



SIM 54 03 25
**PANORAMIC SUNROOF SUNSHADE STICKING, DISCOLORED,
AND/OR DAMAGED**

2025-09-03

☐	THIS REPAIR IS MOBILE FRIENDLY
☐	THIS REPAIR IS REMOTE SOFTWARE UPGRADE (RSU) FRIENDLY

MODEL

E-Series	Model Description	Production Date	Affected Option Code
F65	MINI Hardtop 4 Door	July 31, 2024 – March 20, 2025	402 Panoramic Moonroof
F66	MINI Hardtop 2 Door		

SITUATION

The sunshade for the panoramic sunroof is sticking, discolored, and/or damaged **(Slide 1 in Attachment)**.

CAUSE

In the presence of moisture, the fabric used for the panoramic sunroof sunshade causes a corrosive and adhesive reaction with the crossmember of the panoramic sunroof cassette.

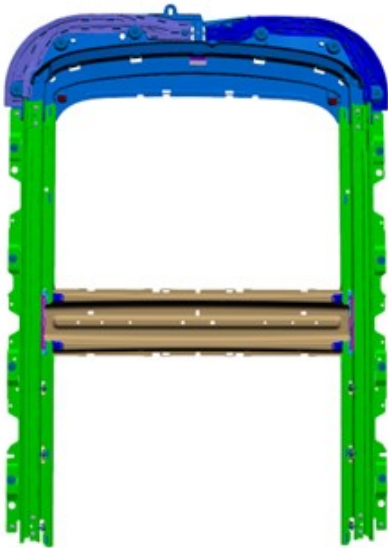
CORRECTION

Clean the crossmember on the panoramic sunroof cassette and apply film tape **(Slide 2 in Attachment)**.

PROCEDURE

- 1. Verify the customer’s concern.** Once it is verified, reference the attachment when following this procedure.
2. Remove the panoramic sunroof glass panels/sunshades following repair instructions listed in ISTA/AIR 54 13 125.
3. Using a clean cloth and R2 cleaner, clean the crossmember at the point marked in green **(Slide 3 in Attachment)**.
4. Apply the film tape in the two marked positions in **(Slide 4 in Attachment)**. Apply the film tape horizontally to the center of the crossmember.

Note: A second person may be needed to apply the film tape onto the crossmember. This avoids unintentionally creating any creases in the tape when applied.



5. Apply the film tape starting from one end of the crossmember, directly from the edge of the plastic component **(Slide 5 in Attachment)**. **DO NOT** attach the film tape to the plastic component on the crossmember!

Slide your finger over the adhesive tape so that the surface is smooth and undistorted.

The procedure needs to be done to both sides (photo showing the yellow horizontal lines as the film tape applied to both sides, approx. 77 cm or 30 inches each side, 154 cm or 60 inches in total).

6. **(Slide 6 in Attachment)** shows that the film tape was not applied correctly.
7. **IF necessary**, clean the dirty panoramic roof sunshade using BMW pet textile cleaner.
8. Once repair is completed, vehicle can be reassembled, and repair can be verified.

PARTS INFORMATION

Obtain and confirm the part numbers for your specific vehicle by entering the chassis number in either ETK or AIR which considers specific equipment and/or options.

Part Number	Description	Quantity
83 19 0 417 324	Cleanser R2 (DN: 500 ml)	Sublet as needed
83 19 9 407 798	Low-friction adhesive tape (DN: W=15 mm, L=33 m)	Sublet length 154 cm / 60 inches
83 12 5 B54 995	BMW Pet Textile Cleaner (DN: 250 ml)	Sublet as needed

CLAIM INFORMATION

Covered under the terms of the MINI New Vehicle Limited Warranty for Passenger Cars and Light Trucks.

Repair Code:	5412900300	F65 F66 Panorama roof roller blind blocked, discoloured, damaged
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Diagnosis

Labor Operation	Description	Labor Allowance
54 00 001*	Sliding / tilting sunroof and convertible top / Locating convertible top/sliding/tilting sunroof complaint(s) (Work time)	WT FRU
Or:		
00 58 500*	Diagnosis Worktime Flat Rate	2 FRU

And, with the diagnosis above that applies your dealer together with the work below that was performed.

Labor Operation	Description	Labor Allowance
54 13 125	Removing and installing/replacing both roller sunblinds (Main work)	As applicable
Or:		
54 13 625	Removing and installing/replacing both roller sunblinds (Plusposition work)	As applicable
And:		
00 78 650	Additional work/reworking the headlining cross member	3 FRU

If you are using a Main labor operation code for another repair, then use the Plusposition labor operation code 54 13 625 instead of 54 13 125.

