

Bulletin #: C-00-0316-0005		<input checked="" type="checkbox"/> Take Note	<input type="checkbox"/> Take Action
<input type="checkbox"/> Retail Operator	<input type="checkbox"/> Sales Pre-Owned	<input checked="" type="checkbox"/> Business Manager	<input checked="" type="checkbox"/> Parts & Accessories
<input checked="" type="checkbox"/> General Manager	<input type="checkbox"/> Sales New Car	<input type="checkbox"/> Service	<input type="checkbox"/> Administration
Name: Jonathan Inzano		Phone Number: 949-630-5725	
Title: National Collision Program Manager		Source: Aftersales Business Development	
Date: 03/16/2023		Supersedes: --	



The **Ultimate**
Driving Machine®

ALUMINUM PARTS RESTRICTIONS

TAKE NOTE

Due to complexity of repair and the requirement of highly specialized tools, training, & repair procedures, BMW of North America will restrict the provision of certain aluminum structural parts to those collision centers that successfully complete specific training requirements and who possess the required tooling pertaining to the repair.

MORE DETAILS

Repairs involving the aluminum structure require highly specialized training and tooling. As a result, BMW of North America will be restricting certain aluminum structural parts to ensure the correct repair process is followed and crash performance is not compromised.

BMW Group Body & Paint training requirements

Course Code	Course Name	Notes
OL5510	Bonding & Riveting Techniques	Online Course
SB061	Aluminum Structural Repair	Instructor-Led
OR		
SB026E	BMW Group Body Repair Level 2 & 3	Sunset course

Take note: SB026E has been sunset and is an equivalency. Prerequisites may be required for certain training courses. Any approved BMW Group B&P training equivalencies are accepted.

Overall tooling requirements

Part Number	Part Name	Notes
Non-BMW tool	Approved Frame Bench	Celette, Car-O-Liner, Car Bench
Non-BMW tool	Belt Sander	Electric only
Non-BMW tool	Glue Cartridge Gun	With speed regulator
81 43 0 301 744	Gesipa Powerbird Riveting Tool	
81 43 2 158 706	Power Bird Head Extension	May be required on certain repairs
81 43 0 301 742	BSP-03 Stud Welder	
83 30 5 A56 089	Punch Rivet Tool XT2	
83 30 2 355 732	Rivet Adapter Set	For Punch Rivet Tool XT2
Required for i20 (BMW iX) aluminum rocker structure		
Non-BMW tool	Fein Supercut Oscillating Tool	
81 43 5 A4D E59	Saw Blade	For Fein Supercut Oscillating Tool
81 43 5 A22 339	Starlock Adapter	For Fein Supercut Oscillating Tool
81 43 5 A0B 392	Depth Stop Guide	

Take note: Supplied BMW part numbers are recommended. A supplier-provided tool is accepted as an alternative considering there are no mechanical variations compared to the requirement.

