

FRONT & REAR WINDOW

51 31 ... INSTRUCTIONS ON GLUING WINDSCREEN

IMPORTANT: The following topics were included or amended in March 2005: Storage temperature of all adhesive products of 5° C to 25° C must be observed. Special instructions for hot processing must be observed:

- Temperature of cartridge oven must be checked every morning with DIS or GT1.
- Temperature of cartridge < 80° C results in the formation of bubbles/blisters (gluing/cementing not permitted).
- Insufficient heating (< 1 hour) results in the formation of bubbles/blisters (gluing/cementing not permitted).
- Heating time of a cartridge max. 8 hours.
- Mistake in mixing in event of an interruption in application >1 minute (gluing/cementing not permitted).
- A test bead of 50-70 mm must be rejected after an interruption in application.
- Cartridge may only be heated up once; if the lower label is black, this adhesive may only still be used cold without accelerator while adhering to the Best before date.

Work Steps For Removing And Installing Windscreens: refer to **51 36 070 REMOVING AND INSTALLING/REPLACING LEFT OR RIGHT REAR SIDE WINDOW** , **51 31 200 REMOVING AND INSTALLING/REPLACING REAR WINDOW** , **51 31 000 REMOVING AND INSTALLING/REPLACING WINDSCREEN** and **51 34 191 REPLACING LEFT OR RIGHT FIXED DOOR WINDOW IN REAR WINDOW FRAME** .

General:

The windscreen and rear window (also the rear side windows if necessary) are bonded to the body. This gluing will increase the torsional strength of the vehicle. To obtain perfect bonding, comply with the installation procedure described in the following.

It is possible to tow or drive without windscreen or rear window.

The windscreen must be secured with yellow plastic adhesive tape after being installed. The paint must be completely hardened after painting work.

- Set down window glass and process on BMW-approved X-universal stand.
- In winter, the vehicles must stand in a room with a temperature of at least 15° C.

On-The-Job Safety:

2001 BMW X5 30i

2001-2003 ACCESSORIES AND EQUIPMENT Exterior/Interior Trim - Repair Instructions - X5 (3.0i) E53

When working with adhesive products (adhesive, cleaning agent, bonding agent etc.):

- Wear protective goggles, protective gloves and if necessary an apron.
- Ensure rooms are well ventilated.
- Change work clothing contaminated with adhesive immediately.
- Change work clothing contaminated with solvents and swelling agents immediately (keep spare work clothing on hand).
- Take skin protection measures, provide washing facilities including hot water, use silicone-free skin creams.
- Provide eye bath facilities, change water regularly (once a month).
- Comply with the relevant safety regulations.
- Do not eat, drink or smoke in areas of PUR processing.

Replacement Of Windscreens:

Version with front passenger airbag:

- Stick on reminder label. Refer to **INFORMATION/WARNING LABELS** .

TOOLS FOR CUTTING THROUGH ADHESIVE BEAD

Type	Model	Order/Part Number
Special cutter (manufacturer: Fein) with oscillating blade.	Pneumatically operated. Electrically operated.	81 43 9 429 183 81 43 9 427 786
BMW blade set.	All required blades.	81 43 9 428 596
Blade (U-shape).	19.5 mm ⁽¹⁾ .	6 39 03 118 01 3
	24 mm.	6 39 03 076 01 6
	36 mm.	6 39 03 079 01 2
	45 mm.	6 39 03 154 01 0
Blade (straight with stop roller).	16 to 35 mm (adjustable).	6 39 03 143 01 3
	10 mm (fixed) ⁽¹⁾ .	6 39 03 189 01 0
	14 mm (fixed).	6 39 03 082 01 6
"Roll Out 2000", refer to <u>51 31 ... REMOVING WINDSCREEN WITH "ROLL OUT 2000"</u> .	Wire cutting system ⁽¹⁾ .	81 62 0 301 76 8
Scalpel	For heavy-duty applications ⁽¹⁾ .	
Handles for cutting wire.	Self-locking ⁽¹⁾ .	Special tool 51 3 270
(1) Not included in BMW blade set		

Storage Temperature:

Storage temperature of all adhesive products of 5° C to 25° C must be observed.

Adhesive:

The BMW-approved 1-component polyurethane adhesive must be used for bonding.

- Adhesive cartridge (part number BMW 83 19 0 152 031, MINI 83 19 0 152 032).

Adhesive is applied to window glass with cartridge gun (pneumatically or electrically operated).

When Using Accelerator (Hot Processing):

- Temperature (min. 80 +/- 5° C) of cartridge oven must be checked every morning. Connect temperature sensor to DIS or GT1 in conjunction with MIB (Measurement Interface Box).
- Heat adhesive for at least 1 hour in cartridge oven to 80 +/- 5° C.
 - Write date and time on adhesive when inserting into cartridge oven.
 - Insufficient heating (< 1 hour) results in the formation of bubbles/blisters (gluing/cementing not permitted).
 - Temperature < 80 +/- 5° C results in the formation of bubbles/blisters (gluing/cementing not permitted).
- Remove cured adhesive prior to further processing.
- Mistake in mixing in event of an interruption in application >1 minute (gluing/cementing not permitted).
 - A test bead of 50-70 mm must be rejected after an interruption in application.
- Best before dates of accelerator and adhesive must not be more than 3 months apart.
- Best before date >3 months results in the formation of bubbles/blisters (gluing/cementing not permitted).

Sealed Adhesive:

- May only be stored for a maximum of 8 hours once it has been heated up to 80 +/- 5° C.
- The adhesive will be damaged if this time is exceeded (gluing/cementing not permitted).
- Damaged adhesive must not be used and must be disposed of in compliance with national regulations.
- Cartridge may only be heated up once.
- If the lower label is black, this adhesive may only still be used cold without accelerator while adhering to the Best before date.

IMPORTANT: Not all window glass may be bonded with accelerator (hot processing). If hot processing is not permitted, this is described in the relevant article.

Adhesive Best Before Date:

Repair kit and adhesive cartridges are marked with a date (Best before).

2001 BMW X5 30i

2001-2003 ACCESSORIES AND EQUIPMENT Exterior/Interior Trim - Repair Instructions - X5 (3.0i) E53

The adhesive cannot be used after this date.

Adhesive Disposal:

Pure hardened adhesive is handled as normal waste.

The adhesive is disposed of in paper bags so that it can react with moisture.

Non-hardened adhesive, cartridges and mixtures of adhesive and solvents and the like must be disposed of as special waste.

Accelerator:

Accelerator is screwed onto the adhesive cartridge and contains a reaction paste which is mixed with the heated adhesive.

IMPORTANT: The accelerator may only be paired with the adhesive cartridge of an unopened package (bubbling). Adhesive and accelerator must be paired while taking into account the Best before dates. The accelerator may no longer be used if the Best before dates are more than 3 months apart.

Bonding Agent (Activator):

The BMW-approved bonding agents must be used to treat bonding areas:

- "Glass Activator 1" (on glass ceramic material).
- "Paint Activator A" (on sheet metal flange or residual adhesive bead).

Bonding Agent Best Before Date:

Repair kit and bonding agent are marked with a date (Best before).

- The bonding agent may only be used up to this date (if not already opened previously).
- Once it has been opened (locking ring broken), use for 1 week only even if the Best before date has not been reached.

NOTE: Write the date on the bottle when opening the bonding agent for the first time. Close the bottle immediately after extracting the bonding agent (reaction with air).

Removal Of Window Glass:

IMPORTANT: As of E63 and E87 it will only be possible to remove the rear window with the "Roll Out 2000". Refer to 51 31 ... REMOVING WINDSCREEN WITH "ROLL OUT 2000" .

Cover side panels, roof antenna and if necessary interior trim with protective covers.

Tape off body with fabric adhesive tape (e.g. Tesa) in areas where the oscillating blade could damage the window glass or the paint.

When using cutting wire, pull cutting wire ends through special tool 51 3 270, bend and tape off with fabric adhesive tape (e.g. Tesa) (risk of injury and damage).

When removing the windscreen:

- Wear protective goggles and gloves.

Cut through adhesive bead of window glass:

- With "Roll Out 2000". Refer to **51 31 ... REMOVING WINDSCREEN WITH "ROLL OUT 2000"** . (wire cutting system); No paint is damaged here in the case of narrow gaps.
- With special cutter and oscillating blade.

Prior to each use, regrind the blade with a grinding stone while the machine is running (new blades also).

Avoid damage to paintwork on body cutout.

Guide blade carefully between body and window glass.

Run blade of knife parallel to glass.

Cut through adhesive bead as closely as possible to window glass.

To remove adhesive bead in body cutout (and on window glass if reusing):

- Use a scalpel for heavy-duty applications.
- Cut off residual adhesive to a thickness of approx. 0.5 mm.
- Remove residual bead only briefly before bonding.

Damage To Paintwork In Body Aperture:

To ensure long-term corrosion protection, it is absolutely essential to touch up damage to paintwork!

The "BMW Color System" painting handbook forms the basis of these repair instructions and must be observed without fail.

Touch up damage to paintwork on body cutout with BMW multibase filler.

Grind out scratches in non-visible areas and touch up with BMW multibase filler.

Grind extensive areas of damage down to the bare metal and coat with BMW multibase filler (coating thickness

2001 BMW X5 30i

2001-2003 ACCESSORIES AND EQUIPMENT Exterior/Interior Trim - Repair Instructions - X5 (3.0i) E53

30 - 40 cm.).

Hardening time:

- With infrared, at least 10 minutes.
- Without infrared for at least 60° C, at least 30 minutes.
- Without infrared for at least 20° C, at least 24 hours.

If a complete build-up of paint is required in the visible area:

- Tape off primed bonding flange before applying top coat.

IMPORTANT: Observe hardening time of BMW multibase filler otherwise a perfect bond cannot be guaranteed!

Treatment Of Glued Area In Body:

TOOLS FOR CUTTING THROUGH ADHESIVE BEAD

Glue	Treatment
Bonding and sealing compound for car window glass.	a. Clean with spirit (available in pharmacies). b. Observe an air drying time of at least 1 minute (at least 15 minutes when applied to residual bead). c. Apply "Paint Activator A" to paint and residual bead. d. Observe an air drying time of at least 1 minute (at least 10 minutes when applied to residual bead).

IMPORTANT: Do not use Sika remover 208 for cleaning in the bonding area.

Preparation For Assembly:

Prepare plastic nozzle(s) for shaping adhesive bead (when not using the standard nozzle), can be cut to size during the air drying time.

Lay a test bead of approx. 50 mm - watch out for formation of bubbles/blisters when hot cementing; if OK, apply immediately to window glass.

- Interruption must be < 5 second (incorrect mixture ratio).

Cartridge must be vertical to window glass.

Black ceramic material impermeable to UV light is located on the peripheral zone of the inside edge of the window to protect the adhesive bead.

Glass ceramic material must not be damaged and must be treated as follows.

2001 BMW X5 30i

2001-2003 ACCESSORIES AND EQUIPMENT Exterior/Interior Trim - Repair Instructions - X5 (3.0i) E53

Treatment Of Glass Ceramic Surface (Inside Of Window):

TREATMENT OF GLASS CERAMIC SURFACE

Adhesive (With Part Numbers)	Treatment
Hot cementing: - BMW 83 19 0 147 370, MINI 83 19 0 147 372 Cold cementing: - BMW 83 19 0 147 369, MINI 83 19 0 147 371 Adhesive cartridge: - BMW 83 19 0 152 031, MINI 83 19 0 152 032	a. Clean with spirit (available in pharmacies). b. Observe an air drying time of at least 1 minute. c. Apply a thin coating of "Glass Activator 1". d. Observe an air drying time of at least 10 minutes.

Version with inspection window for vehicle identification number in windscreen only (all except US/GB):

- Seal inspection window (bottom left) with Sika primer 206 G+P.

Adhesive Quantities:

Approx. 1 1/4 adhesive cartridges are needed to cement 7 Series windscreens.

In the case of hot cementing (with accelerator), the missing residual bead is applied from a second adhesive cartridge (not contained in the repair kit) but while cold and without accelerator (bubbling).

Minimum hardening period is thus not increased.

IMPORTANT: If a second cartridge is required for cementing:

- First apply cold adhesive to cowl panel at bottom (skin formation time).
- Accelerator from repair kit must not be used with the second cartridge (bubbling).

Bubbling results in leakage and insufficient bonding strength (torsional rigidity, passenger airbag).

Effect Of Differing Adhesive Quantities:

EFFECT OF DIFFERING ADHESIVE QUANTITIES

--	--

2001 BMW X5 30i

2001-2003 ACCESSORIES AND EQUIPMENT Exterior/Interior Trim - Repair Instructions - X5 (3.0i) E53

Too Little Adhesive:	Too Much Adhesive:
○ Windscreen rests too low in body cutout. ○ Strains/tensions may occur (windscreen breakage). ○ Insufficient squeezing of adhesive bead (leaking).	○ Windscreen rests too high in body cutout. ○ Wind noise may occur. ○ Strains/tensions may occur (windscreen breakage). ○ Fouling of add-on parts by emerging adhesive. ○ Adhesive on uninsulated strainer pressure lines of antenna(s) (interference of reception).

Spacer Buffers:

Before sticking on new spacer buffers, remove all remaining traces of old spacer buffers completely.

Position of spacer buffers must be observed exactly.

Incorrectly fitted spacer buffers will result in:

- Windscreen glass breakage.
- Leakage (if the spacer buffer is in the adhesive area).
- Wind noises.

Assembly:

To prevent a pressure increase in the vehicle interior when the doors are closed:

- Open a window.

IMPORTANT: After the adhesive bead has been applied, the window glass must be fitted within 5 to 10 minutes (depending on air humidity, temperature and use of accelerator). After 5 to 10 minutes the adhesive bead forms a skin which can no longer guarantee a perfect bond. To secure the windscreen, use only the yellow plastic adhesive tape (BMW part number 83 19 9 410 979). The glass will slip down if other adhesive tapes are used. Windscreen slippage will result in leaks and wind noises.

Remove adhesive residue immediately with adhesive remover (Sika remover 208). Do not press out the window glass again.

Hardened adhesive can only be removed by machine.

Check height of windscreen/rear window with special tool 51 0 010 or 51 3 210.

Assemble car.

Hardening:

2001 BMW X5 30i

2001-2003 ACCESSORIES AND EQUIPMENT Exterior/Interior Trim - Repair Instructions - X5 (3.0i) E53

The adhesive hardens as it reacts with air humidity (with accelerator also due to mixed-in reaction paste) at room temperature.

Minimum hardening time (table) is obtained from 22° C and 38 % relative air humidity.

At ambient temperatures above 23° C and 50 % relative air humidity (hot countries), the adhesive open time is shortened to approx. 5 minutes (skin formation time).

The adhesive hardening process is interrupted completely at ambient temperatures below 5° C. In this event, there will be no increase in the strength of the adhesive bond.

Do not subject the vehicle to load on one side during the minimum hardening time (see table, without passenger airbag), such as e.g.:

- One wheel on curb.
- Lifting platform.
- Etc.

Maneuvering Inside Garage/Workshop:

- Only permitted on level ground.
- Do not under any circumstance driver over access ramps, e.g. into multi-store car parks.

Remove adhesive tapes after hardening time.

If you fail to adhere to the minimum hardening times (see table, without passenger airbag):

- Leaks and wind noises will occur when the windscreen is moved.

GLUES AND THEIR MINIMUM HARDENING TIMES

Glue.	Minimum hardening time "without passenger airbag" (after which vehicle can be moved).	Minimum hardening time "with passenger airbag" (countries where seatbelt use is not required by law).
Hot processing with accelerator.	2 hours.	3 hours ⁽¹⁾ .
Cold processing.	9 hours.	20 hours ⁽¹⁾ .
(1) Vehicles with passenger airbag:		

NOTE: The vehicle can be handed over to the customer after the hardening period (vehicle can be moved, adhesive-dependent) with the following warning: Once the windscreen glass has been bonded, all occupants must travel with their seatbelts attached for "... hours"! The time is taken from the "Minimum hardening period" table for countries where seatbelt use is not required by law.

IMPORTANT: If the minimum hardening time is not adhered to:

- The front passenger together with the windscreen may fall out of the vehicle in the event of an accident after the front passenger airbag has been triggered.

Locate Leaks:

- By spraying water underneath sealing lips.
- With ultrasonic leak detector.

If necessary, seal leakage with appropriate nozzle.

Version With Rain Sensor Or Rain/Light Sensor:

Removing rain sensor or rain/light sensor, refer to **61 35 175 REMOVING AND INSTALLING/REPLACING RAIN SENSOR** .

After replacing windscreen:

- Initialize rain sensor or rain/light sensor.
- Refer to function description in DIS (Diagnosis and Information System).

Work Steps For Removing And Installing Windscreens:

Refer to **51 36 070 REMOVING AND INSTALLING/REPLACING LEFT OR RIGHT REAR SIDE WINDOW** , **51 31 200 REMOVING AND INSTALLING/REPLACING REAR WINDOW** , **51 31 000 REMOVING AND INSTALLING/REPLACING WINDSCREEN** and **51 34 191 REPLACING LEFT OR RIGHT FIXED DOOR WINDOW IN REAR WINDOW FRAME** .

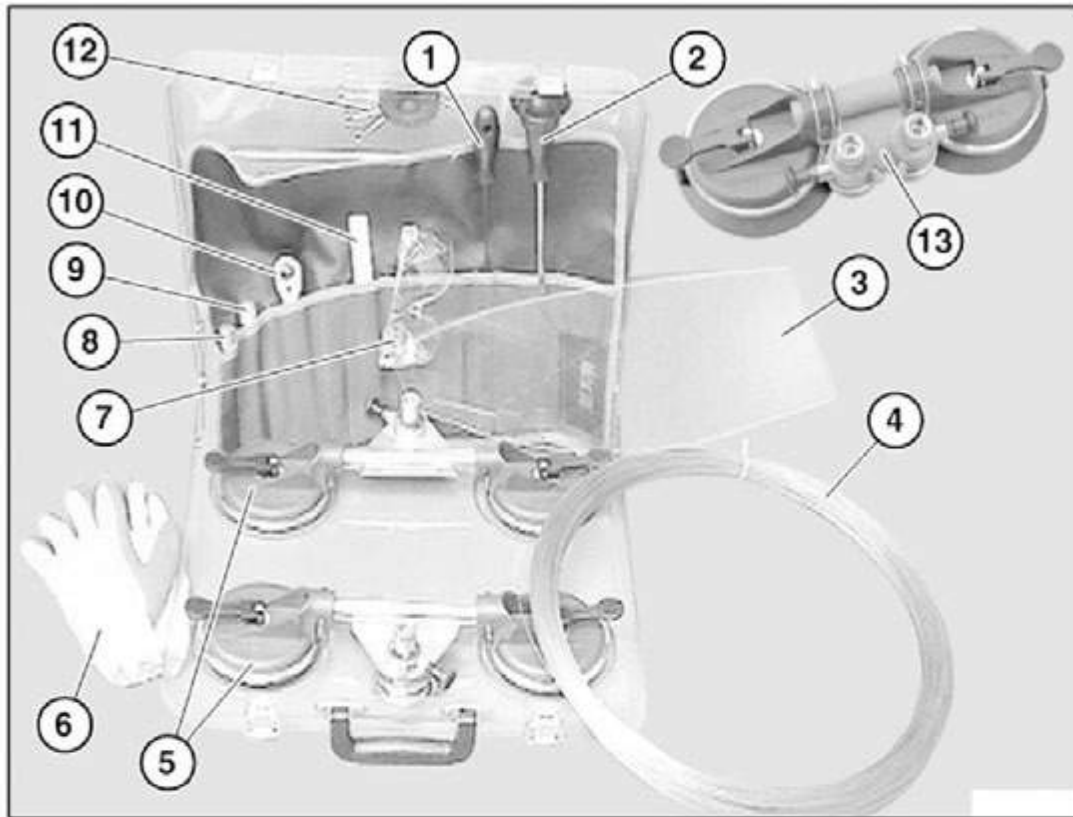
51 31 ... REMOVING WINDSCREEN WITH "ROLL OUT 2000"

NOTE: For Special Tool identification, see **SPECIAL TOOLS - X5 (3.0i)** .

Special Tools Required:

- 51 3 270

Windscreen Removal System "Roll Out 2000"



- | | | | |
|---|---------------------|----|---------------------------|
| 1 | Wire starter | 8 | Extension (short) |
| 2 | Parabolic tool | 9 | Extension (long) |
| 3 | Plastic washer | 10 | Reversible ratchet |
| 4 | Wire cutting roller | 11 | Plastic wedge |
| 5 | Windlasses | 12 | Guide needles |
| 6 | Protective gloves | 13 | Windlass with double coil |
| 7 | Protective goggles | | |

G03255844

Fig. 274: Identifying Windscreen Removal System "Roll Out 2000" Components
 Courtesy of BMW OF NORTH AMERICA, INC.

NOTE: Using the "Roll Out 2000" system minimizes paintwork and ergonomic damage as well as damage that is hazardous to health.

WARNING: Follow safety instructions for working on cars with airbag systems (risk of injury). Refer to 51 00 ... SAFETY INSTRUCTIONS FOR WORKING ON CARS WITH AIRBAG SYSTEMS.

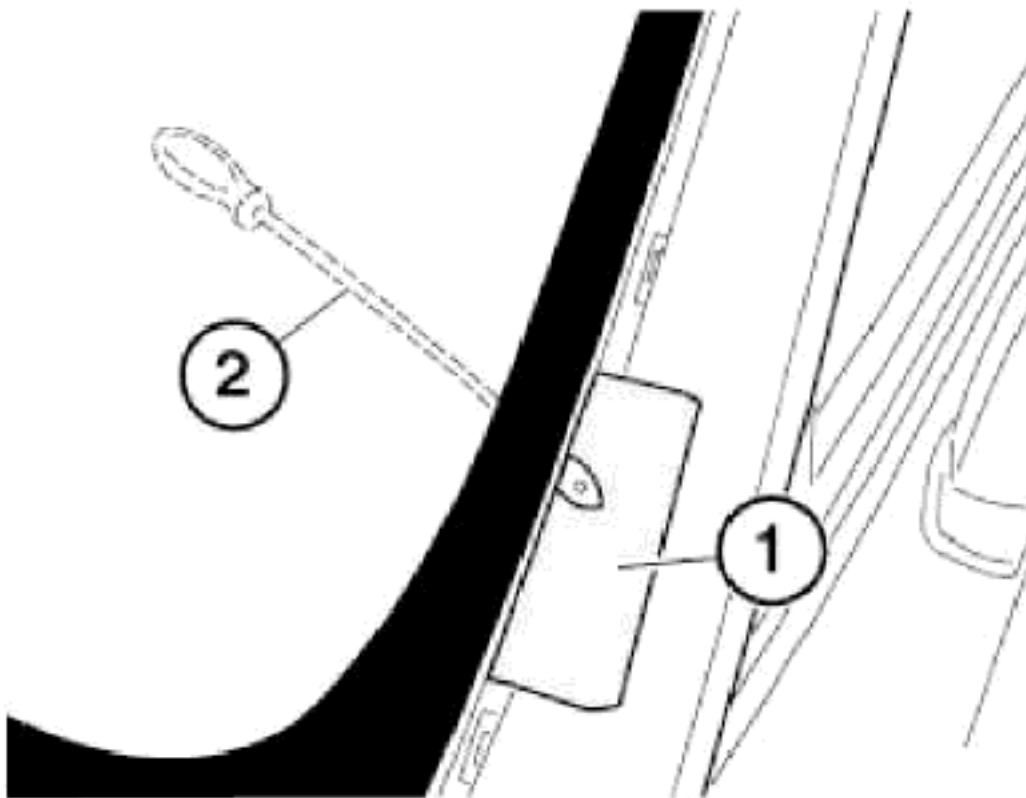
IMPORTANT: Take care when handling sharp-edged tools and cutting wire (risk of damage to

head airbag).

IMPORTANT: Always keep both suckers dry and clean to ensure their optimum adhesion on the windscreen. Lubricate coil if interlock rattling becomes too loud. Always wear protective goggles and gloves for your own safety.

Preparatory Work:

- To avoid paintwork damage, tape off working area over large area at outlet of wire starter (2) with fabric adhesive tape(1).
- Cut off required length (A) from cutting wire (A) = Window diagonal x 4.
- Check whether wire can get caught on rivets or retainers; if necessary, insert guide needles in bonding joint and guide cutting wire past.



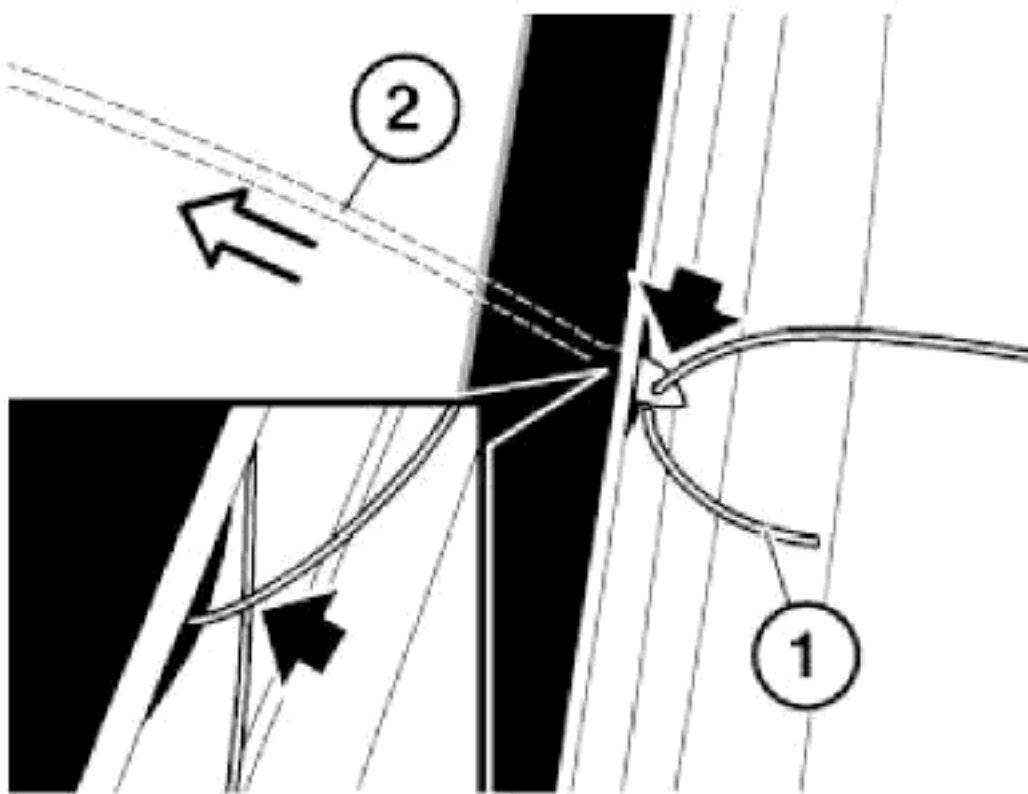
G03255845

Fig. 275: Identifying Areas For Fabric Adhesive Tape
Courtesy of BMW OF NORTH AMERICA, INC.

Pulling Cutting Wire Into Car:

- Push wire starter (2) from inside at a suitable point through adhesive bead.
- Feed wire end (1) into hole of wire starter (2) and bend back.
- Pull in both wires in succession crossways.

NOTE: **Crossing the wires cuts through the adhesive bead completely.**



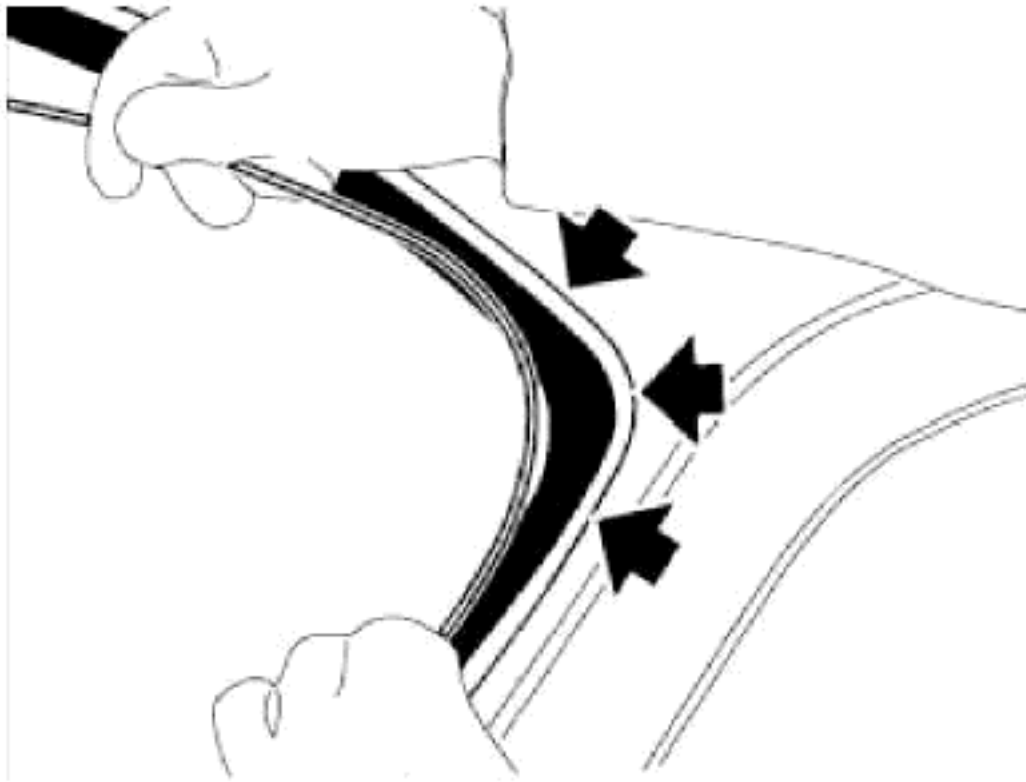
G03255846

Fig. 276: Feeding Wire Into Hole Of Wire Starter
Courtesy of BMW OF NORTH AMERICA, INC.

Laying Cutting Wire Around Windscreen:

- Starting from pull-in point, lay wire eyelet created on the outside counterclockwise around the windscreen.
- Pull excess wire into car interior.

IMPORTANT: Make sure the cutting wire is located at all four corner points below the windscreen. Check that the cutting wire is not caught on retainers or body. Secure window on outside with adhesive tape against slipping

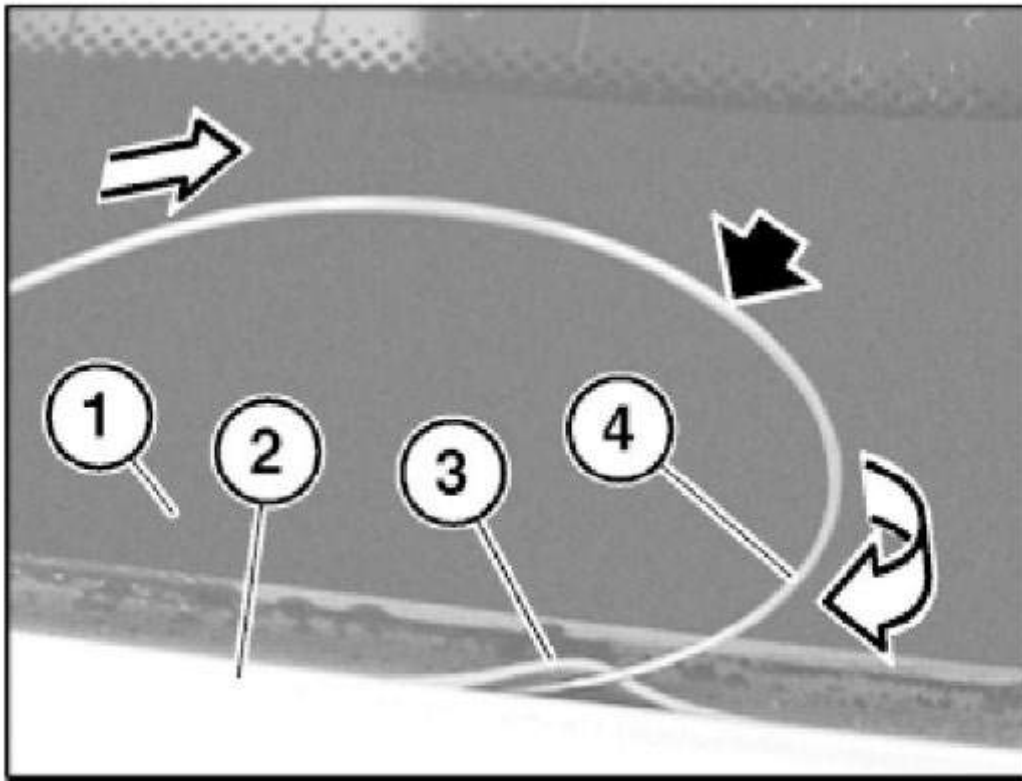


G03255847

Fig. 277: Laying Wire Around Windscreen
Courtesy of BMW OF NORTH AMERICA, INC.

NOTE: Windows (1) with fitted seals (3) or sprayed-on surrounds:

- Moisten cutting wire (4) and seals (3) on window (1) with water.
- Insert cutting wire (4) in bend (without kinking) between window (1) and body cutout (2).



G03255848

Fig. 278: Inserting Cutting Wire In Bend Between Window And Body Cutout
Courtesy of BMW OF NORTH AMERICA, INC.

Protecting Car Interior:

- To avoid damage and if necessary dirt, protect A-pillars, roof and instrument panel by means of parabolic tool (1) or plastic washer (2).
- Move parabolic tool (1) during removal so that wire cannot get caught.
- Always guide plastic washer (2) between wire and panel.

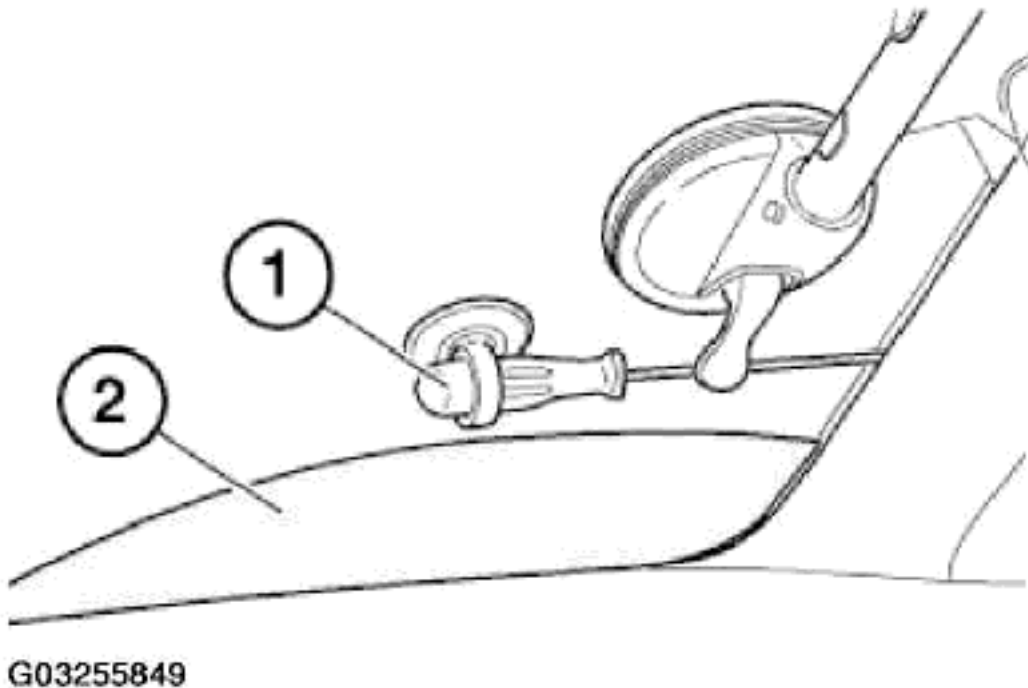


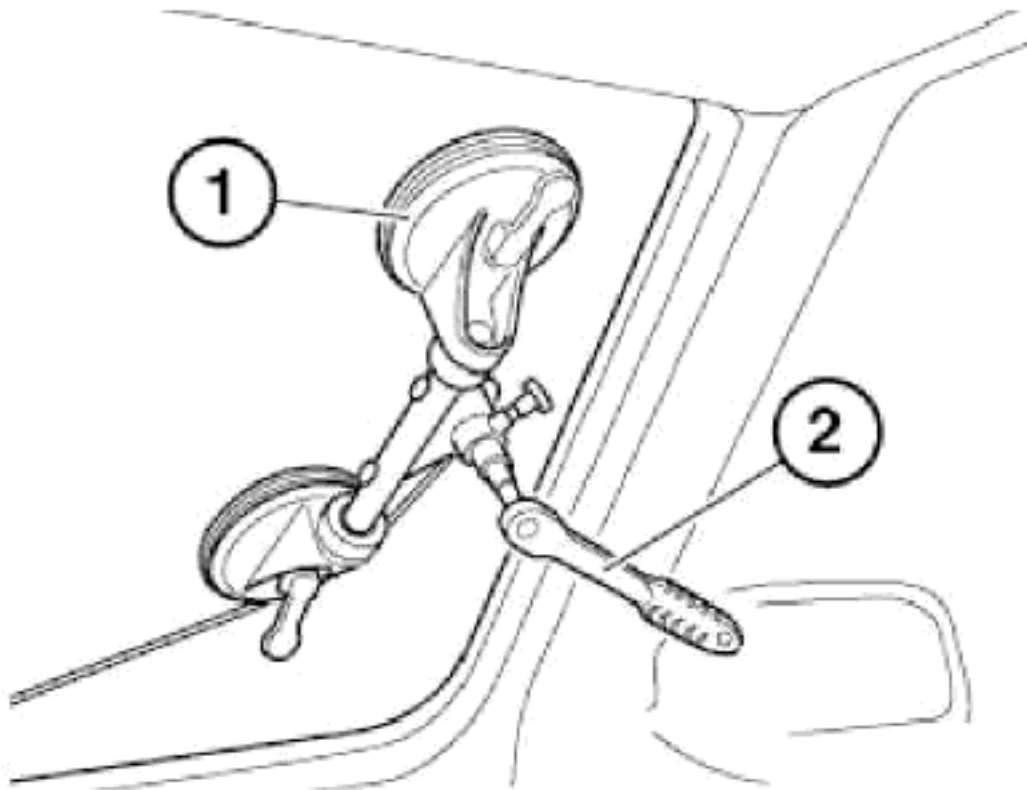
Fig. 279: Identifying Plastic Washer
Courtesy of BMW OF NORTH AMERICA, INC.

Starting Removal:

- Place windlass (1) on windscreen.
- Feed wire end into coil of windlass (1).

NOTE: **Coil can only be turned in one direction.**

- Make sure the wire is always situated in the guide channel of the windlass (1).
- Fit reversible ratchet (2) on coil and tension wire.
- Start by cutting lower adhesive bead.
- Grip second wire end in special tool 51 3 270.

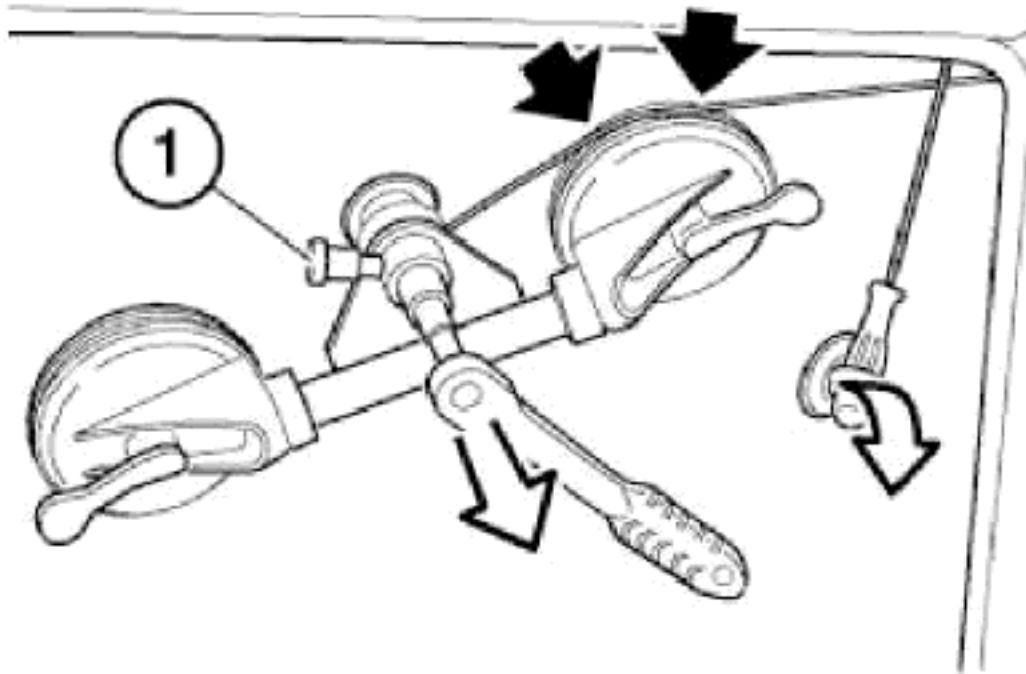


G03255850

Fig. 280: Placing Windlass On Windscreen
Courtesy of BMW OF NORTH AMERICA, INC.

Moving Windlass:

- Before moving windlass, remove reversible ratchet, extension and parabolic tool.
- Release sucker on windlass.
- Pull and hold black locking button (1).
- Turn windlass and move with sucker.
- Refit reversible ratchet, parabolic tool and if necessary extension.
- When cutting the corner points, make sure the wire is situated in the guide channel of the windlass; this makes the cutting job easier.

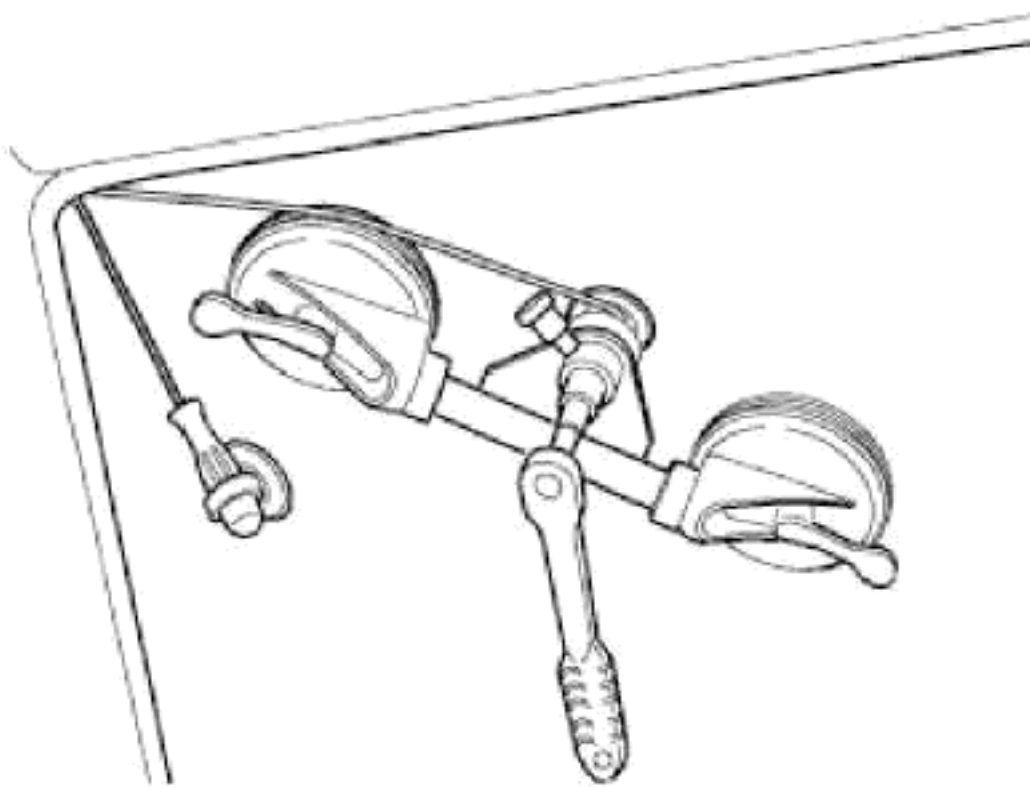


G03255851

Fig. 281: Locating Black Locking Button On Windlass
Courtesy of BMW OF NORTH AMERICA, INC.

