



SIB 61 14 22

2022-10-04

RECALL 22V-541: HIGH-VOLTAGE BATTERY

This Service Information Bulletin (Revision 1) replaces SI B61 14 22 dated July, 2022.

What's New:

- Entire Bulletin except for Affected Vehicles and Situation

MODEL

E-Series	Model Description	Production Date
G26 BEV	i4 Gran Coupe	November 22, 2021 – June 13, 2022

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), ISPA Next or Warranty Vehicle Inquiry.

BMW AG is conducting a Voluntary Safety Recall (effective July 21, 2022) on a small number of Model Year 2022 BMW i4 Gran Coupe vehicles that were produced between November 22, 2021, and June 13, 2022.

Affected vehicles are not to be driven or charged and to be parked away from any buildings.

SITUATION

During supplier production, the high-voltage battery may not have been produced to specifications. A short-circuit could occur which could lead to a thermal event. The affected high-voltage battery cell module will be replaced.

We will be turning VINs green “Remedy Available” based on parts availability. The BMW Customer Relations department will contact the appropriate dealer to have them place a Recall IDS ticket for the parts for a specific vehicle. Then Customer Relations will assist in scheduling an appointment based on the arrival of the parts. **It is essential that the allotted IDS part goes to the assigned vehicle.**

CAUSE

Some high-voltage battery modules may not have been produced to specifications.

CORRECTION

Removal and replacement of affected high-voltage cell modules.

PROCEDURE

Important Warning for Working on the High-Voltage (HV) systems on BMW Group vehicles:

Only properly trained personnel, who passed all applicable HV Technical Training Courses, should perform repairs which require disconnecting, or removal of High Voltage battery components on any Hybrid or Electric Vehicle. Work performed on High Voltage systems by unqualified persons may result in severe injury or damage to the vehicle. Additional safety information is found in Repair Instruction 61 00... “Observe safety instructions when handling electric vehicles”.

Additional Information:

Scheduled Maintenance, or Quality Certification 1 (Pre-Delivery Inspection) on Electric or Hybrid vehicles does not require HV technical training.

Prior to disconnecting, or the removal of any HV component, the HV system needs to be disabled and secured (by means of the HV Disconnect Switch) by a properly trained technician, who has a minimum HV Qualification level after completing the Technical Training Course ST1824 (Alternative Drive Part 1). Once the vehicle's HV system is disabled (the "Blitz" - lightning bolt icon displayed in instrument cluster, see below), a technician without HV Certification may remove a HV component (e.g., EH Heater, EKK Compressor, EME Control Unit, et.), except for the High Voltage Battery.



High Voltage Battery removal and rework can be performed ONLY by a HV Specialist Technician (certified by the Technical Training Course ST1825 – Alternative Drive Part 2), AND with a HV Battery Certification level corresponding to a specific Electric or Hybrid vehicle (e.g., to repair GEN4 battery of G05 PHEV, certification from Technical Training Course "ST2006 – SP44 HV Battery" is required).

Therefore, to perform this SIB 61 14 22 a GEN5 battery Certification is required from Technical Training Course "ST2205 Generation 5 High-voltage" class).

BMW recommends NOT to drive the vehicle NOR charge the high-voltage battery until all repair work below has been completed.

The steps below must be followed precisely:

1. Please perform the **cell module read out** test plan in ISTA to determine the serial numbers and locations of the high-voltage cell modules installed in the vehicle.

Diagnostic path:

Vehicle management > Service function > Electric drive > High-voltage battery unit >

High-voltage battery unit: Read out stored serial numbers ABL.

The "**High-voltage battery unit: Read out stored serial numbers**" test plan has been updated to identify the high-voltage cell modules affected by this campaign and their location in the high-voltage battery.

The update will be included in ISTA version 4.38.1x, estimated availability as of October 21, 2022 (pending verification).

Note:

If the test plan is not yet available at the time of the repair or the test plan was inconclusive in identifying the affected modules, please submit a TSARA case titled "Gen 5 HV Battery cell module ID process" for assistance.

2. The high-voltage battery must be discharged prior to removal to an average **cell voltage** of 3.51V using the ISTA test plan below, **before** the high-voltage battery is opened and the defective modules are removed.

Diagnostic path:

Vehicle management > Service function > Electric drive > High-voltage battery unit >

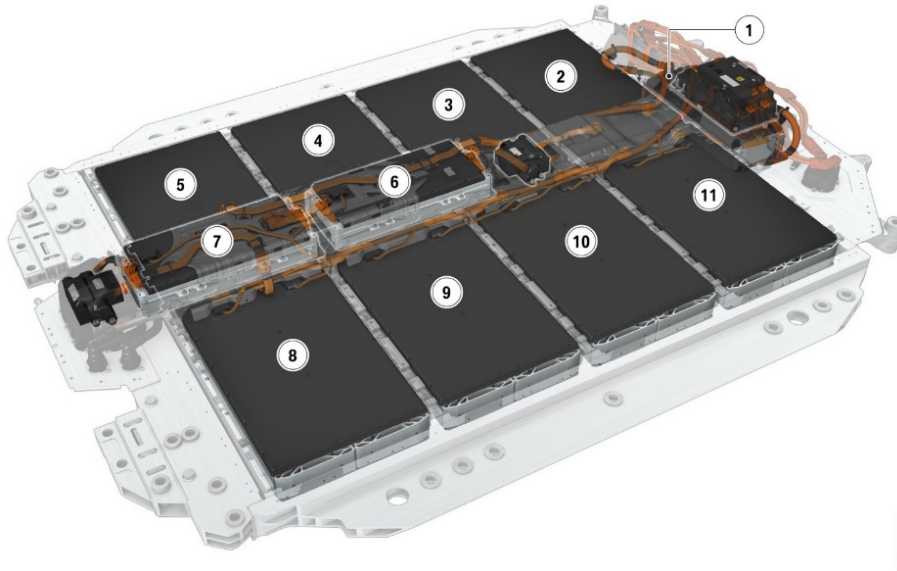
High-voltage battery unit discharged to a defined state of charge (SOC) ABL.

