




SI B63 02 19
Lights

March 2019
Technical Service

RECALL CAMPAIGN 19V-074: REAR TAIL LIGHT

New information provided by this revision is preceded by this symbol  .

Please perform the procedure outlined in this Service Information on all affected vehicles before customer delivery. In the event the customer has already taken delivery of the vehicle, please perform the procedure the next time the vehicle is in the shop.

This Service Information bulletin replaces SI B63 02 19 **dated March 2019**

What's New:

- Procedure changed
- Parts information changed
- Warranty information changed

MODEL

F48 (X1 SAV)

Produced from October 5th, 2018- January 18th, 2019.

SITUATION

One or both tail lights may be loose.

AFFECTED VEHICLES

This Recall Campaign involves 8,489 F48 X1s produced from October 5, 2018 to January 18, 2019.

Vehicles which require this Recall Campaign to be completed will show it as "Open" when checked either in AIR, the "Service Menu" of DCSnet (Dealer Communication System) or with the Key Reader

CAUSE


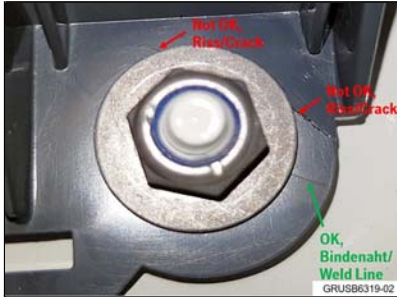



During assembly, oil may have contaminated the plastic housing of the rear tail lights, causing damage to the mounting points of the tail light assembly.

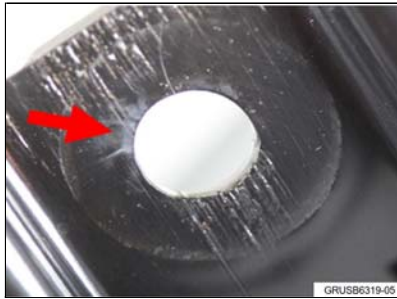
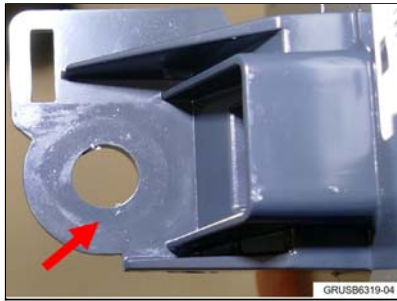
CORRECTION

Inspect the rear tail light assemblies for signs of oil or cracking. Replace the tail light assembly if oil is found or tail light assembly is damaged.

PROCEDURE

1. Remove the water channel trim on both tail lights, following repair instructions REP **63 21 400**

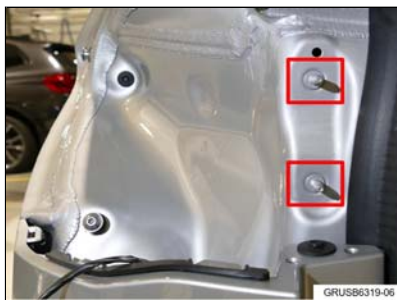
 <p>GRUSB6319-01</p>	<p>“Replace trim for water channel (left or right).</p> <p>2. Before removing the tail light mounting nuts, carefully inspect the tail light mounting areas shown to the left for signs of cracking.</p>
 <p>GRUSB6319-02</p>	<p> Note: Casting lines in the plastic as shown to the left are not a defect.</p> <p>Ensure the tail lights are only replaced in case of cracking or oil contamination.</p>
	<p>3. Regardless of whether the rear lights are cracked, remove both rear tail lights following repair instructions REP 63 21 260 “Removing and installing/replacing left, rear light (on side wall)”.</p>
	<p>4. Immediately secure the tail light mounting nuts so that they cannot be reused.</p> <p> Warning: The tail light mounting nuts may be contaminated and can NOT be reused. Reusing a contaminated mounting nut will cause the new tail light to fail.</p>
 <p>GRUSB6319-03</p>	<p>5. With the tail lights removed, re-inspect both sides of the tail light mounting tabs for signs of cracking.</p> <p>Inspect the mounting tabs of the tail lights for signs of oil residue. Examples of oil residue on the mounting tabs can be seen to the left. All 3 photos</p>



to the left show indications of oil residue and are **NOT OK.**

Inspect the threaded studs on the body and the mounting nuts for signs of oil residue.

Step 6 will be performed regardless of the results of the tail light inspection.



6. With the rear lights removed from the vehicle, the tail light mounting studs and vehicle body **MUST** be cleaned to remove potential residual manufacturing oil.

Using an 80% ethanol/20% water mixture on a clean cloth, clean the mounting studs and body area shown to the left.



Warning: 80% Ethanol/ 20% water is the only suitable cleaning solution that is safe for the vehicle body and tail lights. Do **NOT** use any alternative cleaning solution.

Ethanol can be locally sourced in the form of denatured alcohol

Using any other cleaning solution will cause damage to the vehicle.

UPDATE ! Do not allow the tail lights to come into contact with the cleaning solution.

7. Were cracks or oil residue found on the tail light mounting tabs?

UPDATE! **YES:** Follow the attachment procedure "B63 02 19 repair instructions" and proceed to step 8 afterwards.

NO: Continue to step 9.

