

**SIB 54 04 21**

2023-10-18

GAP IN FRONT SUNROOF SEAL

This Service Information Bulletin (Revision 2) replaces SI B54 04 21 **dated September 2022**.

What's New:

- Procedure
- Tools
- Parts and Claim Information sections updated

<input type="checkbox"/>	THIS REPAIR IS MOBILE FRIENDLY
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MODEL

F95 (X5 M Sports Activity Vehicle)	F96 (X6 M Sports 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 (X6 Sports Activity Coupe)
G07 (X7 Sports Activity Vehicle)			

SITUATION

This situation can result in two customer complaints:

1. Wind noise
2. Excess water entry

CAUSE

The front sunroof glass seal has shrunk, creating a gap which can cause wind noise or excess water entry.

CORRECTION

Replace and bond the seal.

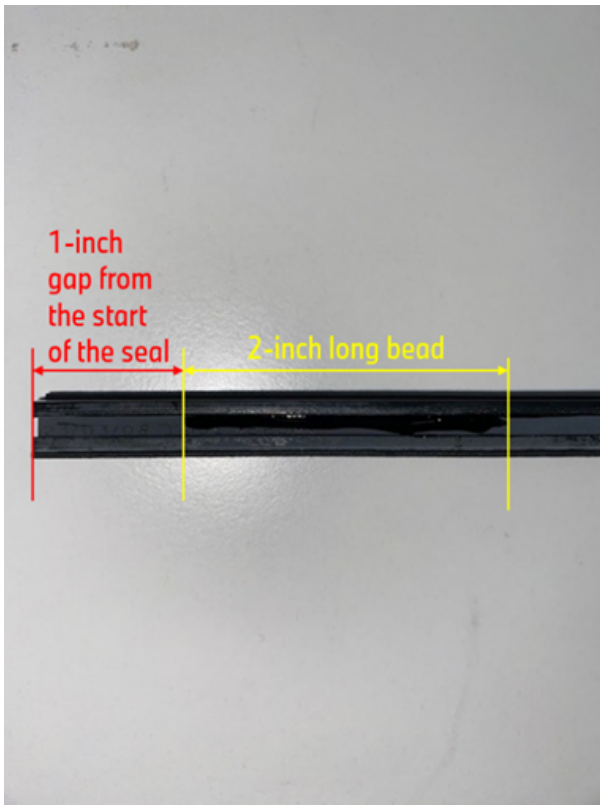
PROCEDURE

1. Remove the front sunroof glass seal following the repair instructions listed in ISTA/AIR 54 13 052.

Note: Once the old seal is removed, inspect the glass encapsulation for the old glue. Please use denatured alcohol and clean cloth to remove the old glue.

2. Apply a 2 inch-long bead on both sides of the seal and bond the seal to the glass panel.

Note: Make sure to leave a 1 inch gap from the start of the seal before applying the adhesive.



Reinstall the seal following the repair instructions listed in ISTA/AIR 54 013 052.

TOOLS

These tools will need to be sourced locally.



48.5 – 50 mL adhesive applicator

50 mL mixing nozzles



48.5 mL 3M Scotch-Weld Urethane Adhesive
DP620NS Black



PARTS INFORMATION

To determine the part number 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
54 10 5 B32 973	Seal glass roof front	1
Source Locally	3M Scotch-Weld Urethane Adhesive DP620NS Black (48.5 ml/1.64 fl. oz)	Sublet

CLAIM INFORMATION

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

Defect Code:	5412253700	Gasket of panorama roof glass slide/tilt sunroof panel Loose
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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, together with the applicable diagnosis above and the repair below, obtain the flat rate unit (FRU) allowances.

Labor Operation	Description	Labor Allowance
54 13 052	Removing/installing/replacing panorama roof frame gasket (Front) (Main work)	As applicable
Or:		
54 13 552	Removing/installing/replacing panorama roof frame gasket (Front) (Plusposition work)	As applicable

If you are using a Main labor code for another repair, use the Plusposition labor operation 54 13 552 instead of 54 13 052.

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

And:

Sublet – Repair-Related Material (RO and Claim Comments Required)

Sublet Code 4	See the sublet reimbursement calculations below	Reimbursement for the repair-related material
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No Part Number (NPN) Weld Urethane Adhesive: Locally sourced supplies (Items not available through BMW NA only) are reimbursed at the cost of the item plus 20 percent, at the quantity needed (WPPM Section 8 Page 25).

Enter the total material cost in sublet and itemize each item in 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.

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 (the last seven (7) characters of the VIN, select the applicable Model if two or more vehicle choices show), or enter the full VIN (17 characters), click on the “Search” button. Next, click on the “Flat Rate Units” button and enter the flat rate labor operation code in the field to the right, click “Search” to display the Flat Rate Unit Group detail choices.

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

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	Warranty Documentation Portal
Parts Feedback	To submit feedback for the PARTS section of this bulletin: Submit an IDS ticket to the Parts Department

