



## SIM 51 04 25

### FRONT DOOR POWER WINDOW(S) ARE INOPERATIVE

2025-10-15

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

## MODEL

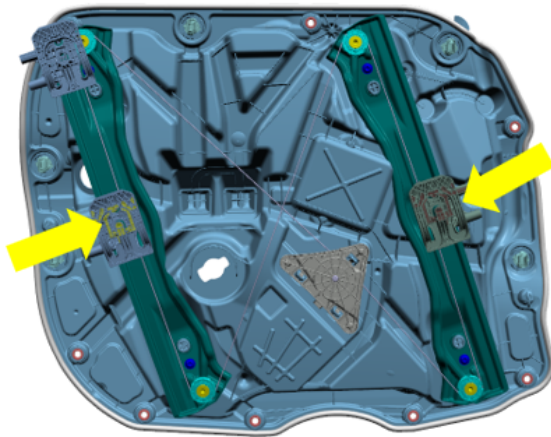
E-Series	Model Description	Production Date
U25	MINI Countryman	October 31, 2023 – September 29, 2025

## SITUATION

Front door power windows (left and/or right side) do not function.

If the window(s) do operate, a grinding sound can be heard while opening and/or closing.

## CAUSE



During the vehicle assembly, too much force was applied when the window glass was installed into the lifter plates (**yellow arrows are pointing to the lifter plates**).

## CORRECTION

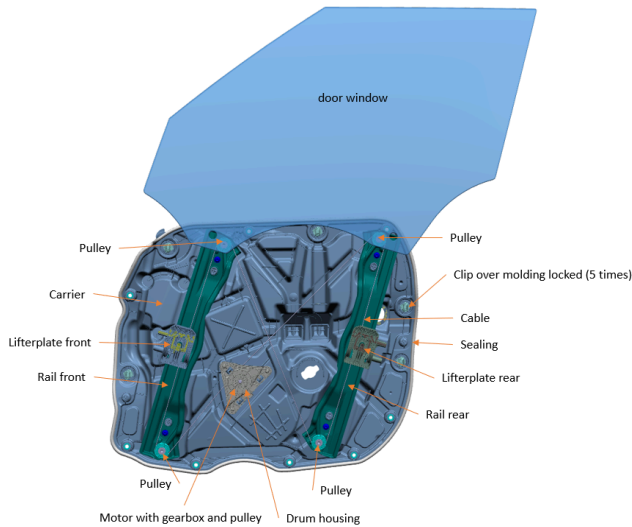
Replace the door carrier of the affected door.

## PROCEDURE

1. Verify the customer's concern.
2. Replace the door carrier of the affected door following the repair instructions listed in ISTA/AIR 51 33 070 (Left) 51 33 072 (Right).

**Note: Before installing the door glass, coat it with lubricant G14 in the area in which the lifter plate clips into the glass.**

3. Without applying excessive force, clip the window glass into the rear lifter plate first and then into the front lifter plate.
4. Once completed, vehicle can be reassembled, and the repair can be verified.



### PARTS INFORMATION

To determine the part number(s) 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.

Part Number	Description	Quantity
Refer to ETK/AIR	Door Carrier Front Left	1 If Needed
Refer to ETK/AIR	Door Carrier Front Right	1 If Needed
83 23 2 360 412 Or; 83 19 5 B4D C02	Lubricant G14 (DN = 900 ml / 30.43 US fluid ounces)	Sublet as needed

### CLAIM INFORMATION

Covered under the terms of the MIN New Vehicle Limited Warranty for Passenger Cars and Light Trucks, or the MINI Certified Pre-Owned Limited Warranty.

<b>Repair Code:</b>	<b>5133251300</b>	<b>Module carrier, front door Broken</b>
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### Diagnosis

Labor Operation	Description	Labor Allowance
51 00 001*	Localizing body complaint(s) (Work time)	WT FRU
Or:		
00 58 500*	Diagnosis Worktime Flat Rate	2 FRU

Work time labor operation codes 51 00 001 and 00 58 500 are not considered Main labor operations.

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

### Replacing the Front Left Side

Labor Operation	Description	Labor Allowance
51 33 070	Replacing left front door module bracket (Main work)	As applicable
Or:		
51 33 570	Replacing left front door module bracket (Plusposition)	As applicable

If you are using a Main labor operation code for another repair, then use the Plusposition labor operation code 51 33 570 instead of 51 33 070.

Or:

**Replacing the Front Right Side**

Labor Operation	Description	Labor Allowance
51 33 072	Replacing right front door module bracket (Main work)	As applicable
Or:		
51 33 572	Replacing right front door module bracket (Plusposition)	As applicable

If you are using a Main labor operation code for another repair, then use the Plusposition labor operation code 51 33 572 instead of 51 33 072.

Or:

**Replacing Both Front Sides**

Labor Operation	Description	Labor Allowance
51 33 074	Replacing both module brackets of the front doors (Main work)	As applicable
Or:		
51 33 574	Replacing both module brackets of the front doors (Plusposition)	As applicable

If you are using a Main labor operation code for another repair, then use the Plusposition labor operation code 51 33 574 instead of 51 33 074.

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

<b>Sublet Code 4</b>	Reimbursement for the repair-related bulk supply material (Do not use the MINI part number for claim submission)	See the sublet reimbursement calculations below
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Sublet reimbursement calculation for claiming the applicable repair-related bulk supply material (MINI part number) is at the dealer net (DN) price for the proportional quantity 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 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

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