



DELIVERY STOP: REWORK TAIL LIGHTS

This Service Information bulletin replaces SI B63 01 19 dated April 2019.

New information provided by this revision is preceded by this symbol.

What's New:

Repair procedure changed for F30 & F80

Parts information added for F30 & F80

Warranty information added for F30 & F80

Model

F22 (2 Series Coupe)	F23 (2 Series Convertible)	F30 (3 Series Sedan)	F31 (3 Series Sports Wagon)
F34 (3 Series Gran Turismo)	F39 (X2 Sports Activity Coupe)	F80 (M3 Sedan)	F87 (M2 Coupe)
G01 (X3 Sports Activity Vehicle)	G12 (7 Series Sedan, including ALPINA)		

Situation

The tail light mounting brackets may be cracked or broken.

Affected Vehicles

This delivery stop involves 11,792 F22, F23, F30, F31, F34, F39, F80, F87, G01, and G12s produced from October, 2018 to February, 2019.

Vehicles which require this campaign to be completed will show it as "Open" when checked either in AIR, the "Service Menu" of DCSnet (Dealer Communication System) or with the Key Reader.

Cause

During assembly, oil may have contaminated the plastic housing of the rear tail lamps, causing damage to the mounting points of the tail light assembly.

Correction

Inspect the rear tail light assemblies for signs of oil or cracking. Vehicles that pass the visual inspection process require no further correction.

Vehicles that do not pass the visual inspection will require tail light replacement or repair and cleaning of the vehicle body.

Effective immediately – Taking Photos and emailing them to BMW is no longer required.

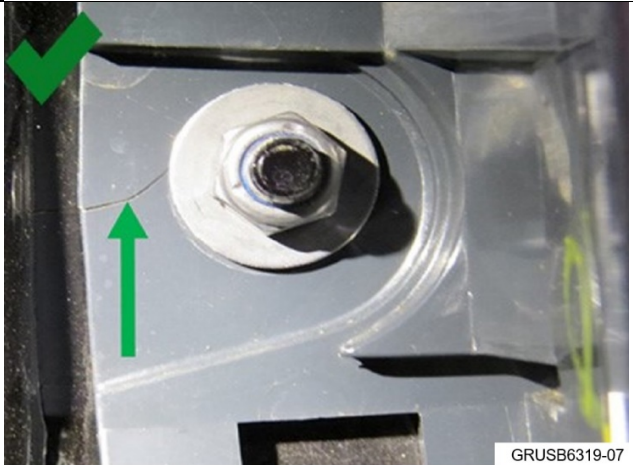
Procedure

1. Reference the specific repair instructions for your model in ISTA/AIR on how to remove the tail light trim panel to inspect the mounting nuts of the tail light.	
Note: Both tail lights require inspection.	
Warning: DO NOT YET REMOVE THE MOUNTING NUTS OF THE TAIL LIGHT. THE TAIL LIGHTS WILL BE INSPECTED VISUALLY WITHOUT REMOVAL OF THE MOUNTING NUTS.	
	2. Visually inspect the mounting area of the tail light as shown to the left. Different models may appear slightly different, but all models will be inspected in the same general location of the mounting tabs. Note: F22 and F23 tail lights are visually different than shown in the photos. The inspection procedure remains the same and

can be completed without removing the tail light.



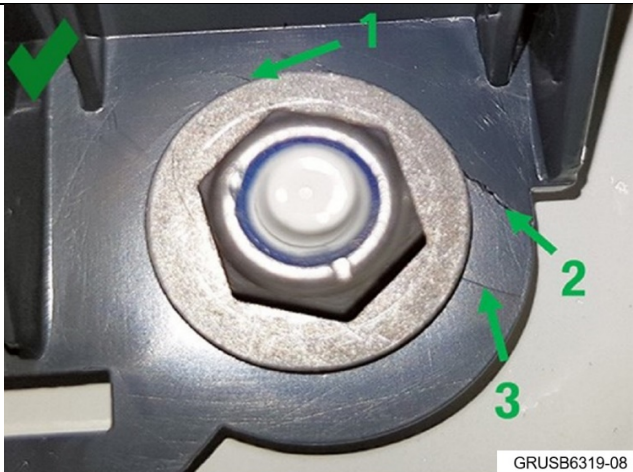
GRUSB6319-01



GRUSB6319-07

3. Reference the photos shown to the left, which demonstrate **acceptable** cracking and which require no further correction.

Single cracks are acceptable.