Installing Second Windlass:

- Secure second windlass by suction on windscreen.
- Feed second wire end into coil.
- Cut left side and top left corner point.
- Finish removal.
- Remove "Roll Out 2000".



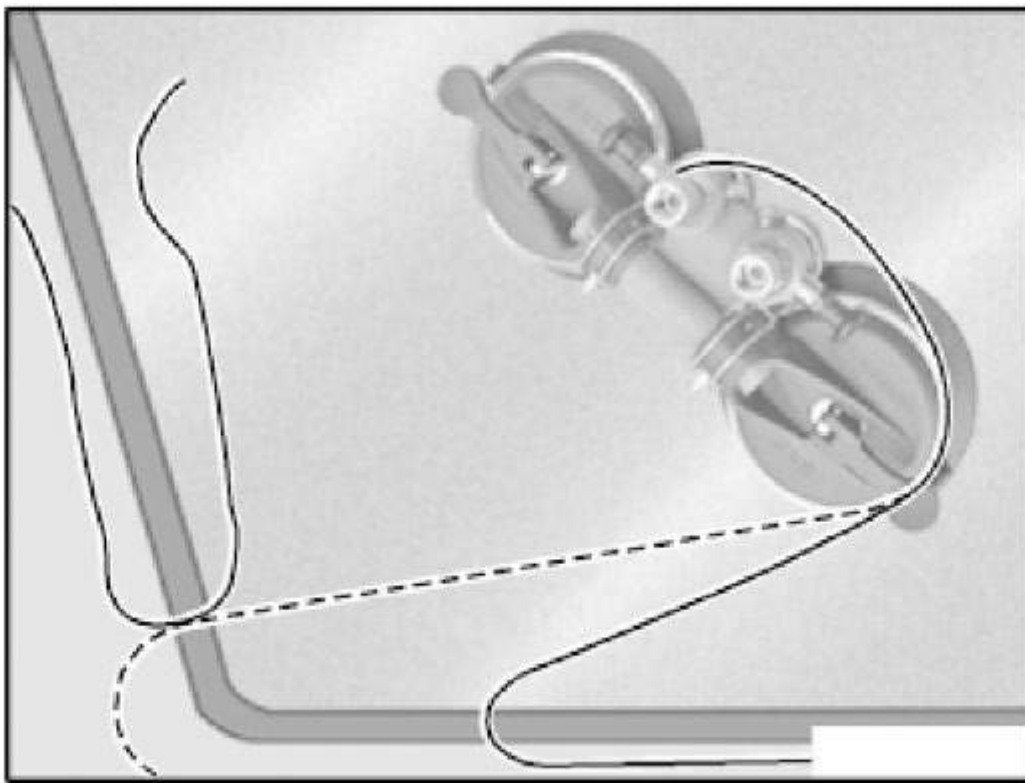
G03255852

Fig. 282: Securing Second Windlass By Suction On Windscreen
Courtesy of BMW OF NORTH AMERICA, INC.

Windlass With Double Coil:

For use with small windows.

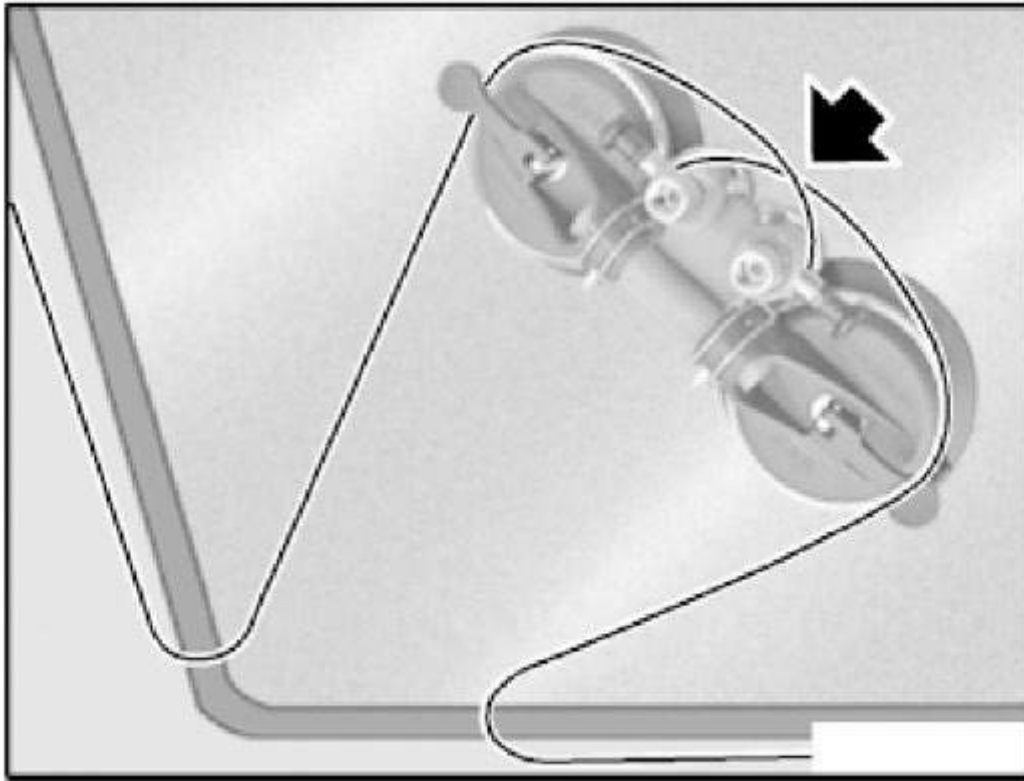
- Attach windlass firmly to window so that both coils are turned away from application point of wire.
- Feed either the upper wire end into the lower coil or the lower wire end into the upper coil.
- Fit reversible ratchet on coil and tension wire.
- Cut through approx. 10 cm of bonding joint.



G03255853

Fig. 283: Attaching Windlass Firmly To Window
Courtesy of BMW OF NORTH AMERICA, INC.

- Feed other wire end into free coil so that the wires cross.
- Continue cutting bonding joint by alternately using the coils.
- Both wires meet ahead of both coils when removal is completed.
- Remove "Roll Out 2000".



G03255854

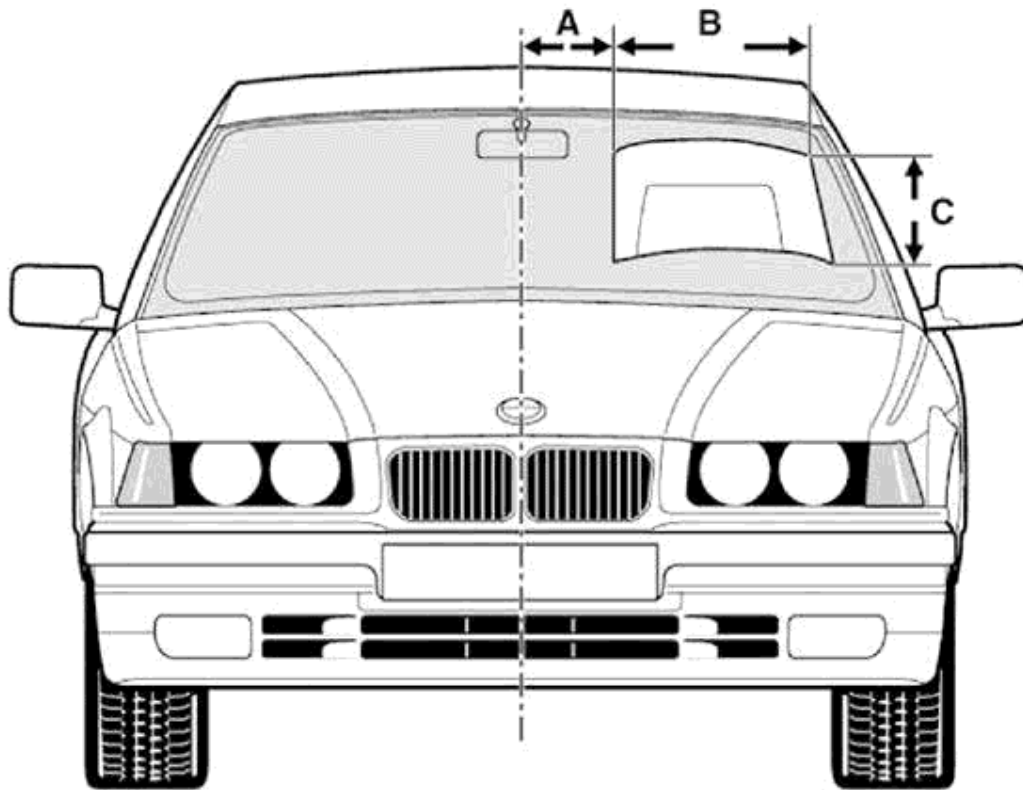
Fig. 284: Feeding Other Wire End Into Free Coil
Courtesy of BMW OF NORTH AMERICA, INC.

51 31 000 REMOVING AND INSTALLING/REPLACING WINDSCREEN

IMPORTANT: The "Instructions for window cementing" serve as the basis for these repair instructions and must be followed without fail. Refer to 51 31 ... INSTRUCTIONS ON GLUING WINDSCREEN .

51 31 015 REPAIRING DAMAGE TO WINDSCREENS CAUSED BY PITTING (STONE CHIPS) (CLEAR AND TINTED LAMINATED SAFETY GLASS)

Field Of Vision (No Repairs Acceptable):



- A 50 mm (gap between field of view / centre of vehicle)
- B Up to end of wiper range, outside (field of view width)
- C Restriction by wiper range (height of field of view)

G03255855

Fig. 285: Identifying Dimensions Of Field Of Vision

Courtesy of BMW OF NORTH AMERICA, INC.

IMPORTANT: Repairs must only be carried out outside of the field of vision (refer to sketch).

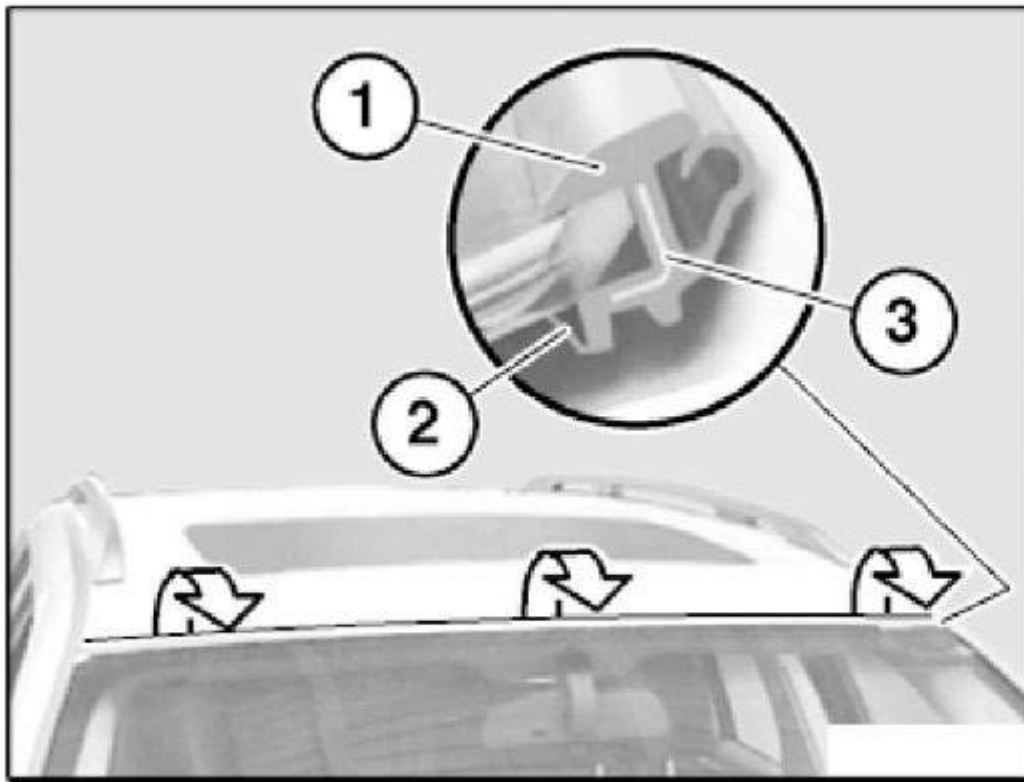
If the stone chip damage is outside the field of vision, replace windscreen.

51 31 021 REMOVING AND INSTALLING/REPLACING RUBBER FRAME FOR WINDSHIELD (TOP)

CAUTION: Rubber frame is reinforced with an aluminum strip. Do not damage windshield when removing rubber frame.

Carefully turn and remove rubber frame (1).

- (2) Tear-off lip.
- (3) Aluminum strip.



G03255856

Fig. 286: Identifying Lip And Aluminum Strip
Courtesy of BMW OF NORTH AMERICA, INC.

NOTE: When rubber frame (1) is removed, lip (2) tears off and remains in car.

Removing And Installing Windshield:

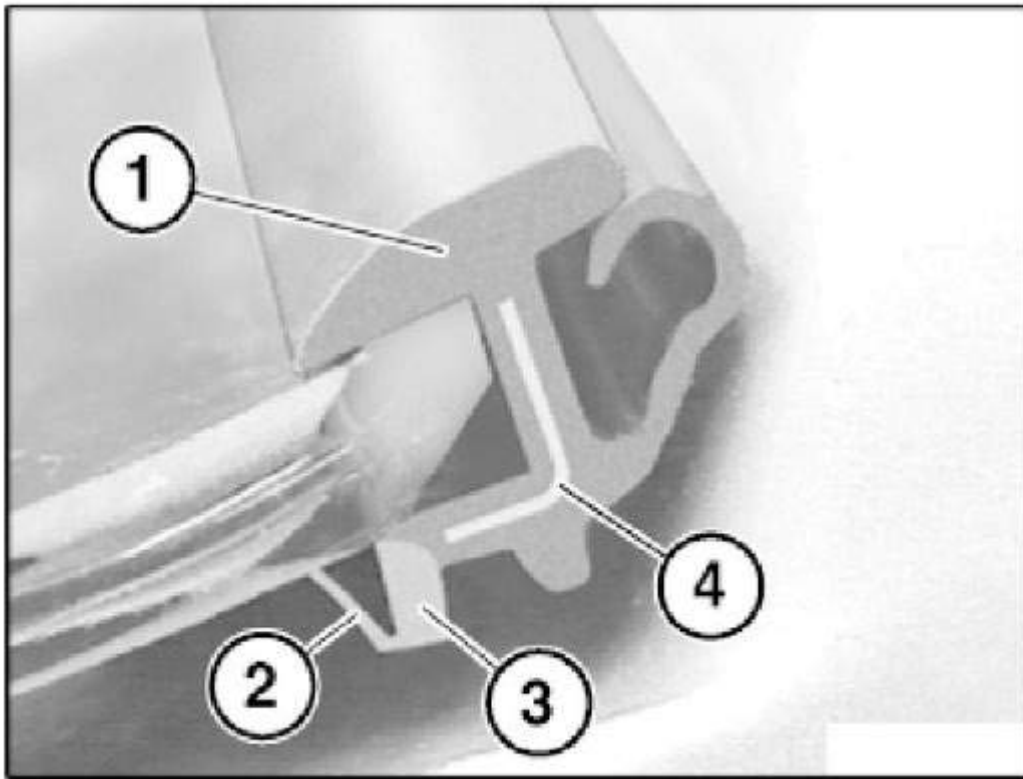
Tear-off lip (2) on new rubber frame (1) must not be damaged. If the tear-off lip (2) is damaged, the rib (3) will stick and the rubber frame (1) will not be able to be removed without major damage.

Removing And Installing Rubber Frame (1):

Cut through tear-off lip (2) on new rubber frame (1). If adhesive has reached rib (3) through tear-off lip (2), this area must be cut out partially.

To facilitate installation, coat rubber frame and body cutout with turpentine substitute.

(4) Aluminum strip.



G03255857

Fig. 287: Identifying Rubber Frame And Lip
Courtesy of BMW OF NORTH AMERICA, INC.

51 31 200 REMOVING AND INSTALLING/REPLACING REAR WINDOW

IMPORTANT: The "Instructions for window cementing" serve as the basis for these repair instructions and must be followed without fail. Refer to 51 31 ... INSTRUCTIONS ON GLUING WINDSCREEN .

51 31 221 REPLACING REAR WINDOW (REAR WINDOW BROKEN)

Operation Is Described In:

Remove and install rear window refer to **51 31 200 REMOVING AND INSTALLING/REPLACING REAR**

WINDOW .

Remove all glass splinters, also from underneath seats.

Check seat belts:

- Condition of seatbelt strap,
- Function of retractor mechanism,
- Locking reel and seatbelt buckle.

51 31 231 REPLACING REAR WINDOW (COMPLETE REAR WINDOW)**Operation Is Described In:**

Remove and install rear window, refer to **51 31 200 REMOVING AND INSTALLING/REPLACING REAR WINDOW** .

FRONT MANUALLY OPERATED WINDOWS**51 32 154 ADJUSTING LEFT OR RIGHT FRONT DOOR WINDOW**

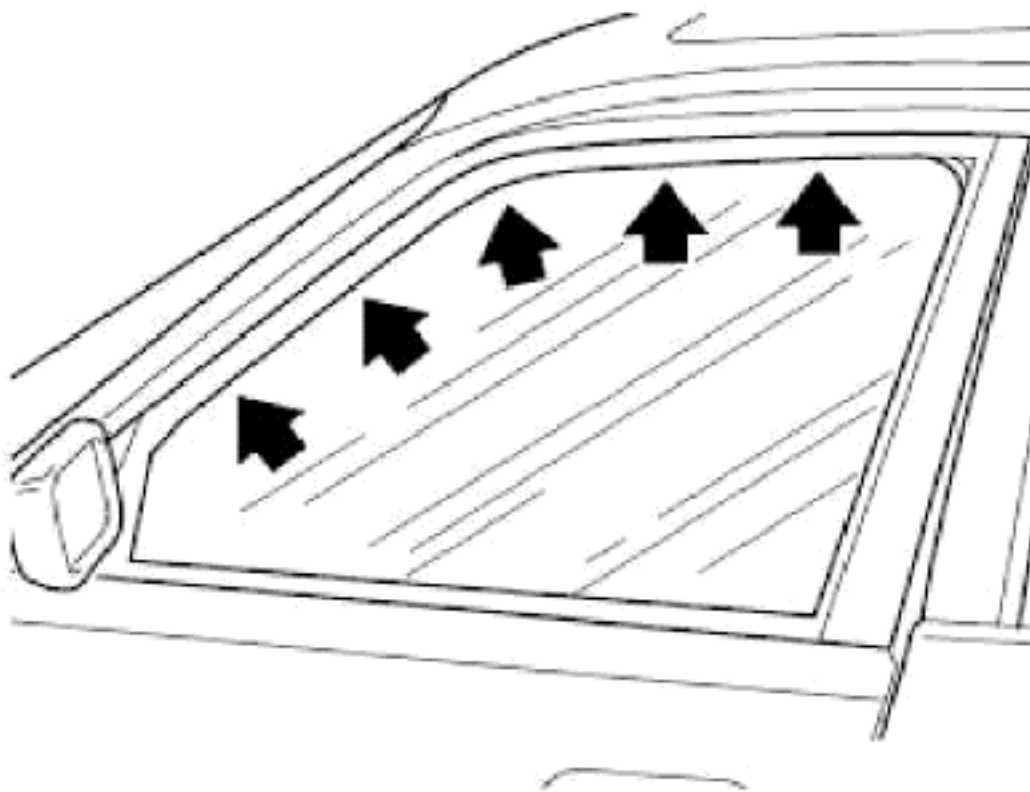
NOTE: For Special Tool identification, see **SPECIAL TOOLS - X5 (3.0i)** .

Special Tools Required:

- 51 3 080

Ideal adjustment:

Retraction depth along window edge min. 6 mm.



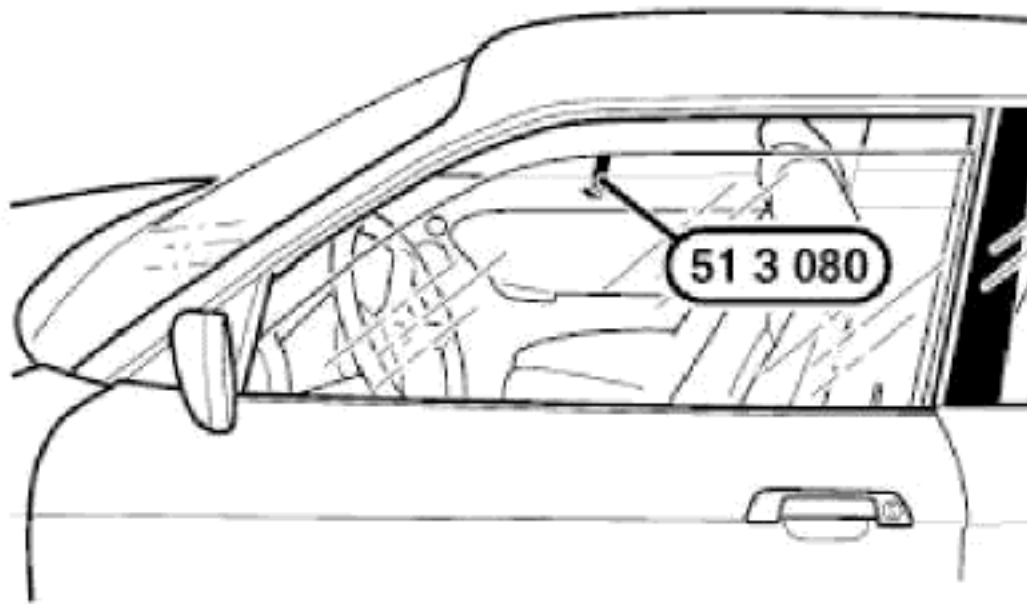
G03255858

Fig. 288: Retraction Depth Along Window Edge Min. 6 mm

Courtesy of BMW OF NORTH AMERICA, INC.

Measuring retraction depth:

Open door, attach special tool 51 3 080 to door window glass and close door.



G03255859

Fig. 289: Measuring Retraction Depth

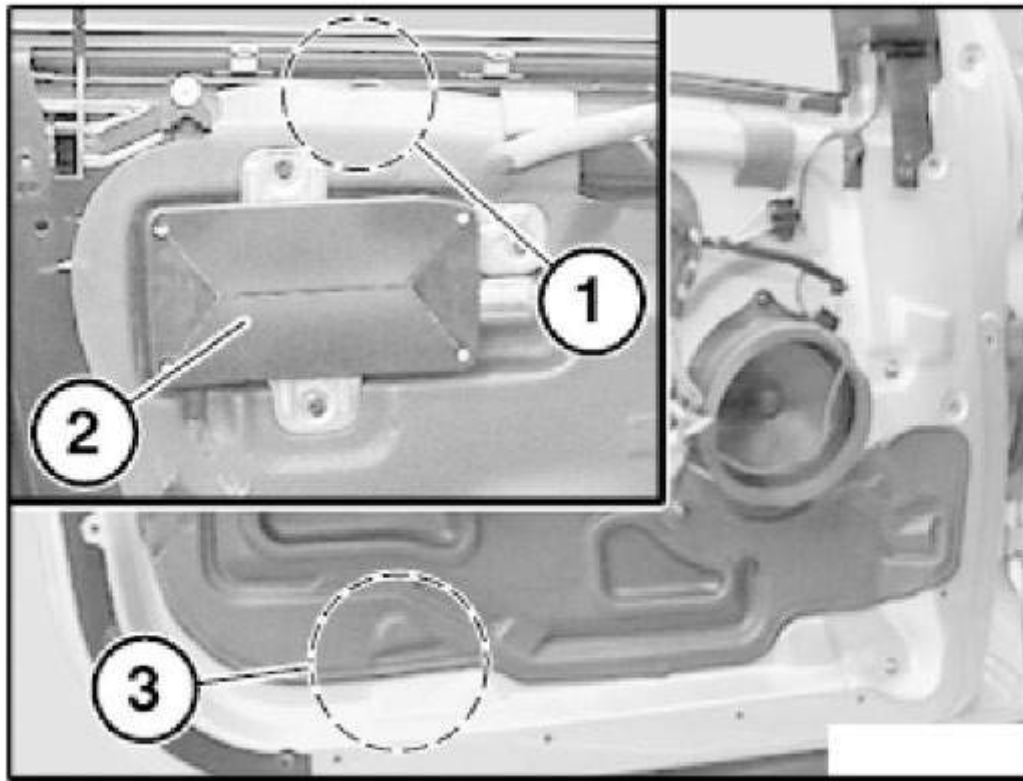
Courtesy of BMW OF NORTH AMERICA, INC.

Adjusting Door Window Glass:

NOTE: **Partially detach soundproofing in areas (1) and (3) only.**

Side airbag (2) remains fitted.

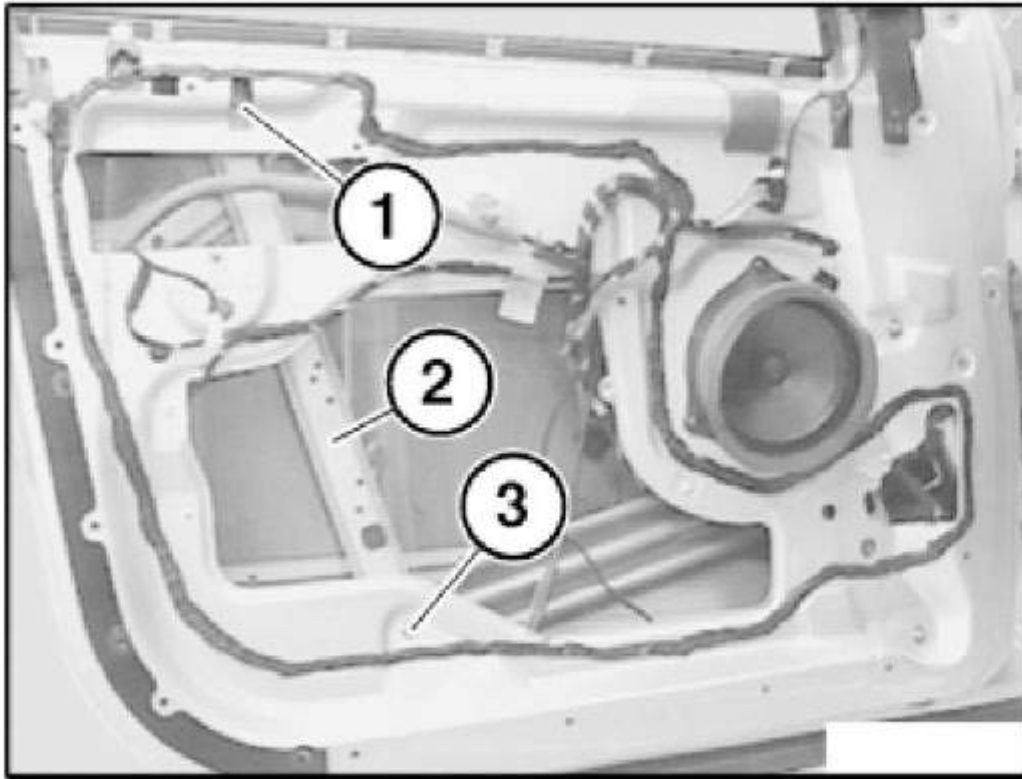
For partial detachment of soundproofing, follow procedure detailed in Removing and installing/replacing soundproofing in left or right front door, refer to **51 48 ... REMOVING AND INSTALLING/REPLACING SOUND INSULATION IN FRONT DOOR, LEFT OR RIGHT** .



G03255860

Fig. 290: Identifying Areas Of Soundproofing
Courtesy of BMW OF NORTH AMERICA, INC.

NOTE: For purposes of clarity, illustration shows soundproofing removed. Slacken off nuts (1) and (3) (do not release fully). Close door window glass with window lift (2) fully and if necessary press upwards until ideal setting is obtained. Tighten down nuts (1) and (3).



G03255861

Fig. 291: Locating Window Lift Nuts

Courtesy of BMW OF NORTH AMERICA, INC.

51 32 160 REMOVING AND INSTALLING/REPLACING COVER (ANTI-TRAPPING PROTECTION) ON DOOR WINDOW FRAME, LEFT OR RIGHT, INSIDE

Remove front door trim panel. Refer to **51 41 000 REMOVING AND INSTALLING LEFT OR RIGHT FRONT DOOR TRIM PANEL** .

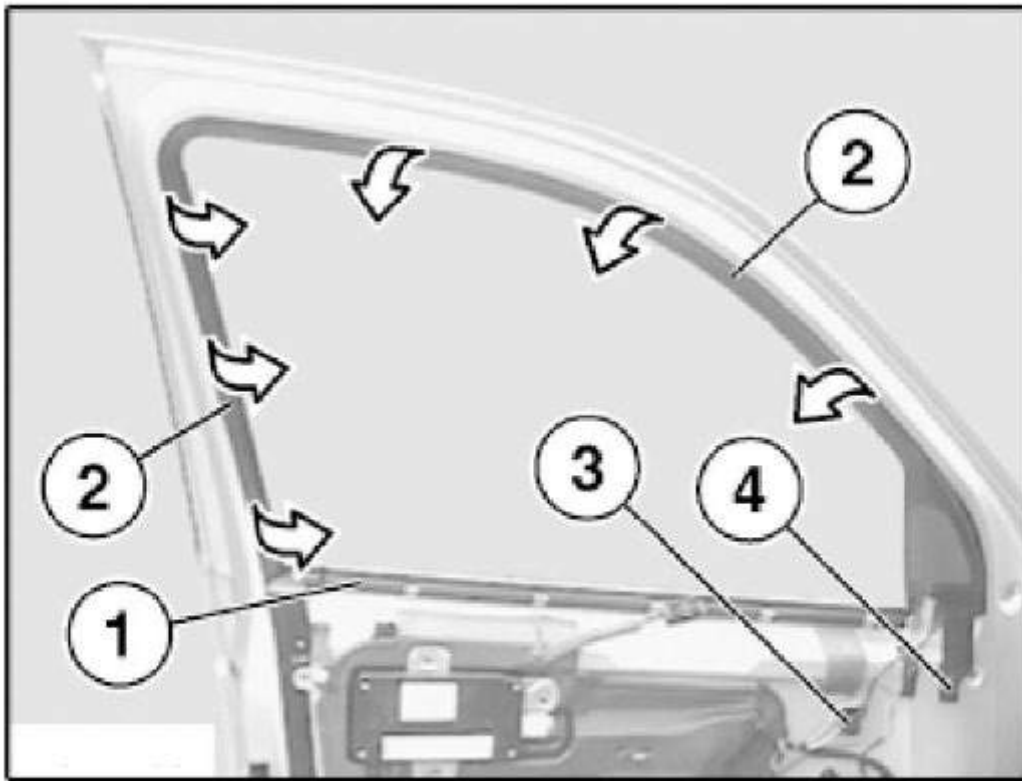
Rear for outside trim only:

Carefully lever out clip (1) and lever out cover (2) in rear area.

Additionally for complete removal:

Disconnect plug connection (3).

Carefully lever out clip (4) and lever out cover (2) completely.

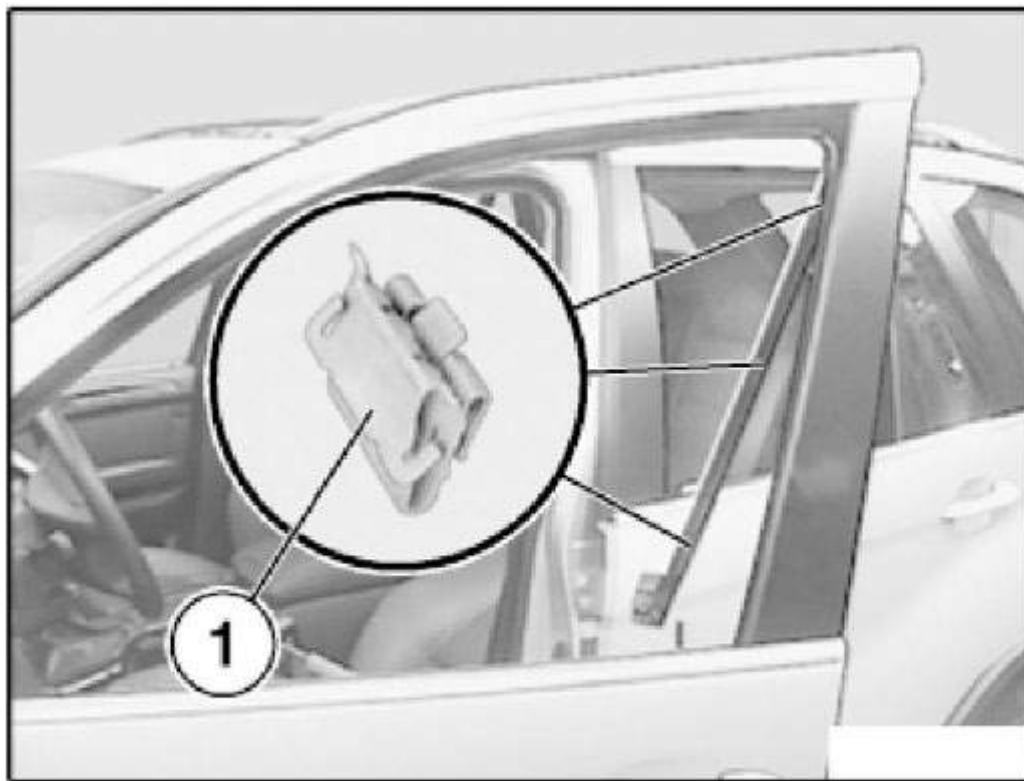


G03255862

Fig. 292: Removing Cover On Door Window Frame
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

If applicable, replace defective clips (1).

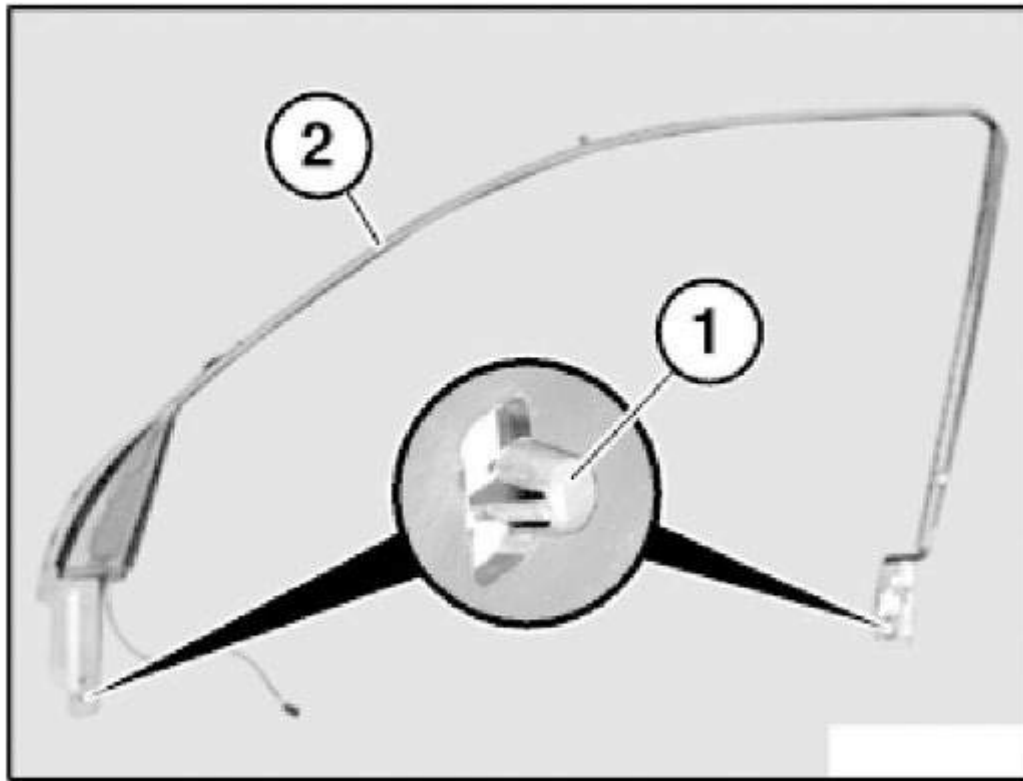


G03255863

Fig. 293: Identifying Door Cover Clips
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Clips (1) on cover (2) must not be damaged.



G03255864

Fig. 294: Identifying Clips On Cover

Courtesy of BMW OF NORTH AMERICA, INC.

51 32 170 REMOVING AND INSTALLING/REPLACING DOOR WINDOW GLASS, FRONT LEFT OR RIGHT

Remove window cavity cover strip on outside. Refer to **51 21 300 REMOVING AND INSTALLING/REPLACING WINDOW CAVITY COVER STRIP ON OUTSIDE OF FRONT DOOR** .

Remove sound insulation on front door. Refer to **51 48 ... REMOVING AND INSTALLING/REPLACING SOUND INSULATION IN FRONT DOOR, LEFT OR RIGHT** .

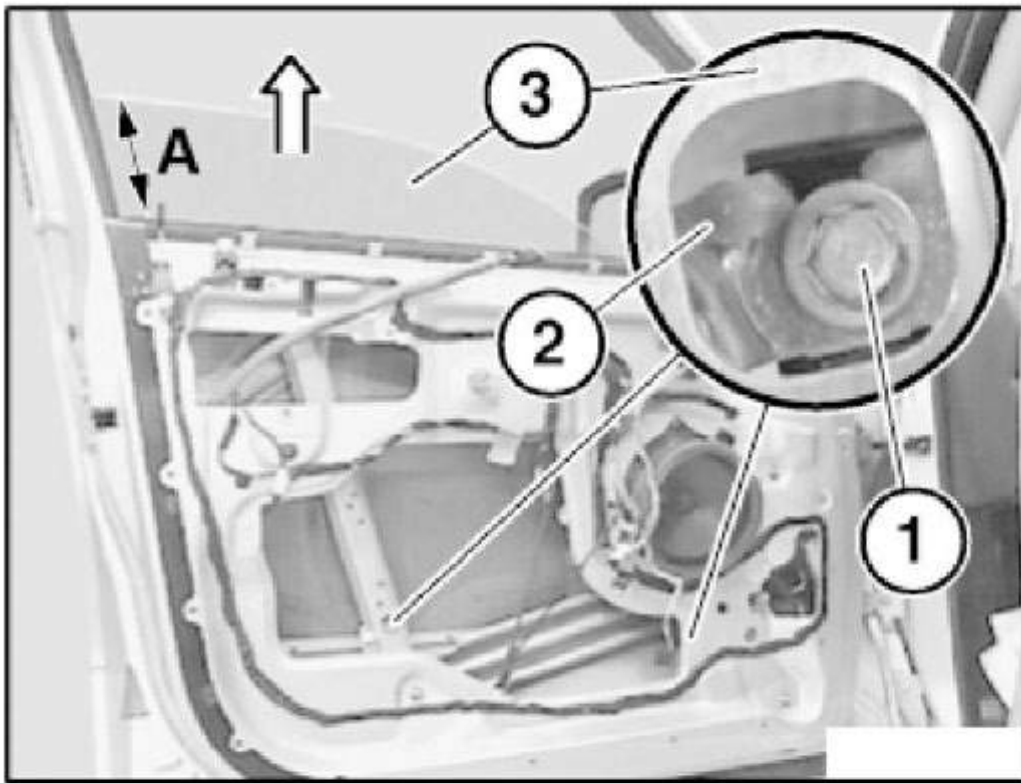
Open door window glass to distance (A).

A = approx. 145 mm.

CAUTION: Disconnect battery negative lead. Refer to 12 00 ... INSTRUCTIONS FOR DISCONNECTING AND CONNECTING BATTERY .

Loosen screws (1).

Detach glass (3) from window regulator (2), turn and lift out towards rear/top from front door.



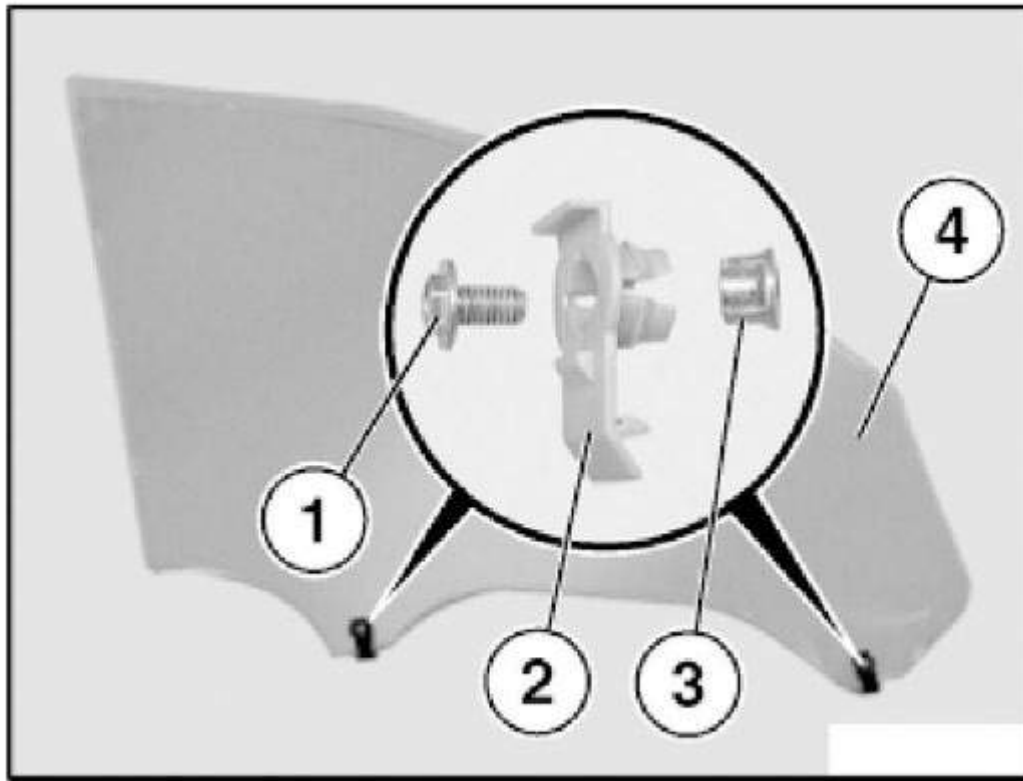
G03255865

Fig. 295: Identifying Window Glass And Regulator
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Each time the door window glass is removed or replaced, the holders (2) must be replaced.

If necessary, fit new screws (1) and nuts (3) on door window glass (4).



G03255866

Fig. 296: Identifying Screws And Nuts On Door Window Glass
Courtesy of BMW OF NORTH AMERICA, INC.

