



MODEL

I15 (i8 Roadster)

SITUATION

The door weather strip may appear loose or misaligned at one end as seen below.



CAUSE

Insufficient adhesive used on the weather strip seal during production.

CORRECTION

Apply adhesive to the weather strip seal to align and connect the two ends.

PROCEDURE

For conditions that are similar to the situation described:

1. Clean the surface of both seals where the two will be bonded using a clean, lint free cloth. Do not use any cleaning chemicals. Ensure the mating surface of both seals are completely clean of any dust, debris, or residual wax. Prepare a strip of suitable tape, long enough to secure the seals in position while the adhesive dries.
2. Apply adhesive PN 83 19 2 232 322, using a brush. Apply a light coating of adhesive to both seals. Only apply adhesive to the mating surface of the two seals, ensuring that no adhesive overflows onto the visible portion of the seal.
3. Align the ends of the seals and secure using a strip of suitable tape while the adhesive dries. If the seal is distorted, holding the seal in place while it dries may be required. Allow 8 minutes of drying time.

PARTS INFORMATION

Part Number	Description	Quantity
83 19 2 232 322	Adhesive for profile rubber (430g)	Sublet

WARRANTY INFORMATION

Covered under the terms of the BMW New Vehicle Limited Warranty for Passenger Cars and Light Trucks.

Defect Code:	5121083700	
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Repairing One Side

Labor Operation:	Labor Allowance:	Description:
51 99 000	3 FRU	Work time to apply adhesive to driver or passenger weather strip seal (Main Work)
51 99 000	2 FRU	Work time to apply adhesive to driver or passenger weather strip seal (Plus Work)

Repairing Both Sides

Labor Operation:	Labor Allowance:	Description:
51 99 000	5 FRU	Work time to apply adhesive to both side weather strip seals (Main Work)
51 99 000	4 FRU	Work time to apply adhesive to both side weather strip seals (Plus Work)

A separate punch time and an explanation on the repair order and in the claim comments section are both required.

And, as needed:

Sublet – Bulk Materials

Sublet Code 4	Up to \$1.00	Reimbursement for the repair-related bulk materials (Do not use part numbers for claim submission)
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Sublet reimbursement calculation for claiming the repair-related bulk material (BMW part number) is at the dealer net price 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.