Note:

The High-voltage battery unit discharged to a defined state of charge (ABL) service function is ONLY available if the high-voltage battery temperature is between 15°C and 35°C (59 to 95 F).

- Replace the defective high-voltage cell modules using repair instructions **61 27 703** to **61 27 877** depending on the affected cell module location.

G26 BEV SE27 HB Battery module locations shown below-



PARTS INFORMATION

Only use and invoice the applicable part listed number below.

G26 BEV

Part Number	Description	Quantity
61 27 9454253	Multi-purpose bolt (M12X1.5X45)	14
61 25 8833851	Hexagon bolt (M12x5x130)	2
61 25 8833846	Hexagon bolt (5x105)	6
07 14 6884435	ASA Multi-purpose bolt (M10x35)	4
33 32 6760340	Torx bolt with washer (M12x127-10.9)	4
33 30 6861221	Torx bolt (ISA M12x35- 10.9)	10
61 27 9884703	Gasket	1
07 14 8860492	Screw (M5)	82
07 14 8838288	Sealing screw (M8x28)	20
61 27 9454854	Screw	as needed (max 63)
61 27 8677639	Screw (M6x18)	as needed (max. 22)
39 10 6865725	Multi-purpose bolt	4
07 14 8835104	Multi-purpose bolt (M12x1.5x72-10.9)	4
07 14 6899140	Cage nut (M12x1.5-10- ZNS3)	4
depending on the availability		
61 27 8847350	Cell module, high-voltage battery	Up to 3
61 27 8847342	Double module for high-voltage battery	Up to 4
Or		
61 27 8847333	Cell module, high-voltage battery	Up to 3
61 27 8847327	Double module for high-voltage battery	Up to 4

Recalled Part Retention

Recalled parts that are removed from BMW vehicles cannot be used for resale! The recalled parts are the property of BMW NA.

Your center is responsible for the proper identification, storage and documentation of these parts. They must be held in a secure retention area until notification of claim payment is made by BMW NA through DCSnet.

The training for the return process has not changed for Gen 5.

Aftersales Business Development (ABD) Bulletin #: C-2-0322-0301- Required training information for returning defective high-voltage batteries.

The return process information bulletin for Gen 5 high-voltage battery cell modules is different from previous generation modules.

The new updated return process information bulletin for Gen 5 is **NOT yet** available.

This bulletin will be updated when the return process information bulletin is finalized.

Please retain and store the recalled HV battery cell modules (as stated above) until the return process information bulletin instructions are available.

Please DO NOT return these recalled HV battery modules directly to the WPRC.

Please refer to the following document for the procedure that applies to returning these Recalled HV Battery Modules:

- **Bulletin #: C-2-0407-0603_HV-Battery_Recall_Return_Process**

And, for the latest related training, refer to:

- **Bulletin #: B-2-0322-0301_HV-Battery_Recall_Training**

For more information refer to CenterNet: "Menu>BMW>Aftersales>Business Development & Marketing Portal>Batteries>HV Training Module".

CLAIM INFORMATION

Reimbursement for this Recall will be via normal claim entry utilizing the relevant work package, the additional work labor operation for the applicable FRU allowance and the part numbers listed above that apply.

Plus work (+)	The vehicle is already in the workshop
Main work	The vehicle arrives for this Recall, no other Main work will be performed/ claimed during this workshop visit

Defect Code:	0061970600	G26 BEV Replacing high-voltage battery cell module
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Refer to the below for the corresponding flat rate unit (FRU) allowances.

Work Pkg	Labor Operation	Description	Labor Allowance
#1	00 72 880	Removing and installing high-voltage battery unit, and removing/installing lid for high-voltage battery unit (Includes 61 27 900 - High-voltage battery unit final test, draining and topping up the coolant circuit) (Plus work)	109 FRU

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Or:			
#2	00 72 299	Removing and installing high-voltage battery unit and removing/installing lid for high-voltage battery unit (Includes 61 27 900 - High-voltage battery unit final test, draining and topping up the coolant circuit) (Main work)	111 FRU

Only one of the flat rate labor operation codes listed above can be used for claim submission and reimbursement. Also, only one Main work flat rate labor operation code can be claimed per workshop visit.

Additional Work with Labor Operation 00 72 880 (WP 1) or 00 72 299 (WP 2)

Note: Claim labor operation 00 72 300 one-time only for the applicable total FRU allowance that applies. Itemize the total work time (WT) FRU allowed claimed on the RO and in the claim comments.

Work time labor operation code 00 72 300 is not considered a Main labor operation.