Structural aluminum restricted parts reference list

Series / Chassis	Part name	Part number	Series / Chassis	Part name	Part number
8' & M8 / F9x G1x			i3 / I01		
	Frame rail, engine support front left	41 00 7359395		Front axle module	39 20 6872731
	Frame rail, engine support front right	41 00 7359396		Wheel house front left	39 20 6867911
	Spring support left	41 00 7329873		Wheel house front right	39 20 6867912
	Spring support right	41 00 7329874		Side member, front left	39 20 6867909
	Rear left wheelhouse	41 00 7499111		Side member, front right	39 20 6867910
	Rear right wheelhouse	41 00 7499112		Wheel house strut, front left	41 00 7361763
	Rear left wheelhouse	41 00 7499115		Wheel house strut, front right	41 00 7361764
	Rear right wheelhouse	41 00 7499116		Rear axle module	39 20 6872732
	Wheel house front left	41 00 7446651	i8 / I12 I15		
	Wheel arch w/o VIN front right	41 00 7446652		Front axle module	39 10 8836246
	Wheel arch w/ VIN front right	41 00 2456303		Trunk floor	41 00 7370344
	Wheel arch, carry support w/ VIN front right	41 00 2433159		Tail trim	41 00 7434490
	Wheel arch, carry support w/o VIN front right	41 00 7446654		Rear end	41 00 7488283
	Rear side member left	41 00 7381815		Rear axle module	41 10 2973445
	Rear side member right	41 00 7381816		Front axle module	39 10 8836246
	Rear side member left	41 00 7443883	iX / I20		
	Rear side member right	41 00 7443884		Body carcass with panorama roof	41 00 9633236
	Wheel house rear left	41 00 7499111		Engine support right without VIN	41 00 9880896
	Wheel house rear right	41 00 7499112		Engine support left	41 00 9880895
	Wheel house rear left	41 00 7499115		Engine support with VIN	41 00 9633342
	Wheel house rear right	41 00 7499116		Strut tower, front left	41 00 9880899
	Wheel house rear left	41 00 7428899		Strut tower, front right	41 00 9880900
	Wheel house rear right	41 00 7428900		Support strut tower top left	41 00 9880903
	Body base frame rear	41 00 7499120		Support strut tower top right	41 00 9880904
	Body base frame rear	42 00 7499121		Repair adapter strut tower front left	41 00 9880901
	Body base frame rear	41 00 7499122		Repair adapter strut tower front right	41 00 9880902
X6 & X6M / G06 F96				Repair adapter strut tower rear left	41 00 9623781
	Frame rail, engine support left	41 00 7417571		Repair adapter strut tower rear right	41 00 9623782
	Frame rail, engine support right	41 00 7417572		Holder, brake hose, front left	41 00 9880905
	Strut tower, front left	41 00 7933485		Holder, brake hose, front right	41 00 9880906
	Strut tower, front right	41 00 7933486		Repair panel carrier support bottom	41 00 9623787
	Wheel housing strut, front left	41 00 7933479		Repair panel carrier support top outer	41 00 9624947
	Wheel housing strut, front right	41 00 7933480		Repair panel carrier support top inner	41 00 9624948
	Wheel house, supporting strut exterior left	41 00 7933507		Repair element engine support	41 00 9623785
	Wheel house, supporting strut exterior right	41 00 7933508		Repair panel engine support	41 00 9627391
	Wheel house, supporting strut exterior right w/ VIN	41 00 2464639		Repair element carrier support	41 00 9623786
X7 / G07				Repair element side member	41 00 9626980
	Frame rail, engine support left	41 00 7417571		End plate side member front	41 00 9629449
	Frame rail, engine support right	41 00 7417572		Repair panel end plate side member left	41 00 9629451
	Strut tower, front left	41 00 7933485		Repair panel end plate side member right	41 00 9629452
	Strut tower, front right	41 00 7933486		Repair panel side member	41 00 9626981
	Wheel housing strut, front left	41 00 7933479		End plate side member rear	41 00 9629448
	Wheel housing strut, front right	41 00 7933480		Side member, rear	41 00 9880909
	Wheel house, supporting strut exterior left	41 00 7933507		Repair panel side member	41 00 9626979
	Wheel house, supporting strut exterior right	41 00 7933508		Trunk floor	41 00 9629397
	Wheel house, supporting strut exterior w/ VIN	41 00 2464639		Luggage compartment pan	41 00 9629381
7' / G12				Roof panel	41 00 9630944
	Frame rail, engine support left	41 00 7359395	7' / G70		
	Frame rail, engine support right	41 00 7359396		Front left wheelhouse	41 14 5A37961
	Spring support left	41 00 7329637		Wheelhousing, front right	41 14 5A37962
	Spring support right	41 00 7329638		Engine support right	41 00 7359396
	Wheel house front left	41 00 7412925		Engine support, left	41 00 7359395
	Wheel house front right	41 00 7412926		Spring support left	41 00 9481881
	Wheel house, inner half rear left	41 00 7413087		Spring support right	41 00 9481882
	Wheel house, inner half rear right (PHEV)	41 00 7413082		Covering panel for engine beam left	41 00 7412935
	Frame side member, inner left	41 00 7413031		Covering panel for engine beam right	41 00 7412936
	Frame side member, inner right	41 00 7413032		Side member, inner left	41 11 8844253
				Side member, inner right	41 11 8844254
				Rear left wheelhouse, inner half	41 14 5A37AA1
				Rear right wheelhouse, inner half	41 14 5A37AA2