Adjust door window glass. Refer to **51 32 154 ADJUSTING LEFT OR RIGHT FRONT DOOR WINDOW** .

51 32 211 REPLACING FRONT LEFT OR RIGHT RUBBER GUIDE FOR LEFT OR RIGHT DOOR WINDOW

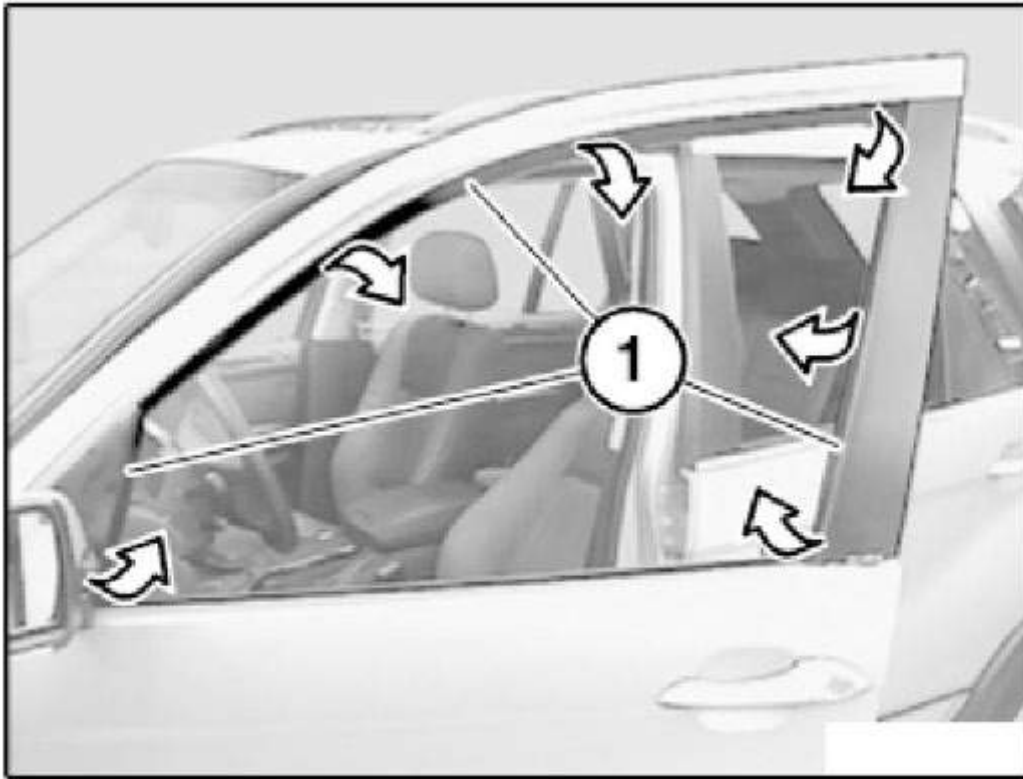
Remove window cavity cover strip on outside of front door. Refer to **51 21 300 REMOVING AND INSTALLING/REPLACING WINDOW CAVITY COVER STRIP ON OUTSIDE OF FRONT DOOR** .

Remove sound insulation on front door. Refer to **51 48 ... REMOVING AND INSTALLING/REPLACING SOUND INSULATION IN FRONT DOOR, LEFT OR RIGHT** .

Remove cover (anti-trap protection) on inside of door window frame. Refer to **51 34 160 REMOVING AND INSTALLING/REPLACING COVER (ANTI-TRAPPING PROTECTION) ON DOOR WINDOW FRAME (REAR DOOR), INSIDE LEFT OR RIGHT** .

Open complete door window glass.

Pull rubber guide (1) completely out of front door.



G03255867

Fig. 297: View Of Rubber Guide In Front Door
Courtesy of BMW OF NORTH AMERICA, INC.

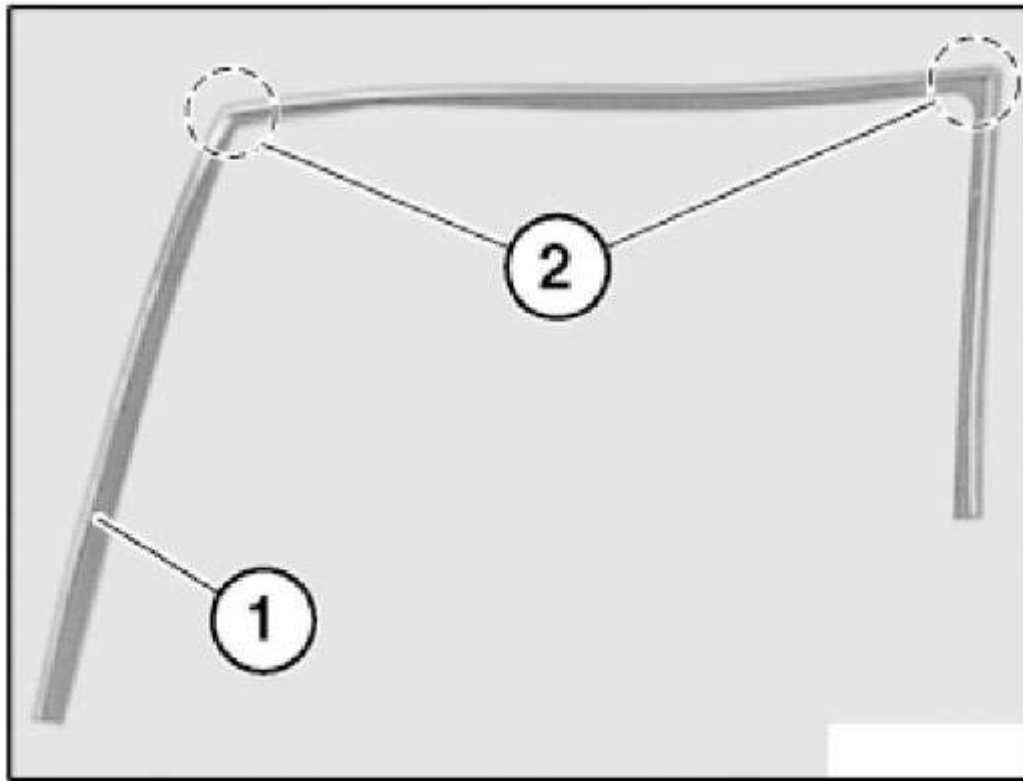
Installation:

For installation, coat window cavity seal (1) with turpentine substitute.

Insert rubber guide at front/bottom into window guide rail.

Installation:

Rubber guide (1) must not be damaged in corners (2).



G03255868

Fig. 298: Identifying Corners Of Rubber Guide
Courtesy of BMW OF NORTH AMERICA, INC.

51 32 390 REMOVING AND INSTALLING/REPLACING DECORATIVE STRIP ON FRONT LEFT OR RIGHT DOOR

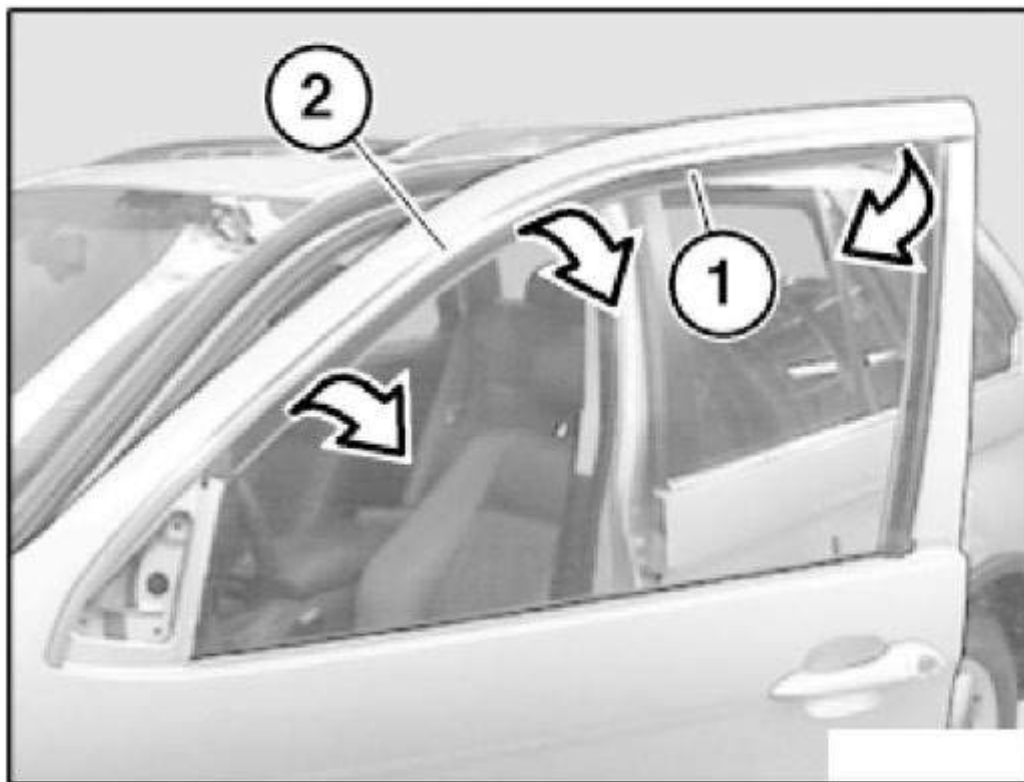
Remove mirror on front door. Refer to **51 16 000 REMOVING AND INSTALLING/REPLACING MIRROR ON LEFT OR RIGHT FRONT DOOR** .

Remove trim on window frame of front door. Refer to **51 32 420 REMOVING AND INSTALLING/REPLACING FINISHER ON FRONT DOOR WINDOW FRAME, LEFT OR RIGHT** .

Remove cover (anti-trap protection) on inside of door window frame. Refer to **51 34 160 REMOVING AND INSTALLING/REPLACING COVER (ANTI-TRAPPING PROTECTION) ON DOOR WINDOW FRAME (REAR DOOR), INSIDE LEFT OR RIGHT** .

Open door window.

Pull off window rubber guide (1) in area of decorative strip (2).

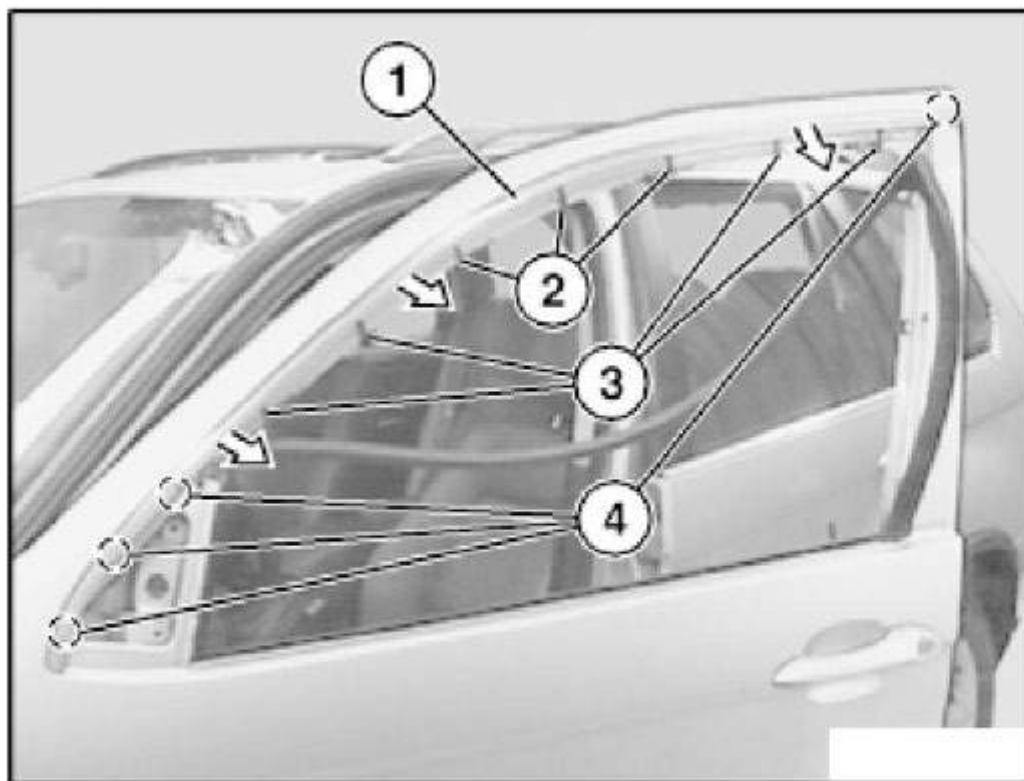


G03255869

Fig. 299: Pulling Off Window Rubber Guide
Courtesy of BMW OF NORTH AMERICA, INC.

Unfasten screws (2).

Carefully unclip clips (4).



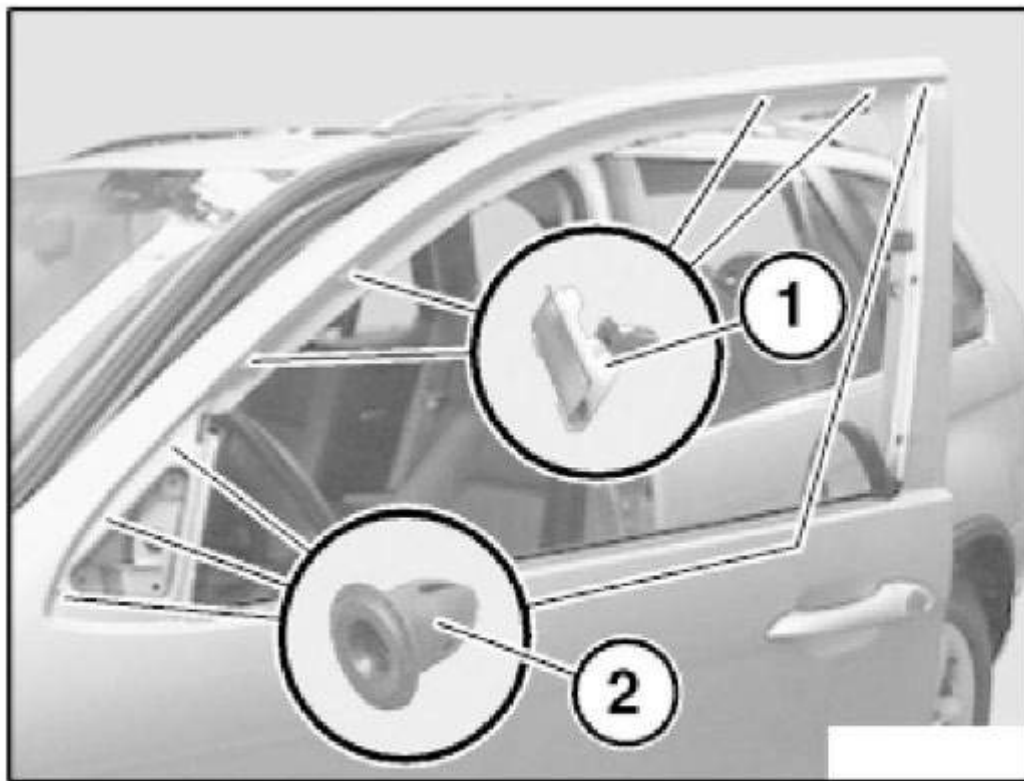
G03255870

Fig. 300: Unfastening Screws And Clips
Courtesy of BMW OF NORTH AMERICA, INC.

Detach decorative strip (1) outwards from clips (3).

Installation:

If necessary, replace faulty clips (1) and grommets (2).

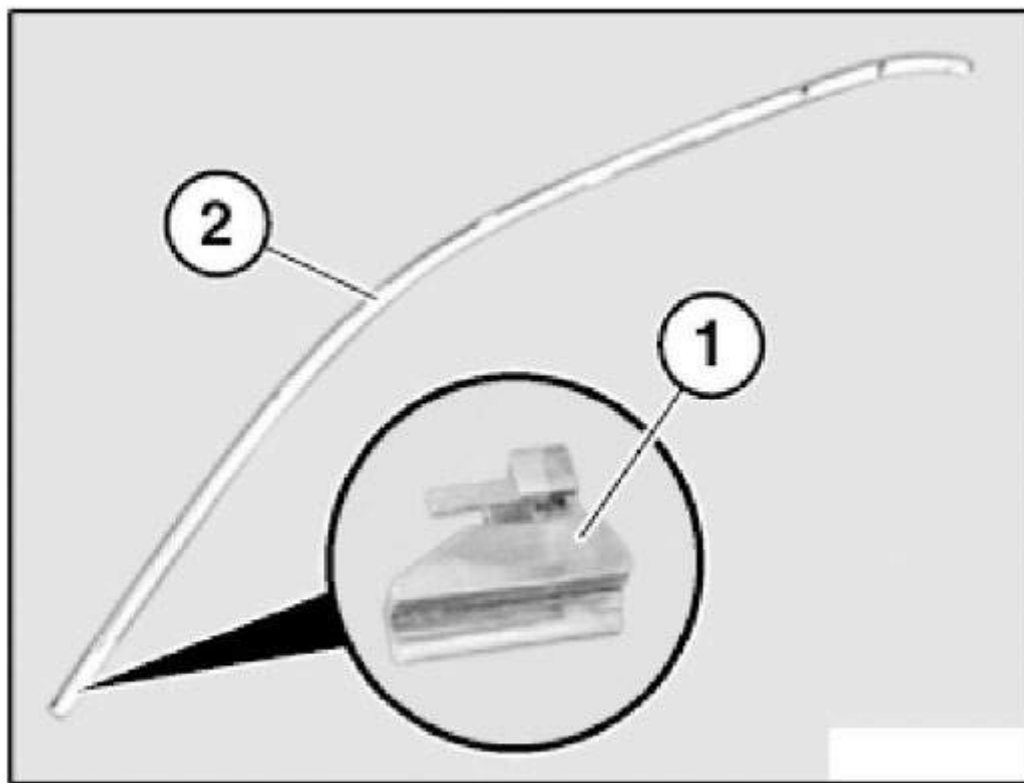


G03255871

Fig. 301: Replacing Clips And Grommets
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

If necessary, replace defective clip (1).



G03255872

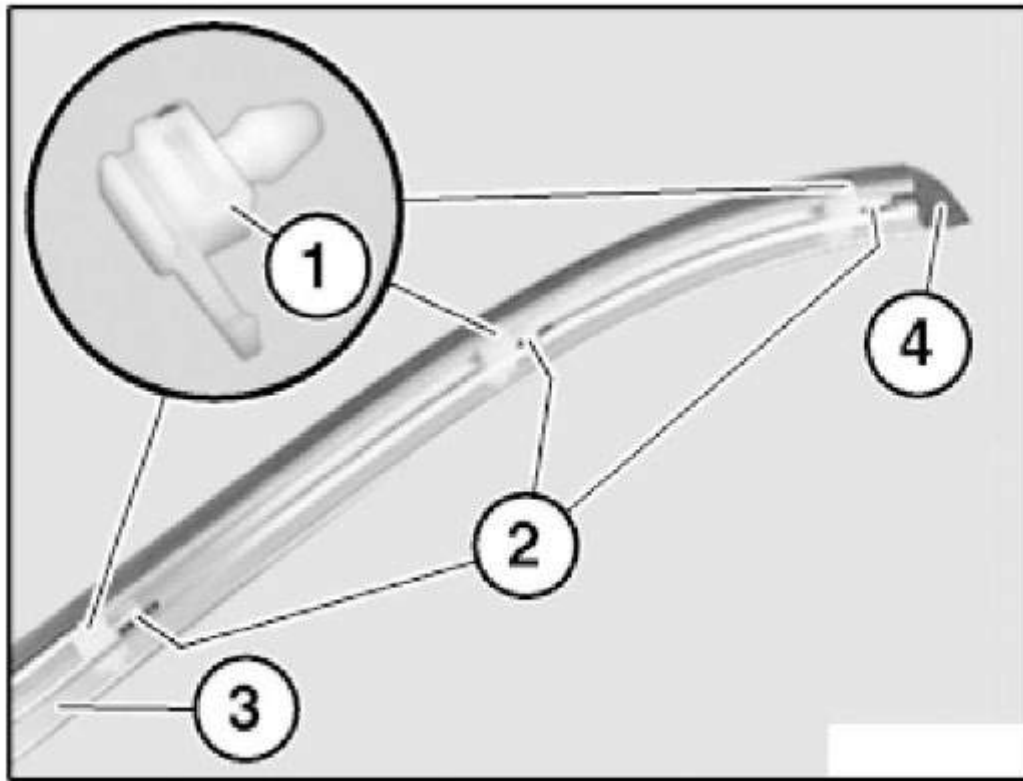
Fig. 302: Replacing Defective Clip

Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

If necessary, replace defective clips (1).

Decorative strip (3) incorporates notches (2) for positioning of clips (1).



G03255873

Fig. 303: Identifying Decorative Strip Clips
 Courtesy of BMW OF NORTH AMERICA, INC.

After installing clips (1), reinsert seal (4) in guide of decorative strip (3).

51 32 420 REMOVING AND INSTALLING/REPLACING FINISHER ON FRONT DOOR WINDOW FRAME, LEFT OR RIGHT

Remove window cavity cover strip on outside of front door. Refer to **51 21 300 REMOVING AND INSTALLING/REPLACING WINDOW CAVITY COVER STRIP ON OUTSIDE OF FRONT DOOR** .

Partially lever out cover (anti-trap protection) on door window frame at rear. Refer to **51 32 160 REMOVING AND INSTALLING/REPLACING COVER (ANTI-TRAPPING PROTECTION) ON DOOR WINDOW FRAME, LEFT OR RIGHT, INSIDE** .

Open door window.

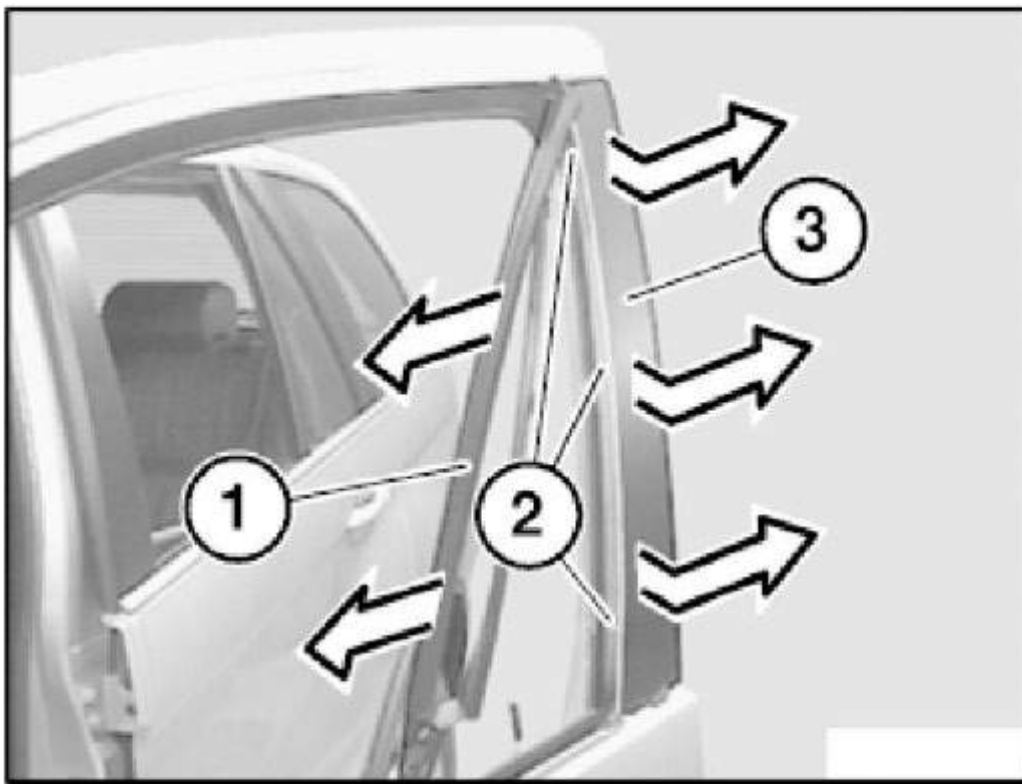
Partially detach rubber window seal (1) at rear.

Installation:

For installation, coat window rubber guide (1) with turpentine substitute.

Release screws (2).

Lever out finisher (3) and detach towards rear.

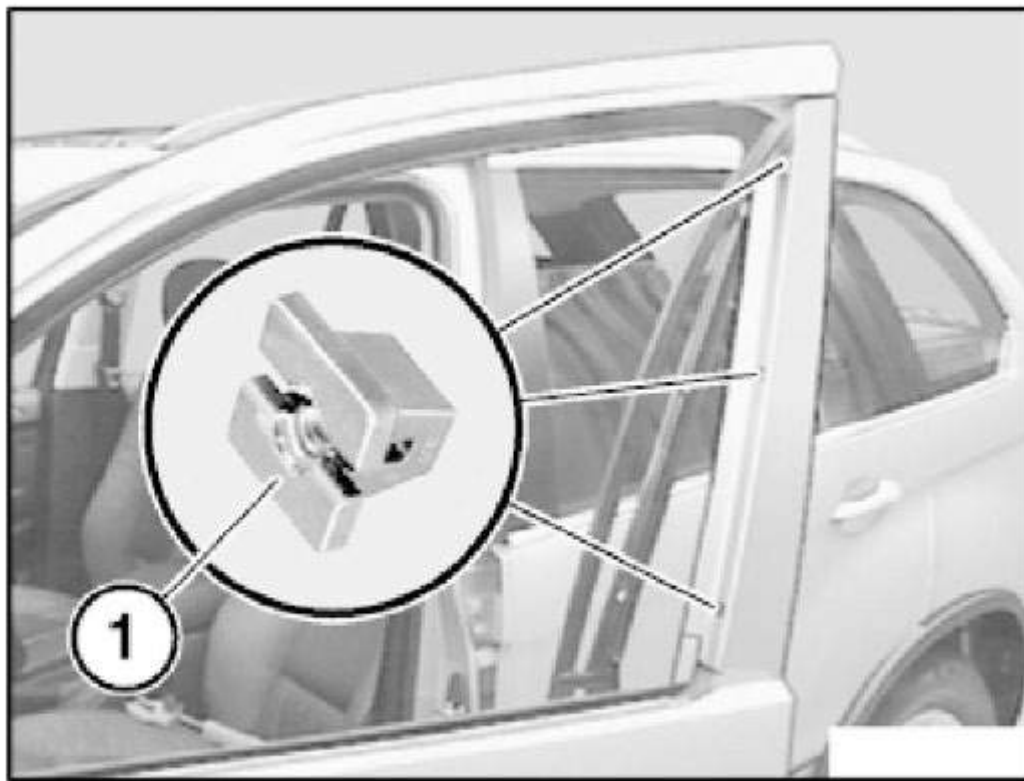


G03255874

Fig. 304: Detaching Rubber Window Seal
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

If necessary, replace faulty plastic nuts (1).



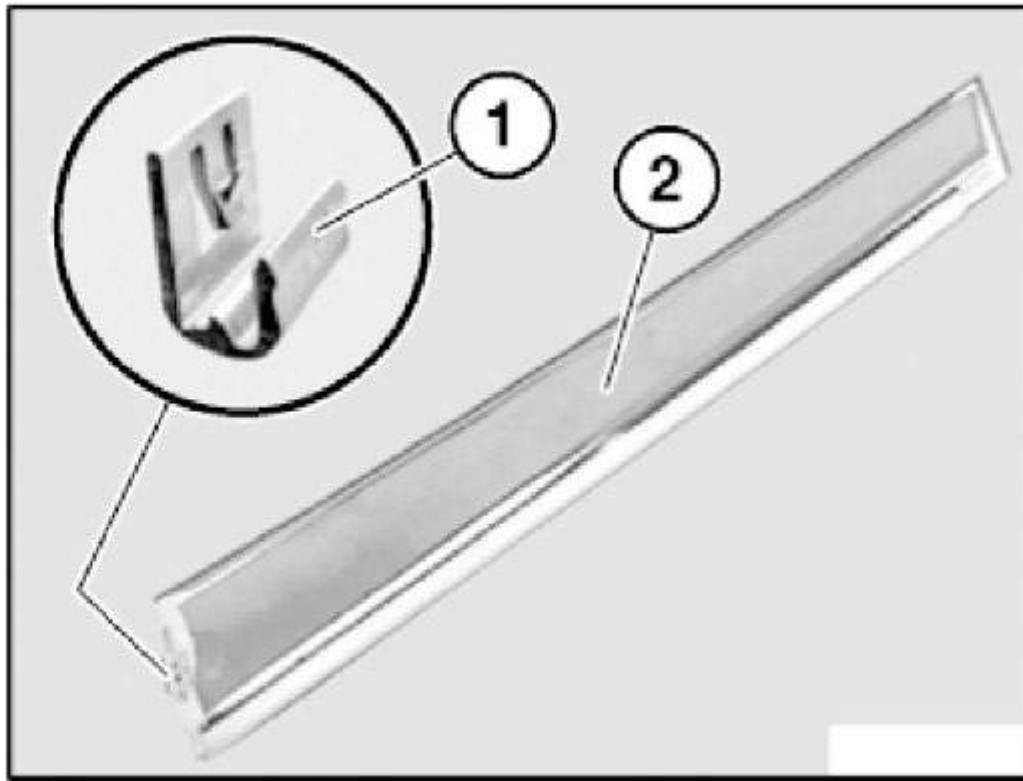
G03255875

Fig. 305: Identifying Plastic Nuts

Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

If necessary, replace faulty clip (1) on finisher (2).



G03255876

Fig. 306: Replacing Finisher Clip

Courtesy of BMW OF NORTH AMERICA, INC.

FRONT ELECTRICAL OPERATED WINDOWS

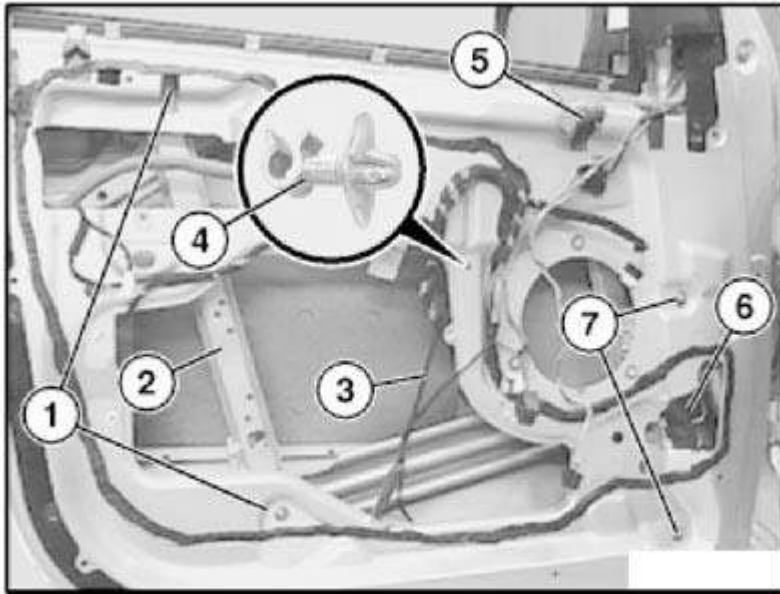
51 33 000 REMOVING AND INSTALLING POWER WINDOW REGULATOR IN LEFT OR RIGHT FRONT DOOR

Remove door window glass. Refer to **51 32 170 REMOVING AND INSTALLING/REPLACING DOOR WINDOW GLASS, FRONT LEFT OR RIGHT** .

Remove speaker in front door. Refer to **65 12 000 REMOVING AND INSTALLING/REPLACING SPEAKER (FRONT LEFT OR RIGHT DOOR)** .

Release nuts (1) and feed rear section (2) of window regulator out of front door.

Unhook cable (3) from clip (4).



G03255877

Fig. 307: Identifying Cable Clip

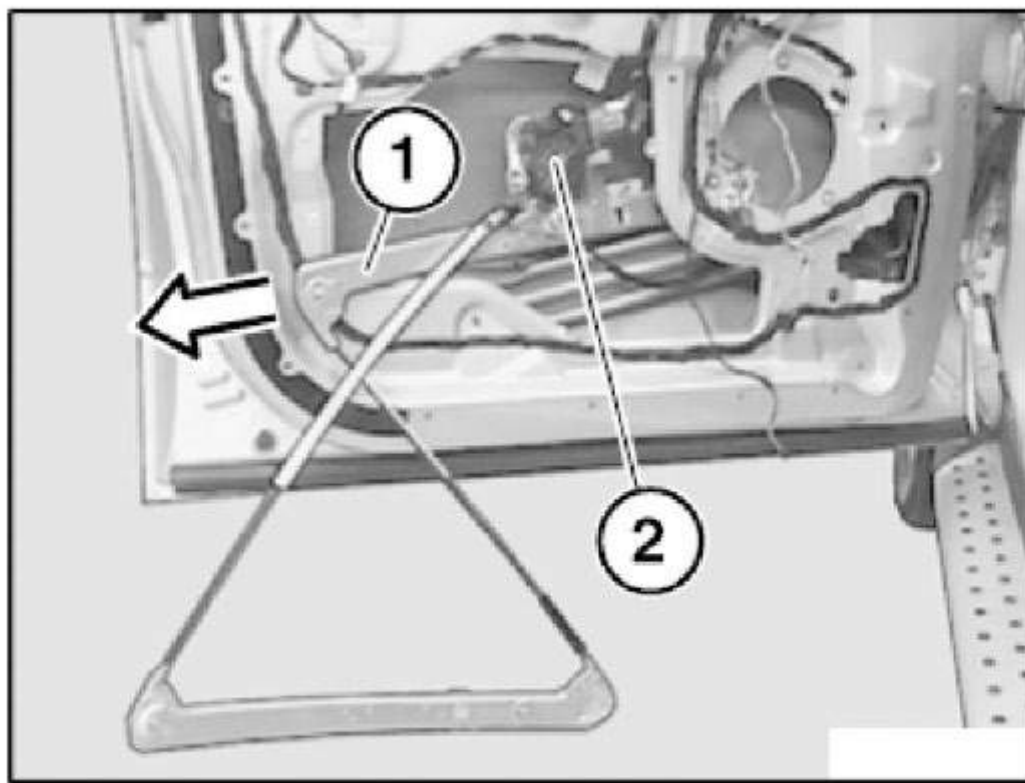
Courtesy of BMW OF NORTH AMERICA, INC.

Lever out foam (5) and release nut underneath.

Disconnect plug connection (6) if necessary.

Release nuts (7).

Feed rear section of window regulator (1) with drive mechanism (2) out of front door.

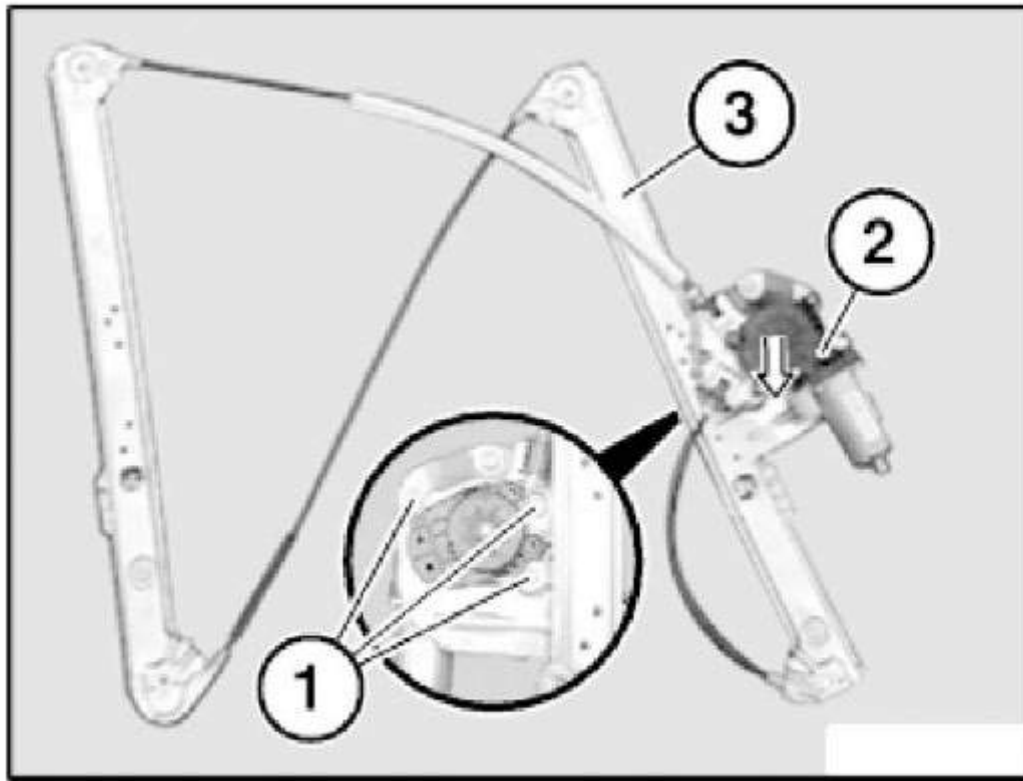


G03255878

Fig. 308: Removing Rear Section Of Window Regulator
Courtesy of BMW OF NORTH AMERICA, INC.

Only Replacement:

Release screws (1) and detach drive mechanism (2) from window regulator (3).



G03255879

Fig. 309: Detaching Drive Mechanism And Screws From Regulator
Courtesy of BMW OF NORTH AMERICA, INC.

REAR MANUALLY OPERATED WINDOWS

51 34... REMOVING AND INSTALLING/REPLACING WINDOW GUIDE RAIL OF REAR DOOR, REAR LEFT OR RIGHT

Version with roller sun blind:

Remove roller sun blind on fixed door window. Refer to **51 16 400 REMOVING AND INSTALLING OR REPLACING SUN BLIND AT FIXED SIDE WINDOW OF LEFT OR RIGHT REAR DOOR** .

Version without roller sun blind only:

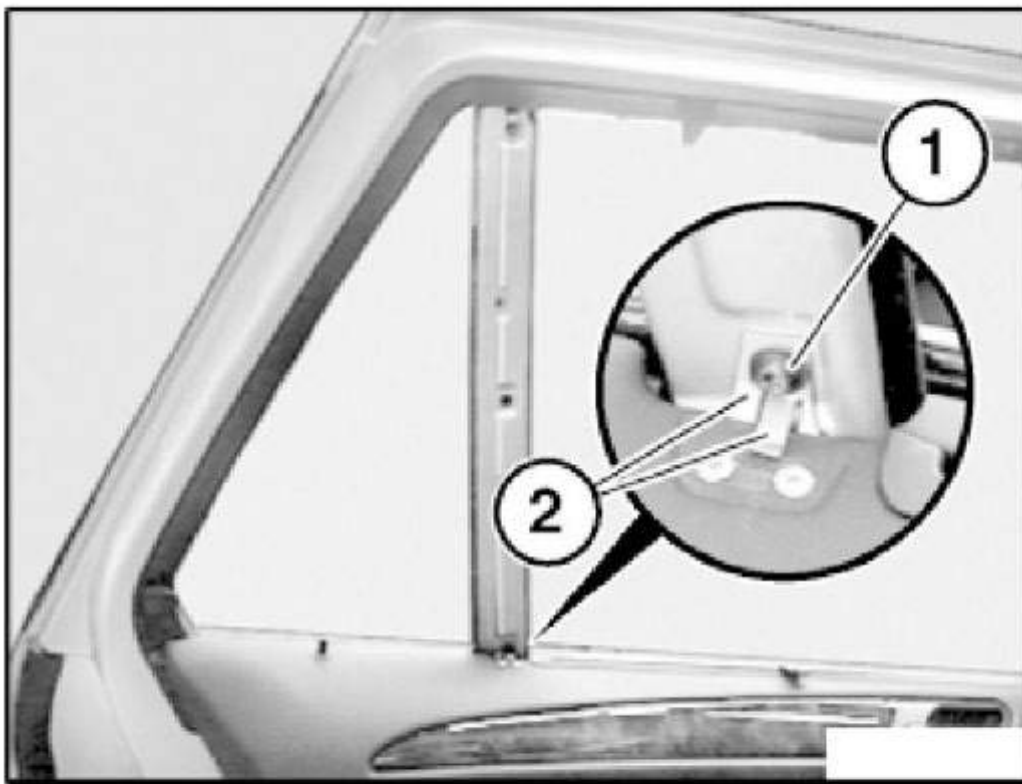
Remove cover (anti-trap protection) on door window frame. Refer to **51 34 160 REMOVING AND INSTALLING/REPLACING COVER (ANTI-TRAPPING PROTECTION) ON DOOR WINDOW FRAME (REAR DOOR), INSIDE LEFT OR RIGHT** .

Release screw (1).

Version with roller sun blind:

Installation:

Holder (2) on door trim panel must not be damaged.



G03255880

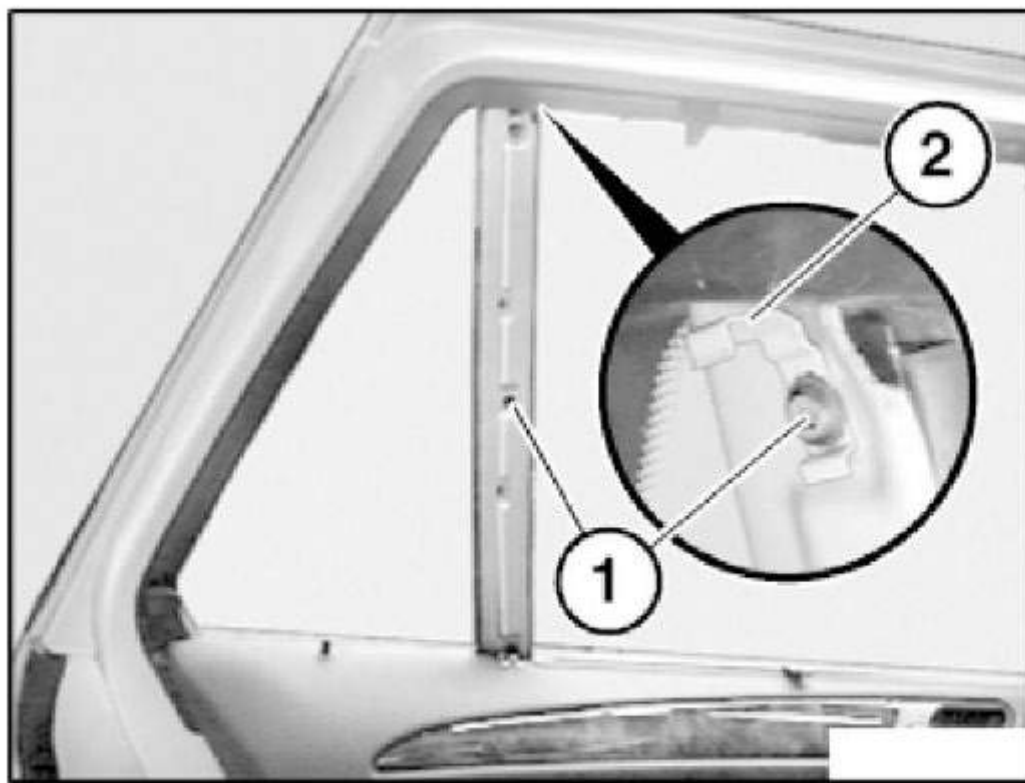
Fig. 310: Locating Holder On Door Trim Panel
Courtesy of BMW OF NORTH AMERICA, INC.

Release screws (1).

