



SIB 61 32 23

2023-12-21

DELIVERY STOP: ENGINE COMPARTMENT SOUNDPROOFING

This Service Information Bulletin (Revision 1) replaces SI B61 32 23 dated December 2023.

What's New:

- Cause
- Correction
- Procedure
- Parts
- Claim Information

THIS REPAIR IS MOBILE FRIENDLY

MODEL

E-Series	Model Description	Production Date
G70	i7 Sedan Battery Electric Vehicle	July 4, 2022 – April 24, 2023

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 December 8, 2023, you can see a list of affected vehicles in Inventory Campaign Details (ICD) under ROSS.

SITUATION

BMW AG has issued a Delivery Stop (effective December 7, 2023) on certain Model Year 2023 BMW vehicles that were produced between July 4, 2022, and April 24, 2023.

Do not deliver to a customer, a New, Certified Pre-Owned or Used vehicle subject to a Delivery Stop, until the vehicle is repaired. Do not use or sell replacement equipment/parts subject to a Delivery Stop.



A small flap of sound insulation material may come into contact with some of the 12 V B+ cables at the remote B+ charging point terminal (general location at arrow) along the engine compartment's passenger side inner fenderwell.

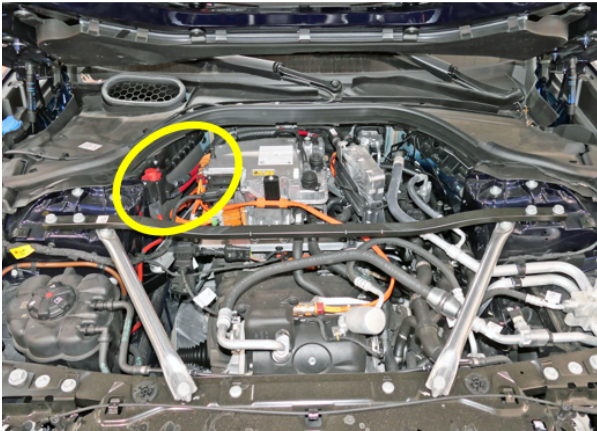
CAUSE

If the sound insulation becomes damp and is in contact with the mounting point of the possible cable terminal or the positive battery cable, in very rare cases corrosion may occur over time.

CORRECTION

Remove the engine compartment sound insulation on the passenger side; and, if necessary, rework the connections of the positive battery cables at the terminal.

PROCEDURE



Remove the acoustic cover from the engine.

The inspection/rework area is circled.



Remove the B+ 12 V junction point cover.

The arrows indicate the sound insulation to be removed.



Remove the sound insulation that sits behind the B+ 12 V cables, by removing the retaining nut (hidden and not shown).

No other components need to be removed in order to remove the sound insulation.

Once the insulation is removed, reinstall the retaining nut.



Inspect the exposed cables for any corrosion.

If there is no corrosion, reinstall the junction point cover and the engine acoustic cover to finish the repair.



If there is corrosion, proceed to the next step.

PRELIMINARY WORK

1-Deactivate vehicle-specific high-voltage or low-voltage vehicle electrical system

[Additional information is available.](#)

RISK OF DAMAGE

Damage to the high-voltage battery due to insufficient deactivation of the high-voltage system before disconnecting the vehicle battery via Service Disconnect in BEV and PHEV vehicles.

Damage to the high-voltage system!

- It is essential to deactivate the high-voltage system before disconnecting the vehicle battery via Service Disconnect on BEV and PHEV vehicles.
- All work on the high-voltage system may only be carried out by specially trained and technically experienced personnel.
- For additional information see: [61 00 ... Safety information on handling hybrid vehicles.](#)
- For additional information see: [61 25 ... Repair information for high-voltage battery unit.](#)

Prior to removing and cleaning the battery cables, follow the repair manual instructions for important safety information in regards to the HV battery.

CAUTION: Prior to disconnecting the 12 V battery ground terminal, deactivate the high voltage (HV) battery circuit. This must be done by a HV-trained technician. Refer to repair instruction 61 25 900 “De-energize the high voltage system”

Take photos of the corrosion and attach them to a TSARA Info case for parts replacement approval.