8. Replace all tail light mounting nuts. Torque the replacement nuts to 2.8nm.

9. Ensure new mounting nuts are installed and completely re-assemble the vehicle.

For any vehicle found with damaged lights:

Pictures of rear lights which show the condition before a repair or handing the vehicle over to the customer (with OK lights) for documentation must be sent to the following e-mail address:

[US Body Electrical TS@bmwna.com](mailto:US_Body_Electrical_TS@bmwna.com)

Information to be report back (please include in the email):











- VIN number
- Production date of vehicle
- And fault found
 - o Crack over a big area in tail light bracket left/right
 - o Broken rear light bracket left/right or eye loop left/right

PARTS INFORMATION

UPDATE! Only replace or repair the tail light assemblies if required after inspection. Not all vehicles will require tail light assembly replacement or repair.

UPDATE! All Vehicles require self-locking hex nut replacement. Some vehicles may require repair or replacement to only 1 tail light. In case of repair to only 1 tail light, the remaining components of the tail light repair kit will not be used.

Part Number	Description	Quantity
UPDATE! Vehicles that require tail light replacement:		
64 50 9 123 157	Self-locking Hex-nut	UPDATE! 2 or 4
If required:		
Refer to ETK/AIR	Rear light in the side panel, left	1
And/or:		

Refer to ETK/AIR	Rear light in the side panel, right	1
 Vehicles that require tail light repair:		
 63 21 2 471 798	 Repair kit for taillights, side panel (Enough for 1 complete vehicle) (Kit includes 4 self-locking hex nuts)	 1
 83 19 2 317 925	 Adhesive set K6	 Sublet as needed
 83 19 2 336 502	 Replacement K6 nozzles (10 pack)	 Sublet as needed up to 2 nozzles per vehicle



Note: Each repair kit includes the following, and includes the parts required to completely

repair 2 damaged tail lights. K6 adhesive and replacement nozzles must be ordered separately.


- Inner and outer holders (enough to repair both tail lights if needed)
- 6 self-tapping screws
- 4 Self-locking hex-nuts
- 2 foam seals

WARRANTY INFORMATION

Reimbursement for this Recall will be via normal claim entry utilizing the following information:

Defect Code:	0063570100	
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Completion “before” the first vehicle delivery to a customer or the vehicle is already in the workshop

Labor Operation:	Labor Allowance:	Description:
00 67 775	4 FRU	Inspect both tail lights, clean all threaded studs, and replace 4 mounting nuts (Plus work)
Or:		
00 67 776	4 FRU	Replace one tail light , clean all threaded studs, and replace 4 mounting nuts (Plus work)
Or:		
00 67 777	4 FRU	Replace both tail lights , clean all threaded studs, and replace 4 mounting nuts (Plus work)
 Or:		

UPDATE! 00 67 855	UPDATE! 9 FRU	UPDATE! Inspect both tail lights, clean all threaded studs, repair 1 tail light and replace 4 mounting nuts (Plus work)
Or:		
UPDATE! 00 67 856	UPDATE! 15 FRU	UPDATE! Inspect both tail lights, clean all threaded studs, repair 2 tail lights and replace 4 mounting nuts (Plus work)
Or:		
UPDATE! 00 67 857	UPDATE! 9 FRU	UPDATE! Inspect both tail lights, clean all threaded studs, repair 1 tail light, replace one tail light, and replace 4 mounting nuts (Plus work)
UPDATE! And if the vehicle requires tail light replacement or repair:		
00 67 833	2 FRU	Administrative time to email photos and vehicle information to US_Body_Electrical_TS@bmwna.com

UPDATE! Or:

The vehicle arrives at your center for this Recall repair (No other Main work will be performed/claimed during this workshop visit)

Labor Operation:	Labor Allowance:	Description:
00 67 203	5 FRU	Inspect both tail lights, clean all threaded studs, and replace 4 mounting nuts (Plus work)
Or:		
00 67 204	5 FRU	Replace one tail light , clean all threaded studs, and replace 4 mounting nuts (Plus work)
Or:		
00 67 205	5 FRU	Replace both tail lights , clean all threaded studs, and replace 4 mounting nuts (Plus work)
UPDATE! Or:		
UPDATE! 00 67 261	UPDATE! 11 FRU	UPDATE! Inspect both tail lights, clean all threaded studs, repair 1 tail light and replace 4 mounting nuts (Main work)
Or:		
UPDATE! 00 67 262	UPDATE! 16 FRU	UPDATE! Inspect both tail lights, clean all threaded studs, repair 2 tail lights and replace 4 mounting nuts (Main work)

Or:		
UPDATE! 00 67 263	UPDATE! 2 FRU	UPDATE! Inspect both tail lights, clean all threaded studs, repair 1 tail light, replace one tail light, and replace 4 mounting nuts (Main work)
UPDATE! And if the vehicle requires tail light replacement or repair:		
00 67 833	2 FRU	Administrative time to email photos and vehicle information to US_Body_Electrical_TS@bmwna.com

And, as needed:

Sublet – Bulk Materials

UPDATE! Sublet Code 4	UPDATE! Up to \$30.00	UPDATE! Reimbursement for the repair-related bulk materials (Do not use the BMW part numbers for claim submission)
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UPDATE! Sublet reimbursement calculation for claiming repair-related bulk materials (BMW part numbers) is at the dealer net price amount for the “quantities used” plus your center’s handling.

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

ATTACHMENTS

View PDF attachment [2019-F48-RearLampAttachment-QA-final \(26Mar2019\)](#).