Labor Operation	Labor Description	Labor Allowance
00 72 300	Only when the test module “High-voltage battery unit: Read out stored serial numbers” is not available: Please submit a TSARA case titled “Gen 5 HV Battery cell module ID process” for assistance. Perform a Vehicle Test (Includes 00 00 556/61 21 528) and run the HV battery discharge procedure	6 FRU

Then, after the test module becomes available

Labor Operation	Labor Description	Labor Allowance
00 72 300	Perform the cell module read out test plan in ISTA to determine the serial numbers and locations of the high-voltage cell modules affected by this Recall (Includes 00 00 556/61 21 528) and run the HV battery discharge procedure	6 FRU

And, as instructed above:

A. 00 72 300 – Replacing Single Cell Module 1

Labor Description	Labor Allowance
Replacing cell module 1	12 FRU

Or:

B. 00 72 300 – Replacing Single Cell Modules 6 and/or 7

Labor Description	Labor Allowance
Replacing cell module 6	14 FRU
Or:	
Replacing cell module 7	14 FRU

Or:

C. 00 72 300 – Replacing Single Cell Modules (1, 6 and/or 7)

Labor Description	Labor Allowance
A and B - 2 single cell modules (1 and 6 or 7)	26 FRU
B only - 2 single cell modules (6 and 7)	28 FRU
A and B for 3 cell modules (1, 6 and 7)	40 FRU

Or:

D. 00 72 300 – Replacing Dual-Cell Modules 2, 3, 4, 5 (Includes cell modules 6 and 7)

Only One (1) Dual-Cell Module (with A when applicable)

Labor Description (Labor Allowance	With Cell Module 1 (A)
Replacing dual-cell module 2 (Includes cell 11)	15 FRU	27 FRU
Or:		
Replacing dual-cell module 3 (Includes cell 10)	13 FRU	25 FRU
Or:		
Replacing dual-cell module 4 (Includes cell 9)	13 FRU	25 FRU
Or:		
Replacing dual-cell module 5 (Includes cell 8)	11 FRU	23 FRU

Or:

Only Two (2) Dual-Cell Modules (with A when applicable)

Dual-cell modules (C)	2/3 (2)	2/4 (2)	2/5 (2)	3/4 (2)	3/5 (2)	4/5 (2)
2 (Includes cell 11)	15 FRU	15 FRU	15 FRU			
3 (Includes cell 10)	13 FRU			13 FRU	13 FRU	
4 (Includes cell 9)		13 FRU		13 FRU		13 FRU
5 (Includes cell 8)			11 FRU		11 FRU	11 FRU
Totals	28 FRU	28 FRU	26 FRU	26 FRU	24 FRU	24 FRU
Cell module 1 (A)	12 FRU	12 FRU	12 FRU	12 FRU	12 FRU	12 FRU
Totals with A	40 FRU	40 FRU	38 FRU	38 FRU	38 FRU	36 FRU

Or:

Only Three (3) Dual-Cell Modules (with A when applicable)

Dual-cell modules (C)	2/3/4 (3)	2/3/5 (3)	3/4/5 (3)	2/4/5 (3)	All (4)
2 (Includes cell 11)	15 FRU	15 FRU		15 FRU	15 FRU
3 (Includes cell 10)	13 FRU	13 FRU	13 FRU		13 FRU
4 (Includes cell 9)	13 FRU		13 FRU	13 FRU	13 FRU
5 (Includes cell 8)		11 FRU	11 FRU	11 FRU	11 FRU
Totals	41 FRU	39 FRU	37 FRU	39 FRU	52 FRU
Cell module 1 (A)	12 FRU	12 FRU	12 FRU	12 FRU	12 FRU
Totals with A	53 FRU	51 FRU	49 FRU	51 FRU	64 FRU

Or:

E. 00 72 300 – All Single Cell (3) and Dual-Cell (4) Modules

Labor Description	Labor Allowance
Replacing all cell modules	99 FRU

And, with any of the above:

Labor Description	Labor Allowance
Additional work with pressure test cooling system high-voltage battery unit Associated work (coolant drained) (to high-voltage battery unit)	4 FRU

Note: Claim labor operation 00 72 300 one-time only for the applicable total FRU allowance that applies.

Claim Repair Comments

Only reference this SIB number, the work package (Pkg) number performed, and cell modules replaced by their reference number in the RO technician notes and the claim comments (For example: B61 14 22 WP 1, Cell modules 2, 4, 5), unless otherwise required by State law.

Sublet – Bulk Materials (RO and Claim Comments Required)

Sublet Code 4	Up to \$100.00	Reimbursement for the repair-related bulk materials (Do not use the BMW part numbers for claim submission)
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Sublet reimbursement calculation for claiming the applicable repair-related bulk materials (BMW part numbers) is at the dealer net price amount for the quantities 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

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 B01 29 16](#) for additional information.

Reimbursement of Prior Customer-Pay Repairs (TREAD Act)

Based on the issue and the age of the Affected Vehicles being addressed by this Safety Recall Campaign, a reimbursement request for a qualifying prior customer-pay repair is not likely.

However, if you do receive a reimbursement request from a customer for a prior repair that may qualify, please contact the Warranty department (include a legible copy of the invoice) through IDS by selecting Coverage, Policy, Coding Questions and Mileage Corrections. The Warranty department will review and respond to your inquiry accordingly.

FEEDBACK REGARDING THIS BULLETIN

Technical Feedback	To submit feedback for the technical topics 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

[picture_as_pdf B611422 Recall Notice\(04Oct2022\).pdf](#)

[picture_as_pdf B611422_2022-MY2022-2023-G26BEV-i20-HV-Battery-FAQ-\(04Oct2022\).pdf](#)

[picture_as_pdf B611422 C_2_0322_0301_HV_Battery_Recall_Training.pdf](#)

SAFETY RECALL NOTICE

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

RE: Recall 22V-541: High-Voltage Battery – B61 14 22

BMW AG is conducting a Voluntary Safety Recall (effective July 21, 2022) on a small number of Model Year 2022 BMW i4 Gran Coupe vehicles that were produced between November 22, 2021 and June 13, 2022.

Affected vehicles are not to be driven or charged and to be parked away from any buildings.

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.

