Manufacturer Name :BMW of North America, LLCSubmission Date :OCT 16, 2020NHTSA Recall No. :20V-490Manufacturer Recall No. :NR

Manufacturer Information :

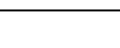
Manufacturer Name : BMW of North America, LLC Address : P.O. Box 1227 Westwood NJ 07675-1227 Company phone : 18005257417

Population :

Number of potentially involved : 713 Estimated percentage with defect : 20 %

Vehicle Information :

Vehicle 1:	2021-2021 BMW 330e
Vehicle Type :	LIGHT VEHICLES
Body Style :	4-DOOR
Power Train :	HYBRID ELECTRIC
Descriptive Information :	Approximately 22 vehicles were manufactured with a high voltage battery that may not have been produced according to specifications.
	Basis for recall population determination: Vehicle manufacturing records were reviewed to determine the potentially affected vehicle population.
	Recall component difference to non-recall component: The high voltage battery was not produced according to specifications.
Production Dates :	JUN 02, 2020 - JUL 03, 2020
VIN Range 1:	Begin :NREnd :NRNot sequential



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	e to non-recall component specifications.	: The high voltage battery was
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Vehicle 4:	2021-2021 B	MW X5 xDrive	e45e	
Vehicle Type :		CLES		
Body Style :				
	HYBRID ELEC			h: - h h - 44 4h - 4
Descriptive information :			cording to specifications.	high voltage battery that may
			determination: Vehicle ma potentially affected vehicle	•
			ce to non-recall component specifications.	: The high voltage battery was
Production Dates :	JUL 11, 2020	- AUG 06, 202	0	
VIN Range 1:	Begin :	NR	End: NR	□ Not sequential
	position o cells whic 1 : NR 2 : NR sk : In rare cas increase t se : NR	of the bead(s), h could lead to ses, the short- he risk of an in	o a short-circuit. circuit could lead to a thern njury.	onductive path between the nal event which could
that can Occ		,		
nvolved Components :				
Component Name 1	: High Voltag	e Battery		
	: High Voltag	e Battery		
Component Description	0			

Supplier Identification :

Component Manufacturer

Name : BMW AG Address : NR NR Country : NR

Chronology :

On July 15, 2020, during high voltage battery production and assembly, an end-of-line inspection noted a potential electrical isolation issue. An immediate hold was issued and additional batteries were inspected. Welding residue was found between several battery modules.

Vehicles containing high voltage batteries at all assembly plants worldwide were held and inspected.

A review of the high voltage battery assembly process was conducted. It was found that during the welding process, welding beads may not have been removed from the battery assembly due to an incomplete cleaning process.

Vehicle assembly information was reviewed to determine the number, and production dates, of potentially affected vehicles.

On August11, 2020, BMW decided to conduct a voluntary safety recall.

BMW Group has not received any reports, nor is BMW Group otherwise aware, of any accidents or injuries related to this issue.

Description of Remedy :

Description of Remedy Program :	The high voltage battery will be inspected and, if necessary, battery modules will be replaced.
	Owners are being contacted by phone. If necessary, owners will be notified by First Class mail and instructed to take their vehicle to an authorized BMW dealer to have the remedy performed for free. If this condition were to occur to a potentially affected vehicle prior to this recall, the remedy would be covered by the BMW/MINI New Vehicle Limited Warranty program. Therefore, reimbursement for a pre-notification remedy re Part 573.13 and Part 577.11 is not necessary.

The information contained in this report was submitted pursuant to 49 CFR §573

How Remedy Component Differs from Recalled Component :	Recall component: High Voltage Battery – p/n (8658344-11/345-11, 8678566-10/567-10).
Identify How/When Recall Condition was Corrected in Production :	
Recall Schedule :	
	Dealer notification is expected to begin and end on August 18, 2020.
	Dealer notification is expected to begin and end on August 18, 2020. Owner notification letters, if necessary, are expected to begin and end on October 12, 2020.
Recall Schedule : Description of Recall Schedule : Planned Dealer Notification Date :	Owner notification letters, if necessary, are expected to begin and end on October 12, 2020.

* NR - Not Reported

The information contained in this report was submitted pursuant to 49 CFR §573