

41 00 ...

Workshop equipment (BMW and MINI vehicles)

Â

Minimum workshop equipment requirements in order to ensure the correct and expert performance of body repairs:

The tools listed below **must be used**.

Â

Repair stage 1:

Tool)*	Sourcing reference BMW	Screwed parts (steel or plastic)	Screwed parts (aluminium)
Body tool trolley		x	x
Aluminium bodywork tool assortment			x
Pressure cup spray gun for cavity preservation	81 45 2 148 795	x	x
Drill		x	x
Blind riveting tongs Electrical or pneumatic With rivet head extension		x	x
Manual riveting machine for blind rivet nuts	81 43 2 155 739 (up to M12) or 81 43 9 429 204 (up to M8)	x	x

Â

Repair stage 2:

		Steel		Aluminium	
Tool)*	Sourcing reference BMW	Structure	Outer skin	Structure	Outer skin

Body tool trolley accessory set		x	x		
Bodywork saw	81 43 2 299 088 or 81 43 2 299 089	x	x		
Belt sander	81 43 2 236 488 (230V) or 81 43 2 333 873 (100-115V)	x	x	x	x
Single-handed grinder		x	x	x	x
Welding spot remover	81 43 9 428 600	x	x		
Punch riveting tool	81 43 2 158 708	x	x	x	
MAG welding apparatus		x	x		
Cartridge gun for adhesives		x	x	x	x
Infrared heater	81 44 2 211 107 (220V) or 81 45 2 211 615 (110V)		x		

In addition, the repair stage 1 tools are required.

Â

Repair stage 3:

	Steel		Aluminium	
Tool)*	Structure	Outer skin	Structure	Outer skin
Spot welding apparatus	x	x		
Straightening system	x		x	
Stud welding apparatus	x		x	
Flame coating set			x	
MIG welding apparatus			x (E52 only)	

In addition, the repair stage 1 and 2 tools are required.

Â

)*Sourcing reference [BMW Workshop Equipment Catalogue](#)

Â

Important!

In vehicles from model year 2001, higher-tensile and high-tensile steels are used in certain areas.

It is essential to check whether the spot-welding apparatus used conforms to the technical requirements of the currently recommended welding sets. Should you have any questions, please contact the country-specific Hotline.

The use of technically obsolete equipment may have serious consequences for the structure of the vehicle (e.g. in the event of a crash). In the end, this can result in safety and product liability risks which cannot be calculated.

Â

Use and restrictions:

Definition of recommendation:

All currently recommended spot welding sets comply according to the *latest* information with the requirements relating to reliable welding of today's and future BMW Group vehicles. A spot welding unit will lose its recommendation as soon as tests with materials and material combinations designated for future use in BMW Group vehicles return negative results (see Table Group 1). All previous application before the withdrawal of the recommendation shall remain unaffected.

	Device designation	Manufacturer
Group 1	CR500	Car-O-Liner
Devices currently <i>no</i> longer recommended	Spot9000	Tecna
Â	ATL 400V	Wieländer&Schill
Group 2	MIDIsport QSVM9000	Celette)*
Devices currently <i>recommended</i>	MIDIsport QSVM9000	Elmatech)*
Â	CR600 QSM	Car-O-Liner)*
Â	MIDIsport QSVM12000T	Car-O-Liner
	MIDIsport QSVM12000T	Elmatech)*
	Multisport MI-100 Control	Elektron

	Inverta Spot GT BM	Wieländer&Schill
	3664 BM	Tecna

)* no longer produced

Â

Application options and restrictions of above devices.

Vehicle	Group 1	Group 2
All BMW convertibles from E64	x Except A-pillar, B-pillar, sill	x
All BMW model series from E70	x Except B-pillar	x

Note:

April 2012

All BMW and MINI vehicles not mentioned can be repaired with the equipment of Group 1 and Group 2.