GRUSB6319-08

Description of picture:

1 – small crack, not circulating, no net of cracks, **OK**

2 – small crack, not circulating, no net of cracks, **OK**

3 – weld line, **OK**

Attention: the position of the weld line can vary from model to model



GRUSB6319-09

4. Reference the photos to the left showing examples of cracks that are **NOT** acceptable and which require tail light replacement or repair.

Holder broken.

Eye broken off.



5. Does the vehicle pass the inspection, showing only acceptable cracking as shown in the step 3 examples?

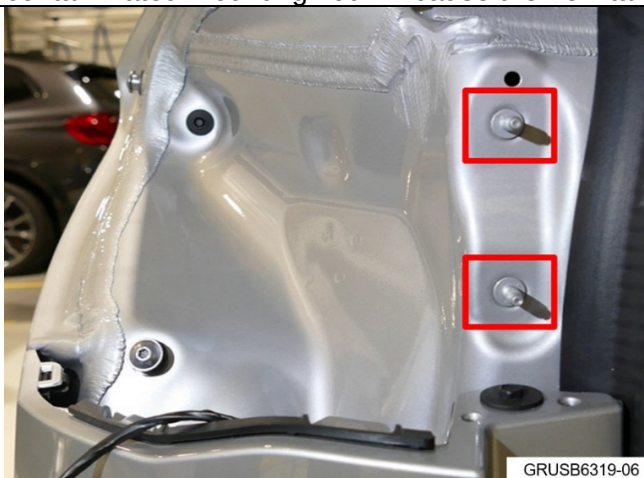
YES: No further correction is required, the vehicle can be reassembled.
NO: FOR F30/F80- Reference the attachment “B63 01 19 Repair procedure”
FOR ALL OTHER VEHICLES-
Continue to step 6.

6. Remove one or both rear lights, depending on whether one or both lights are found to be damaged following the ISTA repair instructions for the applicable model.

Note: It is possible that only one light may be damaged and require replacement or repair. Do not remove a tail light that does not fail the visual inspection procedure.

7. Immediately dispose of the removed tail light mounting nuts so that they cannot be reused.

Warning: The tail light mounting nuts are contaminated and can **NOT** be reused. Reusing a contaminated mounting nut will cause the new tail light to fail.



8. With the damaged rear light removed from the vehicle, the tail light mounting studs and vehicle body **MUST** be cleaned to remove residual manufacturing oil.

Using an 80% ethanol/20% water mixture on a clean cloth, clean the mounting studs and body area shown to the left.

Warning: 80% Ethanol/ 20% water is the only suitable cleaning solution that is safe for the vehicle body and tail lights. Do **NOT** use any alternative cleaning solution.

Ethanol can be locally sourced in the form of denatured alcohol.

Using any other cleaning solution will cause damage to the vehicle.

9. Once the vehicle body has completely dried, install a new or repaired tail light on the affected side(s). **Replace all of the tail light mounting nuts with new nuts.** The tail light mounting nuts **MUST BE REPLACED** if they were removed to replace or repair a tail light.

10. Completely reassemble the vehicle.

Parts Information

Only replace or repair the tail light assemblies if required after inspection.

Not all vehicles require tail light replacement or repair. Please refer to the Parts Matrix for the ordering procedure.

Part Number	Description	Quantity
If required:		
64 50 9 123 157	Self-locking Hex-nut	2 or 4
Refer to ETK	Rear light in the side panel, left	1 if needed
And/Or:		
Refer to ETK	Rear light in the side panel, right	1 if needed
And:		

NPN	Denatured alcohol (Ethanol-Local Purchase)	Sublet as needed
For G12 only:		
Refer to ETK	Left rear molding for tail light	1
Refer to ETK	Right rear molding for tail light	1
For F30/F80 only if applicable:		
63 21 2 472 169	Repair kit for tail light F30/F80 (Enough for 1 complete vehicle/both sides) (Kit includes 4 self-locking hex nuts)	1 if needed
83 19 2 211 217	Solvent cleaner R1 (100 ml) (for use with the Adhesive set)	Sublet as needed
83 19 2 317 925	Adhesive set K6 (use the Adhesive 11 ml and two nozzles only)	Sublet as needed
83 19 2 336 502	Replacement mixing nozzles K6 adhesive set (10 pack)	Sublet as needed up to 2 nozzles per vehicle

Warranty Information

Refer to Attachment.

Defect code: 0063580100

Note: Claims with repair dates on or after April 29, 2019 that contain the additional labor operation (00 67 795) for taking photos and emailing them to BMW will not be accepted.

Supporting Materials

[picture as pdf B63 01 19 Repair procedure.pdf](#)

[picture as pdf B630119 Attachment Warranty Information.pdf](#)