



SIB 11 07 25  
SERVICE ACTION: S68T ENGINE- REPLACE CYLINDER HEAD

2025-08-27

<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
G70	7 Series Sedan	August 6, 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 July 27, 2025, you can see a list of affected vehicles in Inventory Campaign Details (ICD) under ROSS.

SITUATION

BMW AG has issued a Service Action (effective August 26, 2025) on certain Model Year 2025 BMW vehicles that were produced on August 6, 2025.

Due to an assembly error, the valvetrain could have a mechanical failure.

CORRECTION

Replace the right side cylinder head (cylinders 1-4).

PROCEDURE

Replace right side cylinder head (cylinders 1-4) as per Repair Instruction 11 12 166 Replacing the right cylinder head.

PARTS INFORMATION

Use and invoice the part numbers listed below.

Part Number	Description	Quantity	Sublet – Bulk Supply Materials
11 12 5 A5C F73	Cylinder head with valve gear	1	
11 12 7 853 634	Cylinder head gasket	1	
11 12 7 607 557	Set of screws for cylinder head	1	
11 12 7 583 138	Shim washer	20	
07 11 9 908 021	ASA bolt	4	

11 37 8 662 525	Shaft sealing ring	1
11 12 8 636 546	Cylinder head cover seal set	1
11 12 7 618 841	Sealing ring	1
11 12 8 071 821	High pressure pump seal	2
11 61 8 610 666	Seal of intake system	2 <sub>[AM1]</sub>
11 12 8 626 647	Micro-encapsulated connecting neck	2
11 12 7 608 405	Lid	1
11 12 7 605 211	Profile seal	1
07 12 9 905 769	Torx socket	4
11 12 7 603 917	Fitting screw	4
11 12 7 603 406	Torx socket	16
11 12 7 603 407	Torx socket	8
11 12 7 606 504	Fitting sleeve	36
11 12 7 605 351	Flat-head screw	16
11 62 7 589 106	Gasket	2
11 62 5 A65 9F2	ASA bolt	16 <sub>[AM2]</sub>
11 65 7 845 076	Sealing ring	2
11 42 9 797 647	Oil return line of exhaust turbocharger	1
11 42 8 627 197	Banjo bolt	2 <sub>[AM3]</sub>
07 11 9 963 072	Sealing ring (rounds to 10)	4
07 14 8 854 461	O-ring	2
11 42 7 578 079	O-ring	2
11 42 8 624 158	Asbestos-free gasket	2
07 12 9 904 707	Torx socket with washer	2
07 12 9 905 536	Torx socket (rounds to 10)	6
18 30 7 553 601	Exhaust turbocharger/catalytic converter seal	2
11 65 8 064 568	V clip	2
11 65 8 088 736	V clip	2
13 54 8 053 515	Sealing ring	2
11 61 8 639 597	Seal of throttle body	2
13 54 7 561 349	Hexagon bolt	6
11 51 7 549 445	Profile seal	1
11 51 7 572 792	O-ring	1

11 51 7 642 402	O-ring	1
07 12 9 905 939	Torx bolt	1
07 12 9 905 938	Torx bolt	1
07 12 9 905 569	Torx bolt	3
11 53 8 632 664	Sealing ring	1
64 53 9 284 019	Sealing ring	3
64 53 9 284 018	Sealing ring	3
64 53 9 284 020	Sealing ring	1
18 30 7 843 213	Sealing ring	2
18 30 9 504 710	Gasket	2
18 30 7 560 781	Clamping sleeve	4
07 14 7 301 867	Torx screw with washer	8
07 14 7 263 759	Oval-head screw with shim (rounds to 10)	2
51 61 8 084 883	Hexagon bolt	2
51 64 9 907 859	Hexagon bolt	6
07 14 7 234 925	Combination oval-head screw	6
07 11 9 908 512	Torx screw with washer	4
13 53 9 847 174	Sealing ring	8
07 12 9 905 003	Torx socket	5
13 53 8 694 095	Screw	1
11 12 8 639 554	O-ring	1

Part Number	Description	Quantity
83 19 5 A32 851	HT-12 Antifreeze RTU (Bulk Drum DN = 1/10 Liter) (Pre-mix)	As needed
Or:		
83 19 2 468 442	Antifreeze/Coolant (DN = 1 Gallon Concentrate) - HT-12	As needed

**Sublet - Oil change without filter (Without CBS reset, see below)**

Part Number	Description	Quantity
83 21 5A42D33	Engine oil (SAE 0W-30 – 209-liter drum) (DN =1/10 Liter)	103
Or:		

83 21 5A42D39	Engine oil (SAE 0W-30 – Tank Delivery (DN = 1/10 Liters)	103
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CLAIM INFORMATION

Reimbursement for this Service Action will be via normal claim entry utilizing the applicable work package information below, and the part numbers listed above.

Repair Code:	0011020800	G70 S68 Replacing cylinder head
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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 Pkg	Labor Operation	Description (Plusposition)	Labor Allowance
# 1	00 78 797	Replace right cylinder head	236 FRU

Or:

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

Work Pkg	Labor Operation	Description (Main work)	Labor Allowance
# 2	00 78 249	Replace right cylinder head	238 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: B11 07 25 Replace right side cylinder head WP 1), unless otherwise required by State law.

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

Sublet Code 4	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 and/or proportional quantities used plus your center’s handling.

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

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## BMW Maintenance Program

If the vehicle has an active maintenance program, and the Engine oil Service task shows Recommended, Due in the Service status field, or if it is Bundling Eligible (BE), change the oil filter, replace the engine oil, and “reset the CBS data” after replacing the engine oil pan’s upper screws.

Claim and submit for this Service Action’s Work Package # 1 RO line item.

### A. Repair Code: 0011020800 - Work Package # 1

Labor Operation	Description (Plusposition)	Labor Allowance
00 78 797	Replace right cylinder head	See Above

Then, as an additional RO line item:

### B. Repair Code: 85990501MP - BMW Maintenance Program Standard Operation

Labor Operation	Description (Main work)	Labor Allowance
00 00 105	Standard scope of service	2 FRU

- Claim and submit for the BMW Maintenance Program’s Standard scope labor operation code 00 00 105 (Main work)

And, as another RO line item:

### C. Repair Code: Applicable BMW Maintenance Program Oil Service Task (The First one, or the, All after the First).

- Claim and submit for the engine oil part number (108 one-tenth liters for the 10.8-liter fill) and the engine oil filter element set part number.
- Reset the CBS data.

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

This Service Action’s repair qualifies for Alternative Mobility Solution (AMS) expense reimbursement, claim this item under the Defect 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