Bulletin #: C-2-0322-0301		<input checked="" type="checkbox"/> Take Note	<input checked="" type="checkbox"/> Take Action
<input type="checkbox"/> Retail Operator	<input type="checkbox"/> Sales Pre-Owned	<input type="checkbox"/> Business Manager	<input checked="" type="checkbox"/> Parts & Accessories
<input type="checkbox"/> General Manager	<input type="checkbox"/> Sales New Car	<input checked="" type="checkbox"/> Service	<input type="checkbox"/> Administration
Name: Cesar Ortiz		Phone Number: 201-571-5143	
Title: Hazardous Materials Training for HV Battery Recall		Source: Aftersales Business Development & Technical Service	
Date: 03.8.2022		Supersedes: B-2-0321-0301	



HAZARDOUS MATERIALS TRAINING FOR HV BATTERY RECALLS

TAKE NOTE

- RECALL 20V-601, (B61 23 20) & (B61 21 20) and RECALL 20V-490 (B61 17 20); HIGH-VOLTAGE BATTERY RECALL will be referred to in this document as HV Battery Recalls. HV Battery Recalls require Centers to ship dangerous goods/hazardous materials (DG/HM).
- Center employees preparing shipments of recalled battery modules must be trained in accordance with US DOT Hazardous Materials Regulations (HMR).
- Training materials are attached to DCS Message & will be hosted in CenterNet after DCS expires. For DGIS subscribers, the materials can also be accessed on the DGIS Homepage. Training content includes general, safety and security awareness as well as function-specific material that references battery modules and packaging applicable to HV Battery Recalls.
- A training acknowledgement letter will be used to communicate to BMW the names of the employee(s) who complete this training. **ITAP**, the HV recall battery recovery services provider, will request a copy of this letter before arranging Center shipments.
- **Recalled parts that are removed from BMW vehicles cannot be used for resale! The recalled parts are the property of BMW NA.** Your Center is responsible for the proper identification, storage, and documentation of these parts. They must be held in a secure retention area until notification of claim payment is made by BMW NA through DCSnet.

TAKE ACTION

- Have designated DG/HM employee(s) review training materials and complete included test.
- Using included answer key, grade test(s) to confirm employee understands how to perform the functions outlined in training materials.
- Complete one training acknowledgement letter with the names of each employee who successfully completed training and return to the BMW Dealer Services Group via IDS Parts Logistics US>Returns/Claims/Quality>Other prior to initiating recall shipments.

DETAILS

RECALL:

High voltage battery modules are classified as damaged, defective, or recalled (DDR) lithium-ion batteries. Shipments of recalled batteries require special packaging, and employees preparing packages must have applicable regulatory compliance training.

KEY REMINDERS:

Acknowledgement letter must be returned to BMW before battery shipments can be initiated.

LEGAL REQUIREMENTS:

Certain legal requirements must be fulfilled to tender hazardous materials for transportation. These requirements include, but are not limited to:

- Centers must have *at least* one hazmat employee trained according to US DOT regulations ([49 CFR, Part 172, Subpart H](#)) to prepare recalled battery shipments.
- Lithium ion batteries must be packaged, marked, labeled, and documented in accordance with applicable requirements of [49CFR, Parts 100-185, the Hazardous Materials Regulations](#). This information can be found in above referenced training and supplemented by instructional documents provided by ITAP.
- A separate communication will provide packaging and reverse logistics details. ITAP will provide module packaging kits and guidance for assembling and closing the packages. ITAP will also coordinate reverse logistics to their recovery location.
- ITAP will provide hazmat shipping papers to Centers once modules are packaged and prepared for shipment.
 - **DO NOT USE DGIS** to create hazmat shipping papers.
 - US DOT regulations require all **hazmat shipping papers** (e.g. bills of lading/BOLs) to be **retained** and accessible **for two years** after the date of shipment (49 CFR 172.201(e)).
- Emergency response phone number and information will also be provided by ITAP for module shipments.
- The Center is exclusively responsible for ensuring compliance with all current US DOT hazardous materials transportation regulations (49CFR, Parts 100-185).
- The Center will be responsible for all fines or penalties resulting from improper shipment of hazardous material to ITAP.

PREREQUISITE FOR HV BATTERY RECALL SHIPMENTS:

- Centers are required to submit acknowledgement of completion of DDR lithium battery training to BMW before shipping any recalled modules.
- **Acknowledgement letter** must be scanned and sent to the Dealer Services Group via **IDS Parts Logistics US>Returns/Claims/Quality>Other**
- Centers are required to submit their training acknowledgement form to ITAP when scheduling their first pickup.

MORE QUESTIONS?

Training files are hosted in CenterNet Via:

Menu>BMW>Aftersales>Business Development & Marketing Portal>Batteries>HV Training Module

Aftersales Business Development Contacts:

Name	Phone	Email	Title
Cesar Ortiz	201-571-5143	Cesar.S.Ortiz@bmwna.com	Chemical & Battery Program Manager
Jimmy Cox	201-307-4324	James.JC.Cox@bmwna.com	Chemical, Battery & Oil Program Sales Manager
Joachim Pusch	201-546-4635	Joachim.Pusch@bmwna.com	Aftersales Business Development Manager – Service and Parts

**Safety Recall 22V-541
High-Voltage Battery
Model Year 2022-2023
BMW iX, i4
Issue Date: 10/04/2022**

- Q1. Which BMW Group models in the US are potentially affected by this Safety Recall?**
A small number of Model Year 2022-2023 BMW iX and i4 models in the US, produced between November 2021 and June 2022, are potentially affected.
- Q2. What is the specific issue?**
The high-voltage battery manufacturer may not have produced the battery to specifications. As a result, a short-circuit could occur and lead to a thermal event.
- Q3. Why are other models / vehicles not included in this Safety Recall?**
Other models have been manufactured with a high-voltage battery that has been produced to specifications.
- Q4. How did BMW Group become aware of the issue?**
BMW Group became aware of the issue through our quality control procedures.
- Q5. Can I continue to drive my vehicle?**
No, please do not drive your vehicle until it is repaired.
- Q6. Can I charge my vehicle?**
No, please do not charge your vehicle until it is repaired.
- Q7. Should I park my vehicle outside and away from structures?**
Yes, please park your vehicle outside and away from structures.
- Q8. How will I be informed of this Safety Recall?**
Potentially affected customers are being contacted by phone and email, and arrangements are being made for the Safety Recall to be performed. Alternate transportation will be accommodated. You can locate your nearest authorized BMW center at www.bmwusa.com/dealer
- To ensure BMW has the most up-to-date contact and vehicle information, owners should register their vehicle at www.bmwusa.com/myBMW. Registration is free and will give them access to other information specific for their BMW vehicle.
- Q9. How and when will my vehicle be repaired?**
The affected battery cell modules will be replaced. Owners will be notified again as soon as the remedy is available.