Work time labor operation codes 54 00 001 and 00 58 500 are not considered Main labor operations.

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

Sublet Code 4	Reimbursement for the repair-related bulk supply materials (Do not use the MINI 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 (MINI part numbers) is at the dealer net (DN) price for the full or proportional quantities used plus your dealer's handling.

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

(*) Based on which one applies to your dealer, please refer to **SI M01 01 20** or **M01 04 20** for the applicable procedure for documenting, claiming, 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 dealer performed, unless otherwise required by State law.

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.

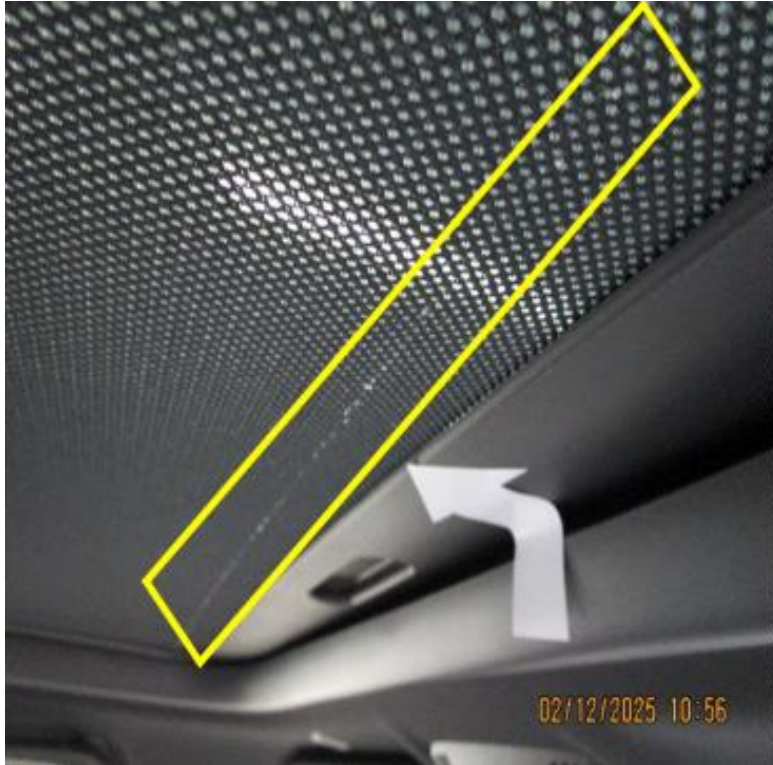
FEEDBACK REGARDING THIS BULLETIN

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 M54 03 25_Attachment.pdf](#)