Version with roller sun blind:

Installation:

Remove holder (2) for roller sun blind.

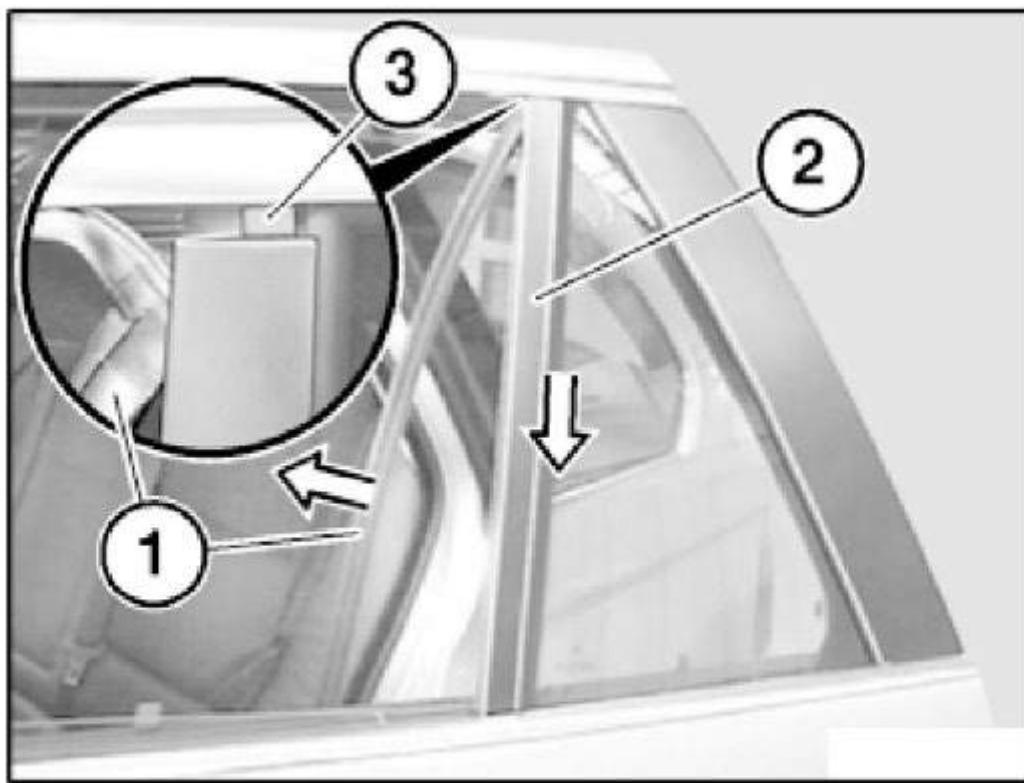


G03255881

Fig. 311: Removing Holder For Roller Sun Blind
Courtesy of BMW OF NORTH AMERICA, INC.

Pull rubber guide (1) out of window guide rail (2).

Slide window guide rail (1) downwards until guide (3) is free and then pull out towards top.

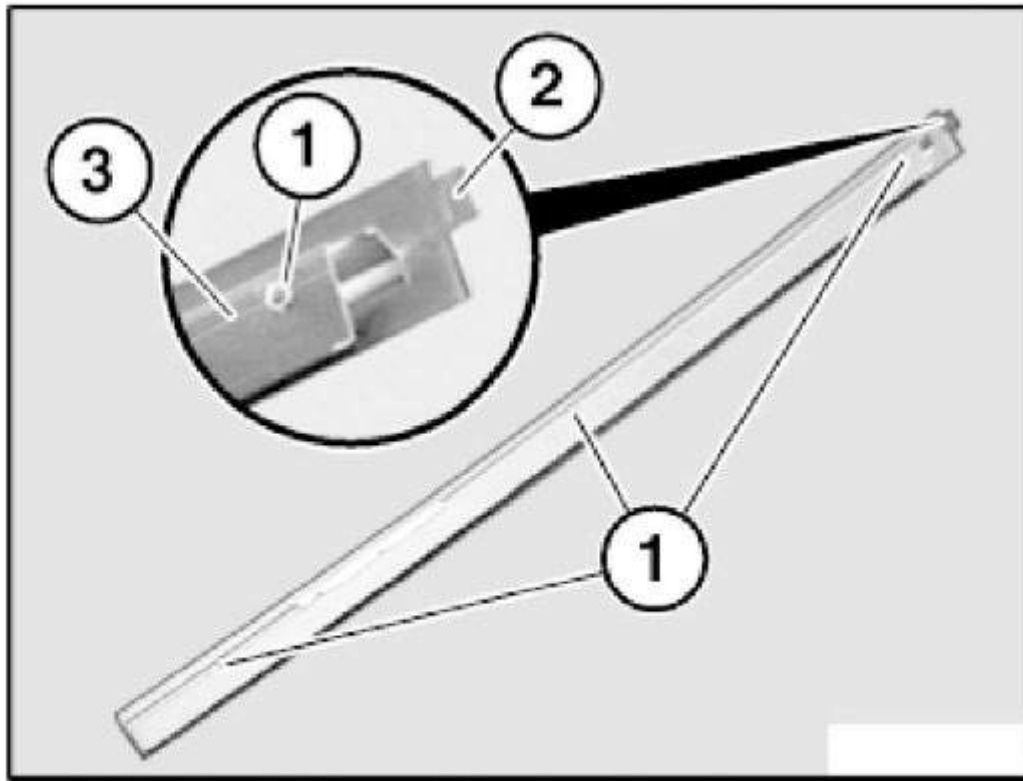


G03255882

Fig. 312: Pulling Rubber Guide Out Of Window Guide Rail
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Threads (1) and guide (2) of window guide rail (3) must not be damaged.



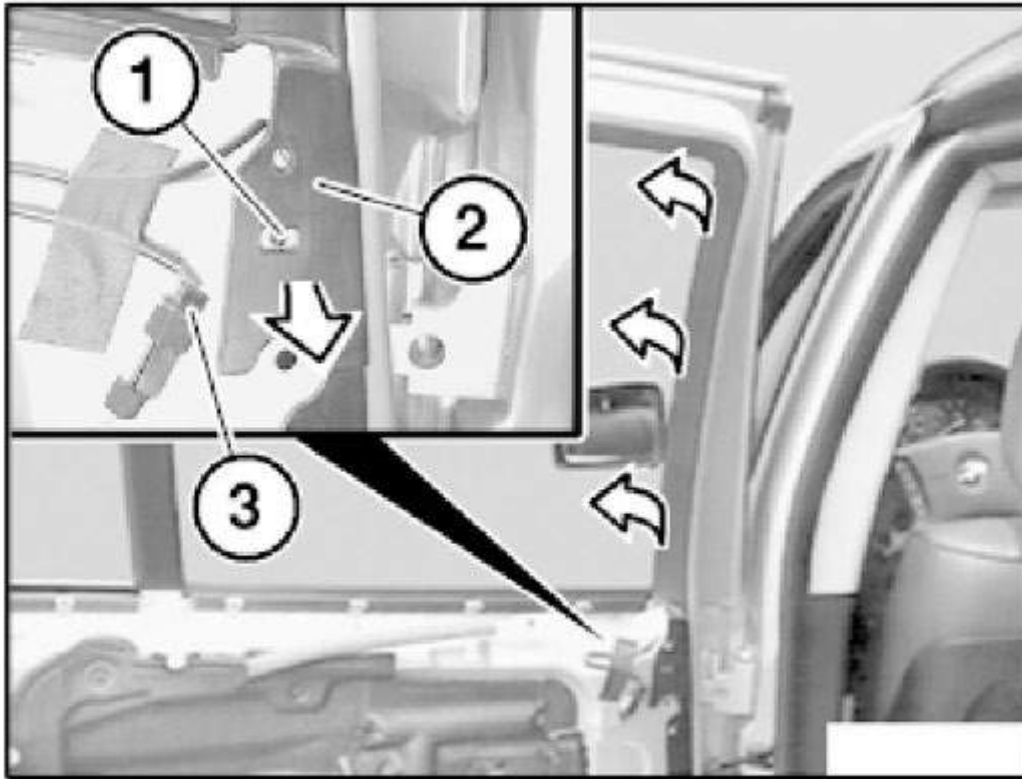
G03255883

Fig. 313: Identifying Threads And Guide Of Window Guide Rail
Courtesy of BMW OF NORTH AMERICA, INC.

**51 34 160 REMOVING AND INSTALLING/REPLACING COVER (ANTI-TRAPPING PROTECTION)
ON DOOR WINDOW FRAME (REAR DOOR), INSIDE LEFT OR RIGHT**

Remove rear door trim panel. Refer to **51 42 000 REMOVING AND INSTALLING REAR LEFT OR
RIGHT DOOR TRIM PANEL** .

Carefully lever out clip (1) and lever out trim (2) in rear area. Disconnect plug connection (3).

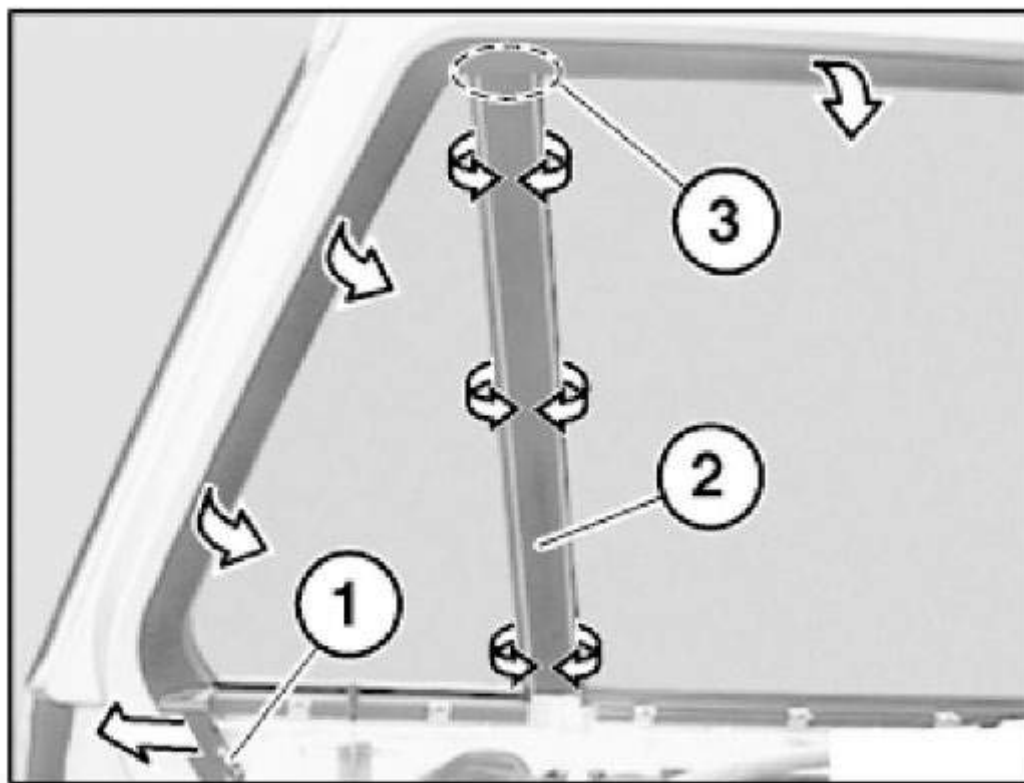


G03255884

Fig. 314: Levering Out Clip And Trim
Courtesy of BMW OF NORTH AMERICA, INC.

Carefully lever out clip (1).

Lift out cover (1) from fixed door window.



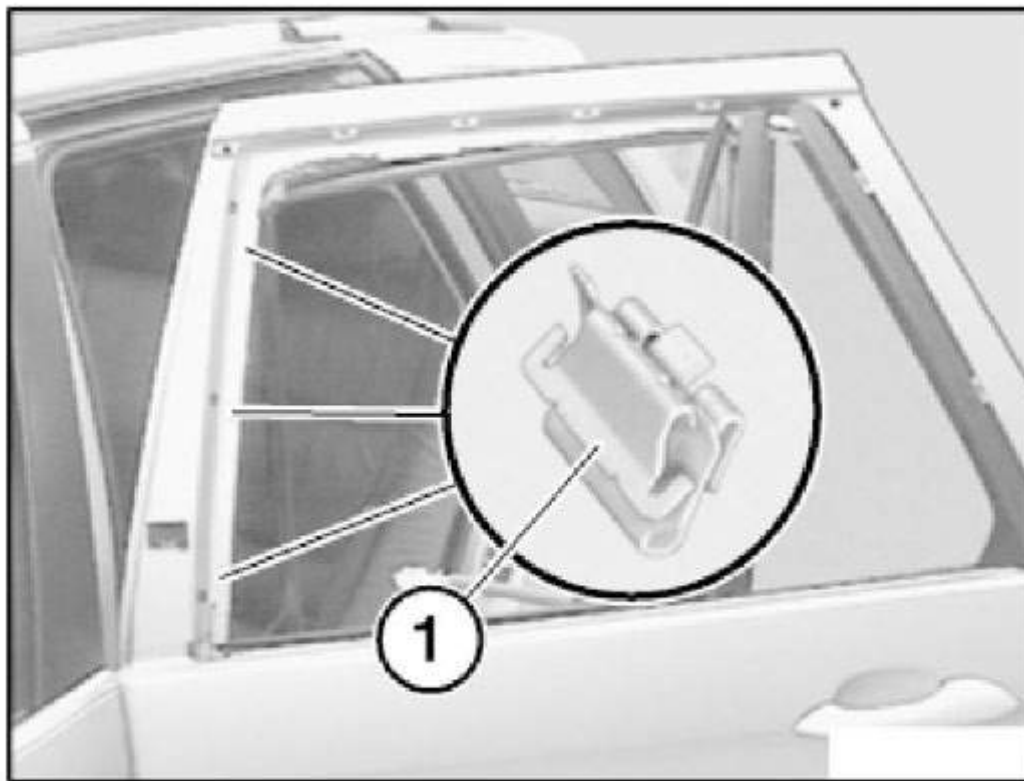
G03255885

Fig. 315: Lifting Out Cover From Fixed Door Window
Courtesy of BMW OF NORTH AMERICA, INC.

NOTE: Do not tear off cover (1) in area (2). Lift out and remove cover (2).

Installation:

If applicable, replace defective clips (1).



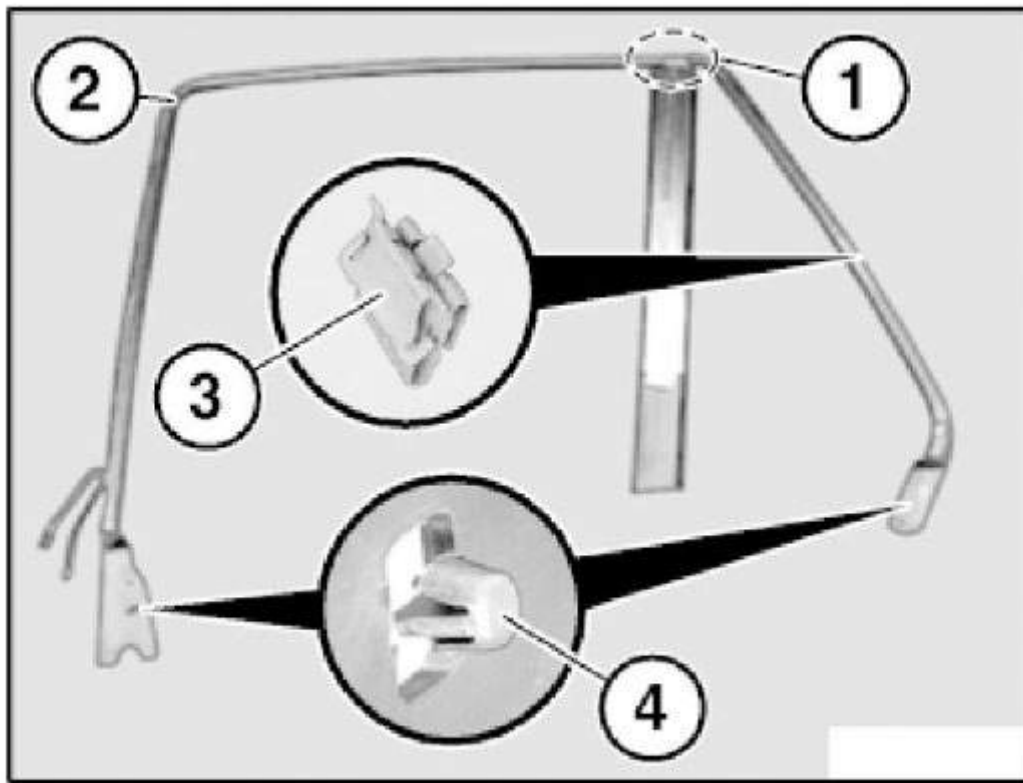
G03255886

Fig. 316: Replacing Door Trim Clips

Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Connection (1) of cover (2) must not be damaged.



G03255887

Fig. 317: Identifying Door Trim Cover Connection
Courtesy of BMW OF NORTH AMERICA, INC.

If necessary, replace faulty clip (3).

Clips (4) must not be damaged.

Carry out function check.

51 34 171 REPLACING REAR LEFT OR RIGHT DOOR WINDOW

Remove sound insulation on rear door. Refer to **51 48 ... REMOVING AND INSTALLING/REPLACING SOUND INSULATION IN REAR DOOR, LEFT OR RIGHT** .

NOTE: When removing the power window lift, do not remove the door window glass.

Only for removal and installation of door window glass:

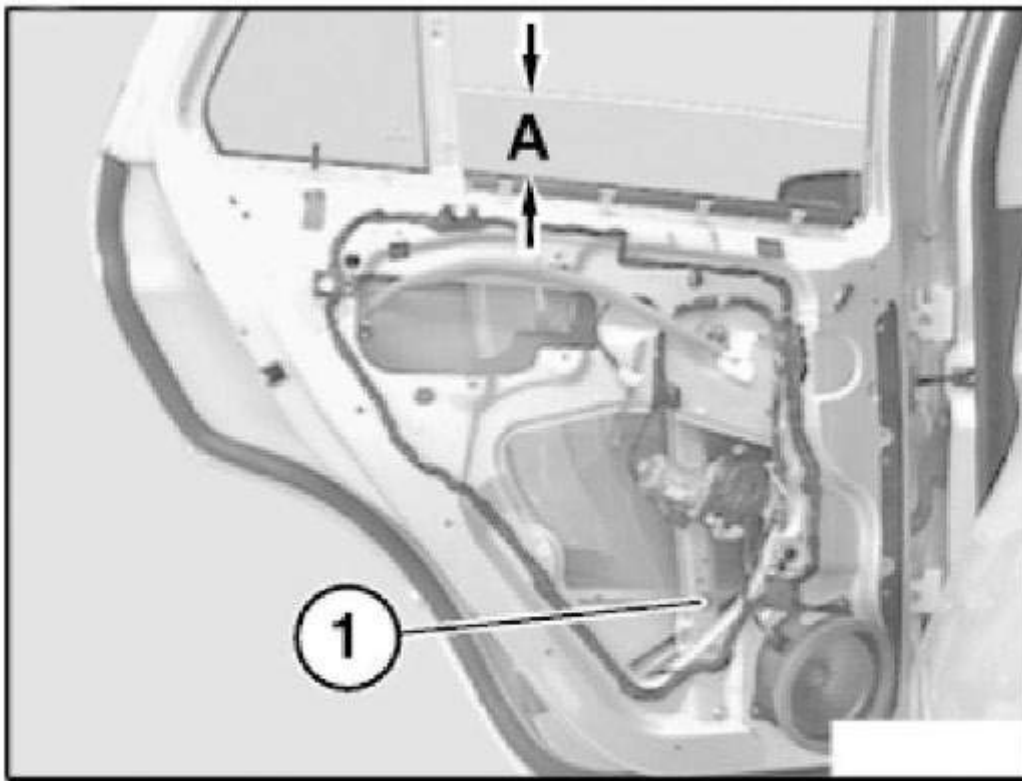
If necessary, remove trim on window frame of rear door (front). Refer to **51 34 420 REMOVING AND INSTALLING/REPLACING TRIM ON WINDOW FRAME OF REAR DOOR (FRONT), LEFT OR RIGHT** .

Open door window glass to distance (A).

A = approx. 85 mm.

CAUTION: Disconnect battery negative lead. Refer to **12 00 ... INSTRUCTIONS FOR DISCONNECTING AND CONNECTING BATTERY** .

Loosen bolt (1).



G03255888

Fig. 318: Removing Bolt On Rear Door
Courtesy of BMW OF NORTH AMERICA, INC.

NOTE: When removing the power window lift, do not remove the door window glass.

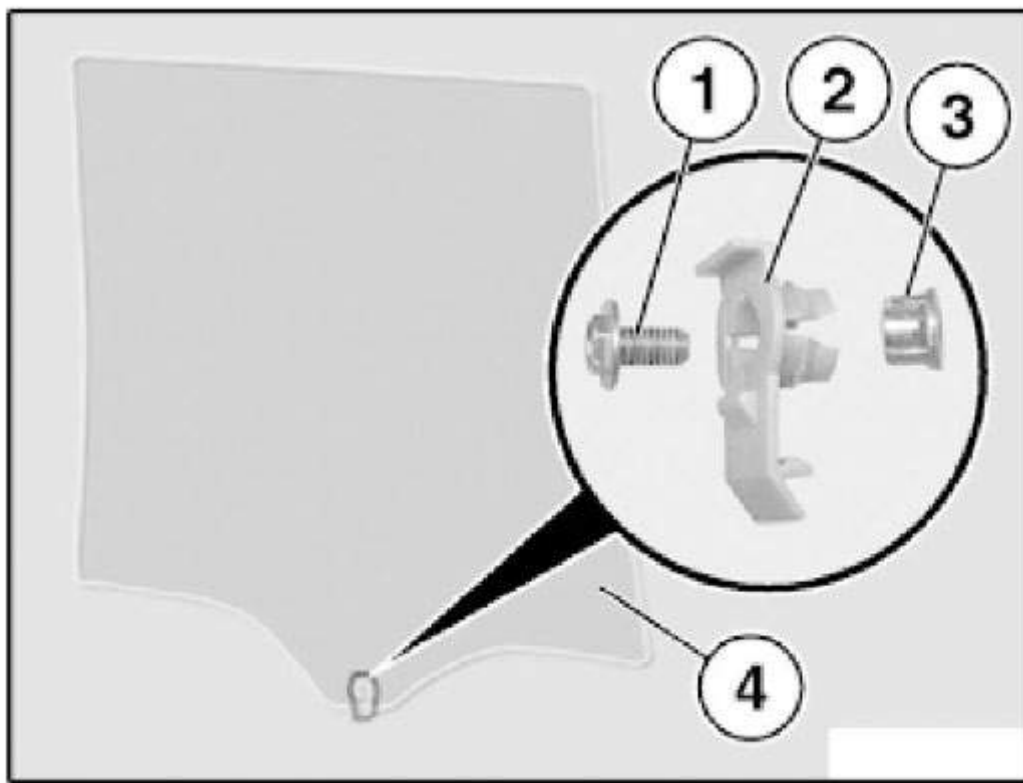
If necessary, stow door window glass towards bottom in rear door.

After removing or replacing door window glass: Remove door window glass towards top.

Installation:

Each time the door window glass is removed or replaced, the holder (2) must be replaced.

If necessary, fit new screw (1) and nut (3) on door window glass (4).



G03255889

Fig. 319: Identifying Holder, Screw And Nut
Courtesy of BMW OF NORTH AMERICA, INC.

NOTE: Door window glass does not need to be adjusted.

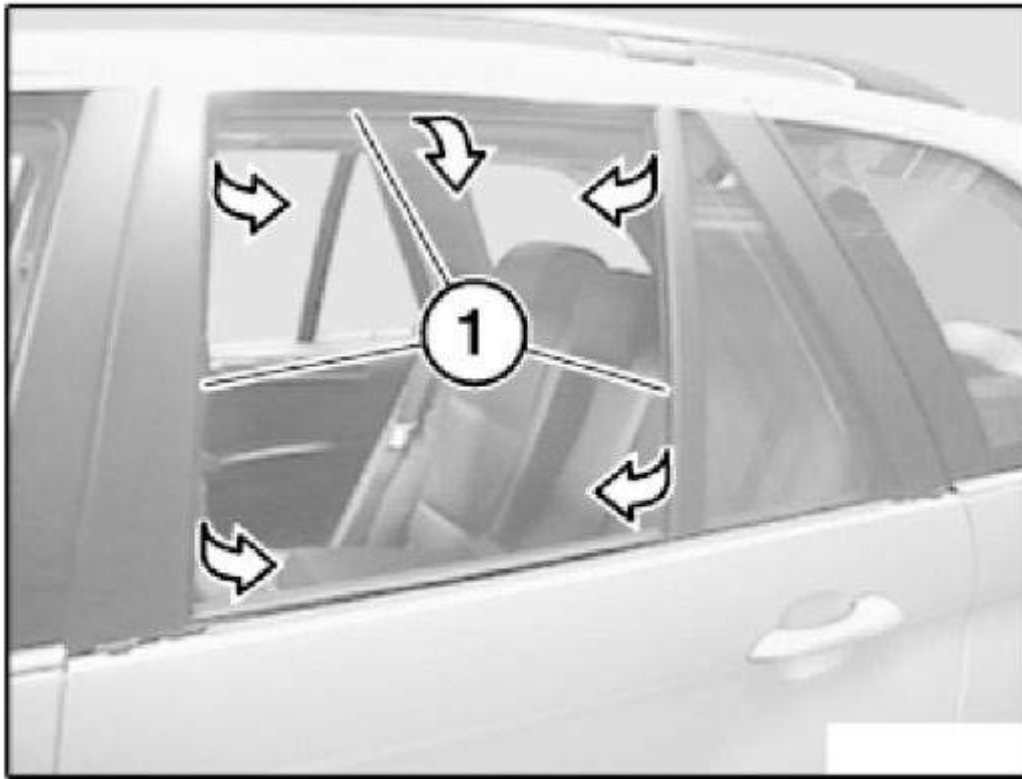
IMPORTANT: The "Instructions for window cementing" serve as the basis for these repair instructions and must be followed without fail. Refer to 51 31 ... INSTRUCTIONS ON GLUING WINDSCREEN .

51 34 211 REPLACING RUBBER GUIDE FOR REAR LEFT OR RIGHT DOOR WINDOW

Remove window cavity cover strip on outside of rear door. Refer to 51 22 300 REMOVING AND INSTALLING/REPLACING WINDOW CAVITY COVER STRIP ON REAR DOOR ON LEFT OR RIGHT .

Remove cover (anti-trap protection) on inside of door window frame. Refer to 51 34 160 REMOVING AND INSTALLING/REPLACING COVER (ANTI-TRAPPING PROTECTION) ON DOOR WINDOW FRAME (REAR DOOR), INSIDE LEFT OR RIGHT .

Remove rubber guide (1).



G03255890

Fig. 320: Removing Rubber Guide
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

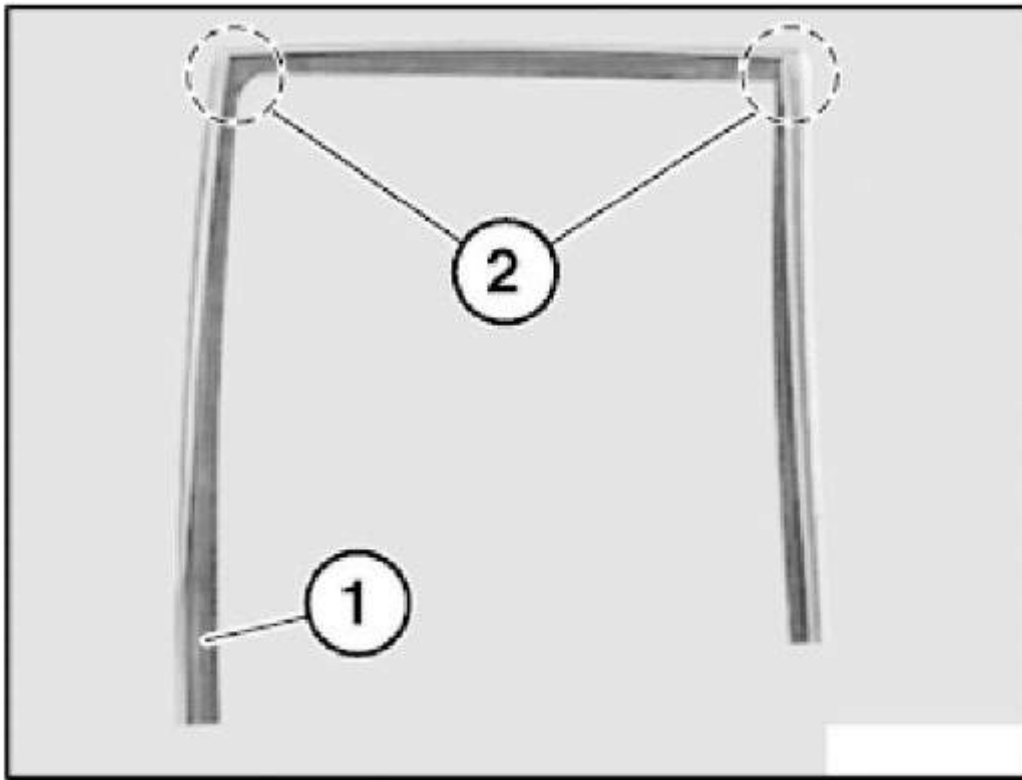
For installation, coat window cavity cover strip (1) with turpentine substitute.

Close door window glass a little.

Push rubber guide (1) onto door window glass and into window guide.

Installation:

Rubber guide (1) must not be damaged in corners (2).



G03255891

Fig. 321: Identifying Rubber Guide Corners
Courtesy of BMW OF NORTH AMERICA, INC.

**51 34 380 REMOVING AND INSTALLING/REPLACING DECORATIVE STRIP ON REAR DOOR
(TOP), LEFT OR RIGHT**

2001 BMW X5 30i

2001-2003 ACCESSORIES AND EQUIPMENT Exterior/Interior Trim - Repair Instructions - X5 (3.0i) E53

NOTE: For Special Tool identification, see **SPECIAL TOOLS - X5 (3.0i) .**

Special Tools Required:

- 00 9 317

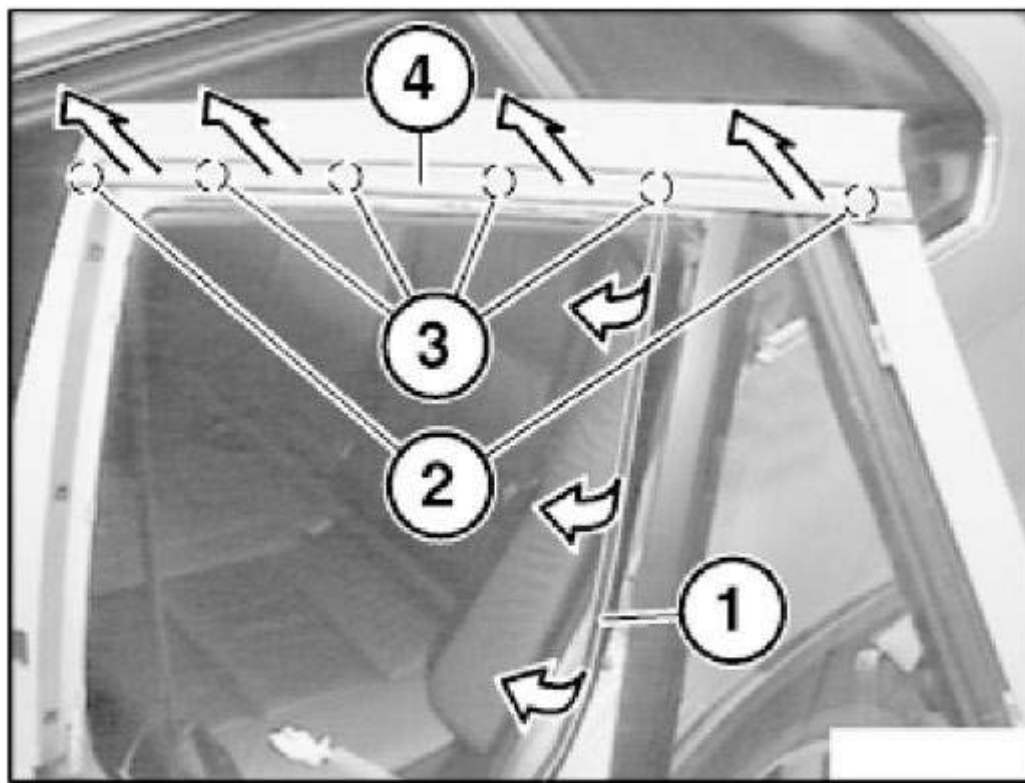
Remove trim on window frame of rear door (front). Refer to **51 34 420 REMOVING AND INSTALLING/REPLACING TRIM ON WINDOW FRAME OF REAR DOOR (FRONT), LEFT OR RIGHT .**

Remove trim on window frame of rear door (rear). Refer to **51 34 425 REMOVING AND INSTALLING/REPLACING TRIM ON WINDOW FRAME OF REAR DOOR, REAR LEFT OR RIGHT .**

Pull out window rubber guide (1) in upper area.

Unclip outer clips (2) with special tool 00 9 317 (trim panel wedge).

Detach decorative strip (4) outwards from clips (3).

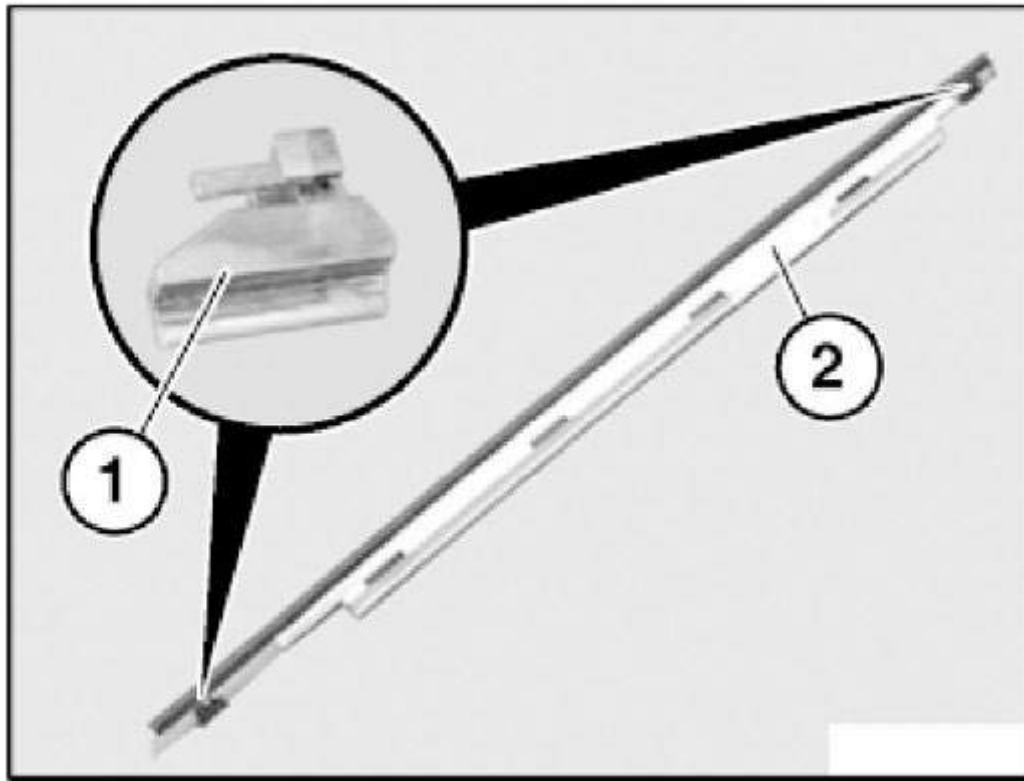


G03255892

Fig. 322: Pulling Out Window Rubber Guide
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

If necessary, replace faulty clips (1) on decorative strip (2).

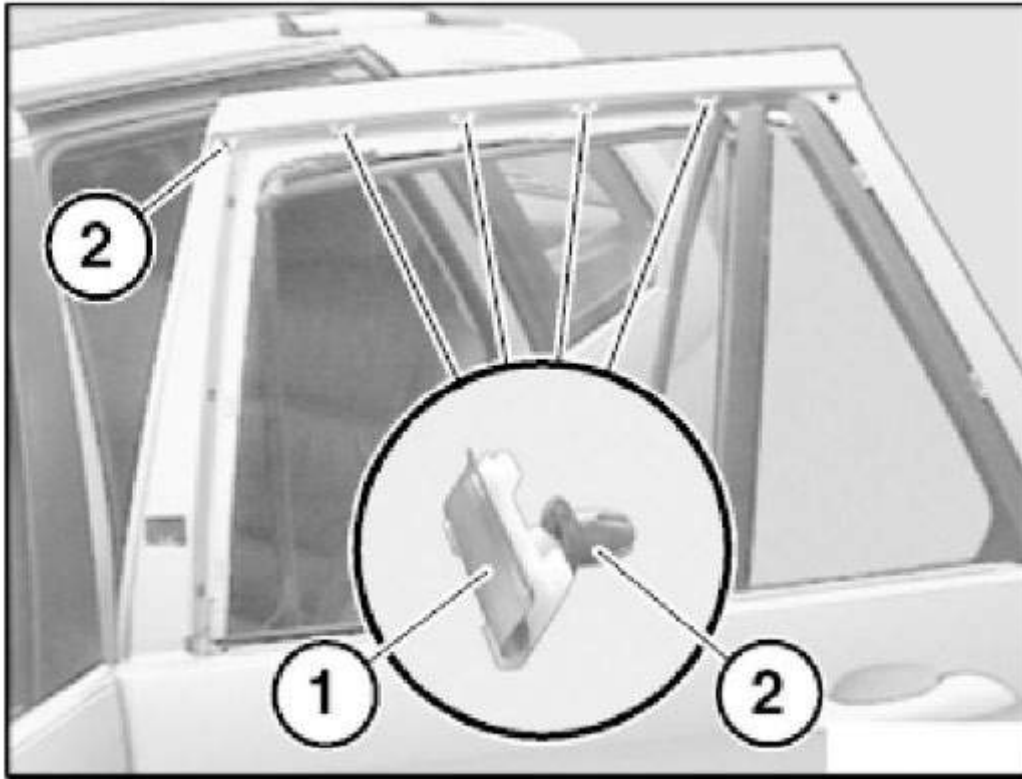


G03255893

Fig. 323: Identifying Decorative Strip Clips
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

If necessary, replace faulty clips (1) and grommets (2).



G03255894

Fig. 324: Replacing Clips And Grommets
Courtesy of BMW OF NORTH AMERICA, INC.

51 34 420 REMOVING AND INSTALLING/REPLACING TRIM ON WINDOW FRAME OF REAR DOOR (FRONT), LEFT OR RIGHT

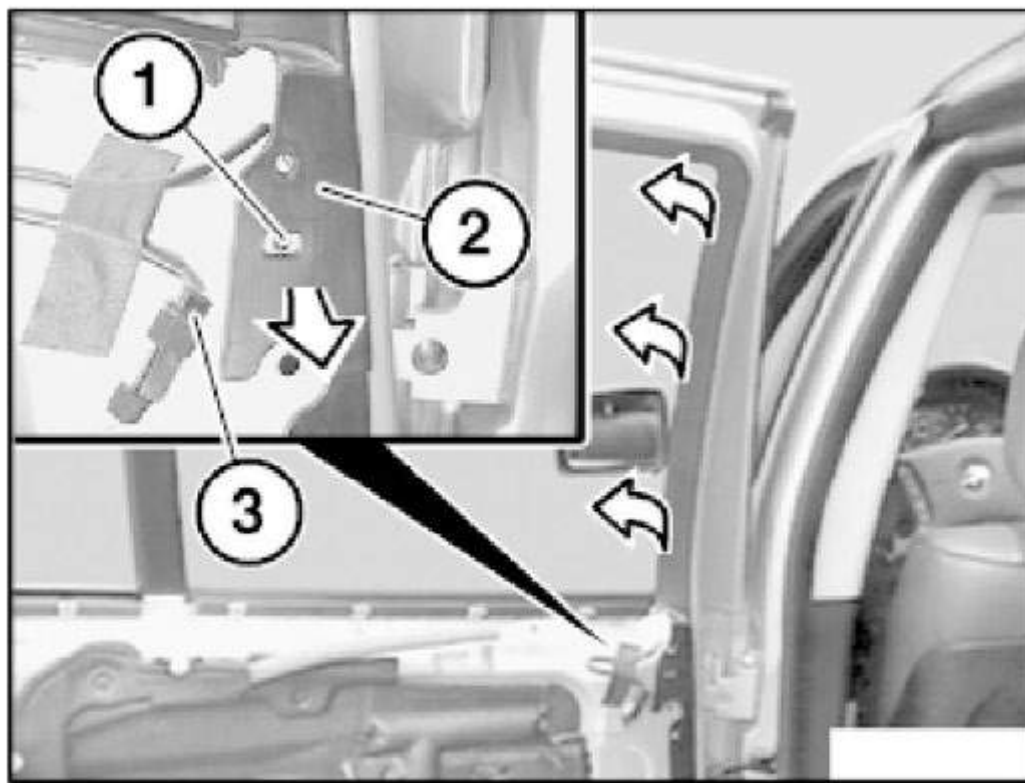
Open door window.

Remove rear door trim panel. Refer to **51 42 000 REMOVING AND INSTALLING REAR LEFT OR RIGHT DOOR TRIM PANEL** .

Remove window cavity cover strip on outside of rear door. Refer to **51 22 300 REMOVING AND INSTALLING/REPLACING WINDOW CAVITY COVER STRIP ON REAR DOOR ON LEFT OR RIGHT** .

Pull out window rubber guide in front area.

Carefully pull out clip (1) and lever out trim (2) in front area.