SIB 61 15 22

2022-10-04

RECALL 22V-541: HIGH-VOLTAGE BATTERY

This Service Information Bulletin (Revision 1) replaces SI B61 15 22 dated July, 2022.

What's New:

- Entire Bulletin except Affected Vehicles and Situation

MODEL

E-Series	Model Description	Production Date
I20	iX Sports Activity Vehicle (SAV)	December 2, 2021 – June 30, 2022

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), ISPA Next or Warranty Vehicle Inquiry.

BMW AG is conducting a Voluntary Safety Recall (effective July 21, 2022) on a small number of Model Year 2022 - 2023 BMW iX SAV vehicles that were produced between December 2, 2021, and June 30, 2022.

Affected vehicles are not to be driven or charged and to be parked away from any buildings.

SITUATION

During supplier production, the high-voltage battery may not have been produced to specifications. A short-circuit could occur which could lead to a thermal event. The affected high-voltage battery cell module will be replaced.

We will be turning VINs green “Remedy Available” based on parts availability. The BMW Customer Relations department will contact the appropriate dealer to have them place a Recall IDS ticket for the parts for a specific vehicle. Then Customer Relations will assist in scheduling an appointment based on the arrival of the parts. **It is essential that the allotted IDS part goes to the assigned vehicle.**

CAUSE

Some high-voltage battery modules may not have been produced to specifications.

CORRECTION

Removal and replacement of affected high-voltage cell modules.

PROCEDURE**Important Warning for Working on the High-Voltage (HV) systems on BMW Group vehicles:**

Only properly trained personnel, who passed all applicable HV Technical Training Courses, should perform repairs which require disconnecting, or removal of High Voltage battery components on any Hybrid or Electric Vehicle. Work performed on High Voltage systems by unqualified persons may result in severe injury or damage to the vehicle. Additional safety information is found in Repair Instruction 61 00... “Observe safety instructions when handling electric vehicles”.

Additional Information:

Scheduled Maintenance, or Quality Certification 1 (Pre-Delivery Inspection) on Electric or Hybrid vehicles does not require HV technical training.

Prior to disconnecting, or the removal of any HV component, the HV system needs to be disabled and secured (by means of the HV Disconnect Switch) by a properly trained technician, who has a minimum HV Qualification level after completing the Technical Training Course ST1824 (Alternative Drive Part 1). Once the vehicle's HV system is disabled (the "Blitz" - lightning bolt icon displayed in instrument cluster, see below), a technician without HV Certification may remove a HV component (e.g., EH Heater, EKK Compressor, EME Control Unit, et.), except for the High Voltage Battery.



High Voltage Battery removal and rework can be performed ONLY by a HV Specialist Technician (certified by the Technical Training Course ST1825 – Alternative Drive Part 2), AND with a HV Battery Certification level corresponding to a specific Electric or Hybrid vehicle (e.g., to repair GEN4 battery of G05 PHEV, certification from Technical Training Course "ST2006 – SP44 HV Battery" is required).

Therefore, to perform this SIB 61 15 22 a GEN5 battery Certification is required from Technical Training Course "ST2205 Generation 5 High-voltage" class).

BMW recommends NOT to drive the vehicle NOR charge the high-voltage battery until all repair work below to remedy the fault has been completed.

The steps below must be followed precisely:

1. Please perform the **cell module read out** test plan in ISTA to determine the serial numbers and locations of the high-voltage cell modules installed in the vehicle.

Diagnostic path:

Vehicle management > Service function > Electric drive > High-voltage battery unit >

High-voltage battery unit: Read out stored serial numbers ABL.

The "**High-voltage battery unit: Read out stored serial numbers**" test plan has been updated to identify the high-voltage cell modules affected by this campaign and their location in the high-voltage battery.

The update will be included in ISTA version 4.38.1x, estimated availability as of October 21, 2022 (pending verification).

Note:

If the test plan is not yet available at the time of the repair Or the test plan was inconclusive in identifying the affected modules, please submit a TSARA case titled "Gen 5 HV Battery cell module ID process" for assistance.

2. The high-voltage battery must be discharged prior to removal to an average **cell voltage** of 3.51V using the ISTA test plan below, **before** the high-voltage battery is opened and the defective modules are removed.

