



**SIM 51 02 19**  
**RECALL 19V-XXX: CRASH PAD**

2019-08-27

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 (Revision 1) replaces SI M51 02 19 **dated August 2019**.

**What's New** (Specific text highlighted):

- entire content

## MODEL

E-Series	Model Description	Production Date
F56	MINI Hardtop 2 Door	June 11, 2019 to August 14, 2019

## AFFECTED VEHICLES

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), Key Reader or Warranty Vehicle Inquiry.

## SITUATION

BMW of North America, LLC is conducting a Voluntary Non-Compliance Recall (effective August 22, 2019) on select Model Year 2020 MINI vehicles that were produced between June 11, 2019 and August 14, 2019.

Affected vehicles may marginally exceed a Federal requirement. An energy absorbing element in each rear door side panel may not have been installed during production. In a side crash of sufficient severity, this could increase the risk of injury to rear seat occupants.

Approximately 1,832 vehicles are affected by this recall.

Recall notice and Q&A have been attached for further information.

## CAUSE

The structural foam, which is normally installed during production, was not installed.

## CORRECTION



Install a molded structural foam pad to both the left and right rear side trim panels.

The pad is applied to the inside surface of the panel, and is not visible either from inside the vehicle nor from the outside.

The general location is indicated on this passenger side panel by the dotted line.

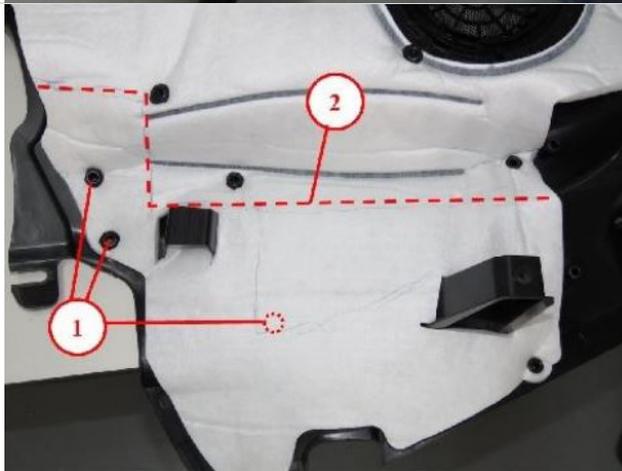
## PROCEDURE

1. Remove the rear side trim panel on both sides of the vehicle following repair instructions REP 51 43 002 "Removing and installing (replacing) rear left or right side trim panel".

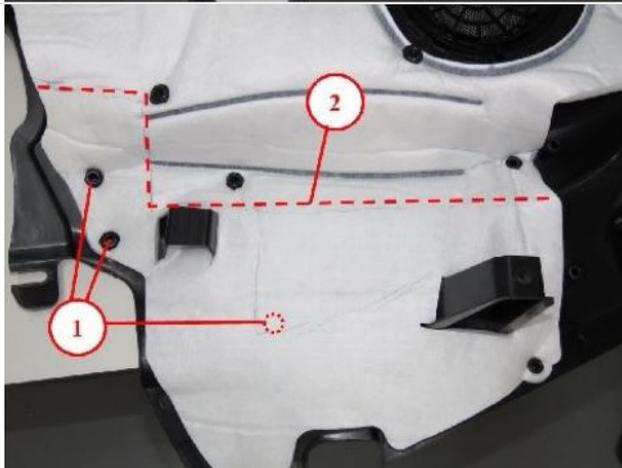
Note: Complete removal of the B and C pillar trim is not required. The trim can be set aside without complete removal.



2. Set the molded foam part (1) down and align the existing bore holes over the welded pins (arrows).



3. Mark (2) the insulating material as shown to the left.

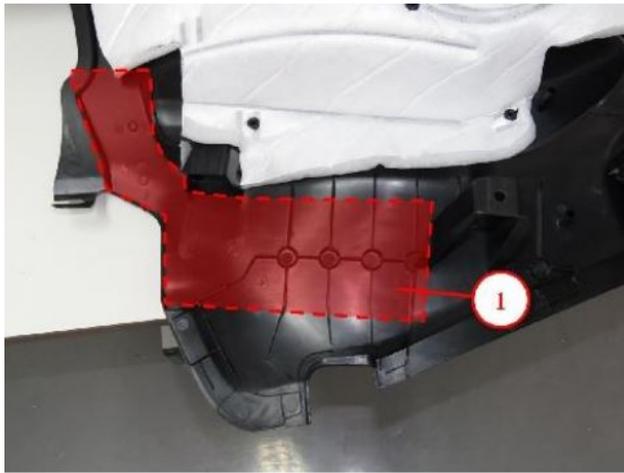


4. Carefully drill out the welded pins (1) flush with the side trim panel.

Note: Use a drill bit that is 10mm in diameter. Do not damage the side trim panel.

5. Cut the noise insulating material following the marking made in step 3.

6. Clean the adhesive area (1) using cleaner R2 P/N 83 19 0 417 324.



7. Apply adhesive (Hot melt adhesive 3731 P/N 83 19 2 409 987) to the molded foam part.

Note: Application time = 2 minutes maximum.

8. Stick the molded foam part to the side trim panel.  
 - Align using the existing bore holes in the molded foam part and the welded pins that you have drilled out (1).