View PDF attachment [B63 02 19 repair procedure](#).

View PDF attachment [B630219 Recall Notice](#).

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SAFETY RECALL NOTICE

To: All Center Operators, Sales Managers, Service Manager, Parts Manager and Warranty Processor

RE: Recall 19V-074: F48 Rear Lamp (B63 02 19)

BMW of North America, LLC is conducting a Voluntary Safety Recall (effective January 30, 2019) on certain Model Year 2018-2019 BMW X1 SAV vehicles that have been produced from October 8, 2018 through January 19, 2019.

Owners will be notified by First Class mail about the Recall and will be instructed to bring their vehicles in for a free repair when parts are available.

Please be reminded that it is a violation of federal law (The Safety Act) for you to sell, lease or deliver any new motor vehicle covered by this notification until the recall repair has been performed. This means that centers may not legally deliver new motor vehicles to consumers until they are fixed or use/sell replacement equipment/parts subject to this recall. Note also that substantial civil penalties apply to violations of the Safety Act.

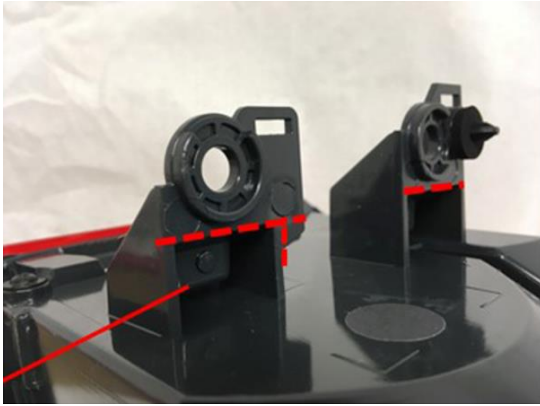
Also, you should not sell, lease or deliver any Certified Pre-Owned or used vehicles subject to a safety recall until the repair is completed.

Please follow any special instructions that we provide to you for the return or disposition of recall parts.

We appreciate all your assistance with this Recall.

B63 02 19 Tail light repair procedure

1. Ensure that the damage does not extend beyond the dotted lines shown below. If cracking extends closer to the tail light housing than the dotted line, or if the mounting tab is completely broken off of the tail light housing beyond the dotted line, the tail light will require replacement following the instructions within the SI B.

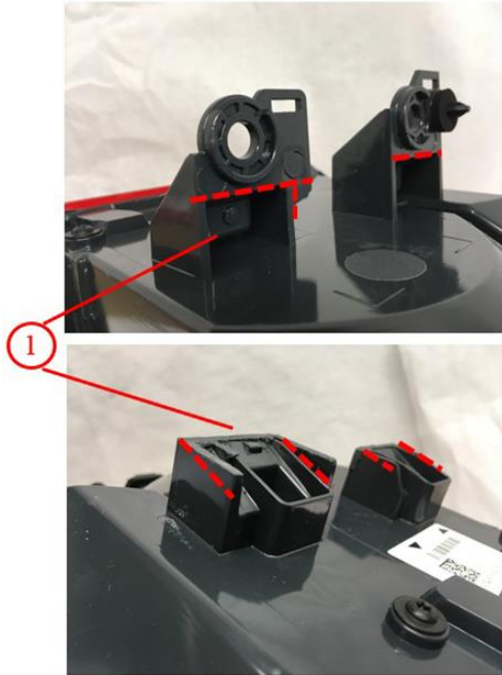


2. Place the tail light on a soft, clean piece of material to ensure the light is not scratched or damaged during the repair. If repairing both tail lights, mark each tail light as “left” or “right” to assist with future steps.
3. Using a suitable saw, such as a handheld hacksaw, oscillating saw, or jigsaw, cut the tabs at the dotted lines shown below:

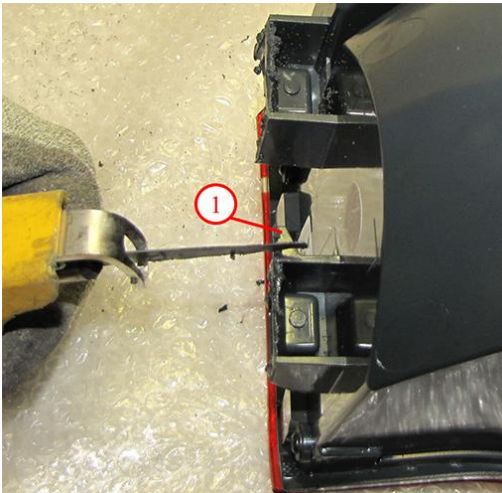
B63 02 19 Tail light repair procedure



Note: The aid of a second person may be needed to hold the taillight while cutting.