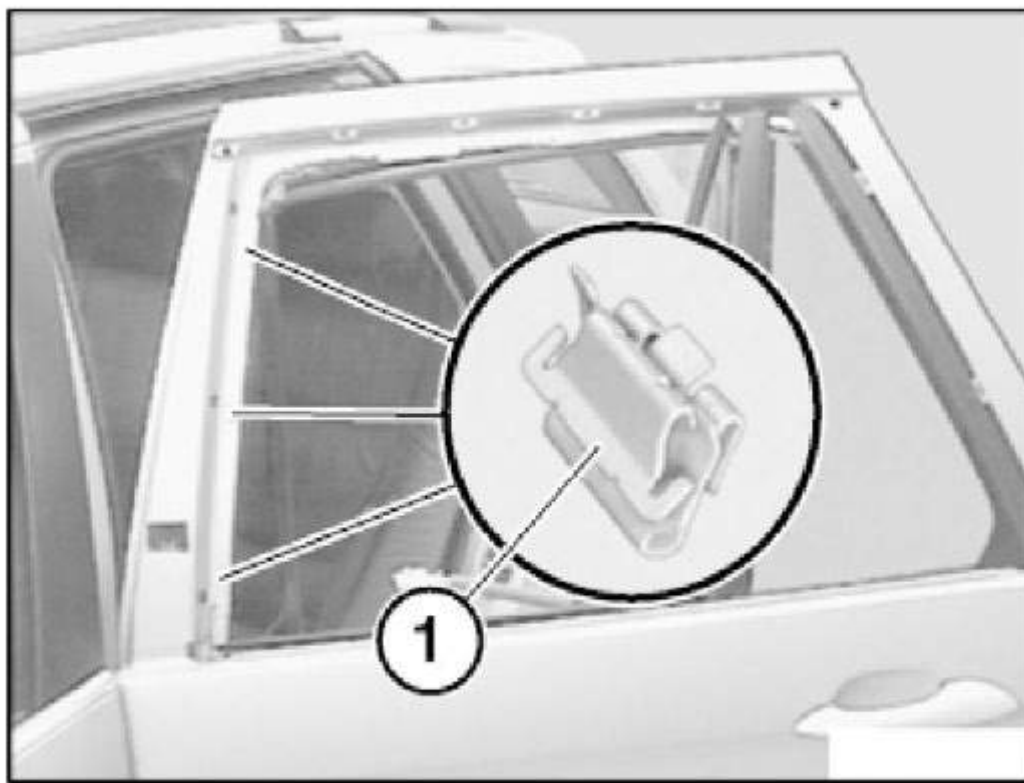


G03255895

Fig. 325: Locating Clip And Window Frame Trim
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

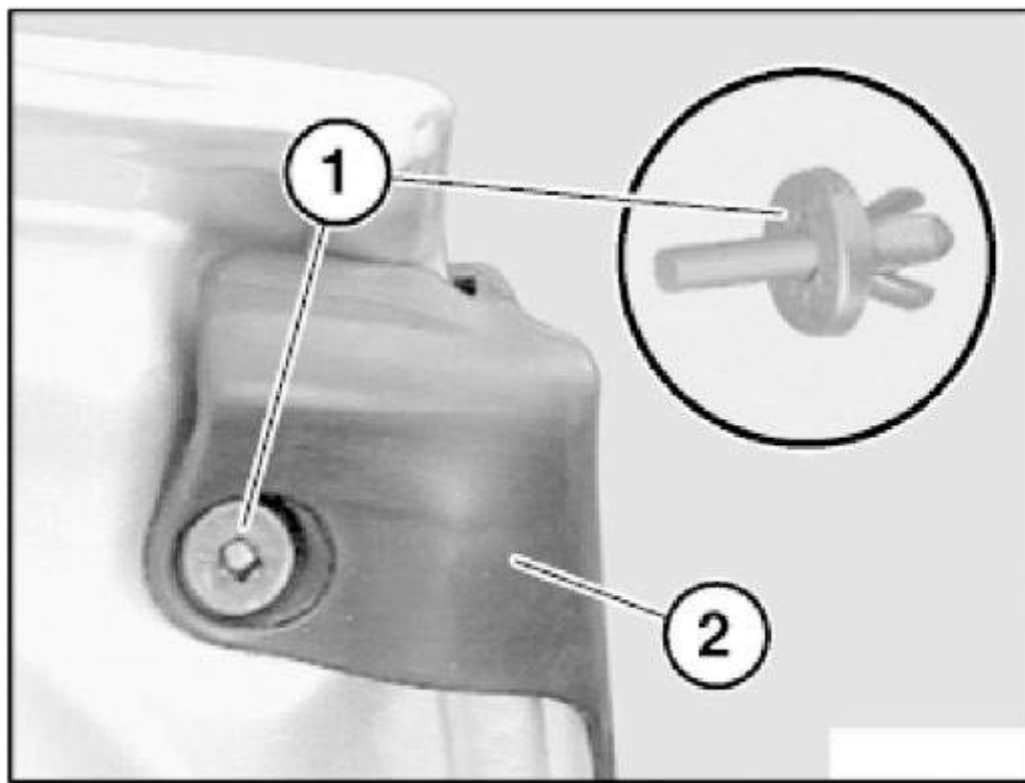
If applicable, replace defective clips (1).



G03255896

Fig. 326: Replacing Window Frame Trim Clips
Courtesy of BMW OF NORTH AMERICA, INC.

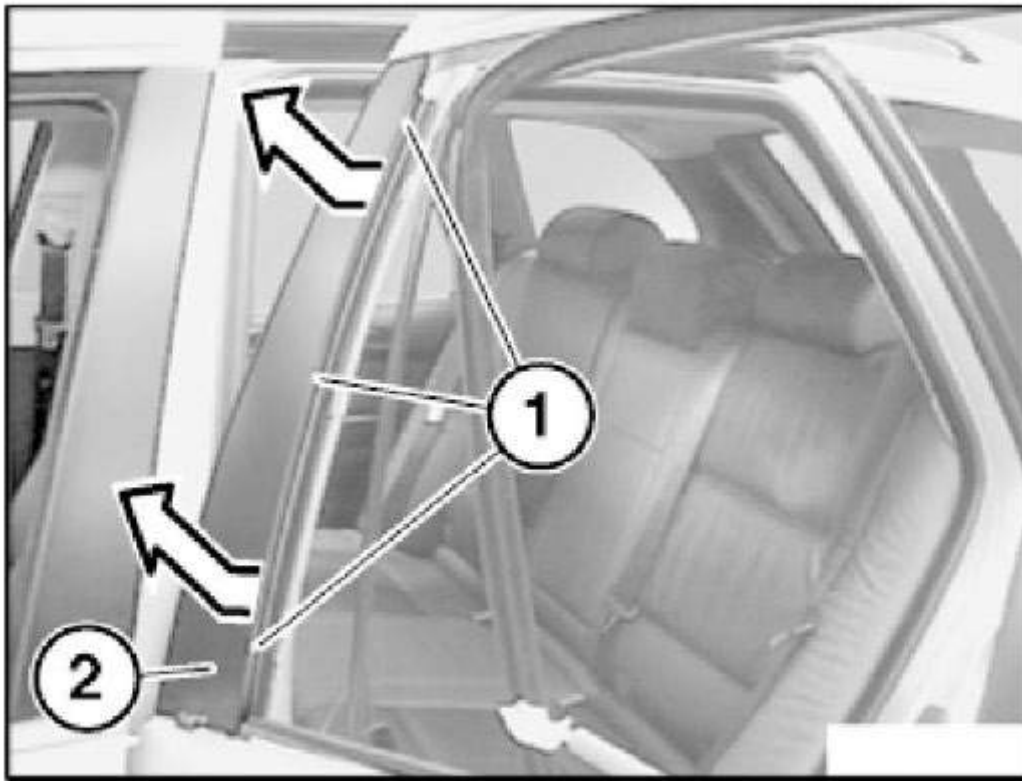
Release expansion rivet (1) on seal (2).



G03255897

Fig. 327: Releasing Expansion Rivet On Seal
Courtesy of BMW OF NORTH AMERICA, INC.

Release screws (1) and detach trim (2).

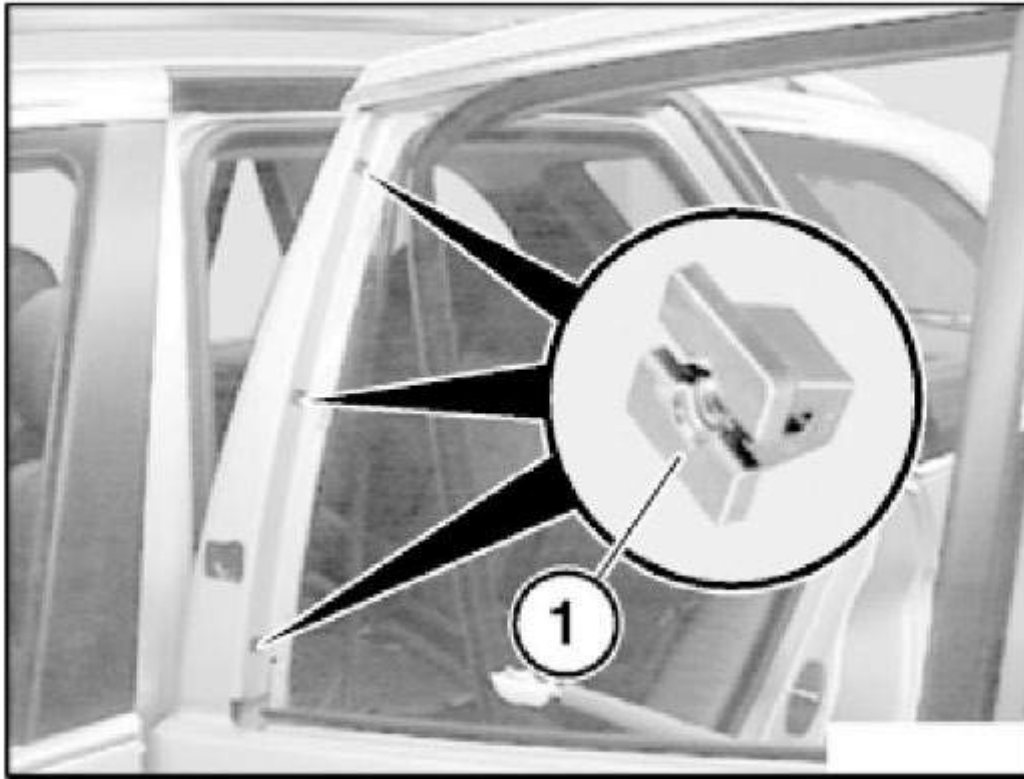


G03255898

Fig. 328: Releasing Screws And Detaching Trim
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

If necessary, replace faulty plastic nuts (1).



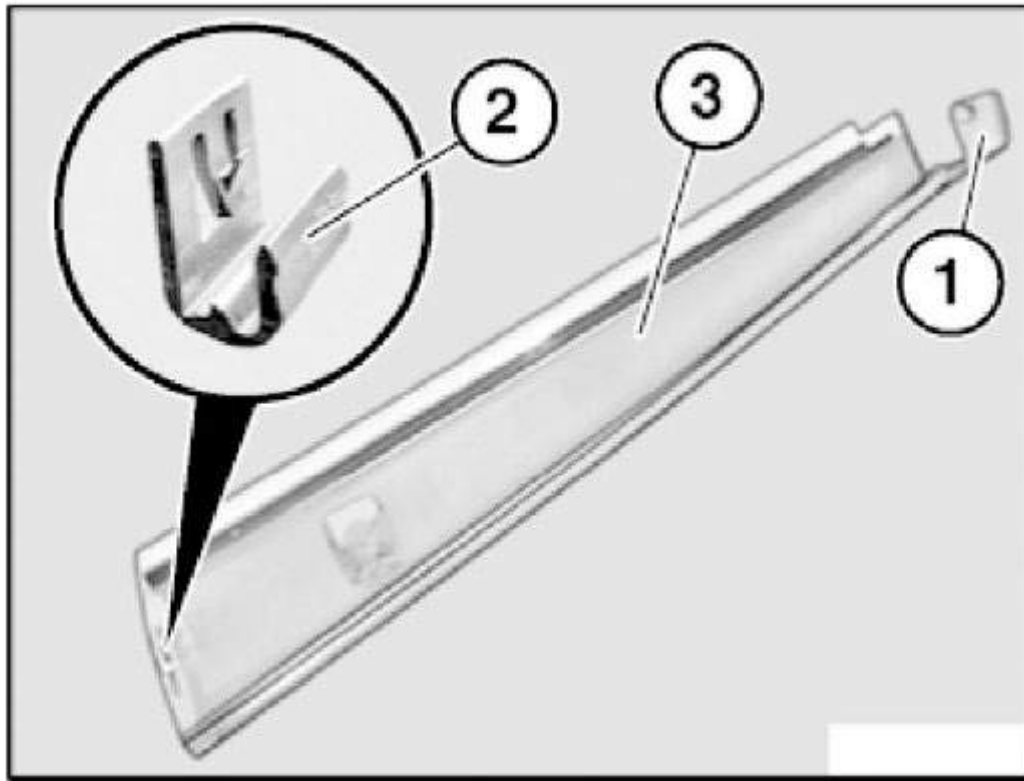
G03255899

Fig. 329: Replacing Plastic Nuts

Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Seal (1) must not be damaged.



G03255900

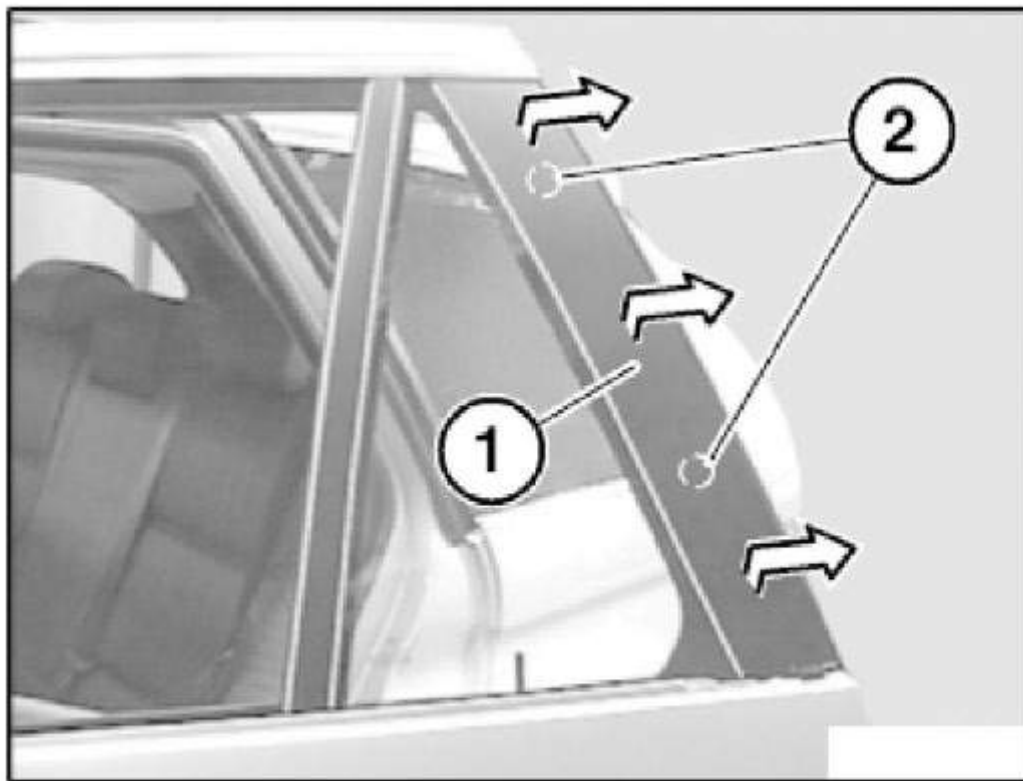
Fig. 330: Identifying Window Frame Seal
Courtesy of BMW OF NORTH AMERICA, INC.

If necessary, replace faulty clip (2) on trim (3).

51 34 425 REMOVING AND INSTALLING/REPLACING TRIM ON WINDOW FRAME OF REAR DOOR, REAR LEFT OR RIGHT

Remove window cavity covering strip on outside. Refer to **51 22 300 REMOVING AND INSTALLING/REPLACING WINDOW CAVITY COVER STRIP ON REAR DOOR ON LEFT OR RIGHT** .

Unclip trim (1) from clips (2) and detach towards rear.

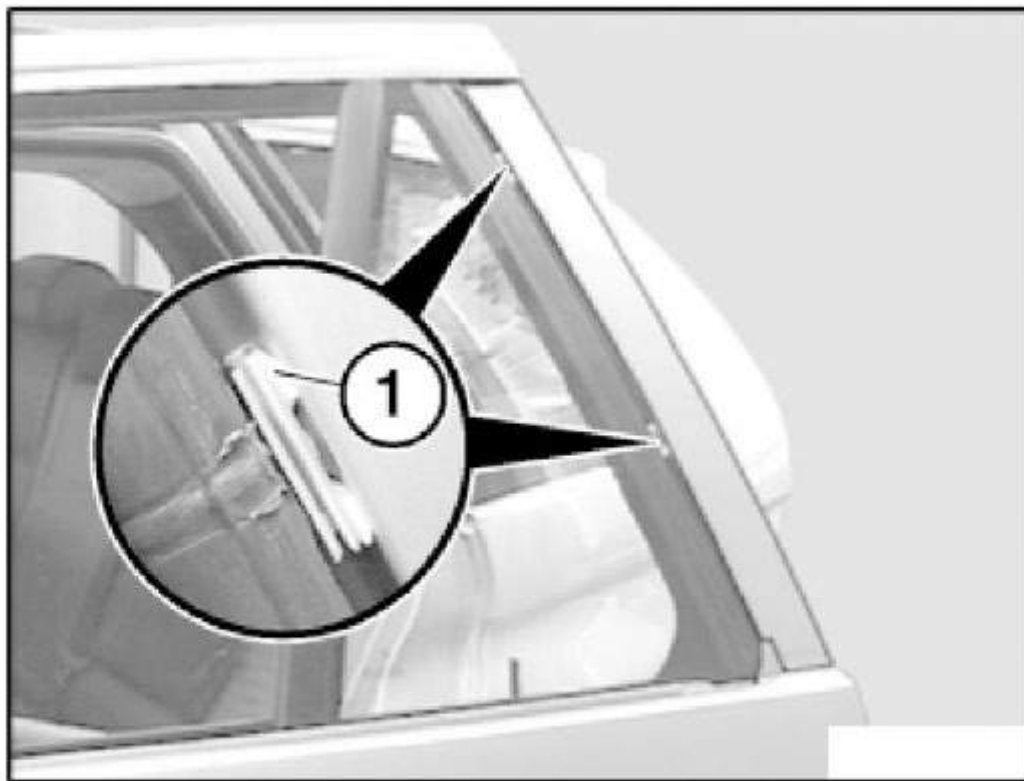


G03255901

Fig. 331: Unclipping Trim From Clips And Detaching Towards Rear
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Retainers (1) must not be damaged.



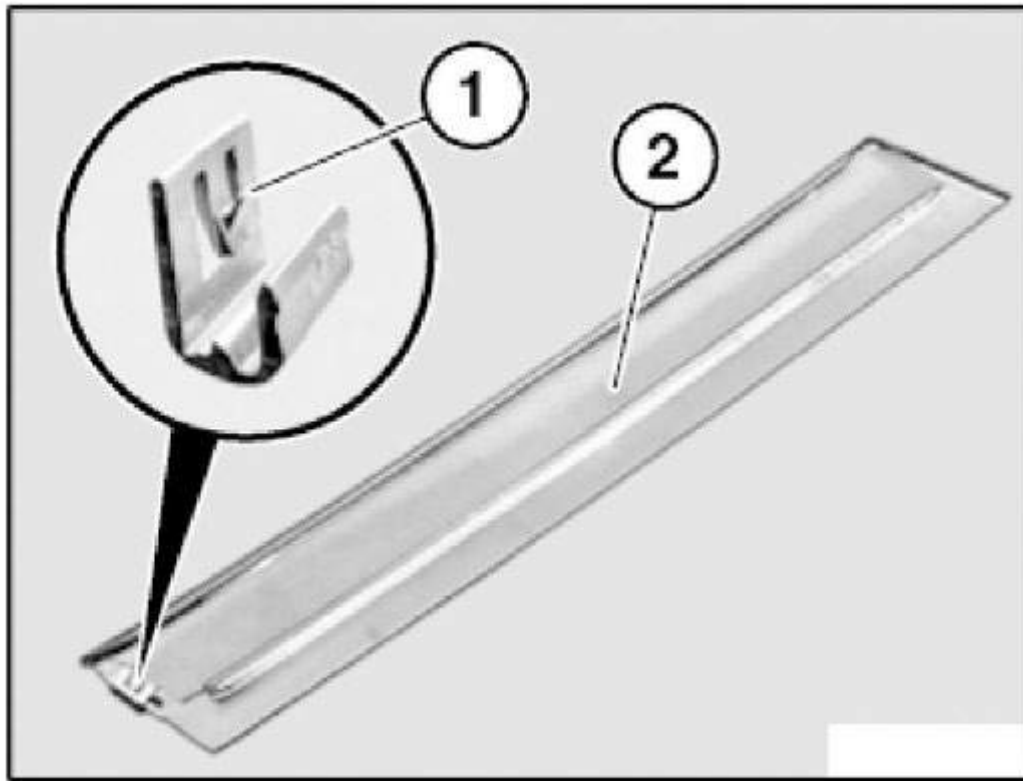
G03255902

Fig. 332: Checking Retainers

Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

If necessary, replace faulty clips (1) on trim (2).



G03255903

Fig. 333: Replacing Clips On Trim

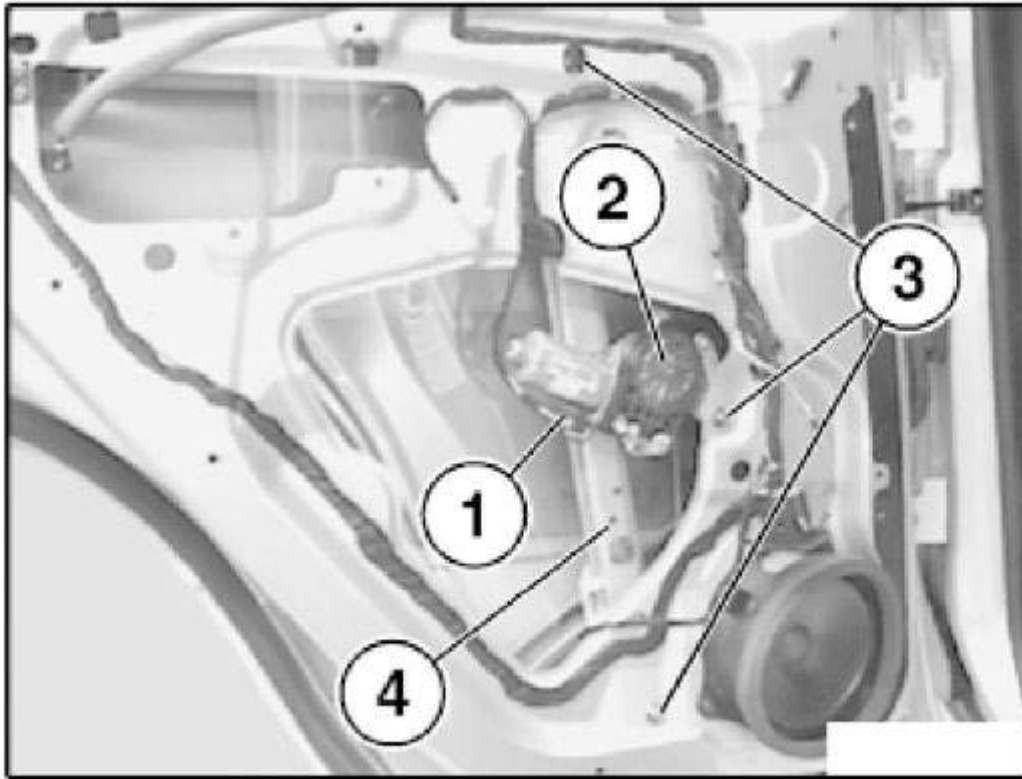
Courtesy of BMW OF NORTH AMERICA, INC.

REAR ELECTRICALLY OPERATED WINDOWS

51 37 000 REMOVING AND INSTALLING COMPLETE POWER WINDOW REGULATOR FROM REAR LEFT AND RIGHT SIDES

Release door window glass at rear (do not remove) and stow at bottom in rear door. Refer to **51 34 171 REPLACING REAR LEFT OR RIGHT DOOR WINDOW** .

Plug connection (1) must be disconnected from power window motor (2).



G03255904

Fig. 334: Disconnecting Plug Connection From Power Window Motor
Courtesy of BMW OF NORTH AMERICA, INC.

Unscrew nuts (3).

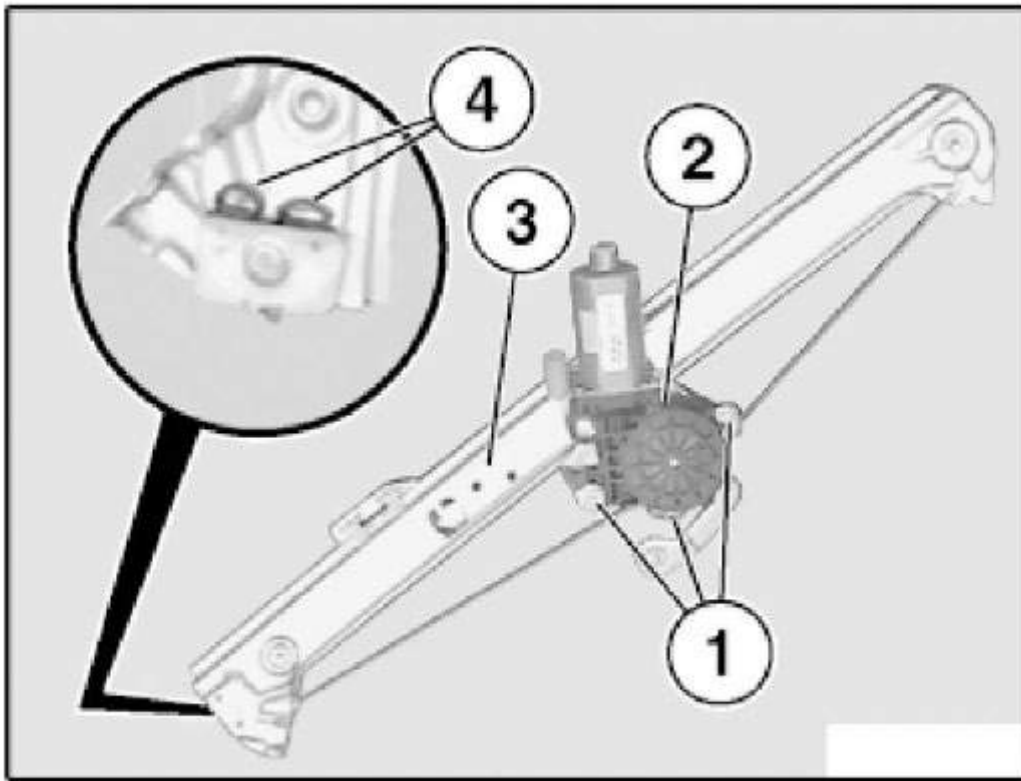
Lever out window regulator (4) and feed out of rear door.

Replacement Only:

Release screws (1).

Turn flat motor (2) and detach from window regulator (3).

Lower end stop (4) must not be damaged.



G03255905

Fig. 335: Locating Lower End Stop

Courtesy of BMW OF NORTH AMERICA, INC.

HINGED WINDOW

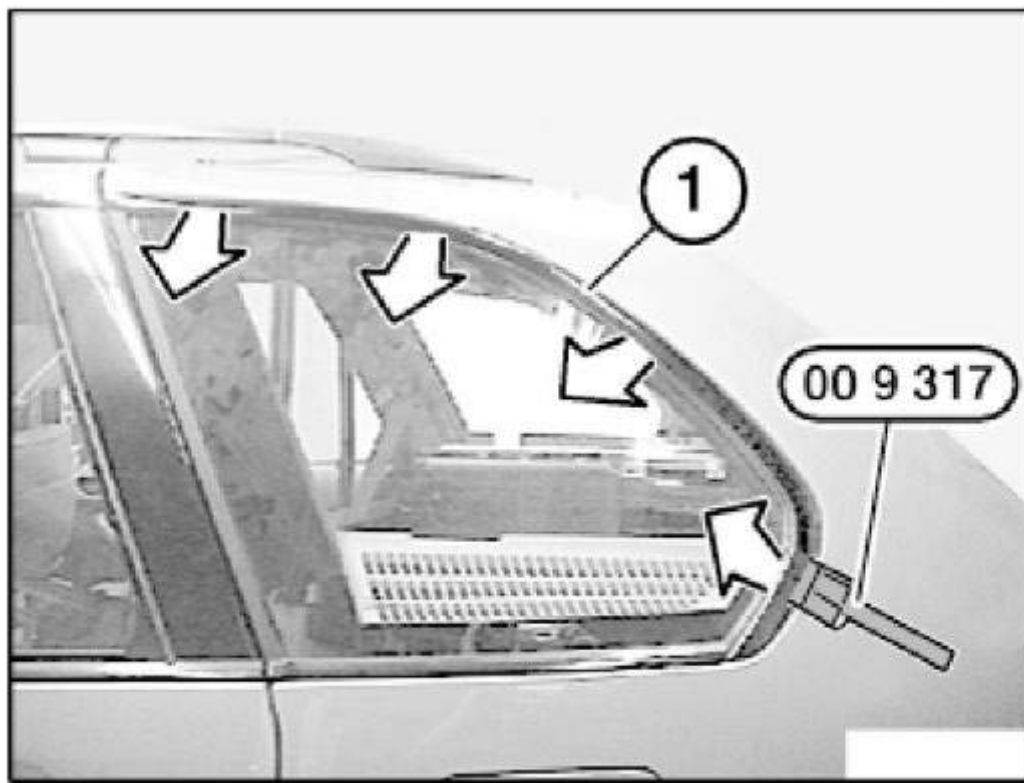
51 36 035 REMOVING AND INSTALLING/REPLACING TRIM ON SIDE WINDOW AT TOP REAR LEFT OR RIGHT

NOTE: For Special Tool identification, see SPECIAL TOOLS - X5 (3.0i) .

Special Tools Required:

- 00 9 316
- 00 9 317

Carefully lever out trim (1) with special tool 00 9 317.

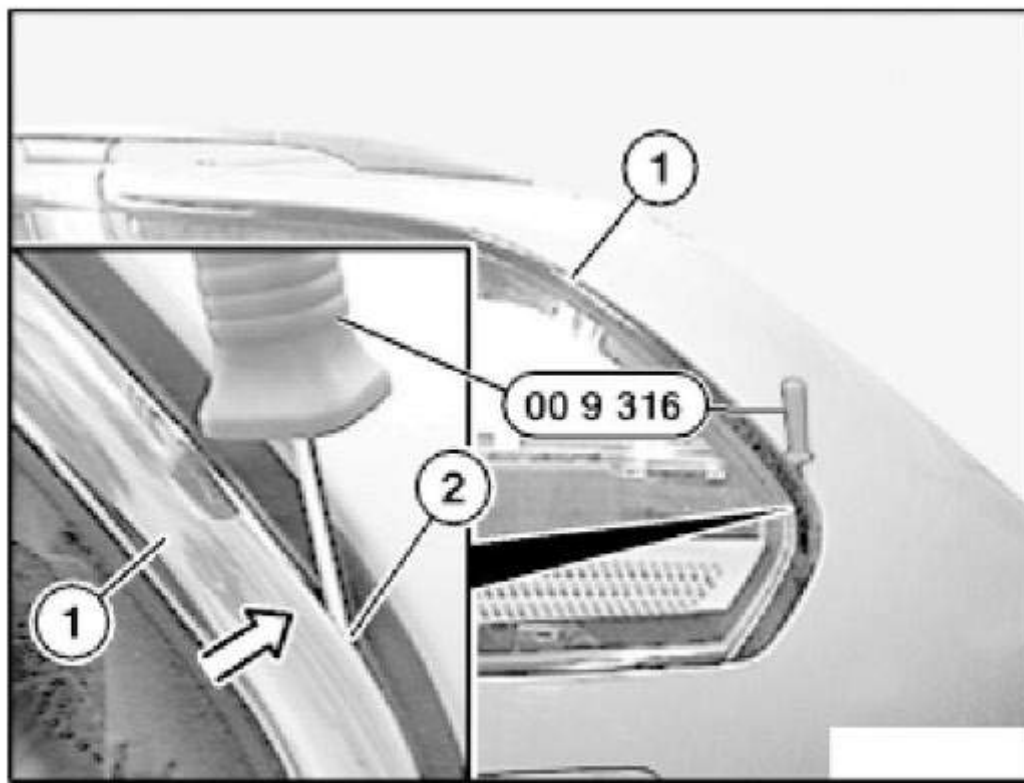


G03255906

Fig. 336: Levering Out Trim With Assembly Wedge
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Fit trim (1), raise sealing lip (2) with special tool 00 9 316 and at same time snap trim (1) into place.

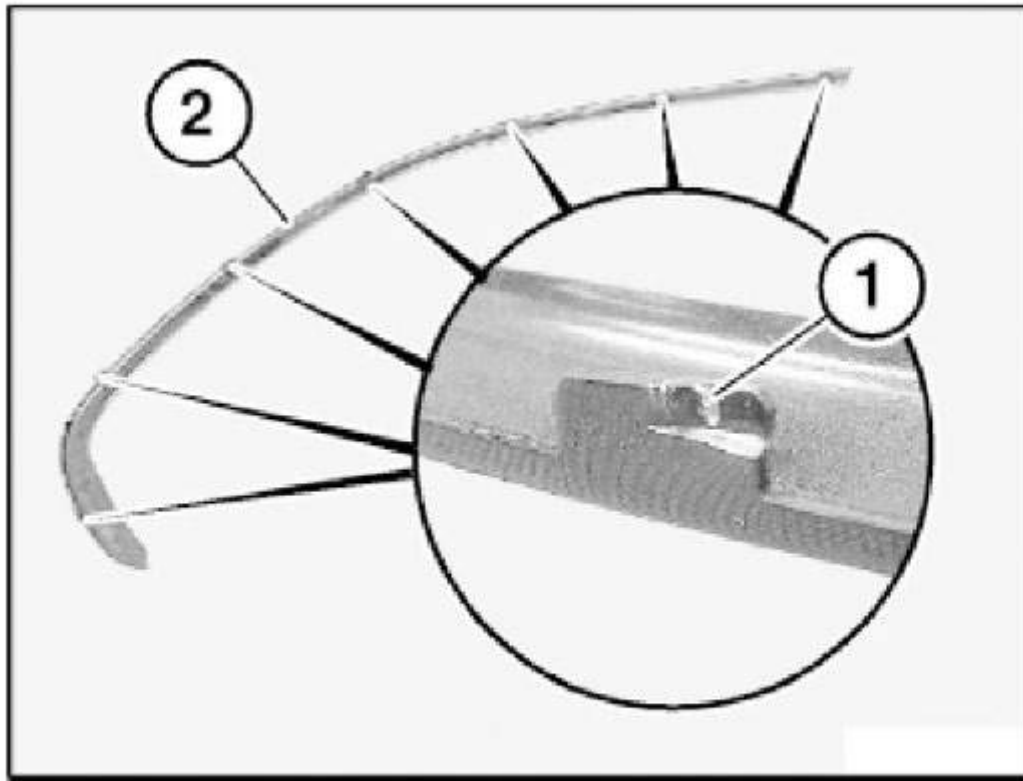


G03255907

Fig. 337: Raising Sealing Lip With Assembly Wedge
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Catches (1) on trim (2) must not be damaged.



G03255908

Fig. 338: Identifying Catches On Trim
Courtesy of BMW OF NORTH AMERICA, INC.

If trim (2) fails to engage correctly, bend catches (1) slightly.

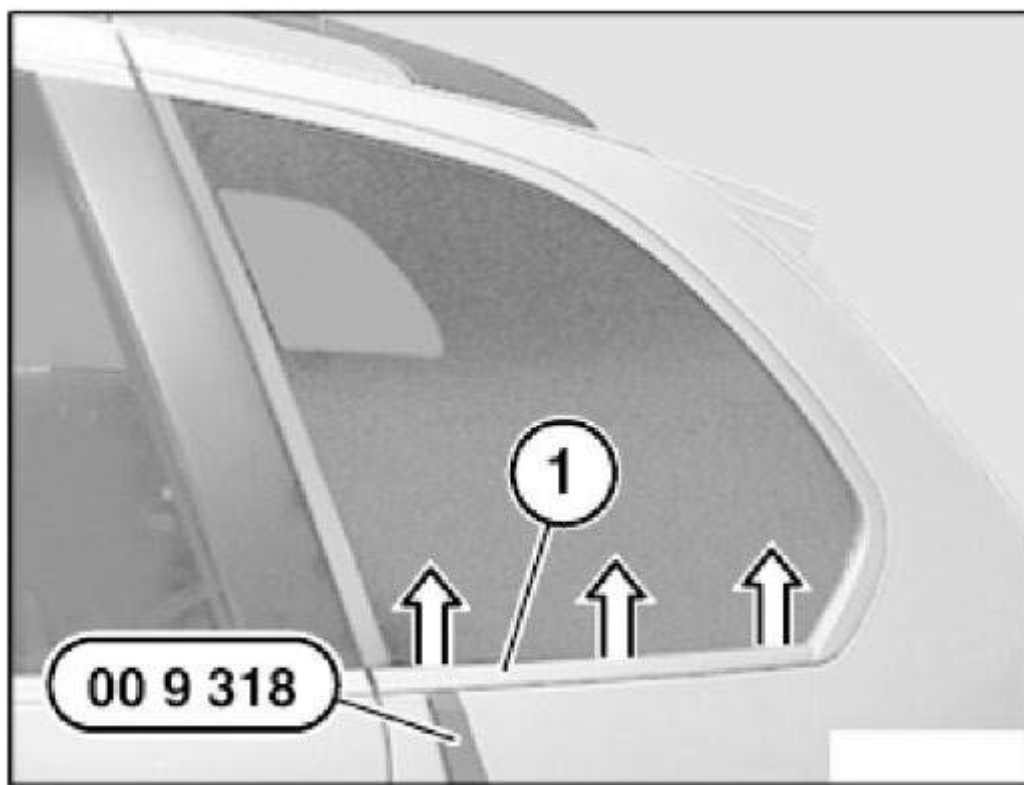
51 36 040 REMOVING AND INSTALLING/REPLACING STRIP ON SIDE WINDOW AT REAR BOTTOM LEFT OR RIGHT

NOTE: For Special Tool identification, see **SPECIAL TOOLS - X5 (3.0i)** .

Special Tools Required:

- 00 9 318

Carefully lever out strip (1) with special tool 00 9 318 from rear to front in direction of arrow.

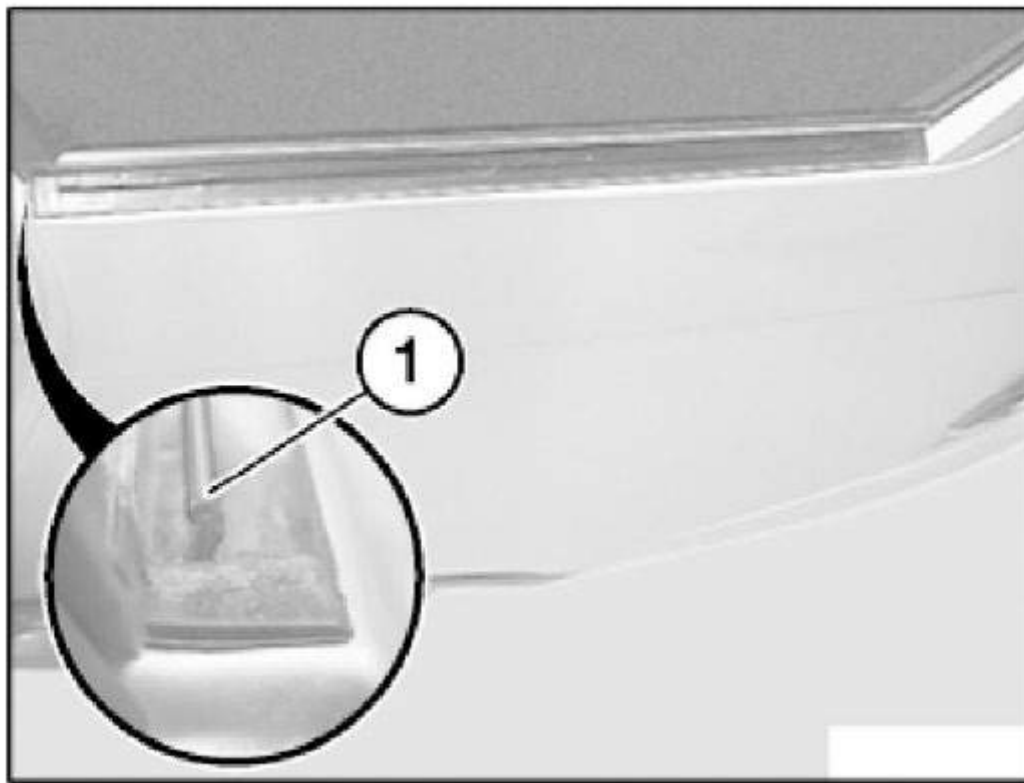


G03255909

Fig. 339: Levering Out Strip With Assembly Wedge
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

If necessary, detach clips from bridge (1). Bridge (1) must not be damaged.



G03255910

Fig. 340: Locating Bridge

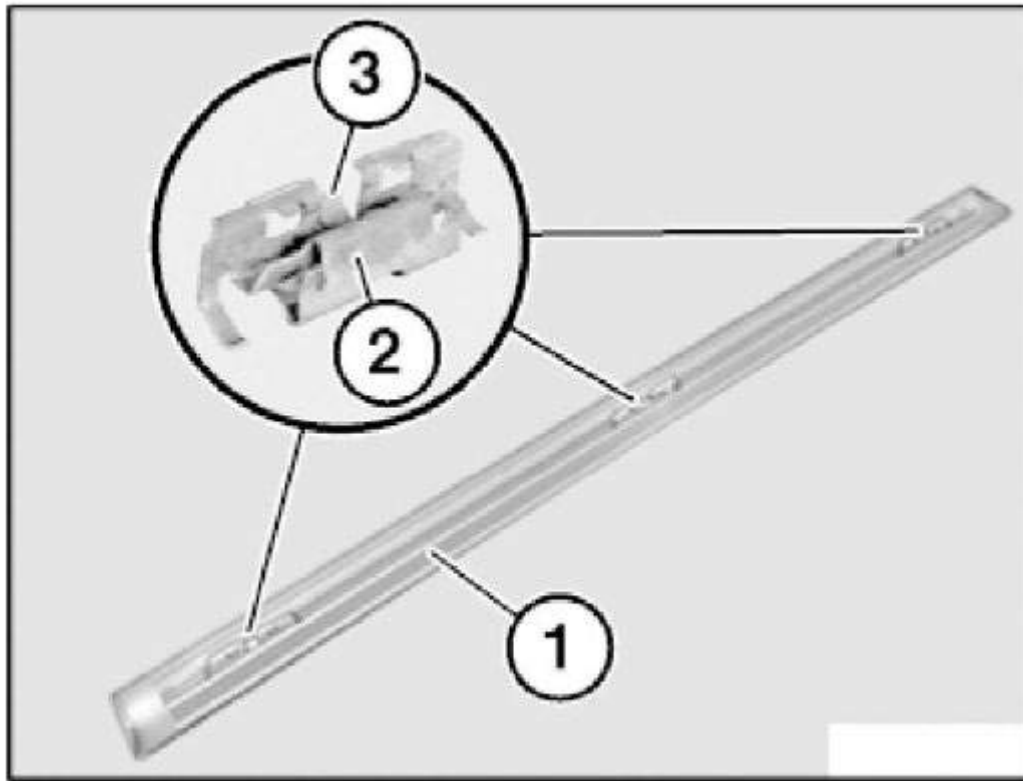
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

If necessary, replace faulty clips (2).

Attach clips (2) to strip (1).

Lock (3) must be correctly engaged in strip (1).



G03255911

Fig. 341: Locating Lock On Clip

Courtesy of BMW OF NORTH AMERICA, INC.

51 36 070 REMOVING AND INSTALLING/REPLACING LEFT OR RIGHT REAR SIDE WINDOW

IMPORTANT: The "Window cementing instructions" serve as the basis for this repair instruction and must be observed without fail. Refer to 51 31 ... INSTRUCTIONS ON GLUING WINDSCREEN .