- Disconnect the 12 V battery per repair instructions 61 20 900 “Disconnecting and connecting battery ground lead.”
- Disconnect the corroded cable(s) and use a brass-bristle wire brush to remove the corrosion. Do not use a metal-bristle brush, which can remove the cable terminals’ protective plating. Brass bristles are softer and do not abrade the plating.
- Apply electrical contact grease KF1 to the exposed cable terminals.
- Reconnect the cable(s) and nut(s). Refer to 6114 “Overview of tightening torques” for the correct tightening torque.
- Reconnect the 12 V battery per repair instructions 61 20 900 “Disconnecting and connecting battery ground lead.”

Reinstall the junction point cover and the engine acoustic cover to finish the repair.

Copyright ©2023 BMW of North America, Inc.

- Activate the HV battery system.

PARTS INFORMATION

An approved TSARA case is required prior to entering a Recall IDS Ticket for parts.

Use and invoice the applicable part numbers listed below.

Part Number	Description	Quantity
61 12 5 A56 467	Battery Cable Positive terminal under floor	If required
61 12 5 A56 470	Wiring Harness emARS under floor	If required

Part Number	Description	Quantity
83 19 2 295 229	Contact Grease KF1 (50 g)	Sublet as required

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, must be selected from the Electronic Parts Catalog, or other approved BMW resources, according to the respective vehicle type. Invoiced these items separately under the Repair Code listed in this bulletin.

CLAIM INFORMATION

Reimbursement for this Action will be via normal claim entry utilizing the applicable work package information below, and when required, the part numbers above that apply.

Repair Code:	0051760500	G70 BEV Removing sound insulation from right side of engine compartment
---------------------	-------------------	--------------------------------------------------------------------------------

Below are the special flat rate labor operation code choices for this action.

Completion before the first vehicle delivery to a customer or the vehicle is already in the workshop.

Work Pkg	Labor Operation	Description (Plusposition work)	Labor Allowance
# 1	00 757 52	Remove motor compartment sound insulation on the right (No repair is necessary)	3 FRU
Or:			
# 2	00 75 753	Remove motor compartment sound insulation on the right and rework battery cables	6 FRU

Or:

The vehicle arrives at your center and this 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
# 3	00 75 193	Remove motor compartment sound insulation on the right (No repair is necessary)	5 FRU
Or			
# 4	00 75 194	Remove motor compartment sound insulation on the right and rework battery cables	8 FRU

Or:

Work Pkg	Labor Operation	Description (Main or Plusposition work)	Labor Allowance
----------	-----------------	-----------------------------------------	-----------------

Copyright ©2023 BMW of North America, Inc.

# 5	00 75 195*	Remove motor compartment sound insulation on the right and replace battery cable (Work time)	WT (Supported, up to a maximum of 110 FRU)
-----	------------	--------------------------------------------------------------------------------------------------------------	---------------------------------------------------

(*) Note 1: Please do not use Plusposition labor code 00 75 754 in place of 00 75 195.

Only one of the flat rate labor operation codes listed above can be used for the claim submission and reimbursement.

Also, only one Main work flat rate labor operation code can be claimed per workshop visit. This applies to labor operation code 00 75 195 when it includes Main work.

Claim Repair Comments

Only reference the SIB number and the work package (Pkg) number performed in the RO technician notes and the claim comments (For example: B61 32 23 WP 1), unless otherwise required by State law.

Sublet – Bulk Materials (RO and Claim Comments Required)

Sublet Code 4	See the sublet reimbursement calculations below	Reimbursement for the repair-related bulk material (Do not use the BMW part number for claim submission)
----------------------	-------------------------------------------------	----------------------------------------------------------------------------------------------------------

Sublet reimbursement calculation for claiming the applicable repair-related bulk material (BMW part number) is at the “proportional dealer net price amount” for the 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.

(*) Note 2: Work Time Labor Operation Codes 00 75 195

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 job/repair work time (WT), unless otherwise required by State law.

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

This 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

Supporting Materials

