIB 41 06 25

2025-07-30

DELIVERY STOP: BULKHEAD HEAT INSULATION

This Service Information Bulletin (Revision 1) replaces SI B41 06 25 **dated July 2025**.

What's New:

- Title updated
- Situation updated
- Correction added
- Procedure added
- Parts information added
- Claim information added

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

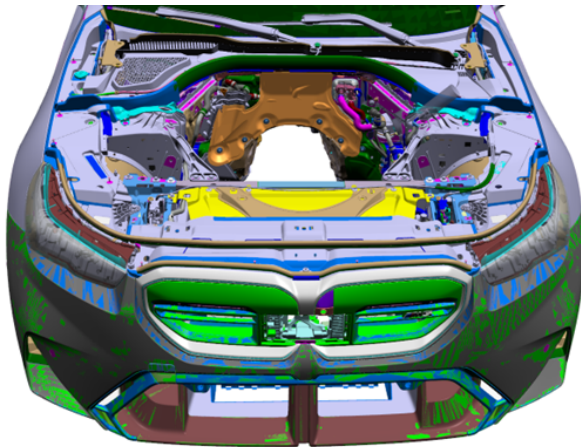
MODEL

E-Series	Model Description	Production Date
G90	M5 Sedan	April 16, 2025
G99	M5 Touring	March 24, 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. You can see a list of affected vehicles in Inventory Campaign Details (ICD) under ROSS.

SITUATION

BMW AG has issued a Delivery Stop (effective July 11, 2025) on certain Model Year 2025 - 2026 BMW vehicles that were produced between March 24, 2025, and April 16, 2025.

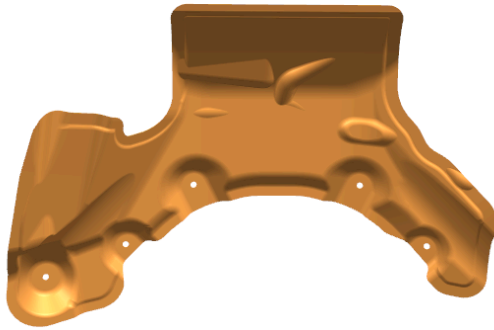
The heat insulator (highlighted in orange) for the bulkhead was not installed. Thermal overload of the components located in the area cannot be ruled out.

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.

CORRECTION

Install the heat insulator onto the bulkhead.

Note: This repair can be performed with the engine in place.



PROCEDURE

Note: Before installing the thermal insulation, the surrounding components (coolant line, high-voltage line, etc.) must be checked for damage and replaced if necessary.

1. Remove both catalytic converters follow the repair instructions listed in ISTA/AIR 18 32 070.
2. Remove the right-side control unit holder following the repair instructions listed in ISTA/AIR 12 52 032.
3. Remove the electric auxiliary heater following the repair instructions listed in ISTA/AIR 64 12 320.
4. Install the heat insulator onto the bulkhead.

Important Warning for Working on the High-Voltage (HV) systems on BMW Group vehicles:

Only properly trained personnel, who passed all applicable HV Technical Training Courses, should perform repairs which require disconnecting, or removal of High Voltage battery components on any Hybrid or Electric Vehicle. Work performed on High Voltage systems by unqualified persons may result in severe injury or damage to the vehicle. Additional safety information is found in Repair Instruction 61 00... "Observe safety instructions when handling electric vehicles".

Prior to disconnecting, or the removal of any HV component, the HV system needs to be disabled and secured (by means of the HV Service Disconnect Switch and lock out) by a properly trained HV technician, who has a minimum HV Qualification level after completing the Technical Training Course "ST2324 High Voltage Drivetrain Systems" which as of 1/2023* includes ST1824 Alternative Drive Part 1.

* Note: As of January 2023, the HV component portion of the "ST2205 Generation 5 High-voltage class" (except for the High Voltage Battery) has been merged into "ST2324 High Voltage Drivetrain Systems".

Up to Generation 4 Vehicles once vehicle's HV system is disabled (the "Blitz" - lightning bolt icon is displayed in instrument cluster, see below), a technician without HV Certification may remove a HV component (e.g., EH Heater, EKK Compressor, EME Control Unit, et.), except for the High Voltage Battery.



For Generation 5 Vehicles however, the specific vehicle training is required to diagnose, remove and service any HV component and it is NOT allowed for non HV certified technicians to work on the high voltage system.

High Voltage Battery removal and rework can **ONLY** be performed by a High-voltage Certified Technician with a HV Battery Certification level corresponding to a specific Electric or Hybrid vehicle, for example:

To repair GEN4 HV battery of G05 PHEV a certification from Technical Training Course “ST2006 – SP44 HV Battery” or equivalent ST1825 – Alternative Drive Part 2 is required (or as of 1/2023 the equivalent “ST 2325 for High Voltage Battery Systems”).

And

To repair A GEN5 HV battery the Technical Training Course “ST2205 Generation 5 High-voltage class” is required or as of 1/2023* the equivalent “ST 2325 for High Voltage Battery Systems”.

***Note:** As of January 2023, the “ST2205 Generation 5 High-voltage stand-alone class” has been merged into “ST2324 for High Voltage Drivetrain Systems” and “ST2325 for High Voltage Battery Systems”

PARTS INFORMATION

Use and invoice the part numbers listed below.

Part Number	Description	Quantity
51 48 8 083 731	Heat insulation, front wall	1
07 14 9 381 677	Plastic nut	34
11 65 8 064 568	Screw clamp	2
18 30 7 553 601	Gasket exh turbocharger/cat converter	3
07 12 9 904 559	ASA bolt	5
07 11 9 904 793	Hex bolt with washer	2
23 00 1 222 888	Torx bolt	5
07 11 9 906 447	Countersunk head screw	4
18 30 7 843 213	Gasket ring	2
18 30 9 504 710	Gasket	2
18 30 7 597 650	Collar nut	4
07 11 9 906 089	Collar nut	4
31 11 6 899 302	Multi-purpose bolt	10
61 25 8 833 846	Hex bolt	6
07 14 8 837 399	ASA bolt	4
31 30 6 874 879	Hex bolt	2
07 14 5 B62 784	Hex bolt	4
07 14 8 076 410	Hex bolt with washer	4

Additionally, other materials and small parts that are not specified above, such as fluids, lubricants (sublet), 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 the part numbers listed above.

Repair Code:	0051270600	G90 G99 S68T Retrofitting heat insulation, bulkhead
---------------------	-------------------	--

Below are the special flat rate labor operation code choices for this action.

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.

Work Package	Labor Operation	Description (Plusposition)	Labor Allowance
# 1	00 78 768	Retrofitting heat insulation on bulkhead	136 FRU
Or:			
# 2	00 78 769	Vehicle was already taken care of through another repair or Technical Campaign	1 FRU

Or:

The vehicle arrives at your center and this Action shows open (No other Main work will be performed or claimed during this workshop visit).

Work Package	Labor Operation	Description (Main work)	Labor Allowance
# 3	00 78 221	Retrofitting heat insulation on bulkhead	137 FRU
Or:			
# 4	00 78 222	Vehicle was already taken care of through another repair or Technical Campaign	1 FRU

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

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: B41 06 25 Retrofit Heat Insulator WP 1), unless otherwise required by State law.

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

Sublet Code 4	Reimbursement for the supported repair-related bulk supply materials amount (Do not use the BMW part numbers for claim submission)	\$150.00
----------------------	--	----------

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.

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

