

**MODEL**

E-Series	Model Description	Production Date
G20	3 Series Sedan	July 13, 2020-September 1, 2020

SITUATION

The rear window may not have been properly bonded.

CAUSE

The rear window may not have been properly bonded to the body during production.

CORRECTION

Inspect the rear window bonding, and re-bond if necessary.

PROCEDURE

The following procedure requires 2 people:

- 1 person uses an air blow gun from the outside of the vehicle
- 2nd person inside the vehicle uses a sheet of paper to check for air entry causing movement, indicating a leak

1. Using an air blow gun (# 1 below), blow air along the perimeter of the back window (aka rear windshield) towards the inside of the vehicle. Ensure the entire perimeter of the window is checked.



2. While air is being blown around the perimeter, person 2 follows along from the inside of the vehicle, moving along the back window perimeter with a piece of paper (#2 above). Movement of the paper caused by air entry indicates a leakage.

Was air leakage present?

Yes: Continue to step 3.

No: No further correction is required.

3. Re-bond the rear window following repair instructions **REP 51 31 200 “Removing and installing rear window”**.

PARTS INFORMATION

Parts are only required if the vehicle fails the air leakage test (Work package #2 or #4)

Part Number	Description	Quantity
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83 19 2 289 180	Windshield adhesive kit	*1 if necessary
51 31 7 288 462	Buffer	11 if necessary

*If more the one vehicle is repaired during the same workshop visit, claim PN 83 19 2 289 180 only one time with only one of the claim submissions. The tube contains enough sealant to repair two or more vehicles.

WARRANTY INFORMATION

Reimbursement for this Service Action will be via normal claim entry utilizing the applicable work package information below, and when required, the part numbers listed above:

Defect Code:	0051120500	Checking the rear window, reworking if necessary
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Completion before the first vehicle delivery to a customer or the vehicle is already in the workshop-

Work Pkg	Labor Operation	Description (Plus work)	Labor Allowance
# 1	00 69 963	Checking the rear window for leak-tightness (No repair is necessary)	5 FRU
Or:			
# 2	00 69 964	Checking the rear window for tightness and re-bonding the rear window	22 FRU

Or:

The vehicle arrives at your center and this Recall shows open (No other main work will be performed or claimed during this workshop visit)-

Work Pkg	Labor Operation	Description (Main work)	Labor Allowance
# 3	00 69 405	Checking the rear window for leak-tightness (No repair is necessary)	7 FRU
Or:			
# 4	00 69 406	Checking the rear window for tightness and re-bonding the rear window	24 FRU

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

Claim Repair Comments

Only reference the SIB number and the work package (Pkg) number performed in the RO technician notes and the claim comments (For example: B51 26 20 WP 1), unless otherwise required by State law.

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