Diagnostic path:

Vehicle management > Service function > Electric drive > High-voltage battery unit >

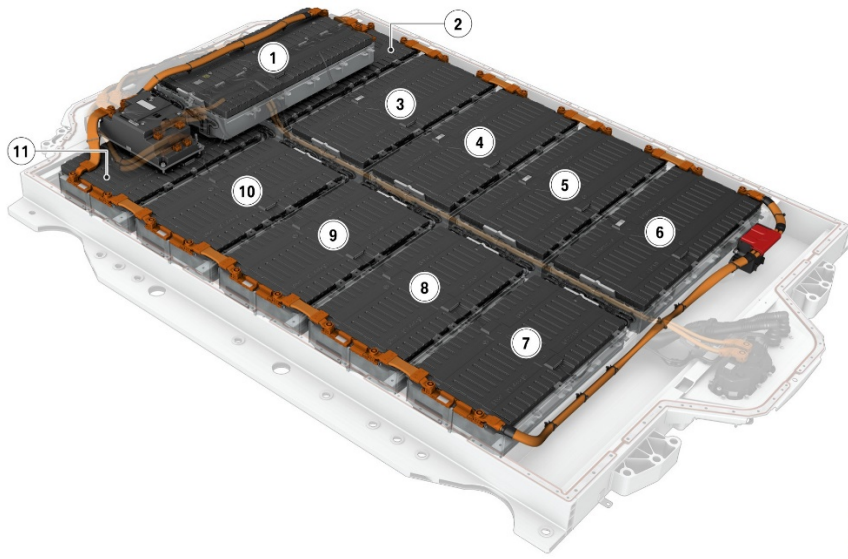
High-voltage battery unit discharged to a defined state of charge (SOC) ABL.

Note:

The High-voltage battery unit discharged to a defined state of charge (ABL) service function is ONLY available if the high-voltage battery temperature is between 15°C and 35°C (59 to 95 F).

3. Replace the defective high-voltage cell modules using repair instructions **61 27 703** to **61 27 877** depending on the affected cell module location.

I20 xDrive50/xDrive60 - SE10 HV Battery module locations shown below-



TH21-0023

PARTS INFORMATION

Only use and invoice the applicable part listed number below.

Part Number	Description	Quantity
07 14 9487466	Screw (12x1.5x50 10.9)	18
61 27 9487465	Screw (12x1.5x100 10.9)	10
31 11 6899302	Multi-purpose bolt (10x45 ZNS3)	14
61 27 9487464	Screw	8
51 16 1881149	Expanding rivet	6
61 27 9468425	Screw	94
07 14 8838288	Sealing screw (M8x28)	24 – 28 as required
61 27 9468423	Housing seal	1
61 27 9454855	Screw	As required (max16)
33 32 6775040	Hex bolt with washer (M14x1.5x148)	2
61 27 9893951	Screw (M8GFX46-10.9)	as required (max 9)
61 27 9454854	Screw	as required (max 43)
61 27 9893948	ASA combination bolt (M8x84-10.9)	as required (max 18)
Depending on the availability		
61 27 8846469	Double cell module for high-voltage battery	Up to 5
61 27 8846470	Double cell module for high-voltage battery	Up to 6
Or:		
61 27 8838260	Double cell module for high-voltage battery	Up to 5
61 27 8838259	Double cell module for high-voltage battery	Up to 6

Recalled Part Retention

Recalled parts that are removed from BMW vehicles cannot be used for resale! The recalled parts are the property of BMW NA.

Your center is responsible for the proper identification, storage and documentation of these parts. They must be held in a secure retention area until notification of claim payment is made by BMW NA through DCSnet.

The training for the return process has not changed for Gen 5.

Aftersales Business Development (ABD) Bulletin #: C-2-0322-0301- Required training information for returning defective high-voltage batteries.

The return process information bulletin for Gen 5 high-voltage battery cell modules is different from previous generation modules.

The new updated return process information bulletin for Gen 5 is **NOT yet** available.

This bulletin will be updated when the return process information bulletin is finalized.

Please retain and store the recalled HV battery cell modules (as stated above) until the return process information bulletin instructions are available.

Please DO NOT return these recalled HV battery modules directly to the WPRC.

Please refer to the following document for the procedure that applies to returning these Recalled HV Battery Modules:

- **Bulletin #: C-2-0407-0603_HV-Battery_Recall_Return_Process**

And, for the latest related training, refer to:

- **Bulletin #: B-2-0322-0301_HV-Battery_Recall_Training**

For more information refer to CenterNet: “Menu>BMW>Aftersales>Business Development & Marketing Portal>Batteries>HV Training Module”.

CLAIM INFORMATION

Reimbursement for this Recall will be via normal claim entry utilizing the relevant work package, the additional work labor operation for the applicable FRU allowance and the part numbers listed above that apply.

Plus work (+)	Completion before the first vehicle delivery to a customer or the vehicle is already in the workshop
Main work	The vehicle arrives at your center and this Recall shows open (No other Main work will be performed or claimed during this workshop visit)

Defect Code:	0061960600	I20 Replacing cell module, high-voltage battery
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Refer to the below for the corresponding flat rate unit (FRU) allowances.

Work Pkg	Labor Operation	Description	Labor Allowance
# 1	00 72 878	Removing and installing high-voltage battery unit, and removing/installing lid for high-voltage battery unit (Includes 61 27 900 - High-voltage battery unit final test, draining and topping up the coolant circuit) (Plus work)	75 FRU
Or: # 2	00 72 297	Removing and installing high-voltage battery unit, and removing/installing lid for high-voltage battery unit (Includes 61 27 900 - High-voltage battery unit final test,	76 FRU

	draining and topping up the coolant circuit) (Main work)	
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Only one of the flat rate labor operation codes listed above can be used for claim submission and reimbursement. Also, only one Main work flat rate labor operation code can be claimed per workshop visit.

Additional Work with Labor Operation 00 72 878 (WP 1) or 00 72 297 (WP 2)

Note: Claim labor operation 00 72 879 one-time only for the applicable total FRU allowance that applies. Itemize the total work time (WT) FRU allowed claimed on the RO and in the claim comments.