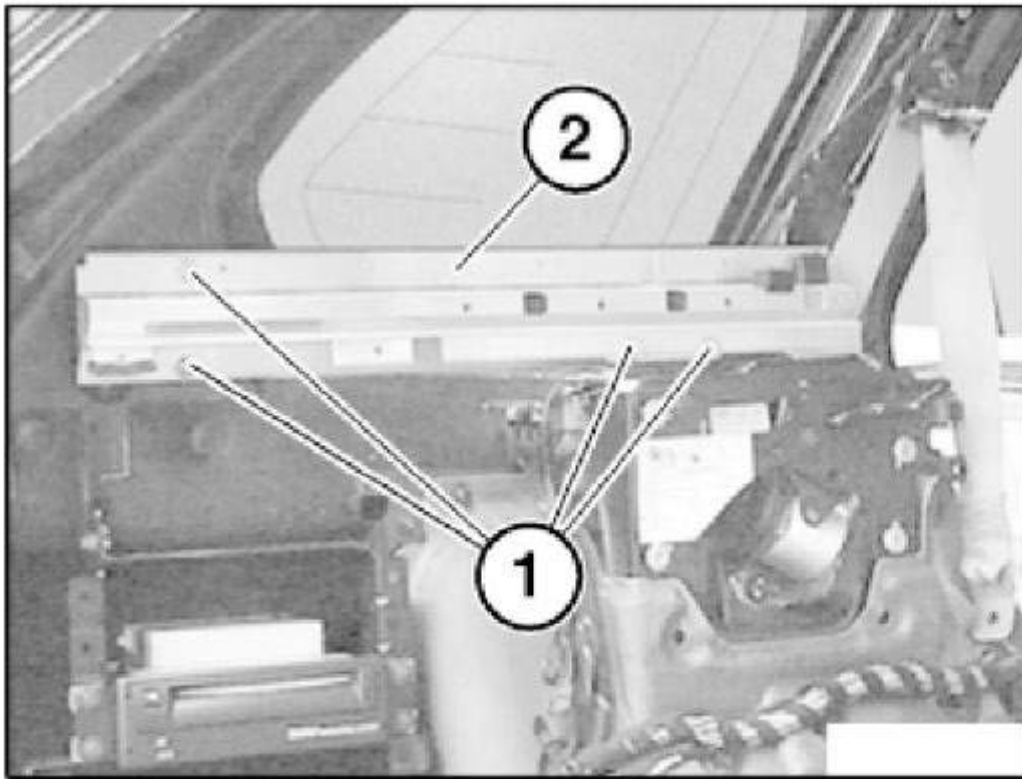
ELECTRICAL POWER WINDOWS, BODY

51 37 ... REMOVING AND INSTALLING/REPLACING MOUNT FOR WINDOW CAVITY COVER STRIP, LEFT OR RIGHT

Remove window cavity cover strip on inside for door window. Refer to 51 37 261 REMOVING AND INSTALLING/REPLACING WINDOW CAVITY COVER STRIP FOR DOOR WINDOW, REAR LEFT OR RIGHT .

Release screws (1).

Remove mount (2).



G03255912

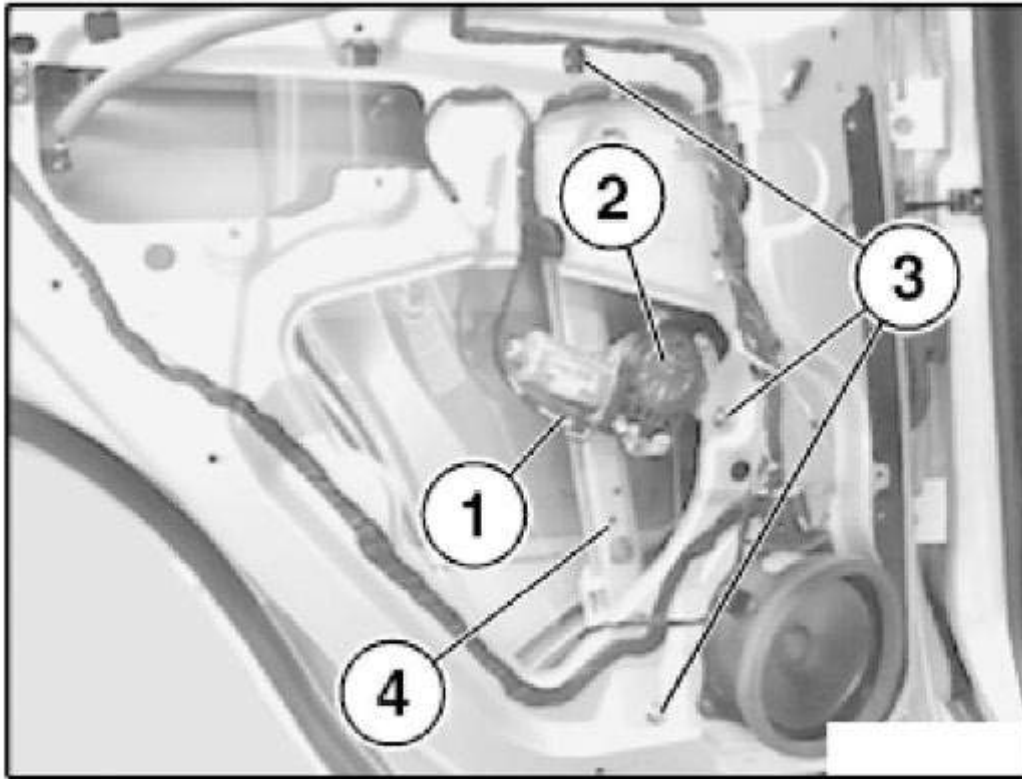
Fig. 342: Releasing Screws On Mount

Courtesy of BMW OF NORTH AMERICA, INC.

51 37 000 REMOVING AND INSTALLING COMPLETE POWER WINDOW REGULATOR FROM REAR LEFT AND RIGHT SIDES

Release door window glass at rear (do not remove) and stow at bottom in rear door. Refer to **51 34 171 REPLACING REAR LEFT OR RIGHT DOOR WINDOW** .

Plug connection (1) must be disconnected from power window motor (2).



G03255913

Fig. 343: Disconnecting Plug Connection From Power Window Motor
Courtesy of BMW OF NORTH AMERICA, INC.

Unscrew nuts (3).

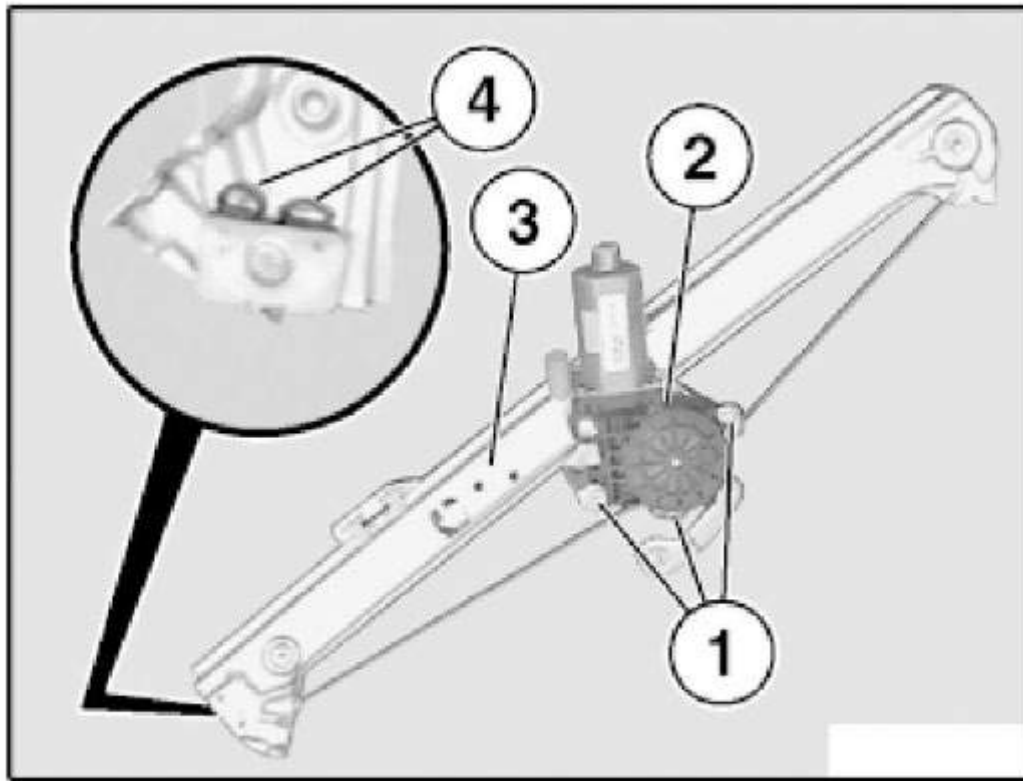
Lever out window regulator (4) and feed out of rear door.

Replacement Only:

Release screws (1).

Turn flat motor (2) and detach from window regulator (3).

Lower end stop (4) must not be damaged.



G03255914

Fig. 344: Locating Lower End Stop

Courtesy of BMW OF NORTH AMERICA, INC.

51 37 261 REMOVING AND INSTALLING/REPLACING WINDOW CAVITY COVER STRIP FOR DOOR WINDOW, REAR LEFT OR RIGHT

Removing roller cover from luggage compartment, refer to Owner's Handbook.

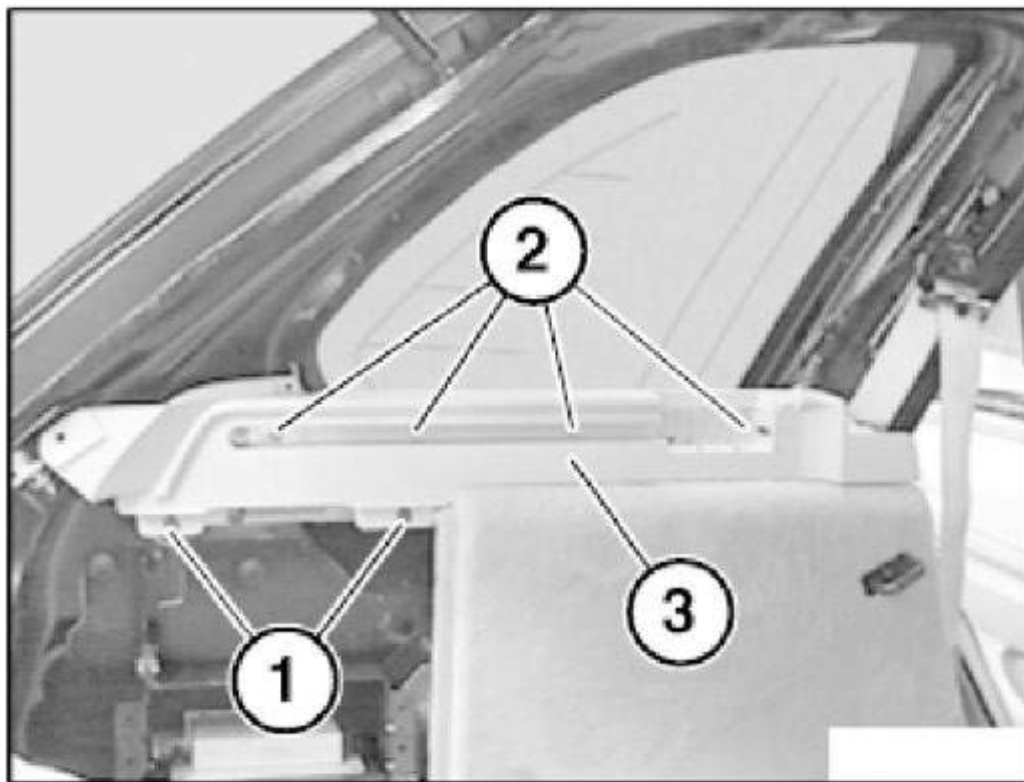
Fold rear-seat backrest forwards.

Remove panel for roof pillar at rear (C-pillar). Refer to **51 43 251 REMOVING AND INSTALLING/REPLACING TRIM PANEL FOR LEFT OR RIGHT REAR ROOF PILLAR (C-PILLAR)** .

Remove panel for roof pillar at rear (D-pillar). Refer to **51 43 252 REMOVING AND INSTALLING/REPLACING PANEL FOR REAR ROOF PILLAR (D-PILLAR), LEFT OR RIGHT** .

Remove screws (1 and 2).

Remove window cavity cover strip (3).



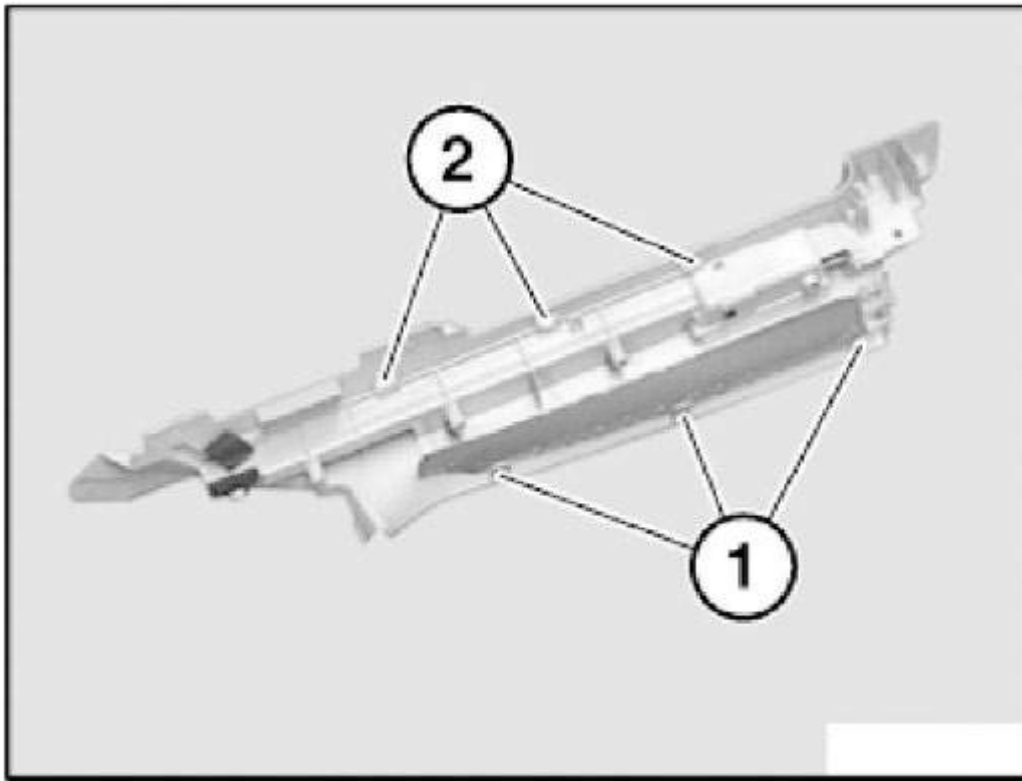
G03255915

Fig. 345: Removing Window Cavity Cover Strip
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Slide guides (1) into mounts of window frame.

Press guides (2) onto mount for window cavity cover strip.



G03255916

Fig. 346: Pressing Guides Onto Mount For Window Cavity Cover Strip
Courtesy of BMW OF NORTH AMERICA, INC.

FRONT DOOR TRIM PANEL WITH ARM REST

51 41 000 REMOVING AND INSTALLING LEFT OR RIGHT FRONT DOOR TRIM PANEL

NOTE: For Special Tool identification, see **SPECIAL TOOLS - X5 (3.0i)** .

Special Tools Required:

- 00 9 317

WARNING: Version with side airbag: Follow safety instructions for working on cars with airbag systems, refer to 51 00 ... SERVICE POSITION OF ENGINE HOOD .

CAUTION: Do not use any sharp-edged tools to remove the panel - risk of damage to airbag.

Remove clipped-in trim (decorative strip) on door trim panel. Refer to **51 16 221 REPLACING A CLIPPED FINISHER (DECORATIVE STRIP ON PANEL FOR INSTRUMENT PANEL, FRONT OR REAR DOOR)** .

Remove toggle switch for door window operation. Refer to **61 31 115 REPLACING ROCKER SWITCH FOR SIDE WINDOW OPERATION (DOOR SWITCH CENTER)** .

Remove footwell light on bottom of door. **63 31 020 REMOVING AND INSTALLING/REPLACING FOOTWELL LIGHT** .

Release screws (1).

Lever out airbag label (2) and release screw underneath.

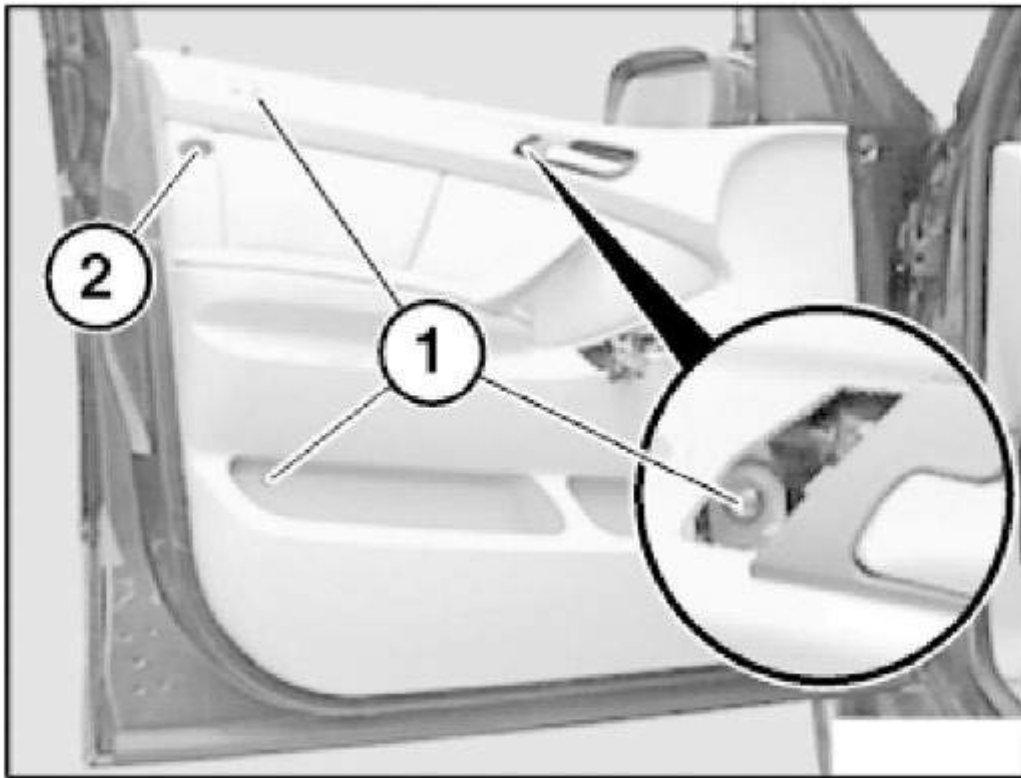
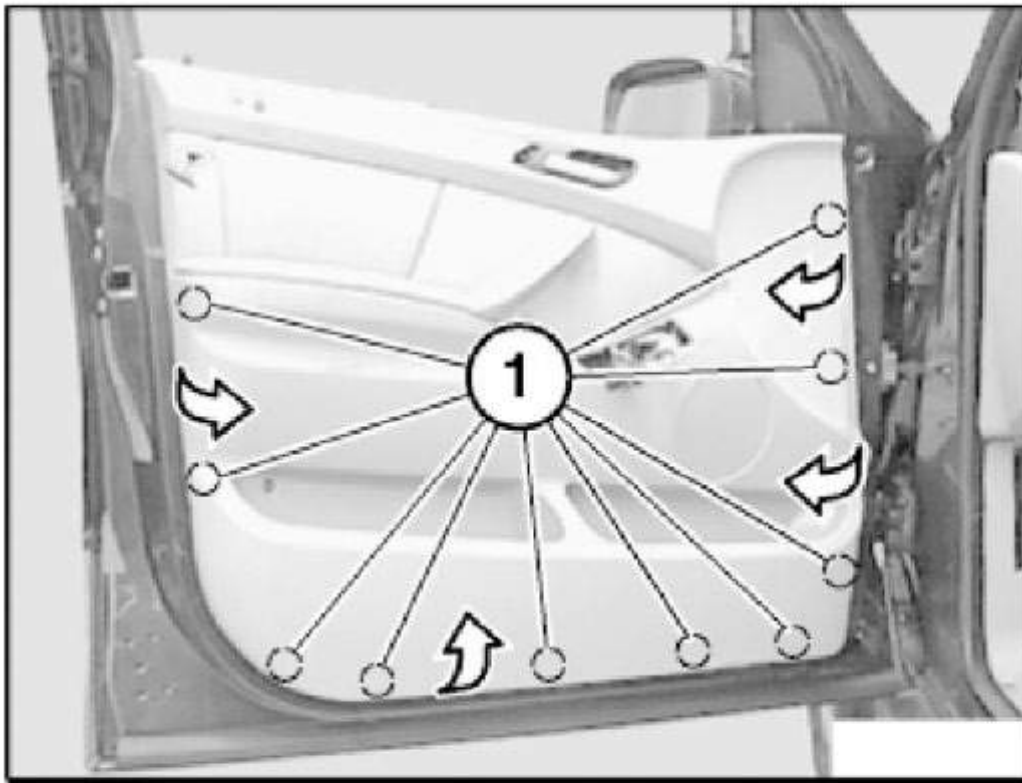


Fig. 347: Removing Airbag Label To Access Screw
Courtesy of BMW OF NORTH AMERICA, INC.

Unclip clips (1) of door trim panel with special tool 00 9 317 (trim panel wedge).



G03255918

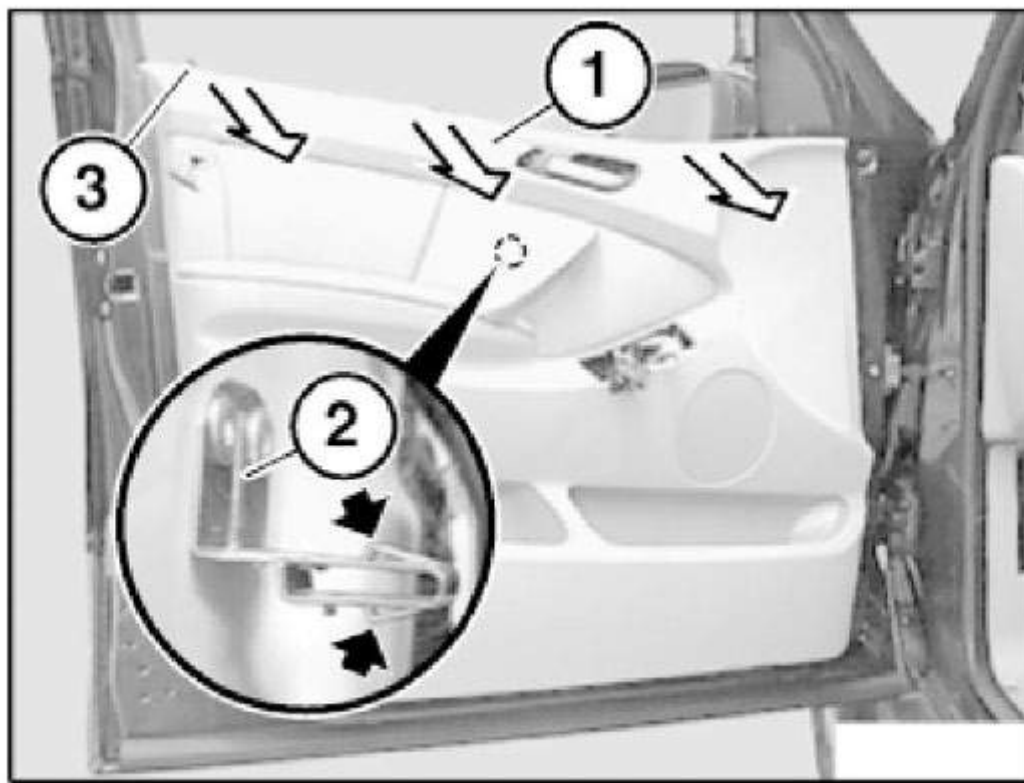
Fig. 348: Unclipping Door Trim Panel Clips With Assembly Wedge
Courtesy of BMW OF NORTH AMERICA, INC.

Carefully unclip door trim panel (1) at top with special tool 00 9 317 (trim panel wedge).

Feed door trim panel (1) out of unlocking button (3).

Installation:

Bend open retainers on inner door plate for accommodating central clip (2) for installation.

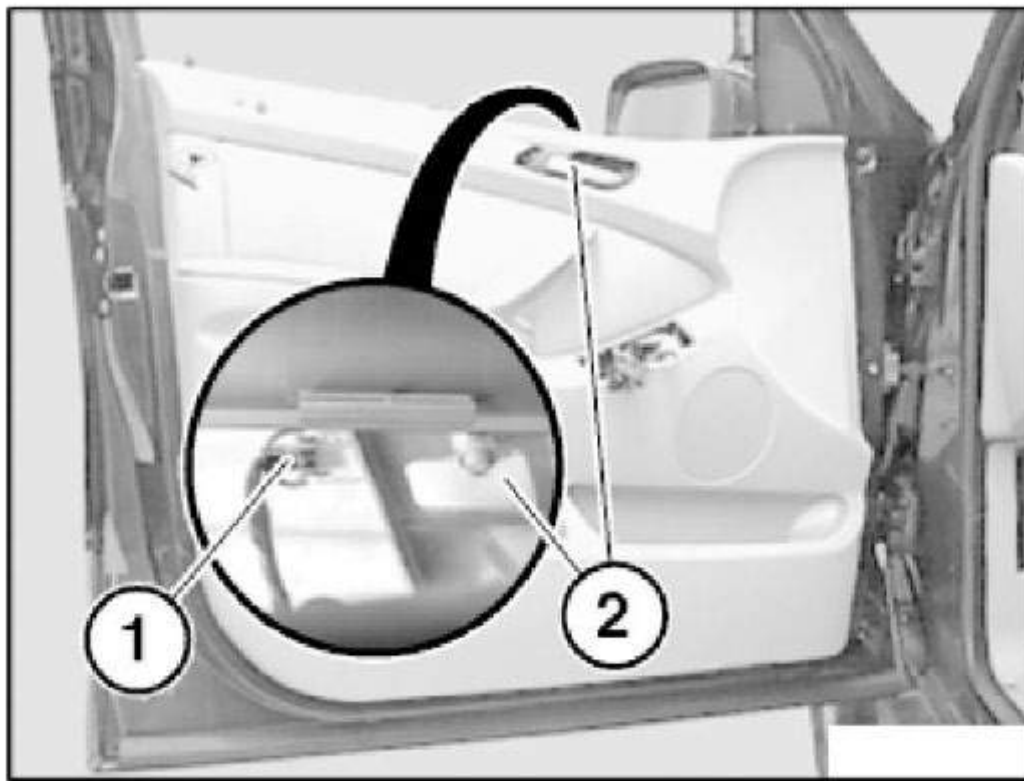


G03255919

Fig. 349: Locating Retainers For Central Clip
Courtesy of BMW OF NORTH AMERICA, INC.

Version with lighting for inside door handle:

If necessary, disconnect plug connection (1) on door opener (2).

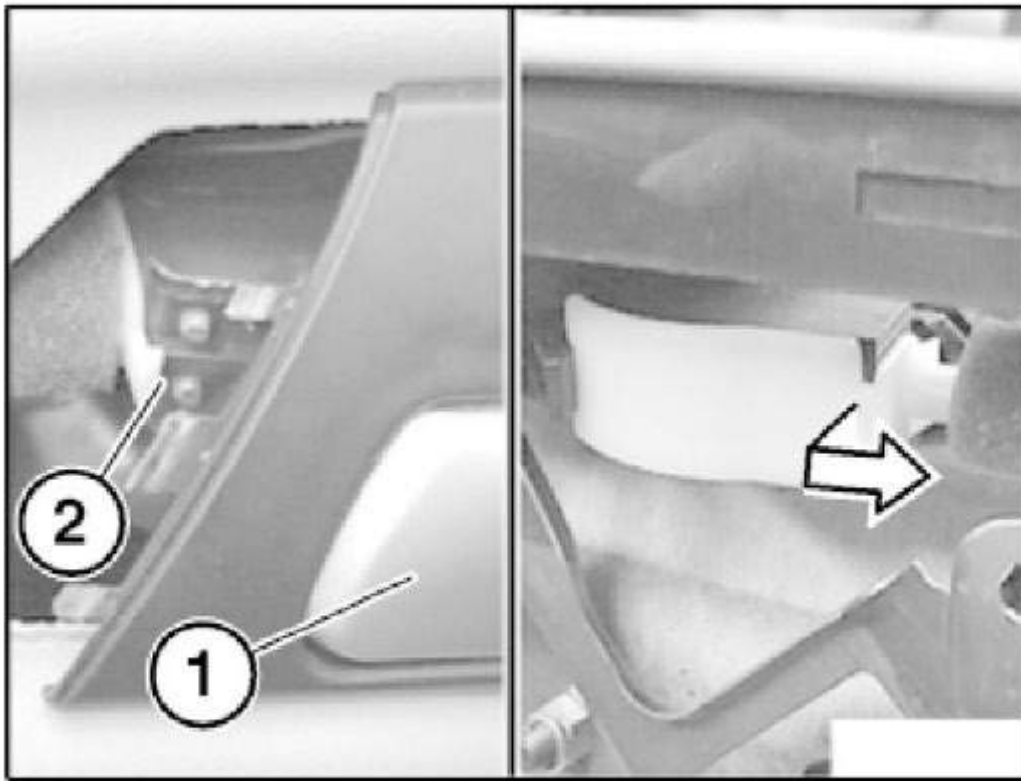


G03255920

Fig. 350: Disconnecting Plug Connection On Door Opener
Courtesy of BMW OF NORTH AMERICA, INC.

Unhook Bowden cable for release lever:

- Tighten release lever (1).
- Lever out lock (2).
- Detach Bowden cable towards inside/rear.



G03255921

Fig. 351: Detaching Bowden Cable

Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Press unlocking lever (1) for installation fully on door trim panel.

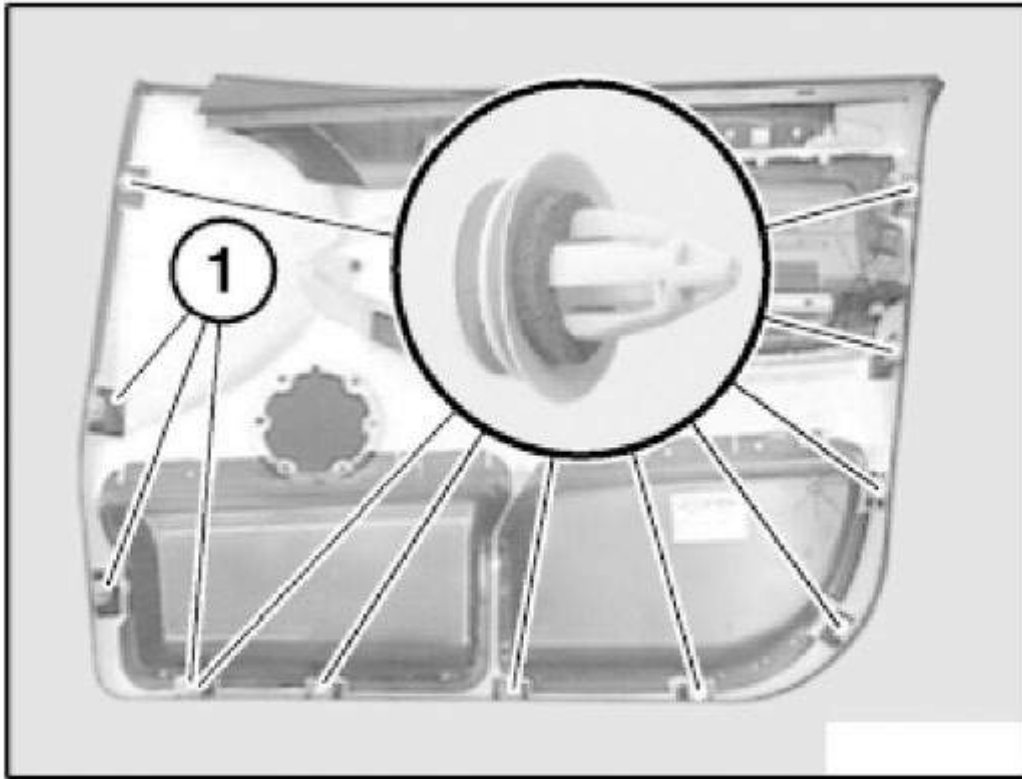
Installation:

Clips (1) are longer than the other clips.

Clips (1) are gray, the other clips are white.

Fit all clips with sealing ring.

If necessary, replace faulty clips.



G03255922

Fig. 352: Identifying Clips With Sealing Ring
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

After assembling the door trim panel proceed as follows:

- Open door window.
- Lock with vehicle key.
- Check whether linkage of safety button can move freely.
- If necessary, align linkages.

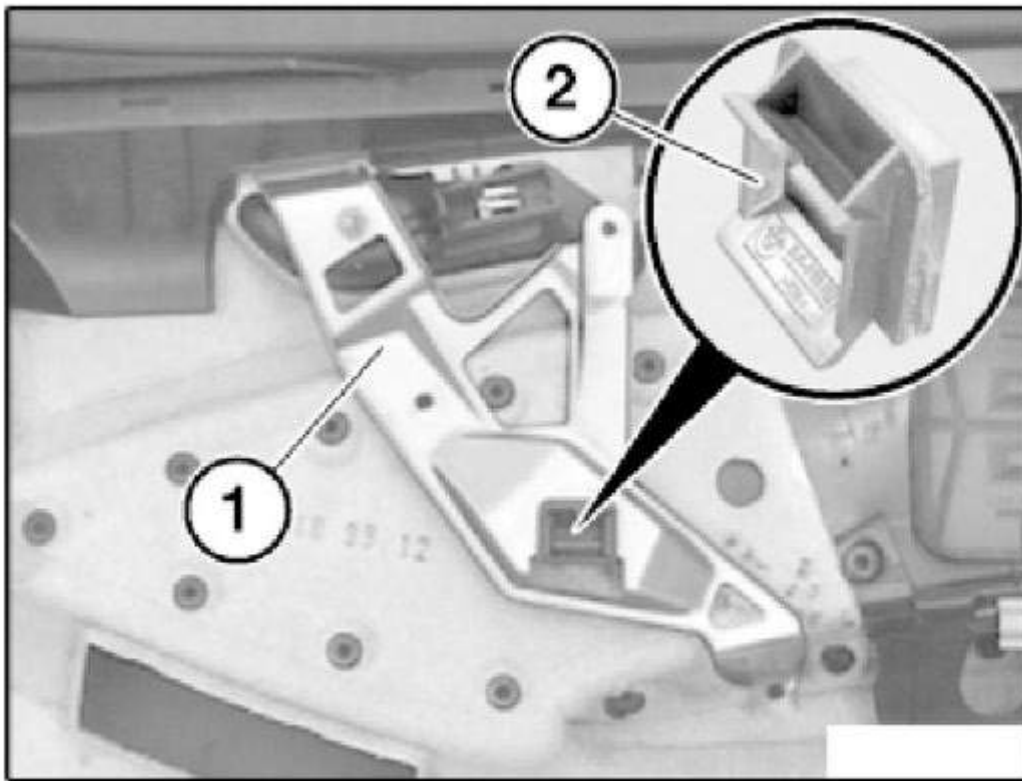
51 41 001 REPLACING FRONT LEFT OR RIGHT DOOR TRIM

Remove front door trim panel. Refer to **51 41 000 REMOVING AND INSTALLING LEFT OR RIGHT FRONT DOOR TRIM PANEL** .

Version with illuminated inside door handle:

If necessary, remove inside door handle. Refer to **51 21 225 REMOVING AND INSTALLING/REPLACING INSIDE DOOR HANDLE IN LEFT OR RIGHT FRONT DOOR** .

Attach central clip (2) to frame (1).



G03255923

Fig. 353: Attaching Central Clip To Frame
Courtesy of BMW OF NORTH AMERICA, INC.

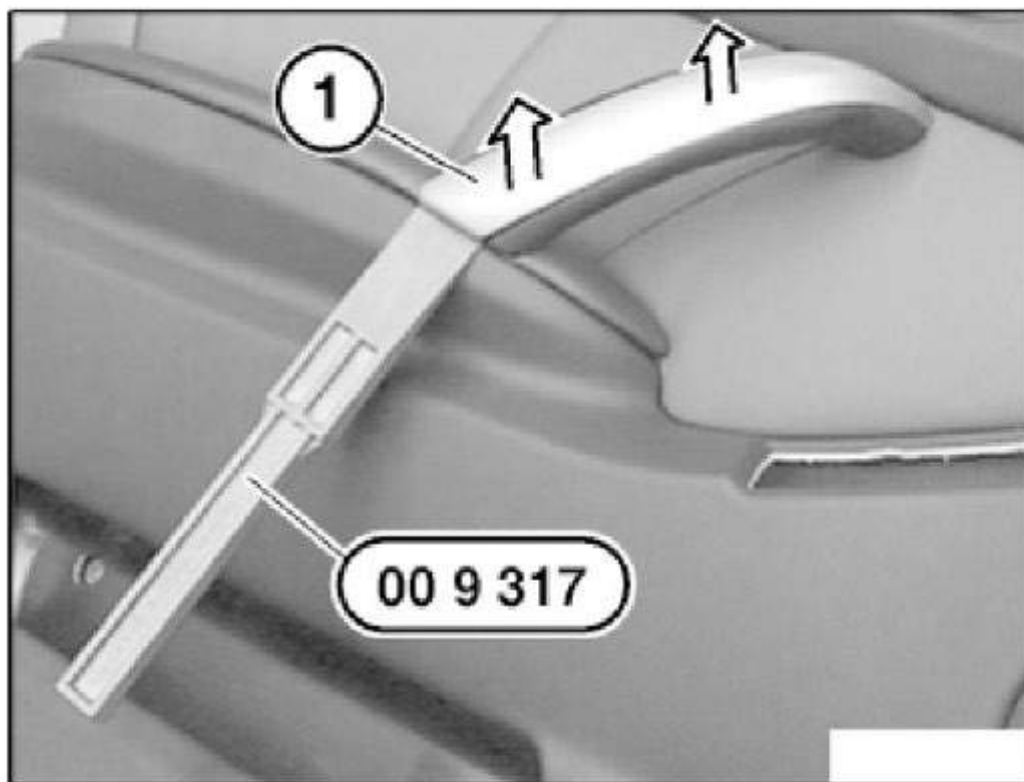
51 41 017 REMOVING AND INSTALLING/REPLACING COVER ON DOOR HANDLE, FRONT LEFT OR RIGHT

NOTE: For Special Tool identification, see **SPECIAL TOOLS - X5 (3.0i)** .

Special Tools Required:

- 00 9 317

Lever out cover (1) with special tool 00 9 317 (trim panel wedge).

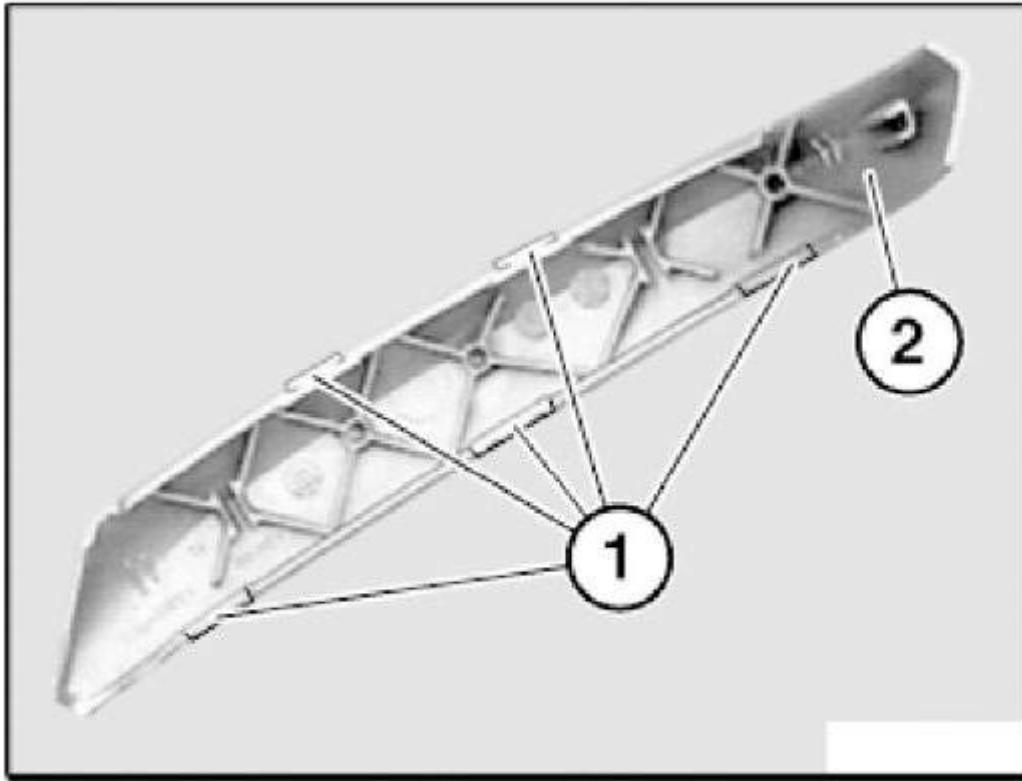


G03255924

Fig. 354: Levering Out Cover With Assembly Wedge
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Catches (1) on cover (2) must not be damaged.



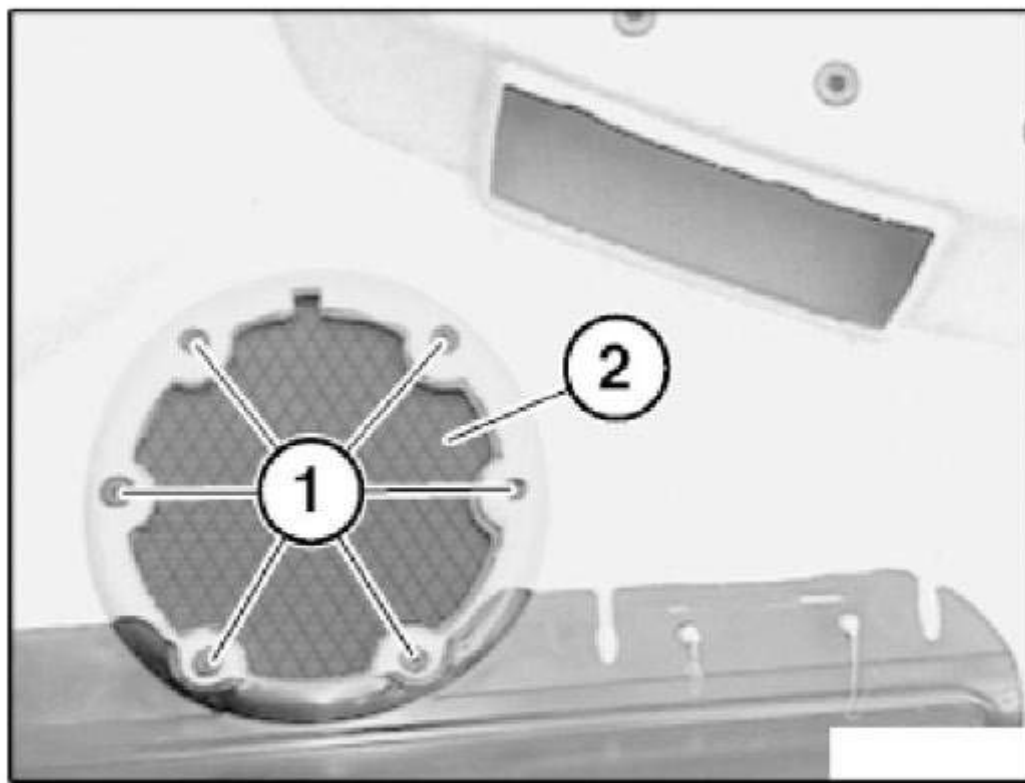
G03255925

Fig. 355: Identifying Catches On Cover
Courtesy of BMW OF NORTH AMERICA, INC.