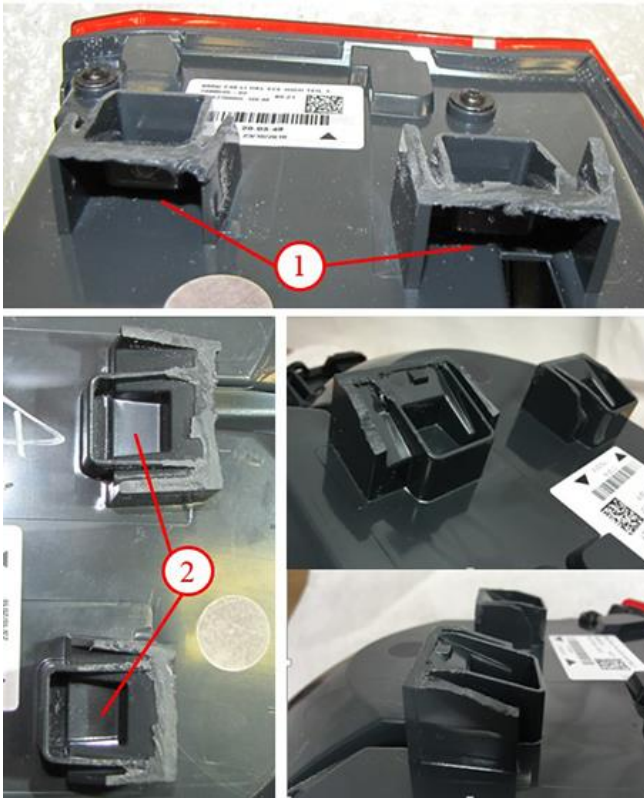
4. Cut off the inner tab (1)



5. De-burr all of the plastic edges from cutting during the previous steps. Using compressed air, ensure that all of the plastic debris is removed. The tail light must be completely free of any cutting remains.

B63 02 19 Tail light repair procedure

6. Reference the photos below for examples of a properly cut tail light:

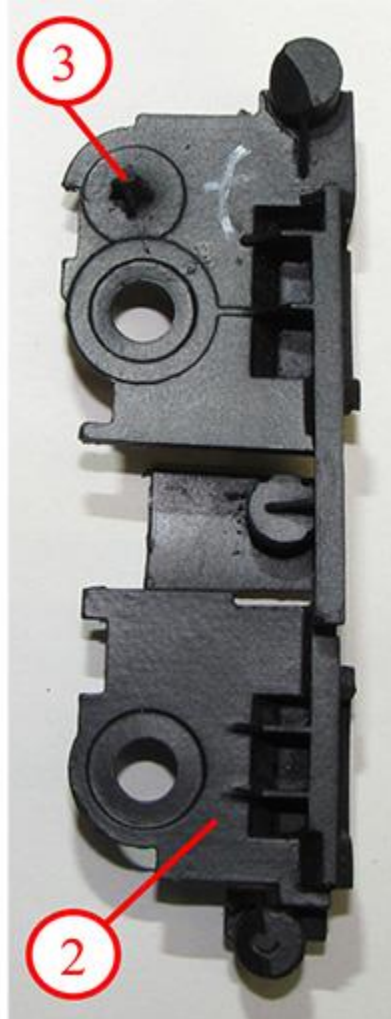


7. Remove the holders from the repair kit. Each side of the repair kit will have an inner holder and an outer holder. Familiarize yourself with which component is the outer, and which is the inner. Label the holders if necessary to aid in future steps. **Note: The repair sets (inner and outer) are side specific and are labeled L & R to be matched to the corresponding tail light.**

B63 02 19 Tail light repair procedure

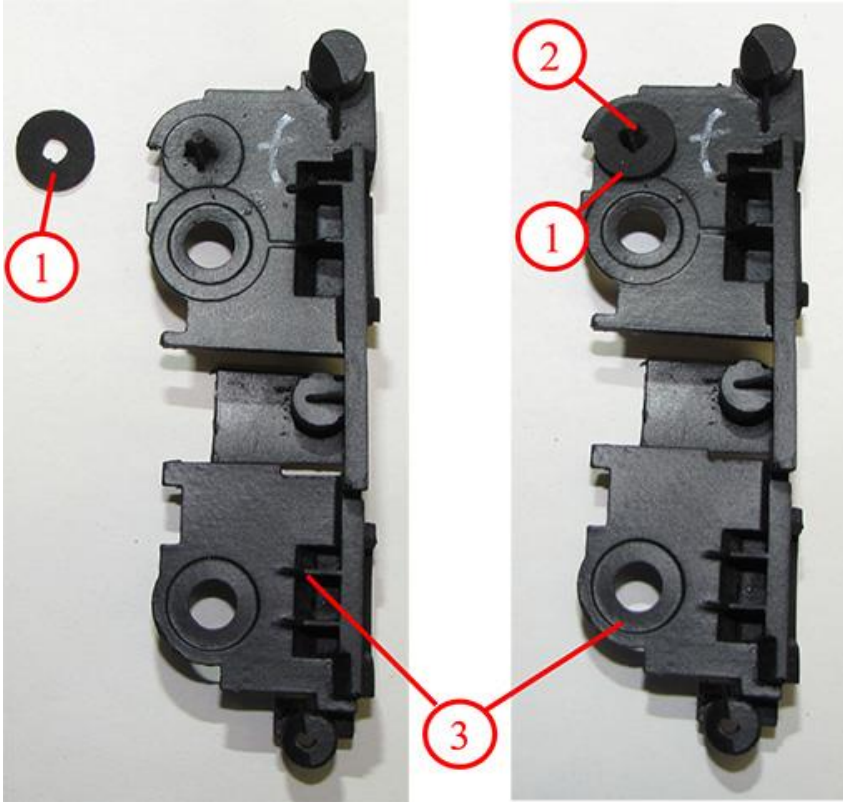
The inner holder can be identified by the pin (3) shown below:

The outer holder (1) can be identified using the photo below:

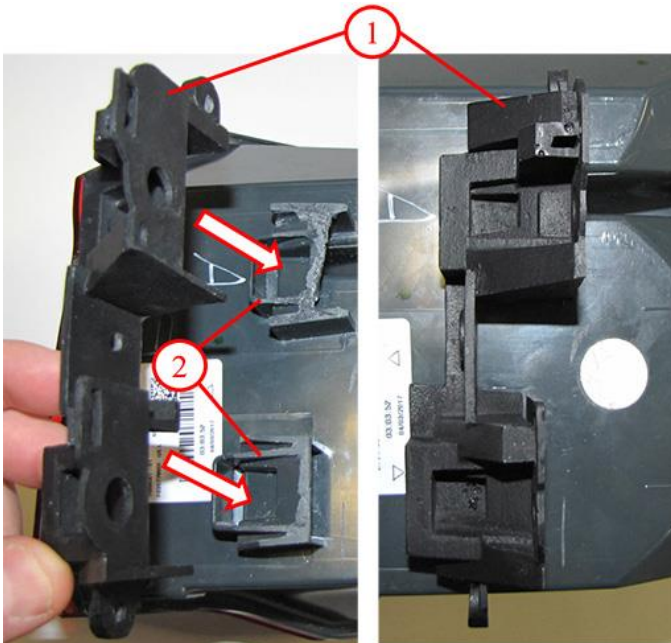


B63 02 19 Tail light repair procedure

8. Remove the foam gasket (1) from the repair kit. Remove the adhesive backing, and install the foam gasket over the pin (2) on the inner holder (3).

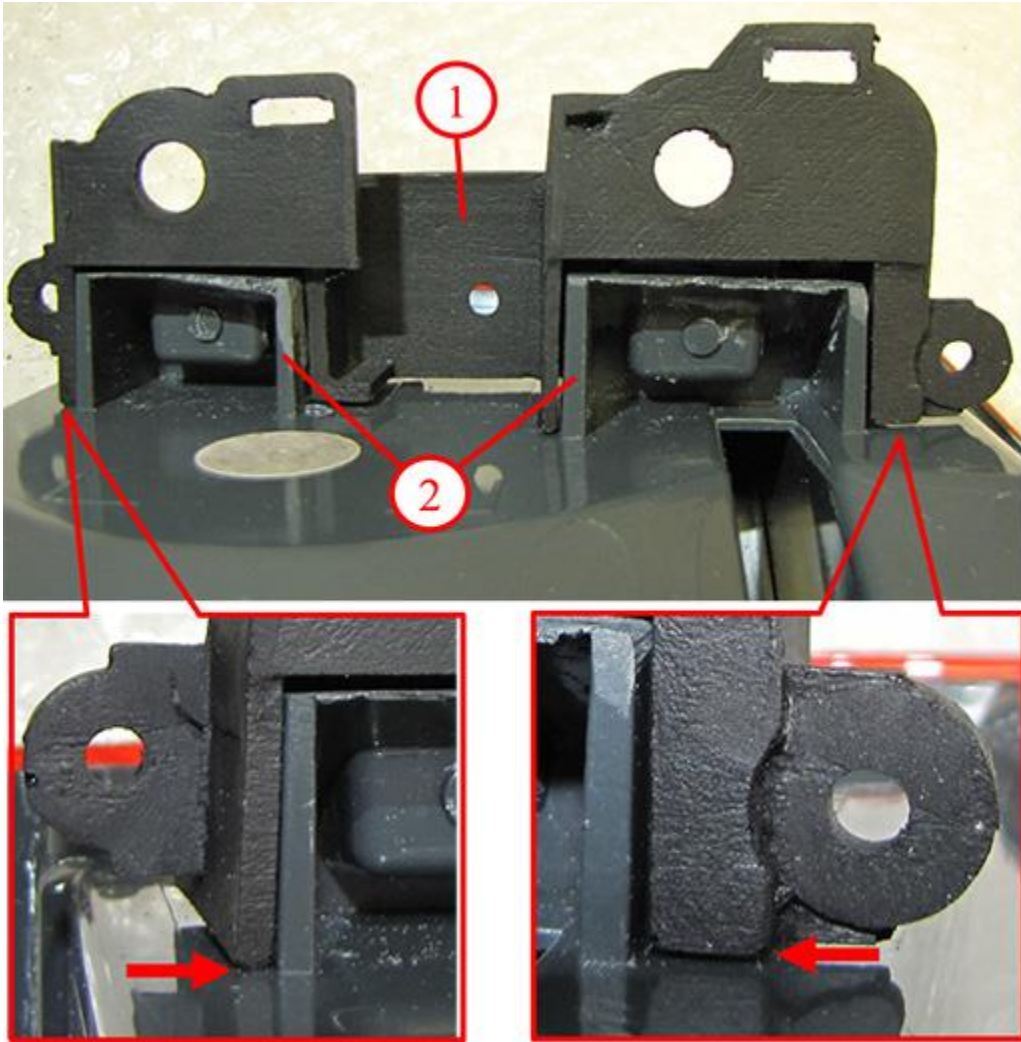


9. Test fit the outer holder by sliding onto the tail light, fitting the tabs of the outer holder into the recesses of the tail light mounting tabs cut in step 3.



