

The following repair represents replacement and installation of the cavity bulkhead in the side member cover.

In this case, the shaped part is already expanded in the spare part.

Location of shaped parts,

refer to Arrangement of shaped parts in cavity bulkhead.

Further scopes,

refer to Installation of shaped parts, except for cover for side member,

refer to Installation of a cavity bulkhead with cavity foam.

Before this operation, the spare part to be fitted should be prepared ready for installation (adjusted to fit, cut to size, coated with zinc dust paint etc.).

Caution!

The open time of the original BMW window adhesive until a skin is formed is 30 minutes in a standard climate of 23 °C and 50 % relative humidity.

The open time of the adhesive until a skin is formed is determined by the relative humidity.

The higher the humidity, the faster the adhesive hardens.

Note:

First clean contact faces of foam residue.

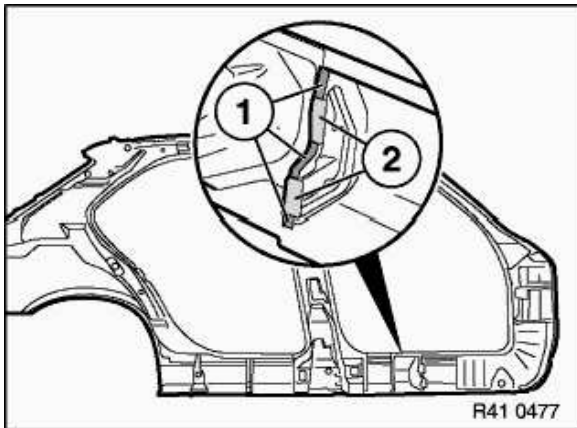
Caution!

If vapors are produced when the foam is removed, these must be extracted. Ensure the area is well ventilated.

Caution!

Observe safety instructions when dealing with

- activator for original BMW windshield adhesive, refer to BMW Parts Service
- original BMW windshield adhesive, refer to BMW Parts Service



Cover for front side member:

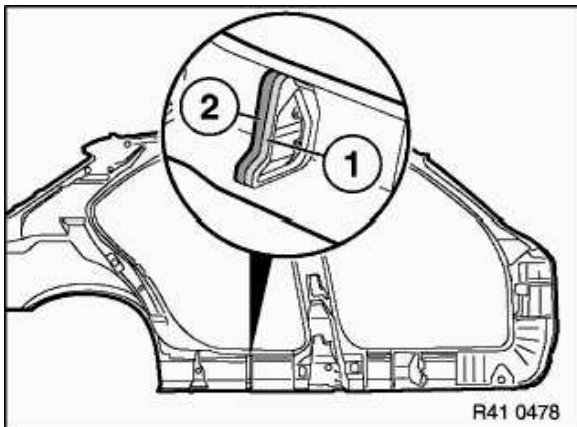
Apply an approx. 15 mm high bead of original BMW windshield adhesive on the contact surface of the already expanded foam insert (1).

Caution!

Do not coat the area for plug welding (2) with original BMW windshield adhesive!

Burn hazard!

Apply as little heat as possible during plug welding to prevent the adhesive coat from being damaged.



Cover for rear side member:

Apply an approx. 15 mm high bead of original BMW windshield adhesive on the contact surface of the already expanded foam insert (1).

Caution!

Do not coat the area for plug welding (2) with original BMW windshield adhesive!

Burn hazard!

Apply as little heat as possible during plug welding to prevent the adhesive coat from being damaged.

Lightly sand the contact surface of the front and rear expanded foam insert of the side member cover with coarse sandpaper (50 - 100 grain).

Clean the contact surface of the front and rear expanded foam part with activator for original BMW windshield adhesive.

Clean contact surface of the front and rear expanded foam part on the body with activator for original BMW windshield adhesive.

Fit, secure and weld up spare part.