51 41 018 REPLACING SPEAKER FRAME ON FRONT LEFT OR RIGHT DOOR TRIM PANEL

Remove front door trim panel. **51 41 000 REMOVING AND INSTALLING LEFT OR RIGHT FRONT DOOR TRIM PANEL** .

Release plastic welded joints (1) and remove speaker frame (2).



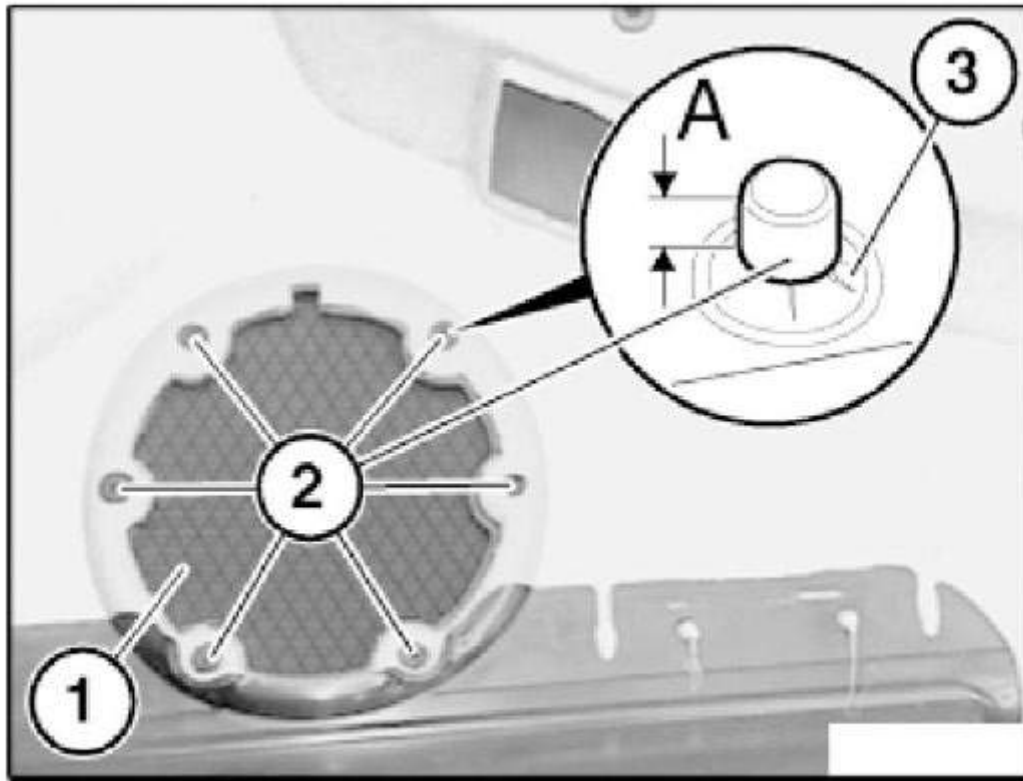
G03255926

Fig. 356: Locating Plastic Welded Joints
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Install new speaker frame (1).

Push locking washers (3) onto plastic pins (2).



G03255927

Fig. 357: Installing Locking Washers Onto Plastic Pins
Courtesy of BMW OF NORTH AMERICA, INC.

Shorten all plastic pins (2) down to measurement (A).

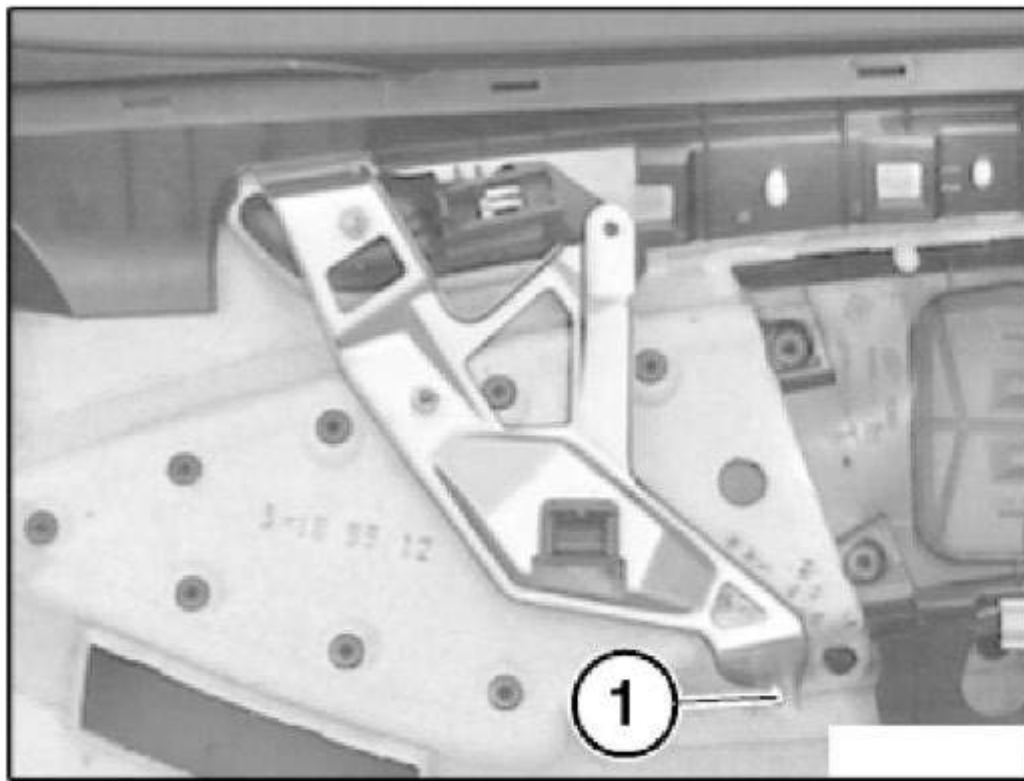
(A) = 2 mm.

51 41 019 REMOVING AND INSTALLING/REPLACING DOOR HANDLE ON DOOR TRIM PANEL, FRONT LEFT OR RIGHT

Remove front door trim panel. Refer to **51 41 000 REMOVING AND INSTALLING LEFT OR RIGHT FRONT DOOR TRIM PANEL** .

Remove cover on door handle. Refer to **51 41 017 REMOVING AND INSTALLING/REPLACING COVER ON DOOR HANDLE, FRONT LEFT OR RIGHT** .

Release screw (1).

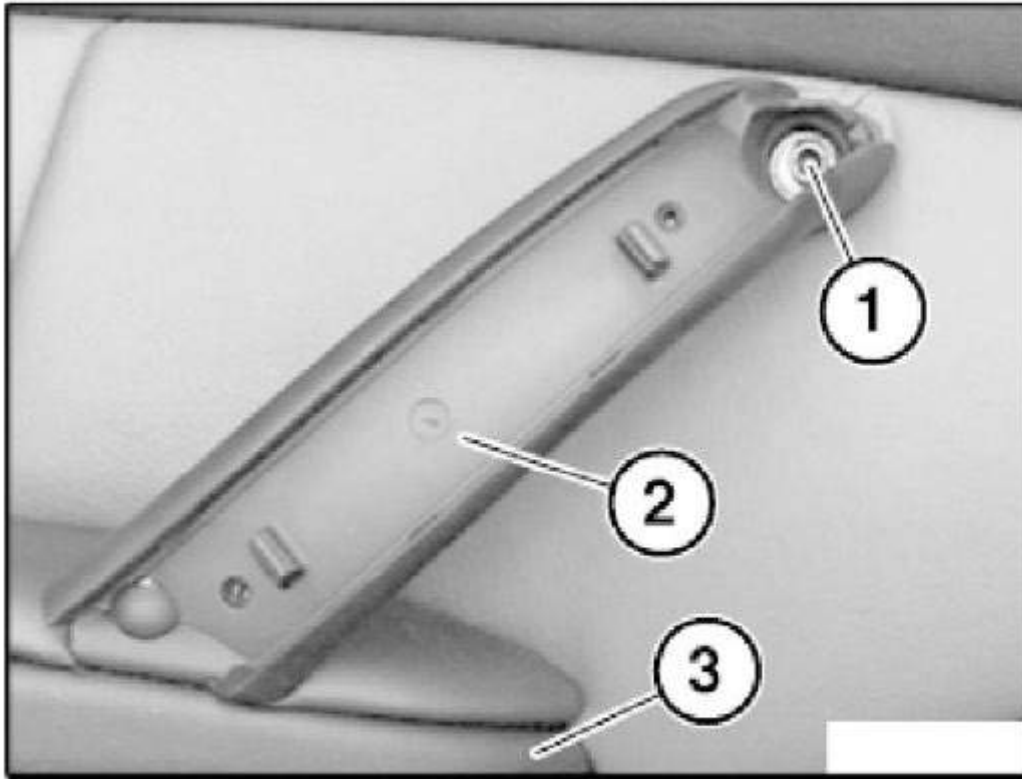


G03255928

Fig. 358: Releasing Screw

Courtesy of BMW OF NORTH AMERICA, INC.

Release screw (1) and detach door handle (2) from door trim panel (3).

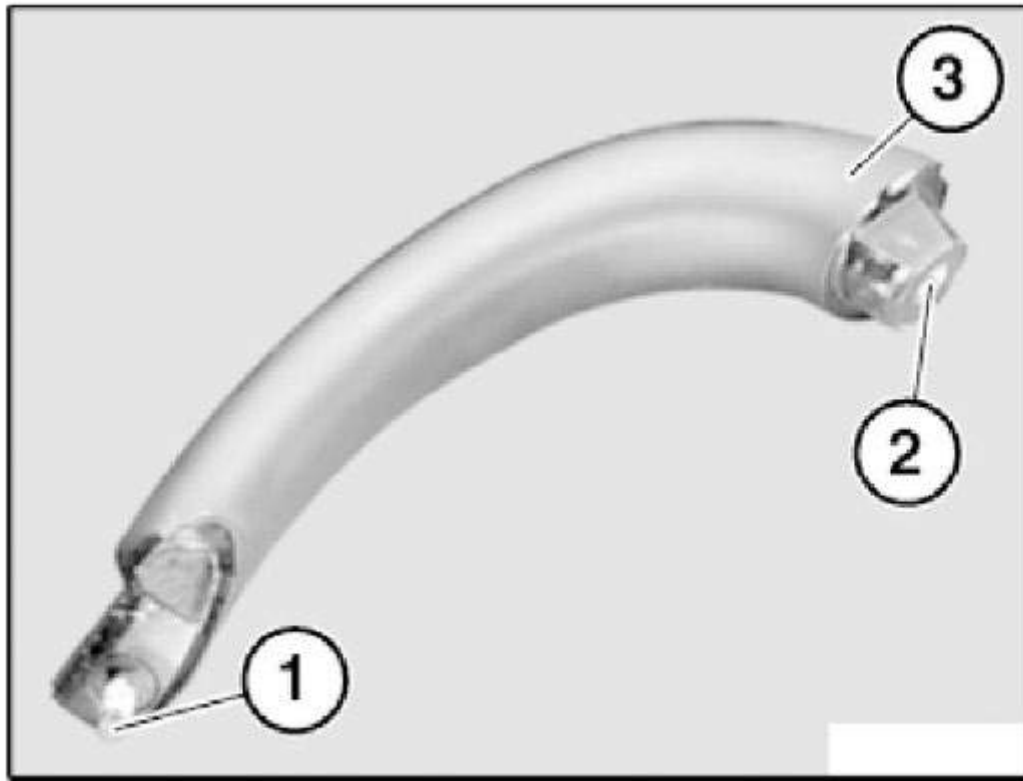


G03255929

Fig. 359: Identifying Door Handle And Door Trim Panel
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Screw (1) and sleeve (2) on door handle (3) must not be damaged.



G03255930

Fig. 360: Identifying Screw And Sleeve On Door Handle

Courtesy of BMW OF NORTH AMERICA, INC.

51 48 ... REMOVING AND INSTALLING/REPLACING SOUND INSULATION IN FRONT DOOR, LEFT OR RIGHT

NOTE: For Special Tool identification, see **SPECIAL TOOLS - X5 (3.0i) .**

Special Tools Required:

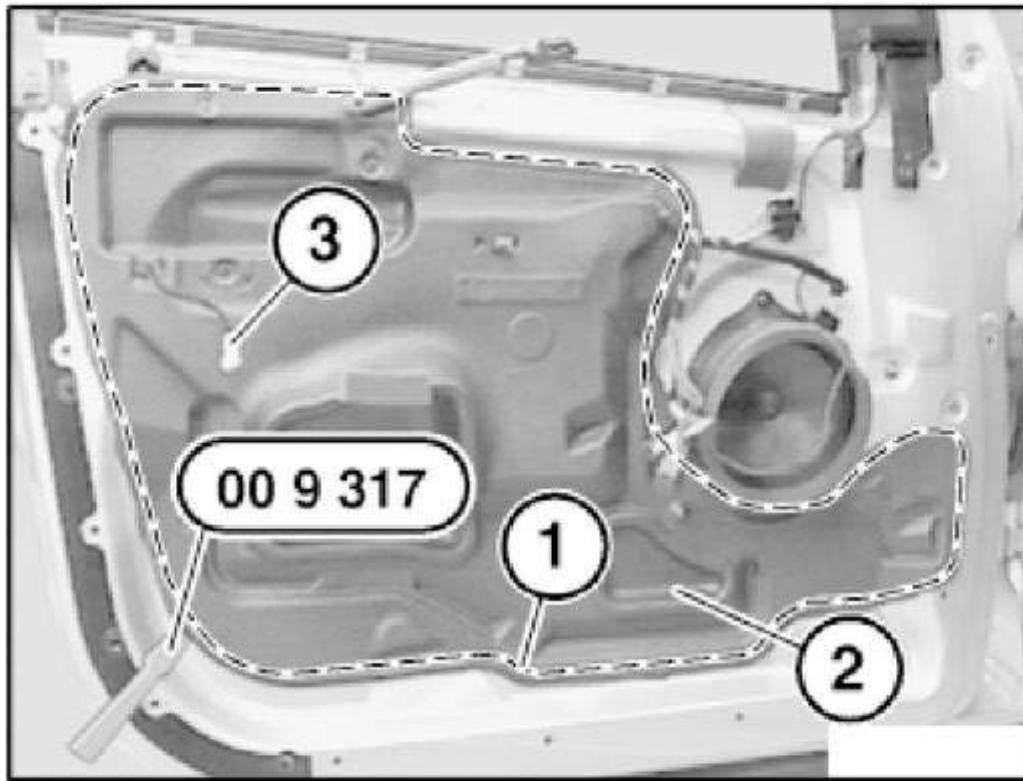
- 00 9 317

Remove front door trim panel. Refer to **51 41 000 REMOVING AND INSTALLING LEFT OR RIGHT FRONT DOOR TRIM PANEL .**

If necessary, remove airbag module in front door. Refer to **SIDE AIR BAG MODULE** for year model 2001, **SIDE AIR BAG MODULE** for year model 2002, or **SIDE AIR BAG MODULE** for year model 2003.

Using special tool 00 9 317 (trim panel wedge), lever out sealing bead (1) of sound insulation (2) completely or if necessary partially.

Feed airbag lead (3) out of sound insulation (2).



G03255931

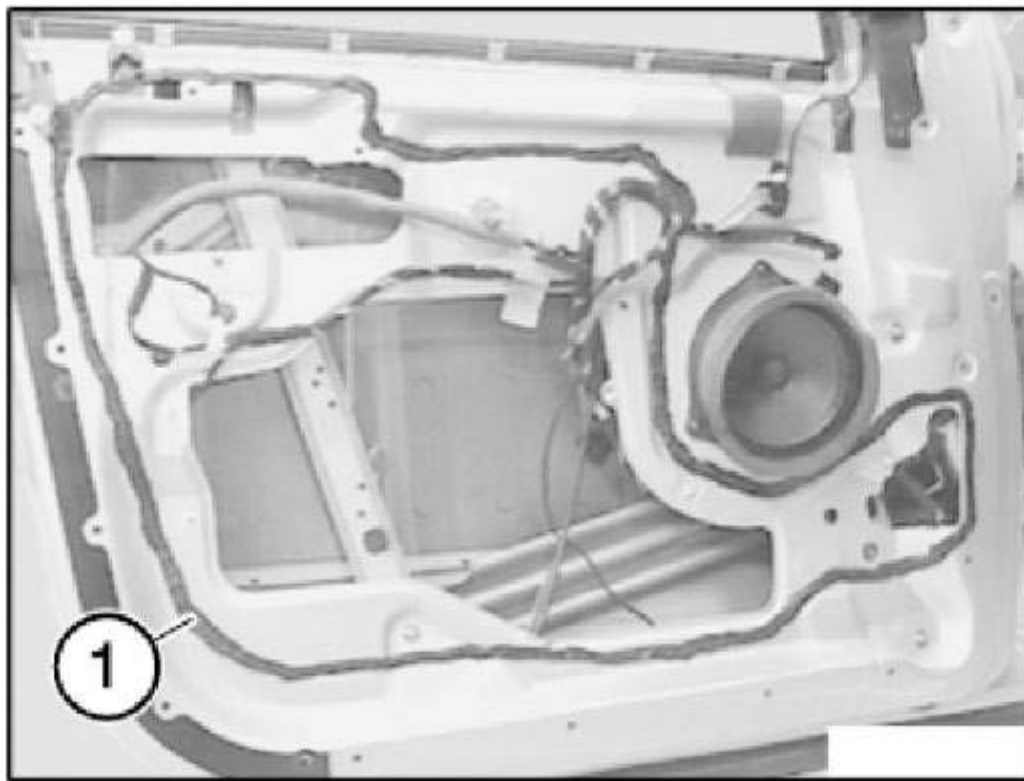
Fig. 361: Levering Out Sealing Bead Using Assembly Wedge
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

In event of replacement or partial detachment, lay butylene tape on inner door plate or sound insulation.

Seal cable penetrations with butylene tape.

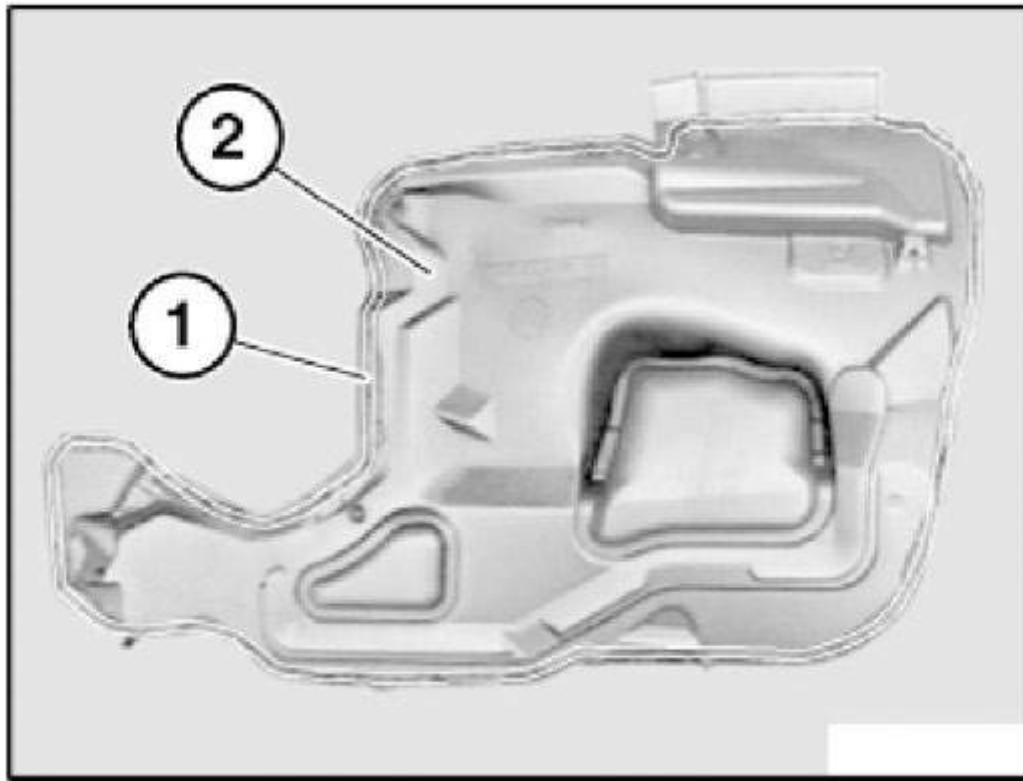
NOTE: **Position of butylene tape (1) on inner door plate.**



G03255932

Fig. 362: Locating Butylene Tape On Inner Door Plate
Courtesy of BMW OF NORTH AMERICA, INC.

NOTE: **Position of butylene tape (1) on sound insulation (2).**



G03255933

Fig. 363: View Of Butylene Tape On Sound Insulation
Courtesy of BMW OF NORTH AMERICA, INC.

Clean specified adhesive area with adhesive cleaner.

Air drying time: 1 minute

CAUTION: The adhesive areas must be dry and free from dust and grease. After cleaning, do not touch the adhesive areas with bare hands.

Lay single row of 6 mm dia. butylene tape or double row of 3 mm dia. tape in specified adhesive area.

Heat butylene tape (hot air blower) and press down firmly on sound insulation all around.

Contact pressure with hand roller: approx. 30 N/cm² . Manual contact pressure: approx. 10 N/cm² .

NOTE:

Firm thumb pressure has approx. 50 N/cm² .

REAR DOOR TRIM PANEL WITH ARM REST

51 42 000 REMOVING AND INSTALLING REAR LEFT OR RIGHT DOOR TRIM PANEL

NOTE: For Special Tool identification, see **SPECIAL TOOLS - X5 (3.0i)** .

Special Tools Required:

- 00 9 317

WARNING: Version with side airbag: Follow safety instructions for working on cars with airbag systems, refer to **51 00 ... SERVICE POSITION OF ENGINE HOOD** .

CAUTION: Do not use any sharp-edged tools to remove the panel - risk of damage to airbag.

Remove clipped-in trim (decorative strip) on door trim panel. Refer to **51 16 221 REPLACING A CLIPPED FINISHER (DECORATIVE STRIP ON PANEL FOR INSTRUMENT PANEL, FRONT OR REAR DOOR)** .

Remove toggle switch for door window operation. Refer to **61 31 115 REPLACING ROCKER SWITCH FOR SIDE WINDOW OPERATION (DOOR SWITCH CENTER)** .

Remove footwell light on bottom of door. Refer to **63 31 020 REMOVING AND INSTALLING/REPLACING FOOTWELL LIGHT** .

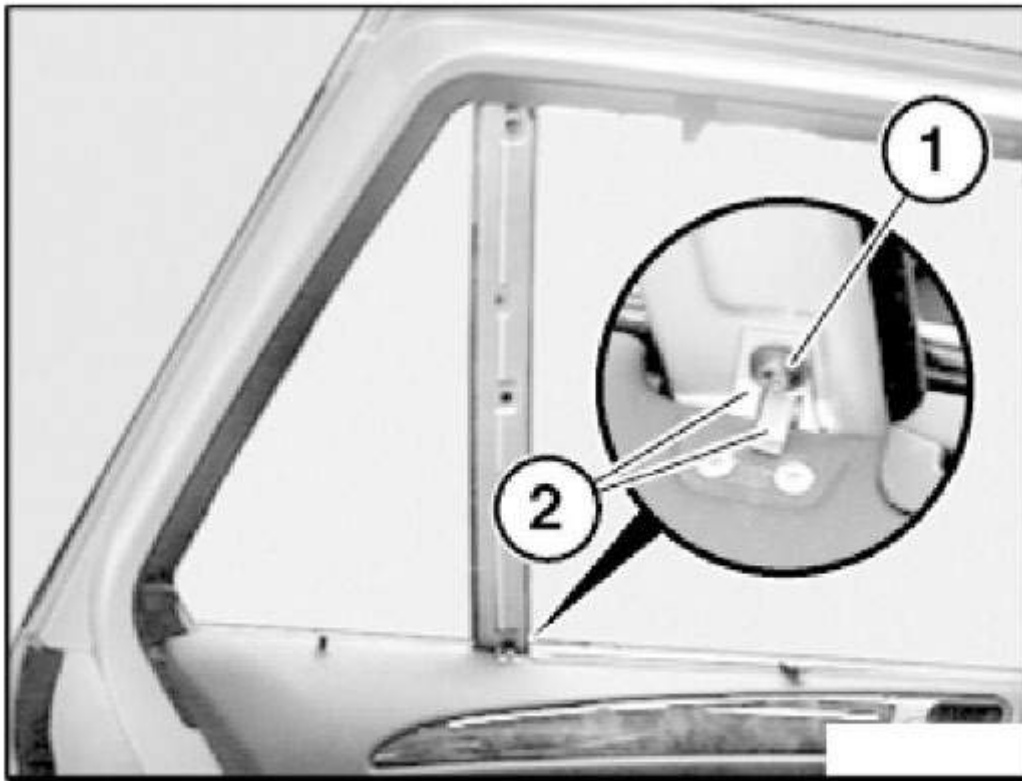
Version with roller sun blind additionally:

Remove roller sun blind on door window. Refer to **51 16 400 REMOVING AND INSTALLING OR REPLACING SUN BLIND AT FIXED SIDE WINDOW OF LEFT OR RIGHT REAR DOOR** .

Release screw (1).

Installation:

Bracket (2) must not be damaged.

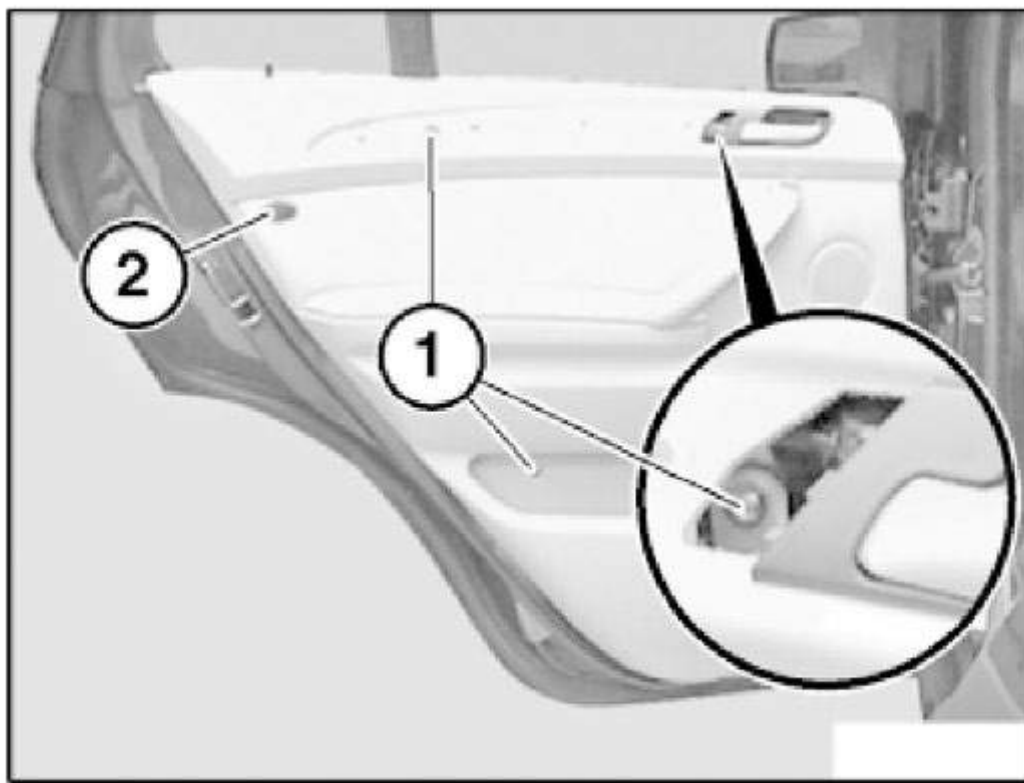


G03255934

Fig. 364: Identifying Bracket And Screw
Courtesy of BMW OF NORTH AMERICA, INC.

Release screws (1).

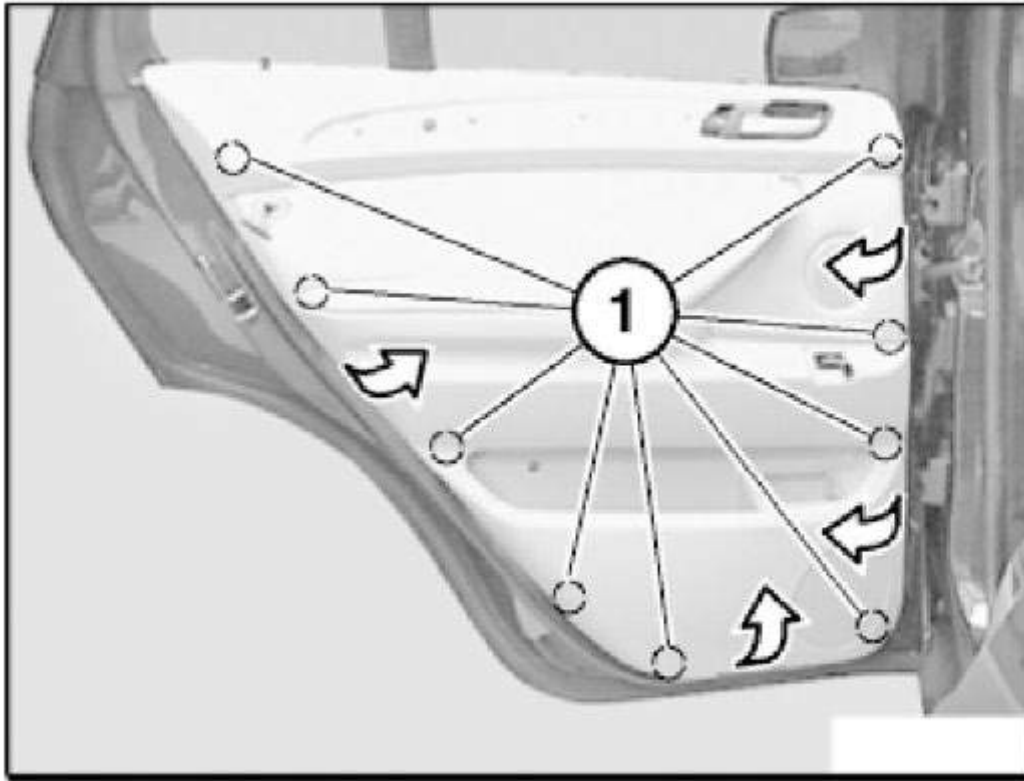
Lever out airbag label (2) and release screw underneath.



G03255935

Fig. 365: Removing Airbag Label And Locating Screw
Courtesy of BMW OF NORTH AMERICA, INC.

Unclip clips (1) of door trim panel with special tool 00 9 317 (trim panel wedge).



G03255936

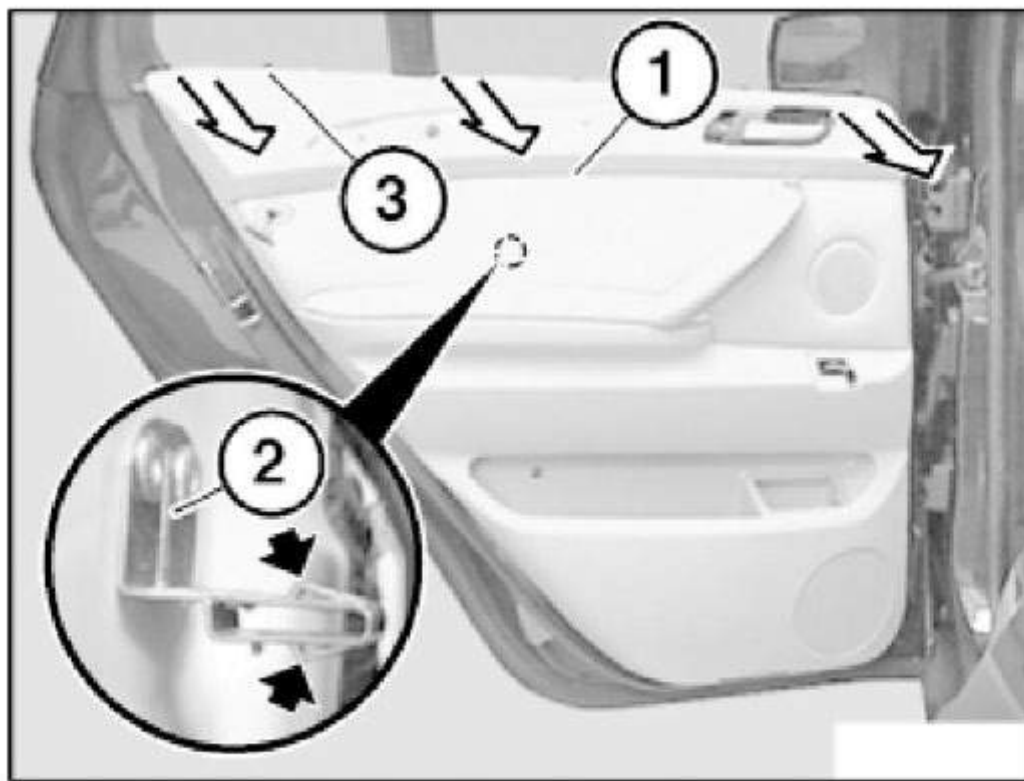
Fig. 366: Unclipping Clips Of Door Trim Panel With Assembly Wedge
Courtesy of BMW OF NORTH AMERICA, INC.

Carefully unclip door trim panel (1) at top with special tool 00 9 317 (trim panel wedge).

Feed door trim panel (1) out of unlocking button (3).

Installation:

Bend open retainers (2) on inner door plate for accommodating central clip.

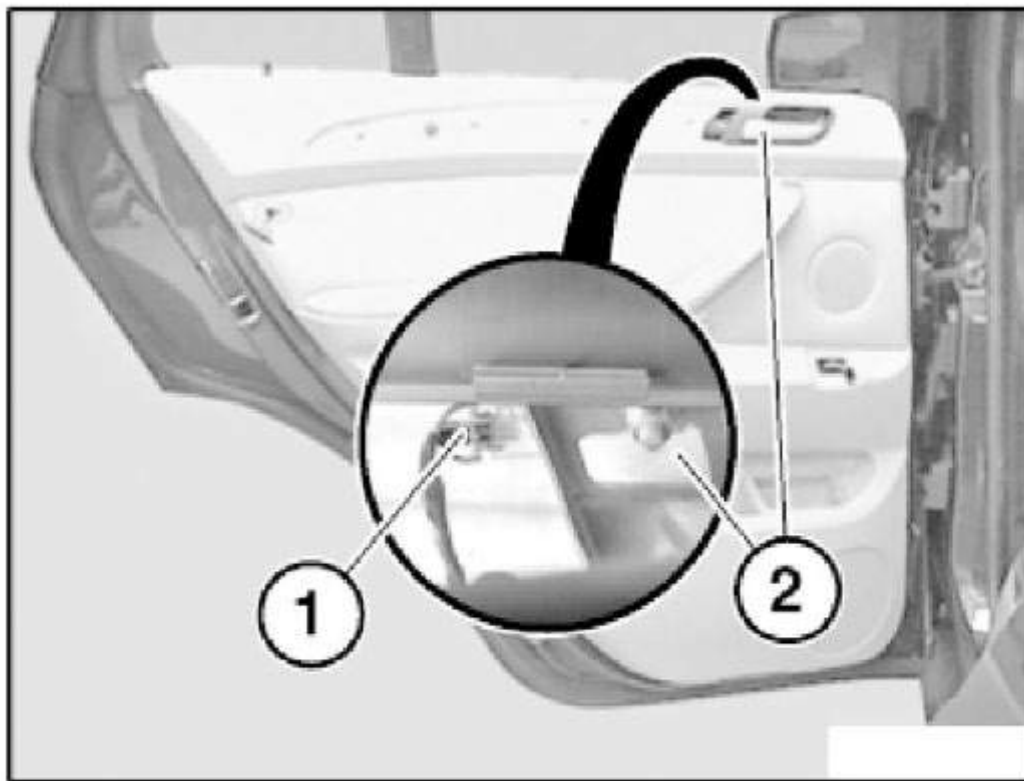


G03255937

Fig. 367: Identifying Retainers For Central Clip
Courtesy of BMW OF NORTH AMERICA, INC.

Version with lighting for inside door handle:

If necessary, disconnect plug connection (1) on inside door handle (2).

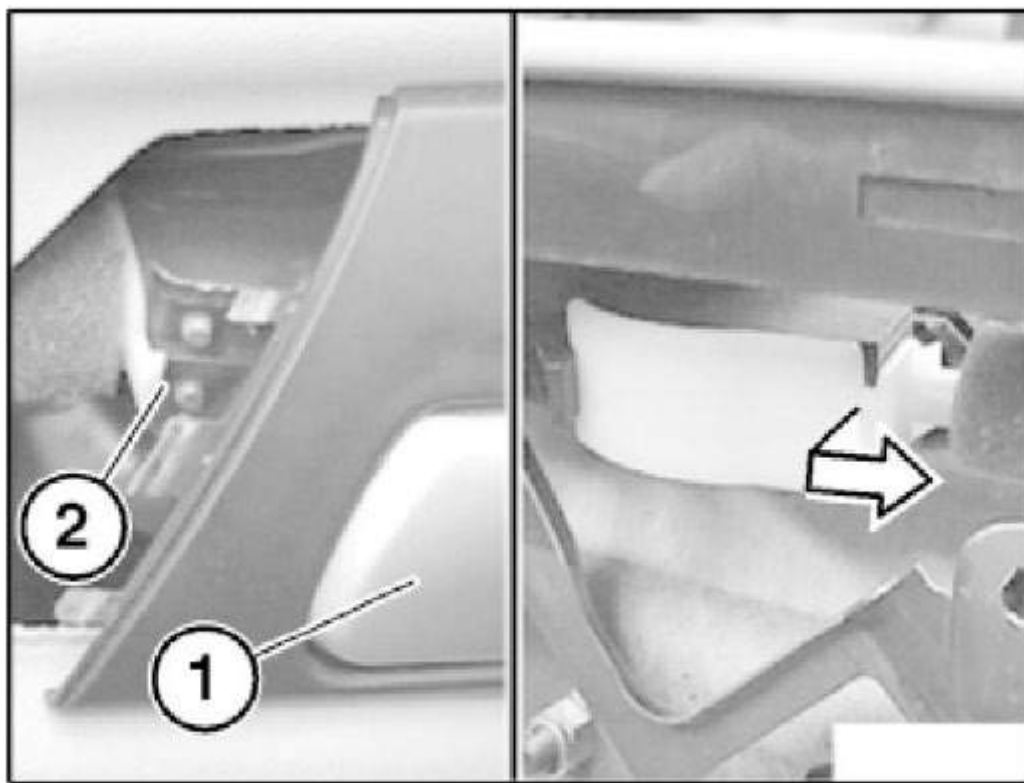


G03255938

Fig. 368: Disconnecting Plug Connection On Inside Door Handle
Courtesy of BMW OF NORTH AMERICA, INC.

Unhook Bowden cable for release lever:

- Tighten release lever (1).
- Lever out lock (2).
- Detach Bowden cable towards inside/rear.



G03255939

Fig. 369: Detaching Bowden Cable

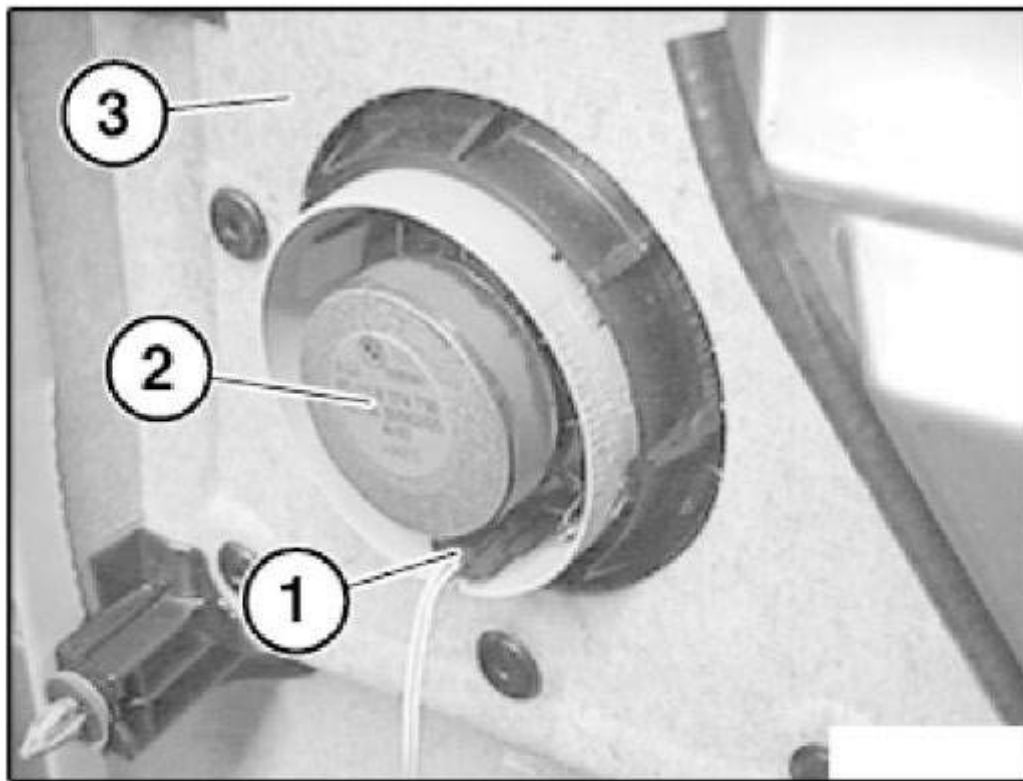
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Press unlocking lever (1) for installation fully on door trim panel.

Version with additional speaker:

If necessary, disconnect plug connection (1) on additional speaker (2).



G03255940

Fig. 370: Identifying Plug Connection On Additional Speaker
Courtesy of BMW OF NORTH AMERICA, INC.

Remove door trim panel (3).

Installation:

Clips (1) are longer than the other clips.

Clips (1) are gray, the other clips are white.

Fit all clips with sealing ring.