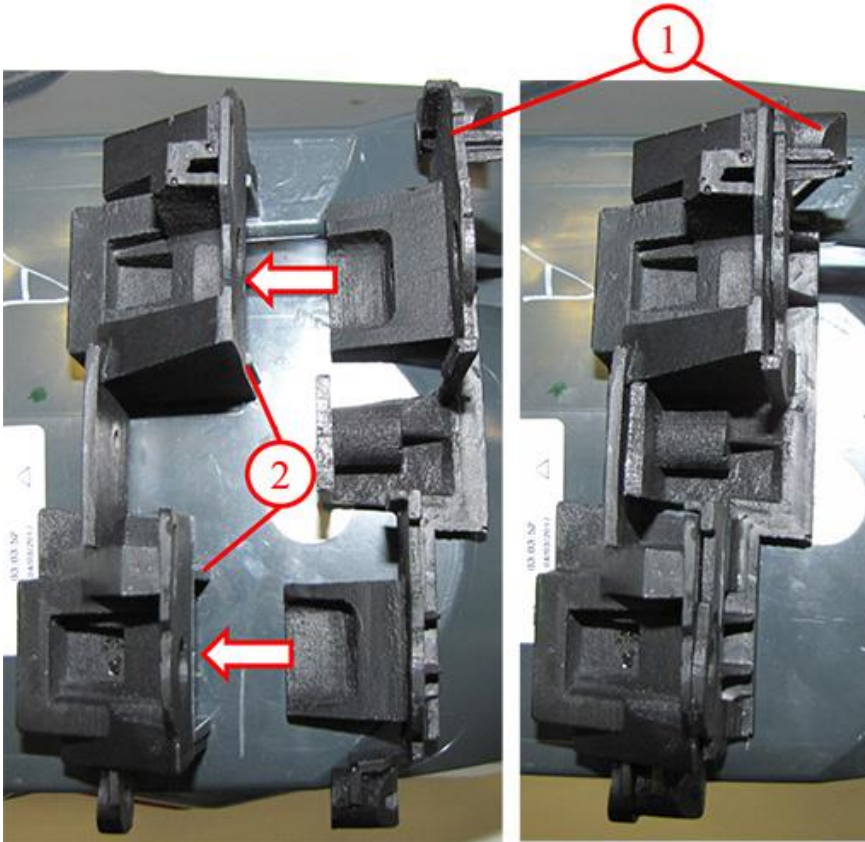
B63 02 19 Tail light repair procedure

10. Ensure that the outer holder slides completely over the tabs and sits flush against the taillight. Reference the photo shown below.



B63 02 19 Tail light repair procedure

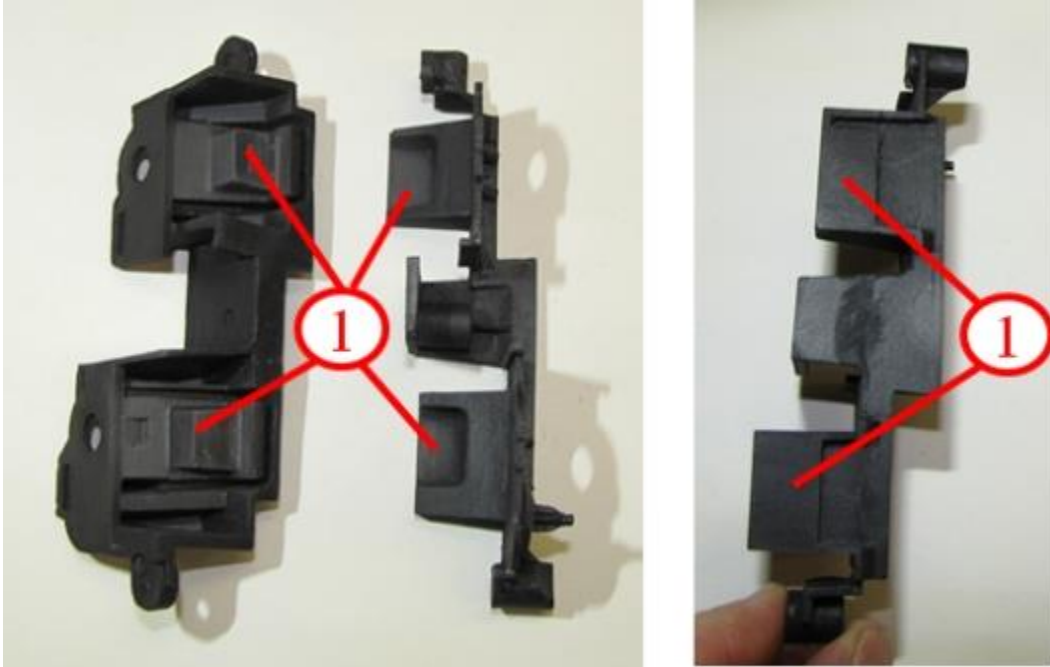
11. Test fit the inner holder by sliding the inner holder into the tail light mounting tabs as shown below:



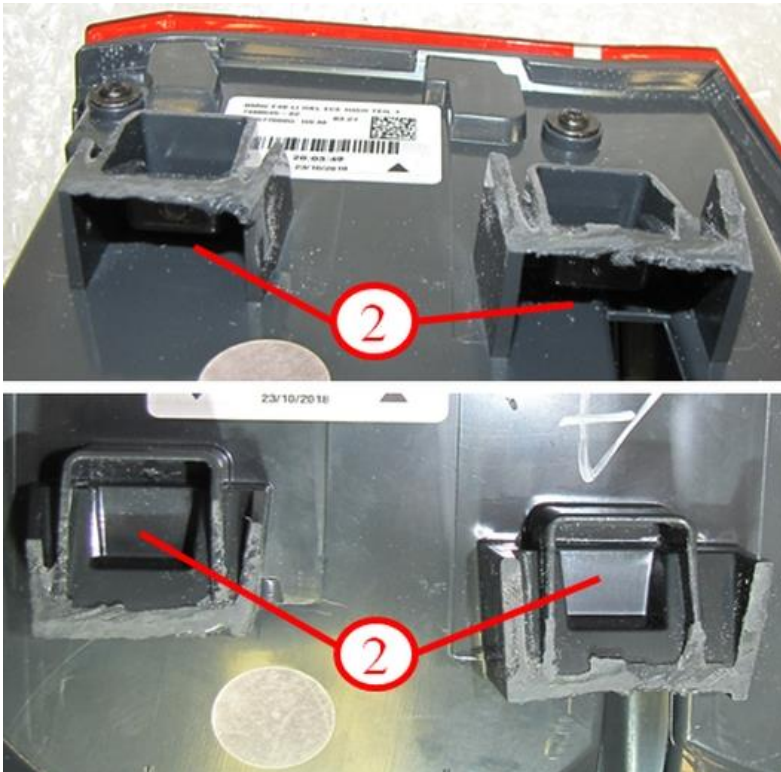
Ensure that both holders sit flush against each other as shown above. There should be no excessive gap between the inner and outer holders.

B63 02 19 Tail light repair procedure

12. After test fitting, remove both the inner and outer holders. Using an abrasive pad or fine sandpaper (220-500 grit), roughen the bonding points shown below (1).



13. Roughen the surface of the tail light in the bonding points shown below (2).



B63 02 19 Tail light repair procedure

14. Apply R1 cleaner, **PN 83 19 2 211 217**, to all of the bonding points that were roughened in steps 12 and 13. Allow the cleaner to dry for 2 minutes.



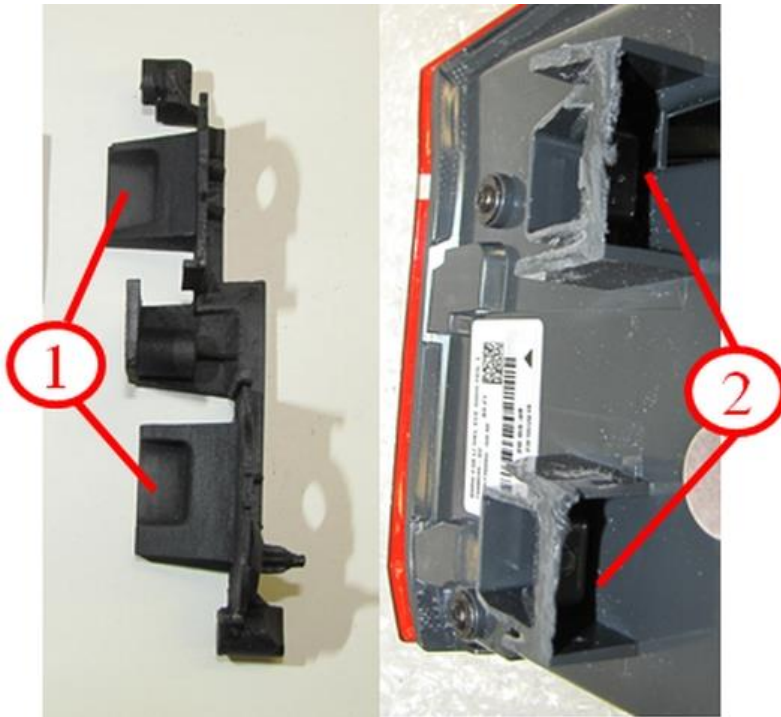
Note: Before continuing, familiarize yourself with the bonding points that were prepared in steps 12, 13, and 14. These areas will be bonded with K6 adhesive, which dries rapidly. Be prepared to bond all required areas before the adhesive can dry. **Read the remainder of the installation instructions before mixing the K6 adhesive.**

15. Once familiar with the bonding points of the tail light and tail light repair holders, separate and mark the inner and outer holders so that they can be rapidly prepared with adhesive for installation without confusion. If needed, test fit the holders again to ensure the installation positions are completely understood.
16. Install a mixing tip onto the tube of K6 adhesive. Apply a small amount of adhesive onto a disposable surface to ensure that the adhesive completely mixes inside the tip.

Apply adhesive to the inner holder at the bonding points (1) prepared in steps 12.

Apply adhesive to the rear light bonding points (2) prepared in step 13.

Install the inner holder onto the tail light, ensuring the holder is slid completely into the tail light.



B63 02 19 Tail light repair procedure

Photo below shows a bonded inner holder (3):



B63 02 19 Tail light repair procedure

17. Apply adhesive to the outer holder at the bonding locations (1) outlined in step 12 and 13.

Install the outer holder onto the tail light, ensuring the holder is slid completely into the tail light.