Existing carbon fiber restricted parts reference list

Series / Chassis	Part name	Part number	Series / Chassis	Part name	Part number
i3 / I01			i8 / i12		
	Body skeleton with chassis number	41 00 2448812		Supporting strut, front wall	41 00 7371982
	Body-in-white	41 00 2925493		Side frame, complete, left	41 00 7371941
	Side frame, complete, left	41 00 7451589		Side frame, complete, right	41 00 7371942
	Side frame, complete, right	41 00 7451590		Side frame, exterior, left	41 00 7371937
	Side frame, exterior, left	41 00 7451585		Side frame, exterior, right	41 00 7371938
	Side frame, exterior, right	41 00 7451586		Cover, rocker panel, left	41 00 7323563
	Reinforcement, rear window frame top left	41 00 7425619		Cover, rocker panel, right	41 00 7323564
	Reinforcement, rear window frame top right	42 00 7425620		Side frame, complete, left	41 00 7371941
	End piece, rear side frame, outer left	41 00 7359013		Side frame, complete, right	41 00 7371942
	End piece, rear side frame, outer right	41 00 7359014		Left interior side frame	41 00 7371933
	End piece, rear side frame, inner left	41 00 7359015		Right interior side frame	41 00 7371934
	End piece, rear side frame, inner right	41 00 7359016		C-pillar reinforcement, left	41 00 7305935
	Left door sill	41 00 7409379		C-pillar reinforcement, right	41 00 7305936
	Right door sill	41 00 7409380		Rear window frame	41 00 7371980
	Tail trim	41 00 7266943		Connector, rear window frame, top right	41 00 7305948
	Rear left side member	41 00 7410903		Connector, rear window frame, upper left	41 00 7305947
	Right rear side member	41 00 7410904		Left side member	41 00 9631613
	Crossmember, rear upper	41 00 7416300		Right side member	41 00 9631614
	Roof cover, without sunroof	51 13 7412389		Reinforcement for side member, left	41 00 7305683
	Roof cover	51 13 7266944		Reinforcement for side member, right	41 00 7305684
	Rear window frame	41 00 7451594		Roof	51 13 7305915
i8 / I15				Upper apron	41 00 7371981
	Body skeleton with chassis number	41 00 2461952		Connector, windshield cowl, lateral, left	41 00 7305941
	Body skeleton with chassis number	41 00 2461955		Connector, windshield cowl, lateral, right	41 00 7305942
	Supporting strut, front wall	41 00 7371982		Connector, rear window frame, top right	41 00 7305948
	Side frame, complete, left	41 00 7478045		Connector, rear window frame, upper left	41 00 7305947
	Side frame, complete, right	41 00 7478044		Door front left	41 51 7312667
	Side frame, exterior, left	41 00 7477971		Door front right	41 51 7312668
	Side frame, exterior, right	41 00 7477972	7' / G12		
	Cover, rocker panel, left	41 00 7323563		Side frame, center left	41 21 9850811
	Cover, rocker panel, right	41 00 7323564		Side frame, center right	41 21 9850812
	C-pillar reinforcement, left	41 00 7305935		Reinforcement tube, roof frame, left	41 21 7407057
	C-pillar reinforcement, right	41 00 7305936		Reinforcement tube, roof frame, right	41 21 7407058
	Rear window frame	41 00 7455653		C-pillar reinforcement, left	41 21 7433519
	Left side member	41 00 9631613		C-pillar reinforcement, right	41 21 7433520
	Right side member	41 00 9631614			
	Reinforcement for side member, left	41 00 7455633			
	Reinforcement for side member, right	41 00 7455634			
	Upper apron	41 00 7477967			
	Rear window frame	41 00 7455653			
	Door front left	51 00 7457823			
	Door front right	51 00 7457824			

MORE QUESTIONS

In case of further questions or comments, please feel free to contact us:

BMW Body & Paint Team			
Name	Title	Phone Number	Email Address
Jonathan Inzano	National Collision Program Manager	(949) 630-5725	Jonathan.Inzano@bmwna.com
Marcos Ehmann	Body & Paint/ Wholesale/Insurance/ R3 Manager	(201) 307-3843	Marcos.Ehmann@bmwna.com