**PARTS INFORMATION**

Part Number:	Description:	Quantity:
51 43 7 436 519	Left structural foam pad	1
51 43 7 436 520	Right structural foam pad	1

**Sublet- Bulk Material**

Part Number:	Description:	Quantity:
83 19 2 409 987	BMW Group Weld Hot Melt Adhesive 3731 Q (Qty 1 = 15 adhesive sticks, sufficient for 15 vehicles)	As needed
83 19 0 417 324	Cleaner R2 (500ml)	As needed

## **WARRANTY INFORMATION**

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

<b>Defect Code:</b>	<b>0051730400</b>
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**Completion “before” the first vehicle delivery to a customer or the vehicle is already in the workshop**

<b>Work Pkg</b>	<b>Labor Operation</b>	<b>Description (Plus work)</b>	<b>Labor Allowance</b>
# 1	00 68 625	Retrofit the structural molded foam parts to both the left and right rear side trim panels (Plus work)	20 FRU

Or:

**The vehicle arrives at your center and this Recall Campaign shows open (No other Main work will be performed/claimed during this workshop visit)**

<b>Work Pkg</b>	<b>Labor Operation</b>	<b>Description (Main work)</b>	<b>Labor Allowance</b>
# 2	00 68 097	Retrofit the structural molded foam parts to both the left and right rear side trim panels (Main work)	22 FRU

### **Claim Repair Comments**

Unless additional related/in conjunction work was required (not addressed and/or included in one of the options provided above), then only reference the SIB number and the work package (Pkg) number performed in the RO technician notes and in the claim comments (For example: B51 02 19 WP 1), unless otherwise required by State law.

And:

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

Sublet Code 4	See sublet reimbursement calculation below	Reimbursement for the used quantities of BMW Group Weld Hot Melt Adhesive 3731 Q (Adhesive sticks – Bulk P/N 83 19 2 409 987: Qty 1 = 15 adhesive sticks) and Cleaner R2 (1 = 500ml)
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Sublet reimbursement calculation for claiming the applicable repair-related bulk materials, Weld Hot Melt Adhesive 3731 Q sticks (bulk P/N 83 19 2 409 987: Qty 1 = 15 adhesive sticks) and Cleaner R2 (1 = 500ml), is at the dealer net price amount for the quantities used plus your dealer's handling.

Enter this material cost in sublet and itemize the amount in the claim comment section.

And, as applicable:

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

This Recall 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 M01 01 17 for additional information.

Supporting Materials

[picture\\_as\\_pdf M510219 2019-F56-CrashPad-QA-\(22Aug2019\)-FINAL.pdf](#)

[picture\\_as\\_pdf M510219 Recall Notice.pdf](#)

## **NON-COMPLIANCE RECALL NOTICE**

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

RE: Recall 19V-xxx: Crash Pad – M51 02 19

BMW of North America, LLC is conducting a Voluntary Non-Compliance Recall (effective August 22, 2019) on select Model Year 2020 MINI vehicles that were produced between June 11, 2019 and August 14, 2019.

**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.

**Crash Pad**  
**Non-Compliance Recall 19V-xxx**  
**Model Year 2020**  
**MINI Hardtop 2 Door**  
***Last Updated 08/22/2019***

- Q1. Which MINI models in the US are potentially affected by this Non-Compliance Recall?**  
Approximately 1,832 Model Year 2020 MINI Hardtop 2 Door models in the US, produced between June 11, 2019 and August 14, 2019, are potentially affected.
- Q2. What is the specific issue?**  
Affected vehicles may marginally exceed a Federal requirement. An energy absorbing element in each rear side panel may not have been installed during production. In a side crash of sufficient severity, this could increase the risk of injury to rear seat occupants.
- Q3. Can I continue to drive my vehicle?**  
Yes. However, when you receive a letter requesting you to make an appointment to have this Non-Compliance Recall performed by an authorized MINI dealer, 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.
- Q4. Why are other MINI vehicles not included in this Non-Compliance Recall?**  
Other vehicles were produced to specifications.
- Q5. How did MINI become aware of this issue?**  
MINI became aware of this issue through its quality control procedures.
- Q6. How will my vehicle be repaired?**  
The crash pads will be installed on affected vehicles for free and will take approximately two hours.
- Q7. Is MINI aware of any accidents or injuries in the US, involving these MINI vehicles associated with this Non-Compliance Recall?**  
No.
- Q8. How will I be informed of this Non-Compliance Recall?**  
You will receive a letter in October via First Class mail advising you of this Non-Compliance Recall and requesting you to schedule an appointment with an authorized MINI dealer to have this Non-Compliance Recall performed. You can locate your nearest authorized MINI dealer at [www.miniusa.com/dealer](http://www.miniusa.com/dealer). To ensure that MINI has your most recent contact and vehicle information, please register your MINI vehicle at [www.miniusa.com/ol](http://www.miniusa.com/ol). Registration is free, and will give you access to factory initiated campaigns and other information specific to your vehicle.
- Q9. Do I have to wait for my letter to have my vehicle serviced?**  
Yes. We are in the process of implementing this Non-Compliance Recall to ensure that the necessary tools, parts, and procedures are available prior to contacting you to schedule an appointment with your authorized MINI dealer to have this Non-Compliance Recall performed. For the latest updates to this Non-Compliance Recall, please visit [www.miniusa.com/recall](http://www.miniusa.com/recall).