

**MODEL**

E-Series	Model Description
G20	3 Series Sedan

SITUATION

There is a whistling noise present from either front door while driving at speeds of 60 mph. This can occur on one or both front doors.

CAUSE

Foam acoustic seals at the A-Pillar and B-Pillar may have shrunk or shifted, causing an air leak.

CORRECTION

Reposition and seal foam using butyl sealing rope.

PROCEDURE

Note: The repair procedure listed below is available for guided step by step instructions using the TSARA vision Ubimax glasses. Scanning the QR code below with the glasses will load the available repair instructions into the glasses for use at the vehicle.

Once the device (glasses) is powered on you will see Scan Task. Say "Scan Task"
Scan the QR Code below

B51 25 20



TSARA Vision Ubimax glasses for repair instructions are in addition to, and secondary to, the repair instructions contained in this bulletin.

TSARA vision repair instructions are currently being piloted. Feedback on the guided repair instructions via TSARA glasses can be sent to Jonathan.Gannon@BMWNA.com when related to this bulletin, or through the technical inquiries feedback option at the top of this bulletin.

For those not wishing to utilize smart glasses for repair instructions, see below:

1. Remove the front door panel of the affected door following repair instructions **REP 51 41 000 “Removing and installing left or right front door trim panel”**
2. Reference the photo below to identify which foam seals will be reworked. There is one foam seal at the front of the door (towards the A-Pillar) and one at the rear of the door (B-Pillar).



3. Ensure the foam seals are fully seated flat against the door.
4. Cut two strips of butyl rope PN 83 22 2 159 535. Each strip should be cut 60mm long. One strip will be used at the B-Pillar, and one strip will be used at the A-Pillar.

Note: Any similar and available butyl 4mm in thickness can be used.

5. Apply the first strip of butyl as shown below to the B-Pillar side, sealing around the foam and into the window channel.



6. Flatten and smooth the butyl as shown below:



7. Apply the second strip of butyl in a similar orientation to the foam seal at the front of the door (A-Pillar side):



8. Flatten and smooth the butyl as shown below:



9. Reassemble the vehicle and retest to ensure noise is no longer present.

PARTS INFORMATION

Part Number	Description	Quantity
83 22 2 159 535	Butyl cord (D=4 mm, L=10 m)	As needed

WARRANTY INFORMATION

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

Defect Code:	5121083200	Inner front window cavity seal deformed / warped
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One door is making noise-

Labor Operation	Description	Labor Allowance
51 41 000	Removing and installing left of right front door trim panel (Main work)	Refer to AIR
Or:		
51 41 503	Removing and installing left of right front door trim panel (Plus work)	Refer to AIR
And:		
51 99 000	Job/repair work time to insulate foam seals (One side)	3 FRU

If you are using a Main labor code for another repair, use the Plus code labor operation 51 41 503 instead of 51 41 000.

Or:

Both front doors are making noise-

Labor Operation	Description	Labor Allowance
51 41 002	Removing and installing both front door trim panels (Main work)	Refer to AIR
Or:		
51 41 505	Removing and installing both front door trim panels (Plus work)	Refer to AIR
And:		
51 99 000	Job/repair work time to insulate foam seals (Both sides)	5 FRU

If you are using a Main labor code for another repair, use the Plus code labor operation 51 41 505 instead of 51 41 002.

Refer to AIR for the corresponding flat rate unit (FRU) allowances.

As applicable to your center, please refer to [SI B01 01 20](#) or [B01 07 20](#) for claiming your diagnosis work time, job/repair work time (WT), WT and the repair-related explanation procedures.

And, as needed:

Sublet – Bulk Materials (RO and Claim Comments Required)

Sublet Code 4	See the sublet reimbursement calculations below	Reimbursement for the repair-related bulk material (Do not use the BMW part number for claim submission)
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Sublet reimbursement calculation for claiming the applicable repair-related bulk material (BMW part number) is at the dealer net price amount for the quantity 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.

[QUESTIONS REGARDING THIS BULLETIN](#)

Technical inquiries	Submit feedback at the top of this bulletin
Warranty inquiries	Submit an IDS ticket to the Warranty Department or use the chat available in the Warranty Documentation Portal
Parts inquiries	Submit an IDS ticket to the Parts Department