



SIB 51 22 24

MAIN DOOR SEAL DETACHING AT THE SEALING JOINT

2026-03-18

This Service Information Bulletin (Revision 3) replaces SI B51 22 24 **dated August 2025**.

What's New:

- Situation updated
- Procedure updated
- Parts Information updated
- Claim Information updated

THIS REPAIR IS MOBILE FRIENDLY

MODEL

F90 (M5 Sedan)	F95 (X5 M Sports Activity Vehicle)	F96 (X6 M Sport Activity Coupe)	F97 (X3 M Sports Activity Vehicle)
F98 (X4 M Sports Activity Coupe)	G01 (X3 Sports Activity Vehicle)	G02 (X4 Sports Activity Coupe)	G05 (X5 Sports Activity Vehicle)
G06 (Sports Activity Coupe)	G07 (X7 Sports Activity Vehicle)	G09 (BMW XM Sports Activity Vehicle)	G20 (3 Series Sedan)
G30 (5 Series Sedan)	G80 (M3 Sedan)	G60 (5 Series Sedan)	G90 (M5 Sedan ^[RP1])
U10 (X2 Sport Activity Coupe)	U11 (X1 Sport Activity Vehicle)		

SITUATION



On the main door seal, detachment behavior can be detected at the **sealing joint**.

Over time, the seal gradually and increasingly detaches which can cause it to-

- Dangle
- Become visible to the customer
- Prevent the door from closing properly

CAUSE

Contamination of the surface onto which the door seal bonds/adheres.

CORRECTION

Partially replace the affected main door seal.

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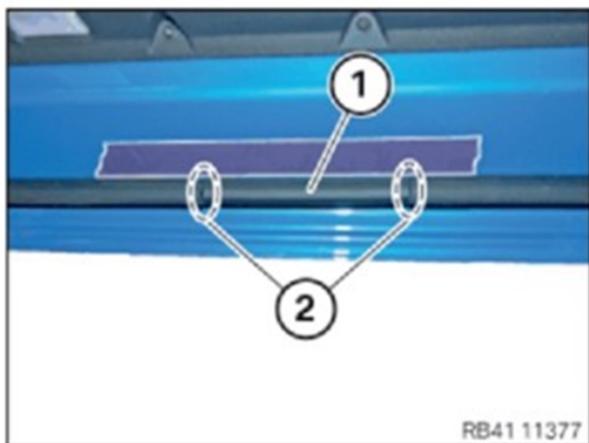
PROCEDURE

Using the WarrantyApp, the minimum required photo documentation includes images of the failed door seal while it is still installed on the vehicle's affected door(s).

To ensure high-quality documentation of the condition of the door seal(s), it is essential to link the seal's condition to the vehicle's VIN by reporting it through the WarrantyApp under the PD category:

- SIB 51 22 24 - Main Door Seal Detaching at the Sealing Joint.

1. Verifying the customer's concern as the issue.



2. For cases where the main door seal detaches in an area not visible to the customer (see illustration above), repair the detached portion by replacing the affected section following the repair instructions in ISTA/AIR 51 71 003.

Note: When replacing the damage section, please ensure the repair does not extend toward the door lock area. It is acceptable to extend toward the door hinge side, as this keeps the repair concealed from the customer's view.



3. Remove residual tape residue with a suitable cleaning product

4. Apply Sika activator 205 sparingly. Allow adequate drying time.

5. Measure and cut the new seal to fit. When installing the seal, ensure that the seams (circled in red) have a gap of no more than 1 mm. Overlapping seams are not permitted.



6. Once the seal is installed, create a water drain at the lowest point of the seal using a suitable small punch tool.

7. For best results use a hole punch, as shown in the illustration. By pinching the seal at its lowest point and using half of the hole punch tool, you can create a perfect drain, as demonstrated.

Note: The complete replacement of the main door seal(s) is not permitted for the issue described in this Service Information Bulletin.

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
51 76 5 B68 FC5	Partial replacement, door seal	Up to 4
83 19 0 030 155	Activator 205 (DN = 250 ML}	Sublet 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 resources, according to the respective vehicle type. Invoiced these items separately under the Repair Code listed in this bulletin.

CLAIM INFORMATION

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

Diagnosis

Labor Operation	Description	Labor Allowance
51 00 001*	Localizing body complaint(s) (Work time) to visually confirm the Situation described above applies to the vehicle	Up to 2 FRU WT Max
Or:		
00 58 500*	Diagnosis Worktime Flat Rate	2 FRU
And:		
00 58 999	Lump-sum fee for photo documentation*	1 FRU

And, with the diagnosis above that is applicable to your center together with the work below that applies and was performed.

Repair (Front Only)

Repair Code:	5171000100	Front door sealing Cracked / broken / torn off
	OR	
	5171003700	Front door sealing Loose

Labor Operation	Description	Labor Allowance
51 71 003	Partially replacing seal on door (Main work, for the first door seal)	As applicable
Or:		
51 71 503	Partially replacing seal on door (Plusposition work, for the first door seal)	As applicable
And, when applicable		
51 99 000**	Work time for each additional door seal that requires repair (Plusposition work)	2 FRU (One other);

And when performed with the above:

Repair (Rear with the Front)

Repair Code:	5171010100	Rear door sealing Cracked / broken / torn off
	Or:	
	5171013700	Rear door sealing Loose

Labor Operation	Description	Labor Allowance
51 99 000**	Work time for each additional door seal that requires repaired (three, or four door seals in total)	4 FRU (Two others); 6 FRU (Three others)

Or:

Repair (Rear Only)

Repair Code:	5171010100	Rear door sealing Cracked / broken / torn off
	Or:	
	5171013700	Rear door sealing Loose

Labor Operation	Description	Labor Allowance
51 71 003	Partially replacing seal on door (Main work, for the first door seal)	As applicable
Or:		
51 71 503	Partially replacing seal on door (Plusposition work, for the first door seal)	As applicable
And, when applicable		
51 99 000**	Work time for each additional door seal that requires repair (Plusposition work)	2 FRU (One other);

If you are using a Main labor operation code for another repair, then use the Plusposition labor operation code 51 71 502 instead of 51 71 003.

Work time labor operation codes 51 00 001, 00 58 500, and 51 99 000 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 material (Do not use the BMW 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 (BMW part number) is at the dealer net (DN) price for the proportional quantity 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. (*) 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, 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 center performed, unless otherwise required by State law.

(**) Claim work time labor operation code 51 99 000 one time per Repair Code for the additional 2 FRU, 4 FRU, or 6 FRU, as applicable, and explain the WT amount claimed in the technician's RO notes and in the claim comments.

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