Labor Operation	Labor Description	Labor Allowance
00 72 879	Only when the test module “High-voltage battery unit: Read out stored serial numbers” is not available: Please submit a TSARA case titled “Gen 5 HV Battery cell module ID process” for assistance. Perform Vehicle Test (Includes 00 00 556/61 21 528) and run the HV battery discharge procedure	7 FRU

Then, after the test module becomes available

Labor Operation	Labor Description	Labor Allowance
00 72 879	Perform the cell module read out test plan in ISTA to determine the serial numbers and locations of the high-voltage cell modules affected by this Recall (Includes 00 00 556/61 21 528) and run the HV battery discharge procedure	7 FRU

And, as instructed above:

A. 00 72 879 – Cell Module 1

Labor Description	Labor Allowance
Replacing cell module 1	11 FRU

Or:

B. 00 72 879 – Cell Modules 2, 11 (Includes Cell Module 1)

Labor Description	Labor Allowance
Replacing cell module 2 (Cell module 1 removed)	7 FRU
Or:	
Replacing cell module 11 (Cell module 1 removed)	7 FRU

Or:

C. 00 72 879 – Cell Modules 3, 10

Labor Description	Labor Allowance
Replacing cell module 3	11 FRU
Or:	
Replacing cell module 10	11 FRU

And:

D. 00 72 879 – Plus Associated work for B and/or C

Labor Description	Labor Allowance
Preliminary work of removing and installing the retaining frame for cell module 1 and SME (Associated work) (Cell modules 2, 3 10 and 11) (One-time)	9 FRU

E. 00 72 300 – Replacing Cell Modules (B, C, or Both)

Labor Description	Labor Allowance	With D (9 FRU)
B only – 3 cell modules (1, 2 or 11)	14 FRU	23 FRU
C only – 2 cell modules (3 and 10)	22 FRU	31 FRU
B and C – 5 cell modules (1, 2, 3, 10 11)	36 FRU	45 FRU

Or:

F. 00 72 879 – Up to 6 Cell Modules (Up to 85 FRU)

Labor Description - Replace	Labor Allowance	Labor Description - Replace	Labor Allowance	Both
Cell module 4	14 FRU	Cell module 9	14 FRU	28 FRU
And/or:				
Cell module 5	15 FRU	Cell module 8	14 FRU	29 FRU
And/or:				
Cell module 6	14 FRU	Cell module 7	14 FRU	28 FRU

Or:

G. 00 72 879 – E and F, up to 10 Cell Modules (FRU allowance as applicable)

Or:

H. 00 72 879 – All Cell Modules (11)

Labor Description	Labor Allowance
Replacing all cell modules	104 FRU

And, with any of the above:

Labor Description	Labor Allowance
Additional work with pressure test cooling system high-voltage battery unit Associated work (coolant drained) (to high-voltage battery unit)	4 FRU

Claim Repair Comments

Only reference this SIB number, the work package (Pkg) number performed, and cell modules replaced by their reference number in the RO technician notes and the claim comments (For example: B61 15 22 WP 1, Cell modules 2, 4, 5), unless otherwise required by State law.

Sublet – Bulk Materials (RO and Claim Comments Required)

Sublet	Up to \$100.00	Reimbursement for the repair-related bulk materials (Do not use the
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Code 4	BMW part numbers for claim submission)
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Sublet reimbursement calculation for claiming the applicable repair-related bulk materials (BMW part numbers) is at the dealer net price amount for the quantities 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

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 B01 29 16](#) for additional information.

Reimbursement of Prior Customer-Pay Repairs (TREAD Act)

Based on the issue and the age of the Affected Vehicles being addressed by this Safety Recall Campaign, a reimbursement request for a qualifying prior customer-pay repair is not likely.

However, if you do receive a reimbursement request from a customer for a prior repair that may qualify, please contact the Warranty department (include a legible copy of the invoice) through IDS by selecting Coverage, Policy, Coding Questions and Mileage Corrections. The Warranty department will review and respond to your inquiry accordingly.

FEEDBACK REGARDING THIS BULLETIN

Technical Feedback	To submit feedback for the technical topics 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

[picture_as_pdf B611522 Recall Notice.pdf](#)

[picture_as_pdf B611522_2022-MY2022-2023-G26BEV-i20-HV-Battery-FAQ-\(21Jul2022\).pdf](#)

[picture_as_pdf B611522 C_2_0322_0301_HV_Battery_Recall_Training.pdf](#)

SAFETY RECALL NOTICE

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

RE: Recall 22V-541: High-Voltage Battery – B61 15 22

BMW AG is conducting a Voluntary Safety Recall (effective July 21, 2022) on a small number of Model Year 2022 - 2023 BMW iX SAV vehicles that were produced between December 2, 2021 and June 30, 2022.

Affected vehicles are not to be driven or charged and to be parked away from any buildings.

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.

Bulletin #: C-2-0322-0301		<input checked="" type="checkbox"/> Take Note	<input checked="" type="checkbox"/> Take Action
<input type="checkbox"/> Retail Operator	<input type="checkbox"/> Sales Pre-Owned	<input type="checkbox"/> Business Manager	<input checked="" type="checkbox"/> Parts & Accessories
<input type="checkbox"/> General Manager	<input type="checkbox"/> Sales New Car	<input checked="" type="checkbox"/> Service	<input type="checkbox"/> Administration
Name: Cesar Ortiz		Phone Number: 201-571-5143	
Title: Hazardous Materials Training for HV Battery Recall		Source: Aftersales Business Development & Technical Service	
Date: 03.8.2022		Supersedes: B-2-0321-0301	