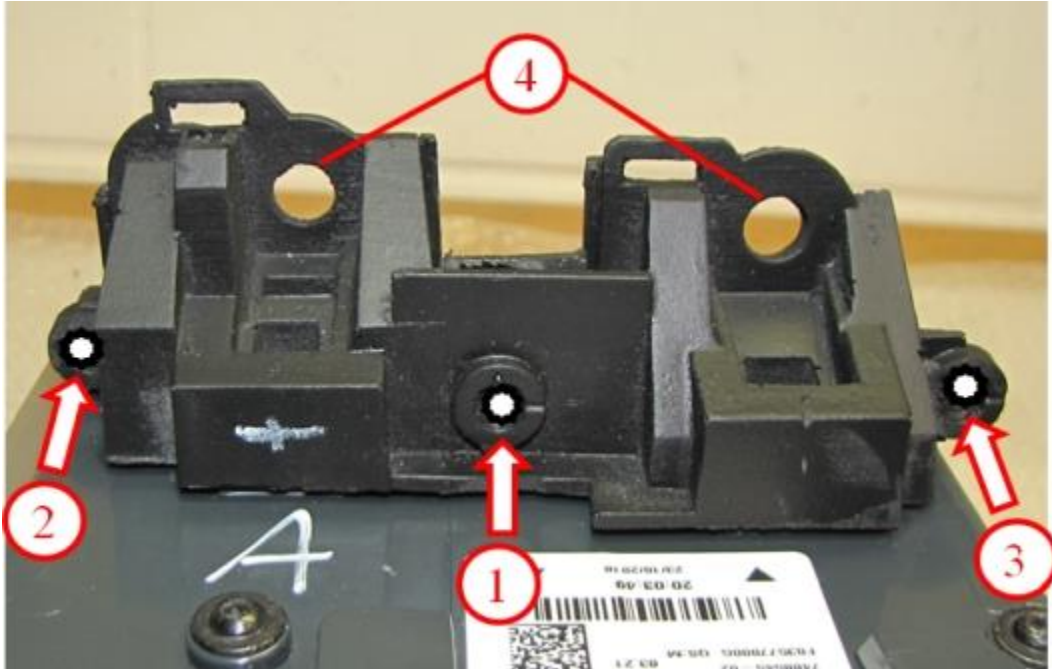


The photo below shows a bonded outer holder (2):



B63 02 19 Tail light repair procedure

18. Install the 3 self-tapping screws into the inner and outer holders, following the tightening order shown below of 1-2-3. Ensure that both holders are held tightly against the tail light during installation of the screws.



19. Reinstall the tail light(s) and proceed to step 8 of SI B63 02 19.



Note: Allow the K6 adhesive to harden in the tip. Do **NOT** remove the tip from the K6 adhesive until you are prepared to perform the repair procedure on another tail light. At which time, a new tip can be used. One tube of K6 adhesive will be sufficient for 2-3 tail lights.

**Rear Lamp
Safety Recall 19V-074
Model Year 2018-19
BMW X1 SAV
*Last Updated 03/22/2019***

- Q1. Which BMW Group models in the US are potentially affected by this Safety Recall?**
Approximately 8,489 Model Year 2018-2019 BMW X1 SAVs in the US, produced between October 5, 2018 and January 18, 2019, are potentially affected.
- Q2. What is the specific issue?**
The rear lamps (left / right) of the vehicle could become loose. In some cases, such as on a rough road, the lamp(s) could separate from the vehicle.
- Q3. What can happen as a result of this issue?**
If a rear lamp separated from the vehicle, it would no longer provide the required lighting to drivers behind your vehicle. Also, there is a possibility that the lamp could fall and become a road hazard, increasing the risk of a crash.
- Q4. Why are other BMW Group vehicles not included in this Safety Recall?**
The attachment of the rear lamps on other vehicles was performed according to specifications.
- Q5. How did BMW Group become aware of this issue?**
BMW Group became aware of this issue through its quality control procedures.
- Q6. Can I determine if this issue exists in my vehicle?**
If you notice an unusual noise and/or vibration from the area of the rear lamps, your vehicle may be experiencing this issue.
- Q7. What should I do if I notice this condition in my vehicle?**
If this condition occurs, please contact your authorized BMW center immediately to have this Safety Recall performed.
- Q8. Can I continue to drive my vehicle (before I receive my letter)?**
Yes. However, when you receive a letter requesting you to make an appointment to have this Safety Recall performed by an authorized BMW center, please do so as soon as possible. If you are not the only driver of this vehicle, please advise all other drivers of this important information.
- Q9. How will my vehicle be repaired?**
The rear lamps of the vehicle will be secured so that they do not become loose. This will be performed for free and can take up to one hour.
- Q10. Is BMW Group aware of any accidents or injuries in the US, involving these BMW Group vehicles associated with this Safety Recall?**
No.
- Q11. How will I be informed of this Safety Recall?**
You will receive a letter in March via First Class mail advising you of this Safety Recall and to schedule an appointment with an authorized BMW center to have this Safety Recall performed. You can locate your nearest authorized BMW center at www.bmwusa.com/dealer.

To ensure the BMW Group has your most recent contact and vehicle information, please register your BMW vehicle at www.bmwusa.com/myBMW. Registration is free, and will give you access to factory initiated campaigns and other information specific to your vehicle.

Rear Lamp
Safety Recall 19V-074
Model Year 2018-19
BMW X1 SAV
Last Updated 03/22/2019

Q12. How long will the repair take?

This repair could take approximately one hour; however, additional time may be required depending upon your BMW center's schedule. The repair will be performed for free by your authorized BMW center.

Q13. Do I have to wait for my letter to have my vehicle serviced?

No. For the latest updates to this Safety Recall, please visit www.bmwusa.com/recall.