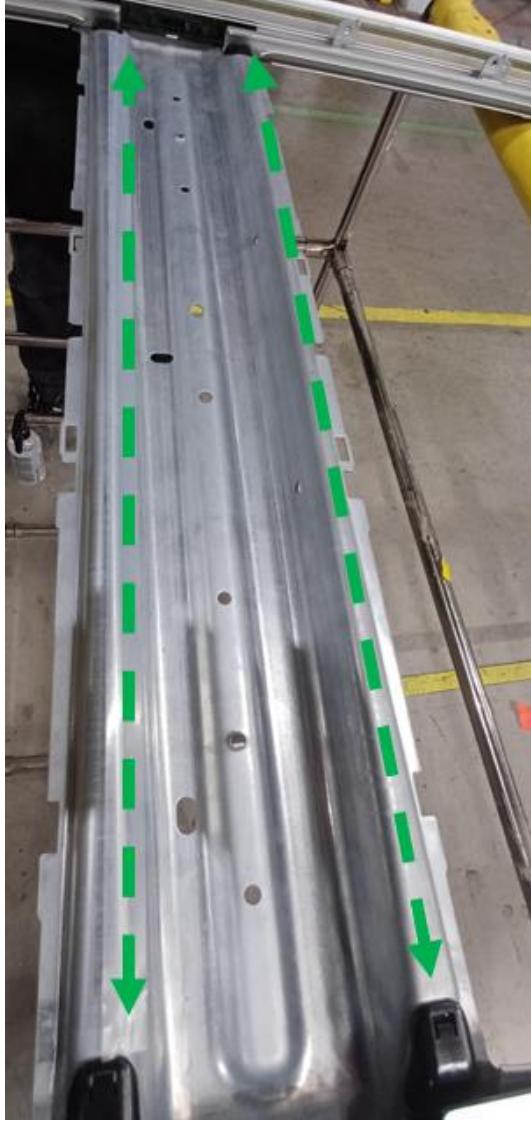
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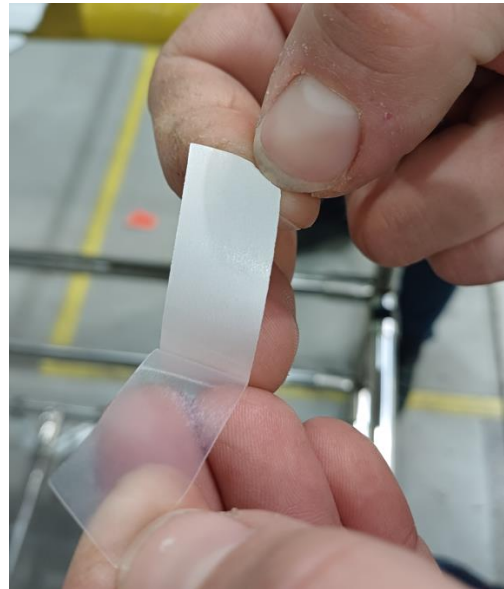
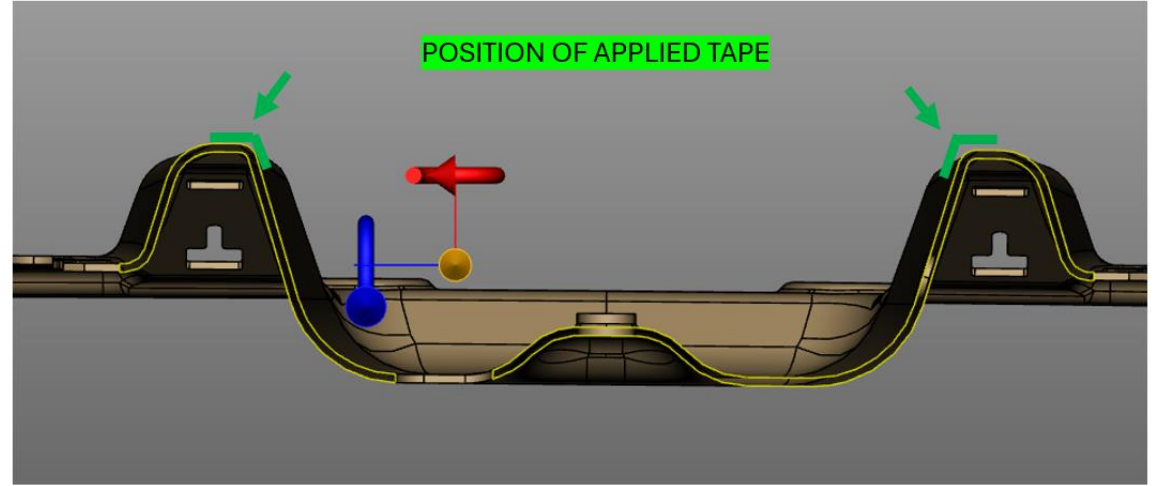
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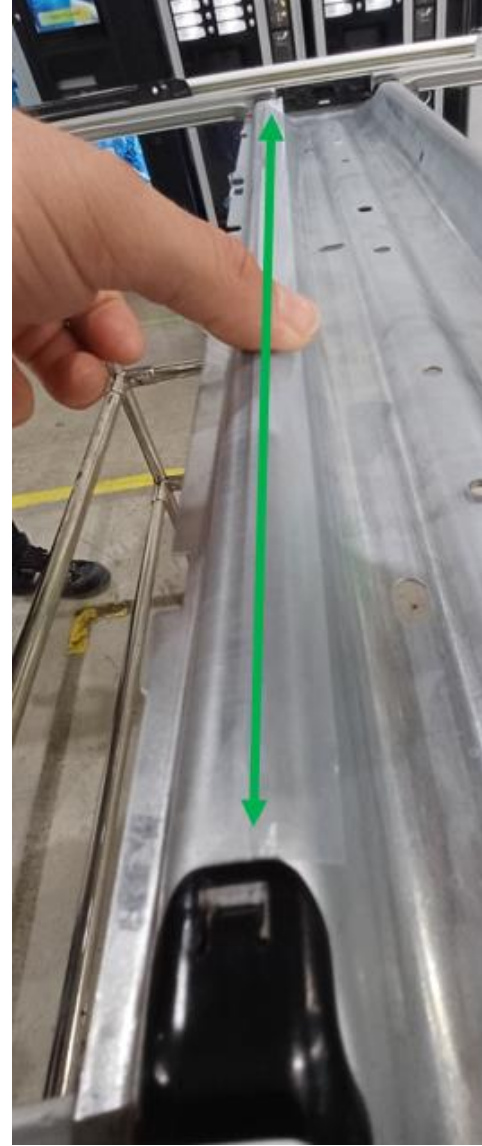
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