HAZARDOUS MATERIALS TRAINING FOR HV BATTERY RECALLS

TAKE NOTE

- RECALL 20V-601, (B61 23 20) & (B61 21 20) and RECALL 20V-490 (B61 17 20); HIGH-VOLTAGE BATTERY RECALL will be referred to in this document as HV Battery Recalls. HV Battery Recalls require Centers to ship dangerous goods/hazardous materials (DG/HM).
- Center employees preparing shipments of recalled battery modules must be trained in accordance with US DOT Hazardous Materials Regulations (HMR).
- Training materials are attached to DCS Message & will be hosted in CenterNet after DCS expires. For DGIS subscribers, the materials can also be accessed on the DGIS Homepage. Training content includes general, safety and security awareness as well as function-specific material that references battery modules and packaging applicable to HV Battery Recalls.
- A training acknowledgement letter will be used to communicate to BMW the names of the employee(s) who complete this training. **ITAP**, the HV recall battery recovery services provider, will request a copy of this letter before arranging Center shipments.
- **Recalled parts that are removed from BMW vehicles cannot be used for resale! The recalled parts are the property of BMW NA.** Your Center is responsible for the proper identification, storage, and documentation of these parts. They must be held in a secure retention area until notification of claim payment is made by BMW NA through DCSnet.

TAKE ACTION

- Have designated DG/HM employee(s) review training materials and complete included test.
- Using included answer key, grade test(s) to confirm employee understands how to perform the functions outlined in training materials.
- Complete one training acknowledgement letter with the names of each employee who successfully completed training and return to the BMW Dealer Services Group via IDS Parts Logistics US>Returns/Claims/Quality>Other prior to initiating recall shipments.

DETAILS

RECALL:

High voltage battery modules are classified as damaged, defective, or recalled (DDR) lithium-ion batteries. Shipments of recalled batteries require special packaging, and employees preparing packages must have applicable regulatory compliance training.

KEY REMINDERS:

Acknowledgement letter must be returned to BMW before battery shipments can be initiated.

LEGAL REQUIREMENTS:

Certain legal requirements must be fulfilled to tender hazardous materials for transportation. These requirements include, but are not limited to:

- Centers must have *at least* one hazmat employee trained according to US DOT regulations ([49 CFR, Part 172, Subpart H](#)) to prepare recalled battery shipments.
- Lithium ion batteries must be packaged, marked, labeled, and documented in accordance with applicable requirements of [49CFR, Parts 100-185, the Hazardous Materials Regulations](#). This information can be found in above referenced training and supplemented by instructional documents provided by ITAP.
- A separate communication will provide packaging and reverse logistics details. ITAP will provide module packaging kits and guidance for assembling and closing the packages. ITAP will also coordinate reverse logistics to their recovery location.
- ITAP will provide hazmat shipping papers to Centers once modules are packaged and prepared for shipment.
 - **DO NOT USE DGIS** to create hazmat shipping papers.
 - US DOT regulations require all **hazmat shipping papers** (e.g. bills of lading/BOLs) to be **retained** and accessible **for two years** after the date of shipment (49 CFR 172.201(e)).
- Emergency response phone number and information will also be provided by ITAP for module shipments.
- The Center is exclusively responsible for ensuring compliance with all current US DOT hazardous materials transportation regulations (49CFR, Parts 100-185).
- The Center will be responsible for all fines or penalties resulting from improper shipment of hazardous material to ITAP.

PREREQUISITE FOR HV BATTERY RECALL SHIPMENTS:

- Centers are required to submit acknowledgement of completion of DDR lithium battery training to BMW before shipping any recalled modules.
- **Acknowledgement letter** must be scanned and sent to the Dealer Services Group via **IDS Parts Logistics US>Returns/Claims/Quality>Other**
- Centers are required to submit their training acknowledgement form to ITAP when scheduling their first pickup.

MORE QUESTIONS?

Training files are hosted in CenterNet Via:

Menu>BMW>Aftersales>Business Development & Marketing Portal>Batteries>HV Training Module

Aftersales Business Development Contacts:

Name	Phone	Email	Title
Cesar Ortiz	201-571-5143	Cesar.S.Ortiz@bmwna.com	Chemical & Battery Program Manager
Jimmy Cox	201-307-4324	James.JC.Cox@bmwna.com	Chemical, Battery & Oil Program Sales Manager
Joachim Pusch	201-546-4635	Joachim.Pusch@bmwna.com	Aftersales Business Development Manager – Service and Parts

**Safety Recall 22V-541
High-Voltage Battery
Model Year 2022-2023
BMW iX, i4
Issue Date: 07/21/2022**

- Q1. Which BMW Group models in the US are potentially affected by this Safety Recall?**
A small number of Model Year 2022-2023 BMW iX and i4 models in the US, produced between November 2021 and June 2022, are potentially affected.
- Q2. What is the specific issue?**
The high-voltage battery manufacturer may not have produced the battery to specifications. As a result, a short-circuit could occur and lead to a thermal event.
- Q3. Why are other models / vehicles not included in this Safety Recall?**
Other models have been manufactured with a high-voltage battery that has been produced to specifications.
- Q4. How did BMW Group become aware of the issue?**
BMW Group became aware of the issue through our quality control procedures.
- Q5. Can I continue to drive my vehicle?**
No, please do not drive your vehicle until it is repaired.
- Q6. Can I charge my vehicle?**
No, please do not charge your vehicle until it is repaired.
- Q7. Should I park my vehicle outside and away from structures?**
Yes, please park your vehicle outside and away from structures.
- Q8. How will I be informed of this Safety Recall?**
Potentially affected customers are being contacted by phone and email, and arrangements are being made for the Safety Recall to be performed. Alternate transportation will be accommodated. You can locate your nearest authorized BMW center at www.bmwusa.com/dealer
- To ensure BMW has the most up-to-date contact and vehicle information, owners should register their vehicle at www.bmwusa.com/myBMW. Registration is free and will give them access to other information specific for their BMW vehicle.
- Q9. How and when will my vehicle be repaired?**
The affected battery cell modules will be replaced. Owners will be notified again as soon as the remedy is available.