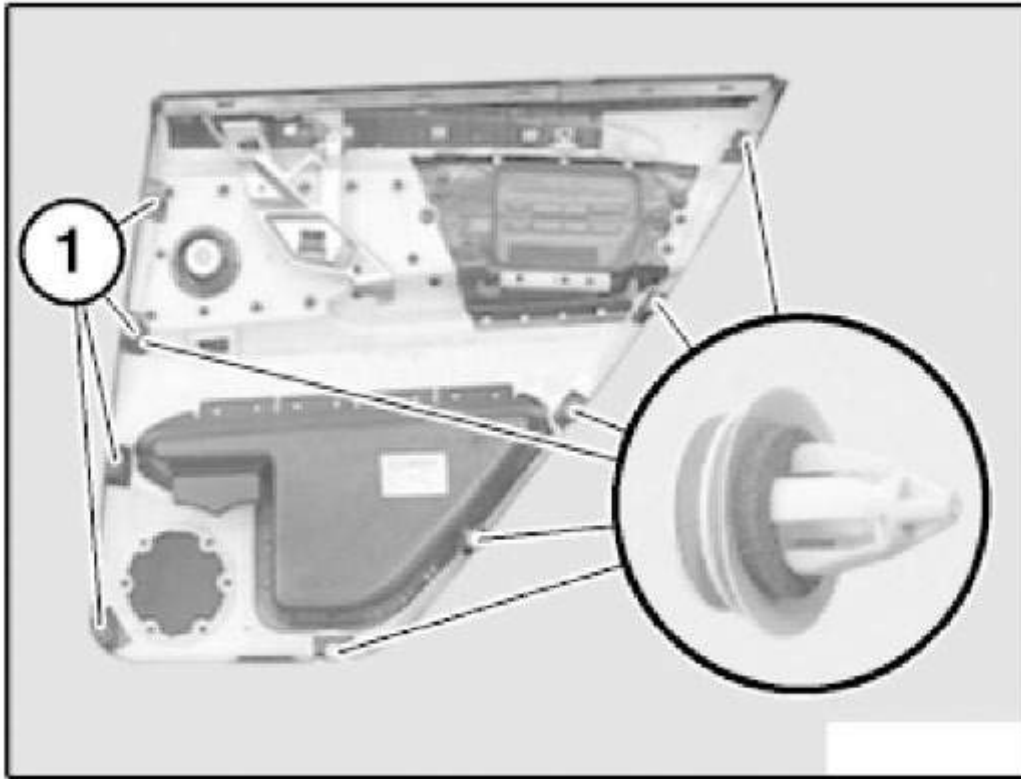
**G03255941**

Fig. 371: Identifying Clips With Sealing Ring
Courtesy of BMW OF NORTH AMERICA, INC.

If necessary, replace faulty clips.

Installation:

After assembling the door trim panel proceed as follows:

- Open door window.
- Lock with vehicle key.
- Check whether linkage of safety button can move freely.
- If necessary, align linkages.

51 42 001 REPLACING LEFT OR RIGHT REAR DOOR TRIM

Remove rear door trim panel. Refer to **51 42 000 REMOVING AND INSTALLING REAR LEFT OR**

RIGHT DOOR TRIM PANEL .

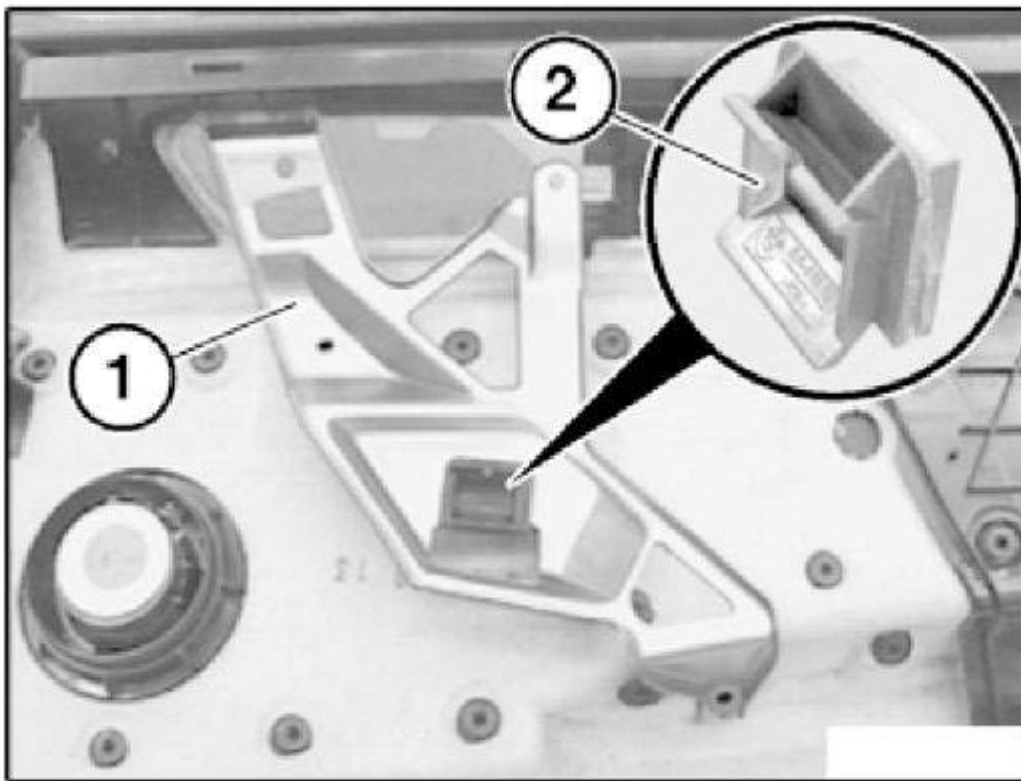
Version with Hi-Fi system:

If necessary, remove mid-range speaker. Refer to **65 13 090 REMOVING AND INSTALLING/REPLACING SPEAKER (MID-RANGE SPEAKER) .**

Version with illuminated inside door handle:

If necessary, remove inside door handle. Refer to **51 22 225 REMOVING AND INSTALLING/REPLACING INSIDE DOOR HANDLE OF REAR LEFT OR RIGHT DOOR .**

Attach central clip (2) to frame (1).



G03255942

Fig. 372: Attaching Central Clip To Frame
Courtesy of BMW OF NORTH AMERICA, INC.

OR RIGHT

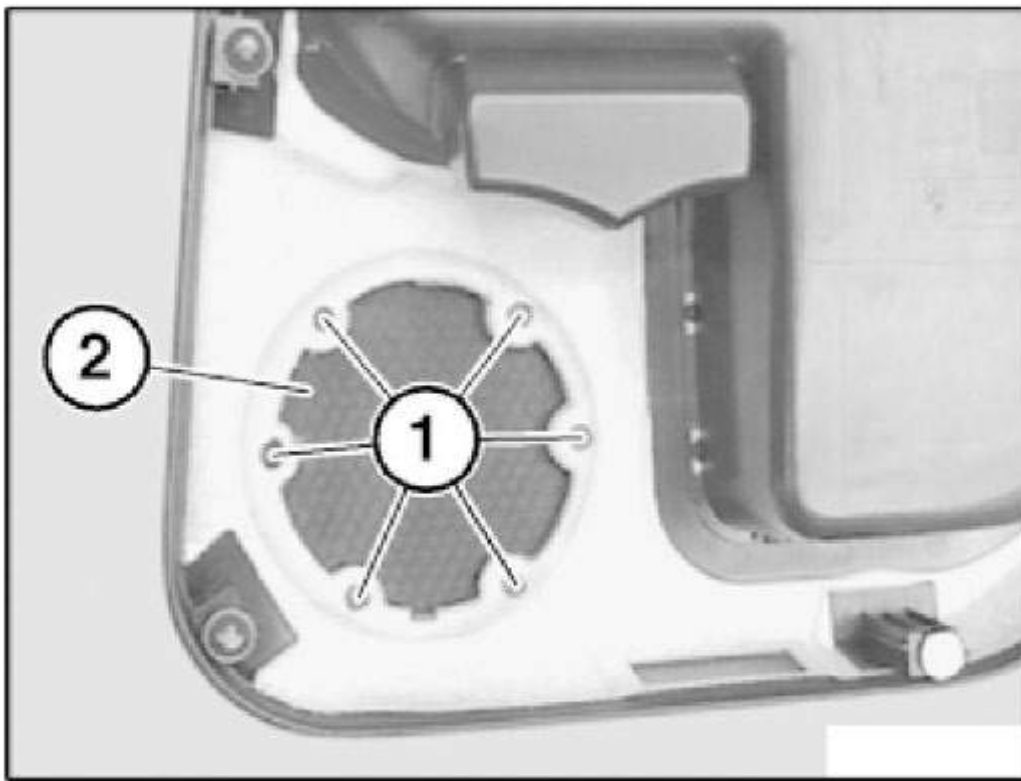
Operation Is Identical To:

Remove cover on door handle at front. Refer to **51 41 017 REMOVING AND INSTALLING/REPLACING COVER ON DOOR HANDLE, FRONT LEFT OR RIGHT** .

51 42 018 REPLACING SPEAKER FRAME ON REAR LEFT OR RIGHT DOOR TRIM PANEL

Remove rear door trim panel. Refer to **51 42 000 REMOVING AND INSTALLING REAR LEFT OR RIGHT DOOR TRIM PANEL** .

Release plastic welded joints (1) and remove speaker frame (2).



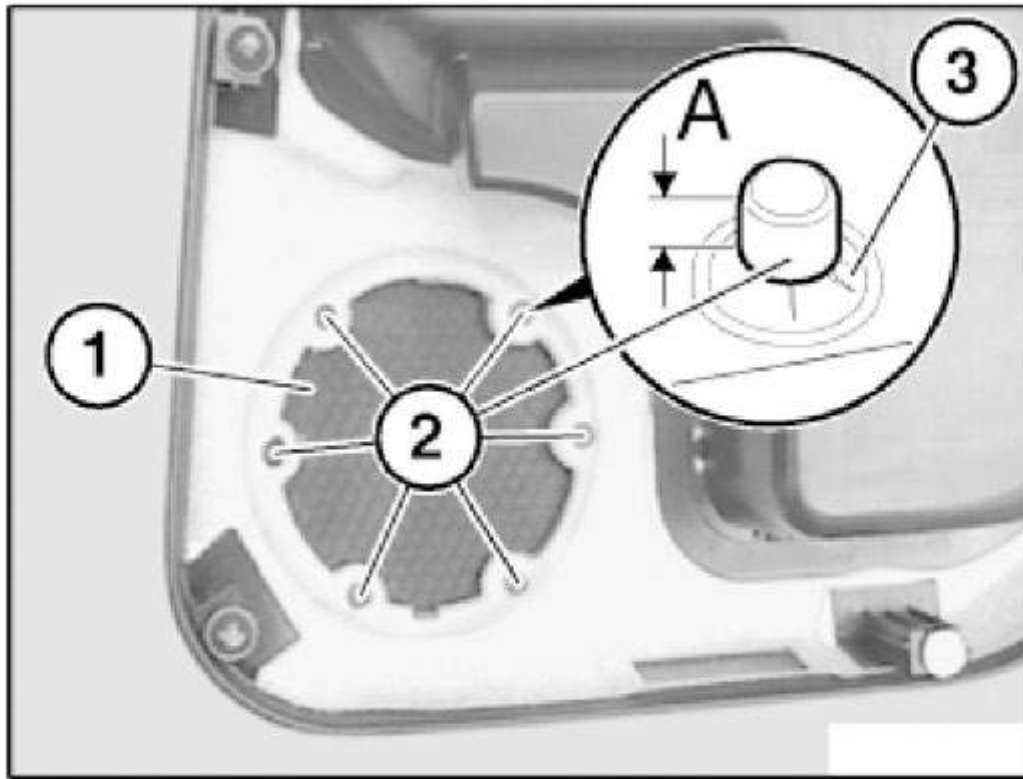
G03255943

Fig. 373: Identifying Plastic Welded Joints
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Install new speaker frame (1).

Push locking washers (3) onto plastic pins (2).



G03255944

Fig. 374: Installing Locking Washers Onto Plastic Pins

Courtesy of BMW OF NORTH AMERICA, INC.

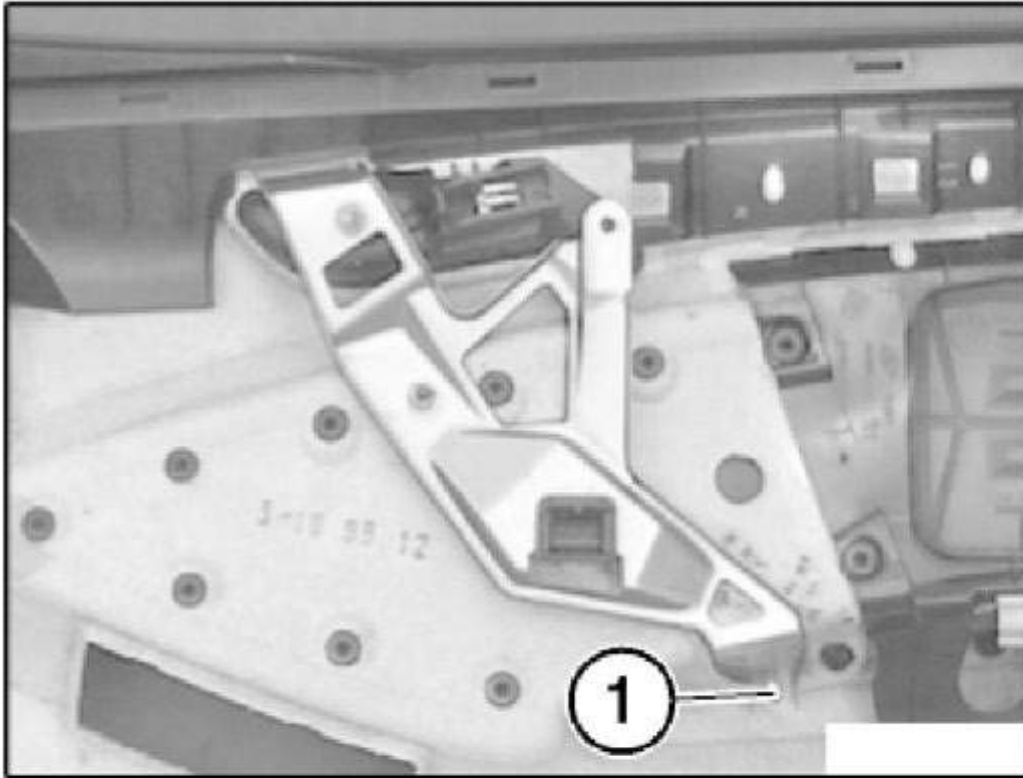
Shorten all plastic pins (2) down to measurement (A).

51 42 019 REMOVING AND INSTALLING/REPLACING DOOR HANDLE ON DOOR TRIM PANEL, REAR LEFT OR RIGHT

Remove rear door trim panel. Refer to **51 42 000 REMOVING AND INSTALLING REAR LEFT OR RIGHT DOOR TRIM PANEL** .

Remove cover on door handle. Refer to **51 41 017 REMOVING AND INSTALLING/REPLACING COVER ON DOOR HANDLE, FRONT LEFT OR RIGHT** .

Release screw (1).

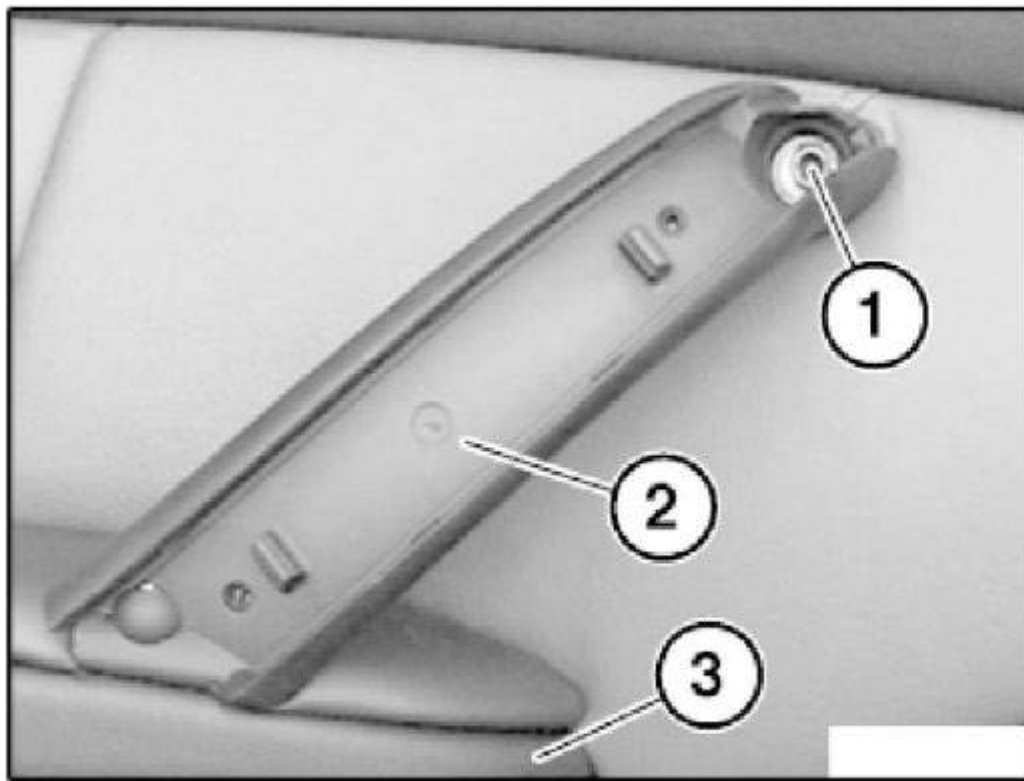


G03255945

Fig. 375: Releasing Screw

Courtesy of BMW OF NORTH AMERICA, INC.

Release screw (1) and detach door handle (2) from door trim panel (3).

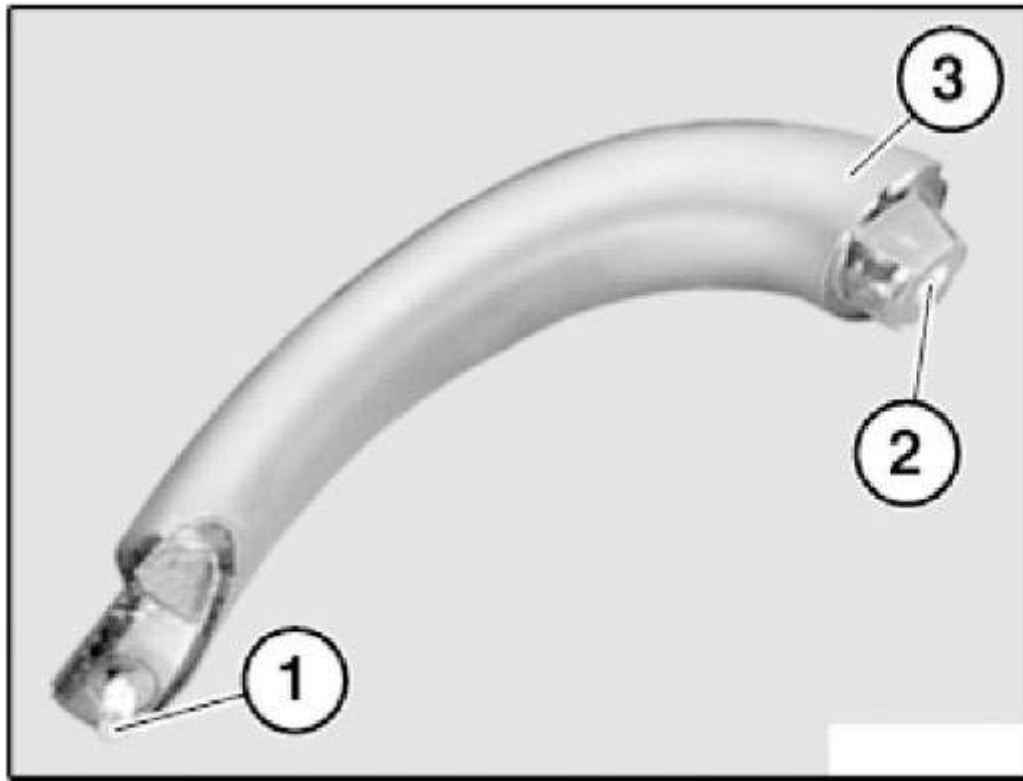


G03255946

Fig. 376: Releasing Screw And Detaching Door Handle From Door Trim Panel
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Screw (1) and sleeve (2) on door handle (3) must not be damaged.



G03255947

Fig. 377: Identifying Screw And Sleeve On Door Handle

Courtesy of BMW OF NORTH AMERICA, INC.

51 48 ... REMOVING AND INSTALLING/REPLACING SOUND INSULATION IN REAR DOOR, LEFT OR RIGHT

NOTE: For Special Tool identification, see **SPECIAL TOOLS - X5 (3.0i) .**

Special Tools Required:

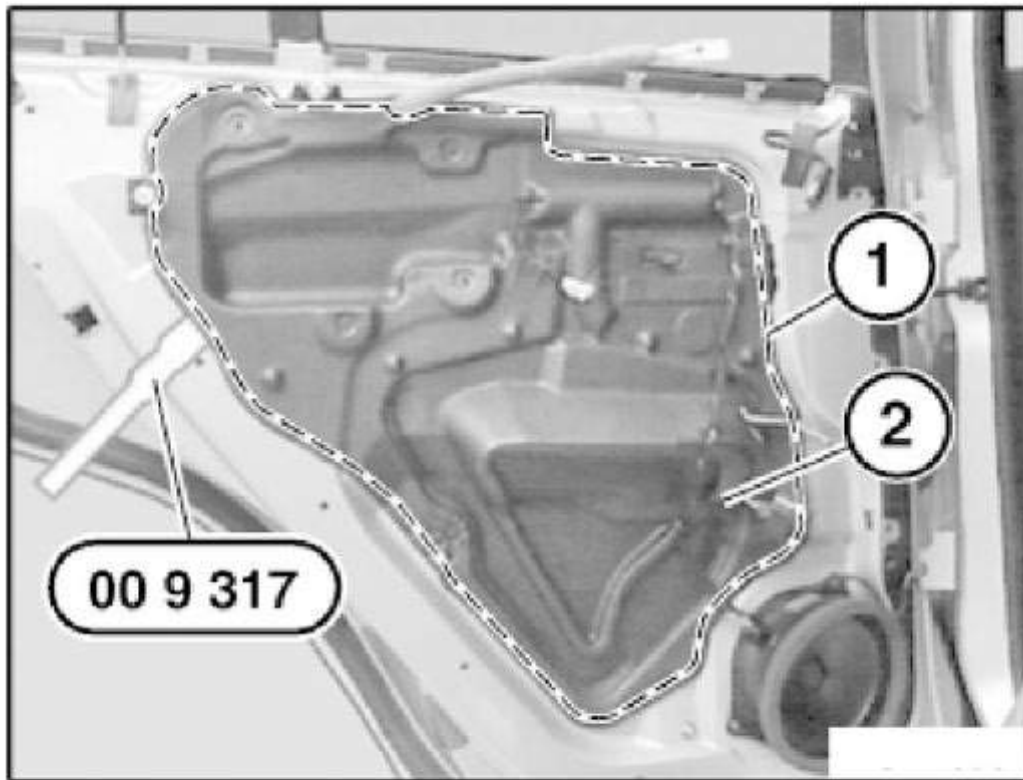
- 00 9 317

Remove rear door trim panel. Refer to **51 42 000 REMOVING AND INSTALLING REAR LEFT OR RIGHT DOOR TRIM PANEL .**

If necessary, remove airbag module in rear door.

Using special tool 00 9 317 (trim panel wedge), lever out sealing bead (1) of sound insulation (2) completely or

if necessary partially.



G03255948

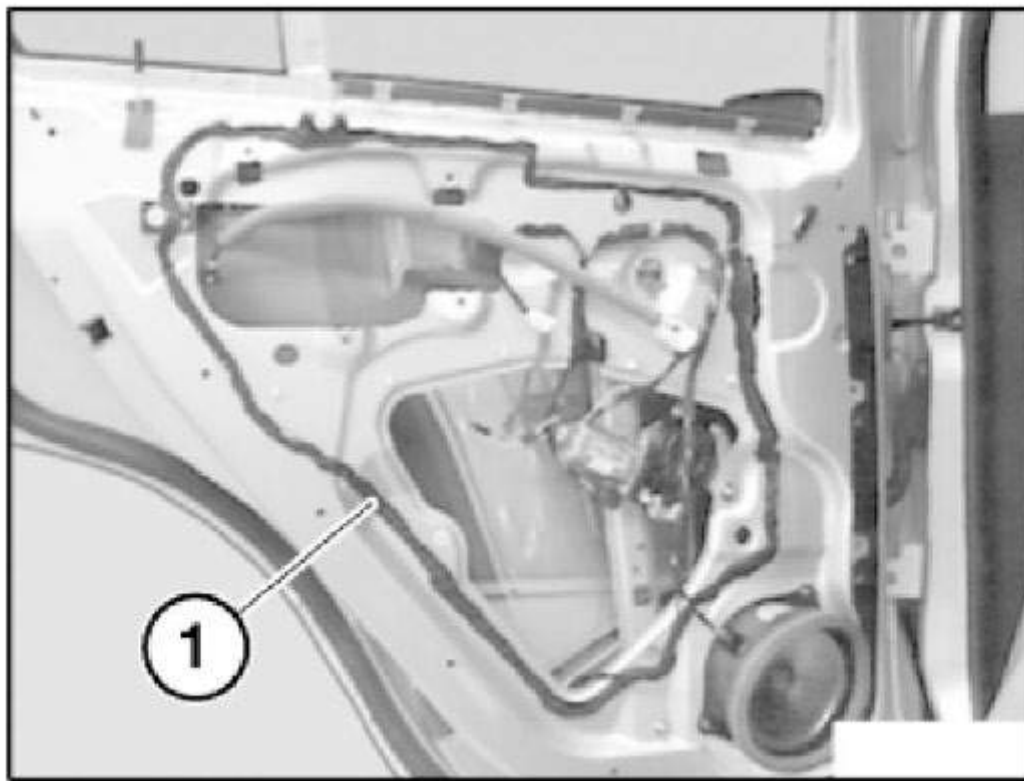
Fig. 378: Removing Sealing Bead Using Assembly Wedge
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

In event of replacement or partial detachment, lay butylene tape on inner door plate or sound insulation.

Seal cable penetrations with butylene tape.

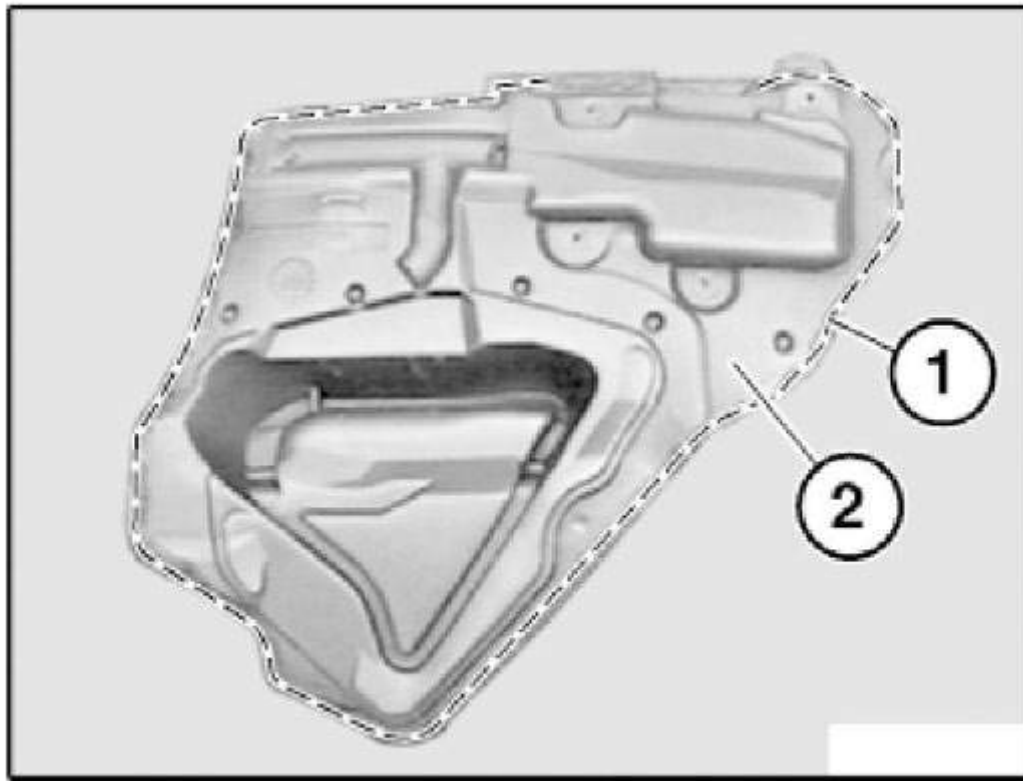
NOTE: **Position of butylene tape (1) on inner door plate.**



G03255949

Fig. 379: Locating Butylene Tape On Inner Door Plate
Courtesy of BMW OF NORTH AMERICA, INC.

NOTE: **Position of butylene tape (1) on sound insulation (2).**



G03255950

Fig. 380: Positioning Of Butylene Tape On Sound Insulation
Courtesy of BMW OF NORTH AMERICA, INC.

Clean specified adhesive area with adhesive cleaner.

Air drying time: 1 minute.

CAUTION: The adhesive areas must be dry and free from dust and grease. After cleaning, do not touch the adhesive areas with bare hands.

Lay single row of 6 mm dia. butylene tape or double row of 3 mm dia. tape in specified adhesive area.

Heat butylene tape (hot air blower) and press down firmly on sound insulation all around.

Contact pressure with hand roller: approx. 30 N/cm².

Manual contact pressure: approx. 10 N/cm².

NOTE: Firm thumb pressure has approx. 50 N/cm² .

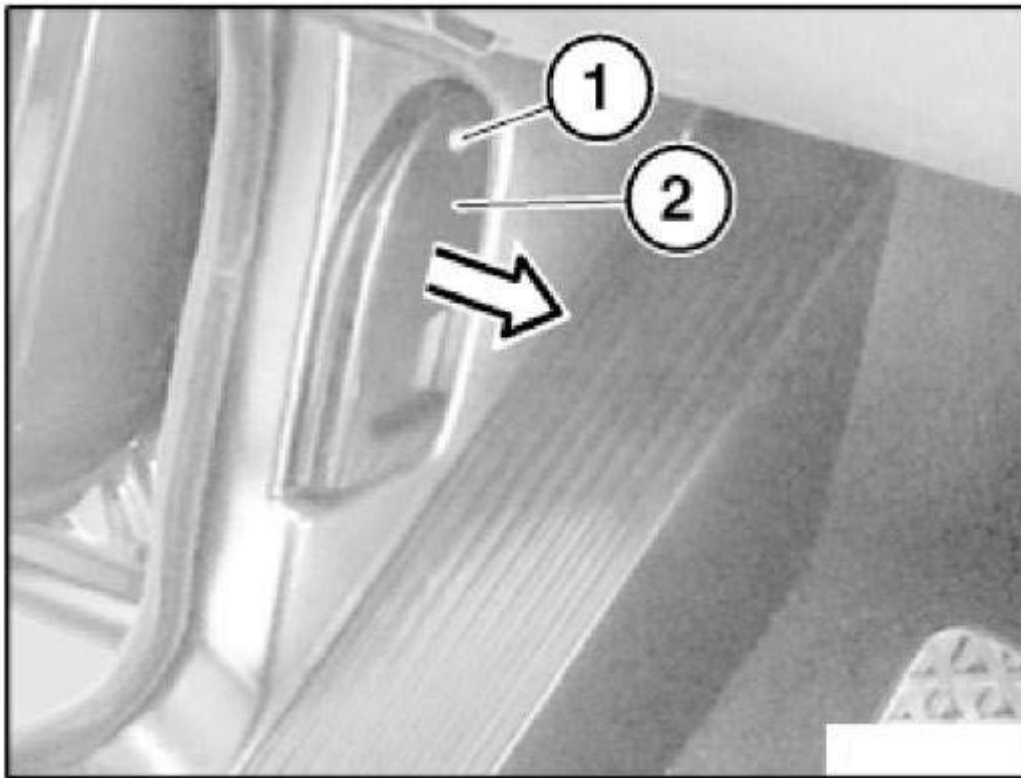
SIDE COVERING WITH ARMRESTS

51 43 070 REMOVING AND INSTALLING/REPLACING SIDE TRIM PANEL, FOOTWELL, ON A-PILLAR, LEFT

Remove trim panel for pedal assembly. Refer to 51 45 185 REMOVING AND INSTALLING/REPLACING TRIM FOR PEDAL ASSEMBLY .

Remove entrance cover strip at front (inside). Refer to 51 47 000 REMOVING AND INSTALLING/REPLACING THE FRONT (INSIDE) LEFT OR RIGHT ROCKER PANEL STRIP .

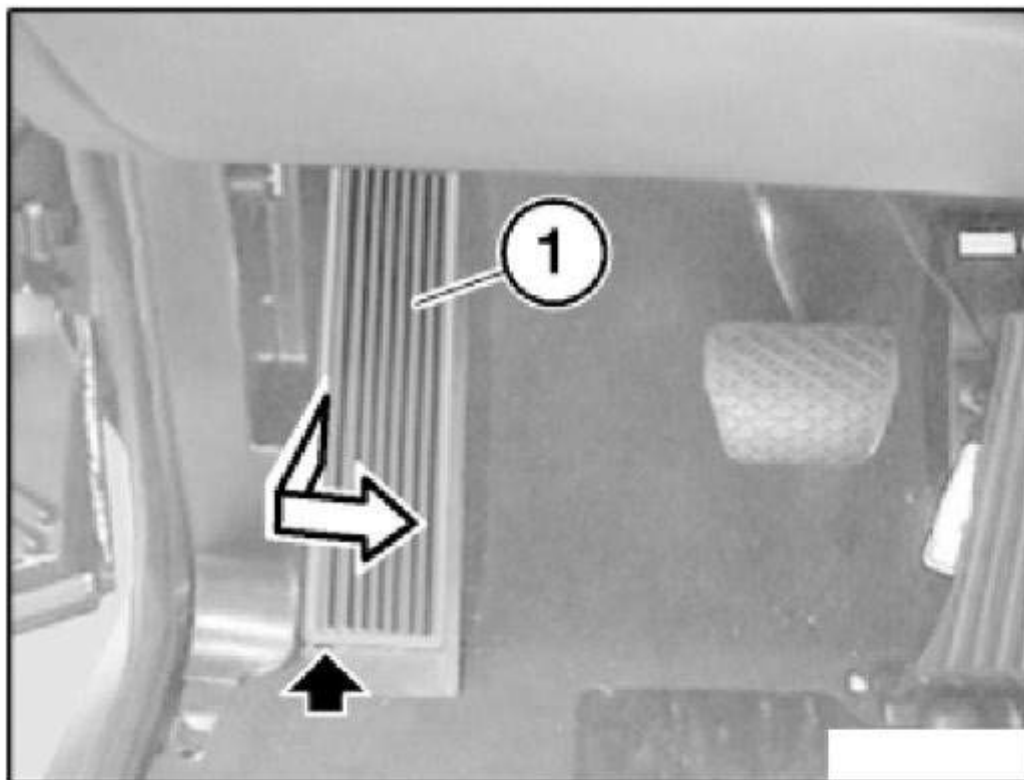
Release screw (1) and remove release lever (2).



G03255951

Fig. 381: Releasing Screw And Removing Release Lever
Courtesy of BMW OF NORTH AMERICA, INC.

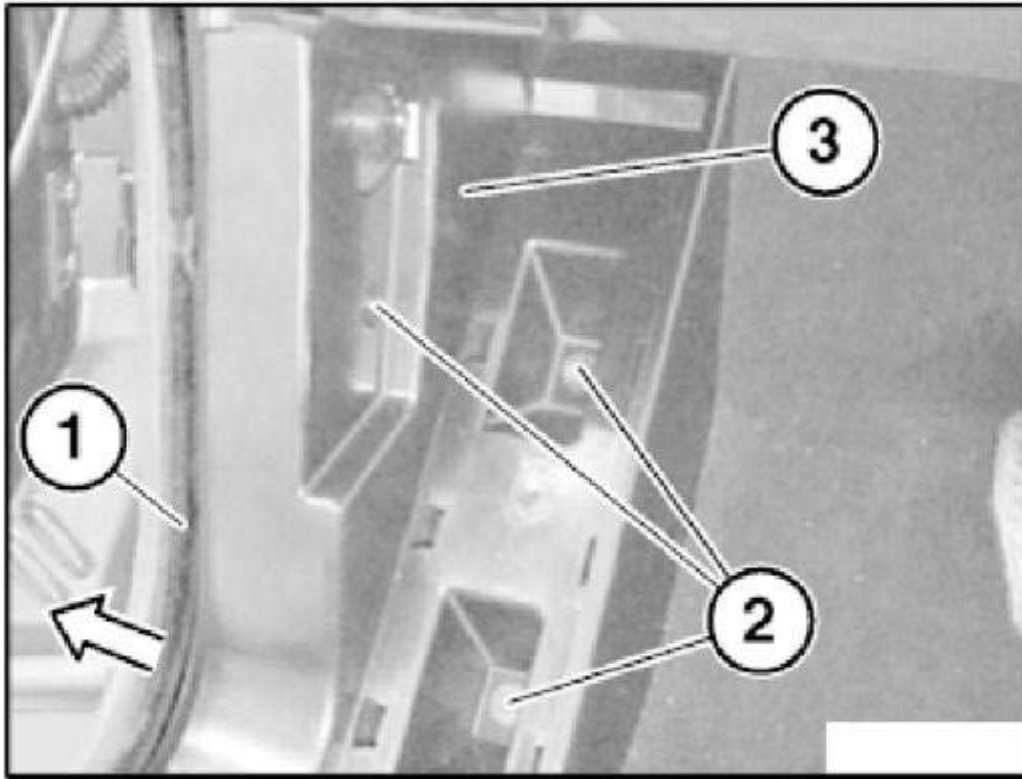
Unclip running board (1) on outside from below towards top and remove towards interior.



G03255952

Fig. 382: Removing Running Board On Outside
Courtesy of BMW OF NORTH AMERICA, INC.

Detach mocket (1) in area of footwell trim (3).



G03255953

Fig. 383: Detaching Mocket In Area Of Footwell Trim
Courtesy of BMW OF NORTH AMERICA, INC.

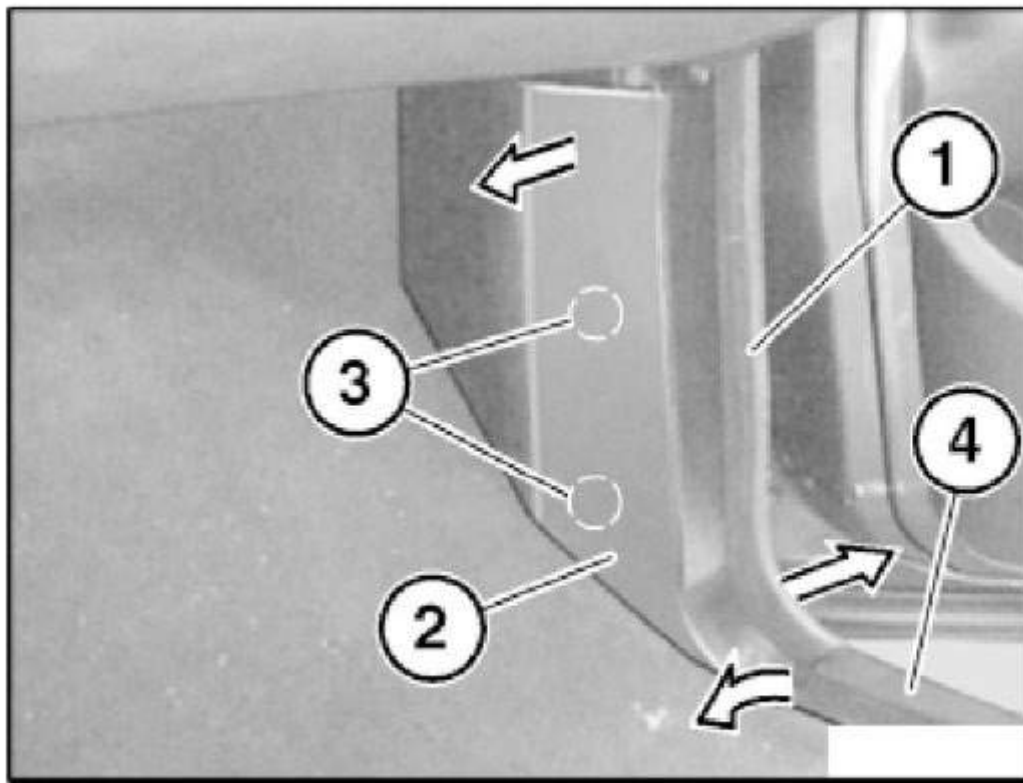
Release screws (2).

Remove footwell trim (3) towards front/interior.

51 43 075 REMOVING AND INSTALLING/REPLACING SIDE TRIM PANEL, FOOTWELL, ON A-PILLAR, RIGHT

Remove bottom right trim panel from instrument panel. Refer to **51 45 181 REMOVING AND INSTALLING/REPLACING TRIM FOR INSTRUMENT PANEL, BOTTOM RIGHT** .

Detach mocket (1) in area of side trim panel (2).



G03255954

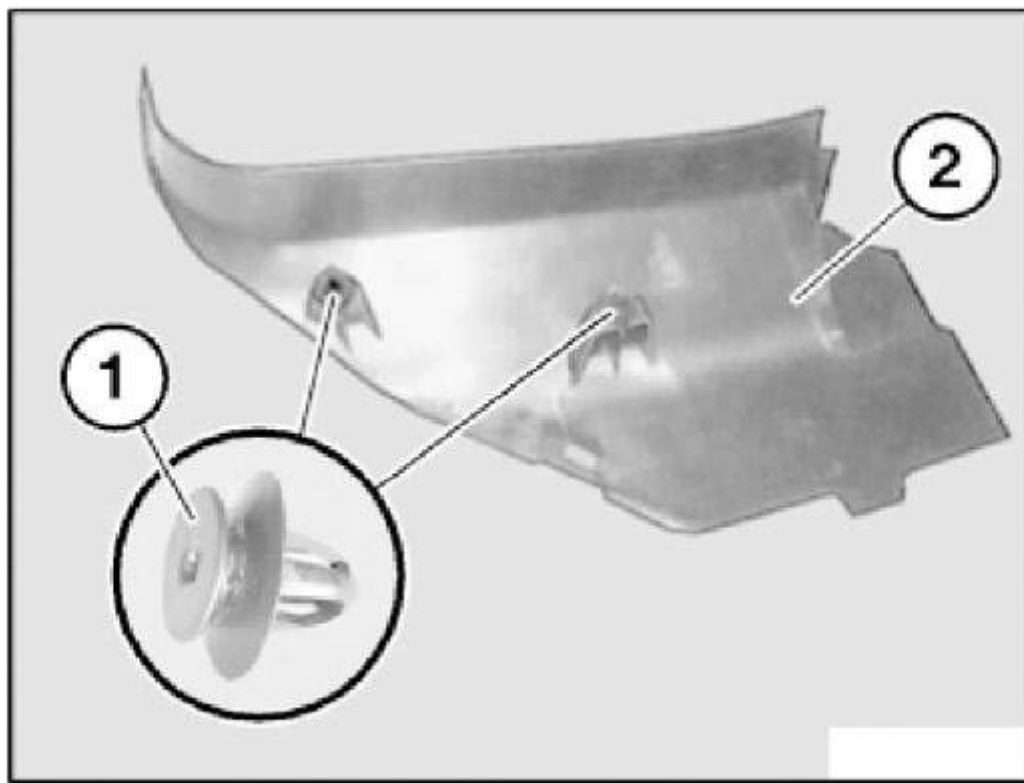
Fig. 384: Detaching Mocket In Area Of Side Trim Panel
Courtesy of BMW OF NORTH AMERICA, INC.

Unclip clips (3) towards interior.

Withdraw side trim panel (2) from entrance cover strip (4) and remove towards interior.

Installation:

If necessary, replace faulty clips (1) in side trim panel (2).

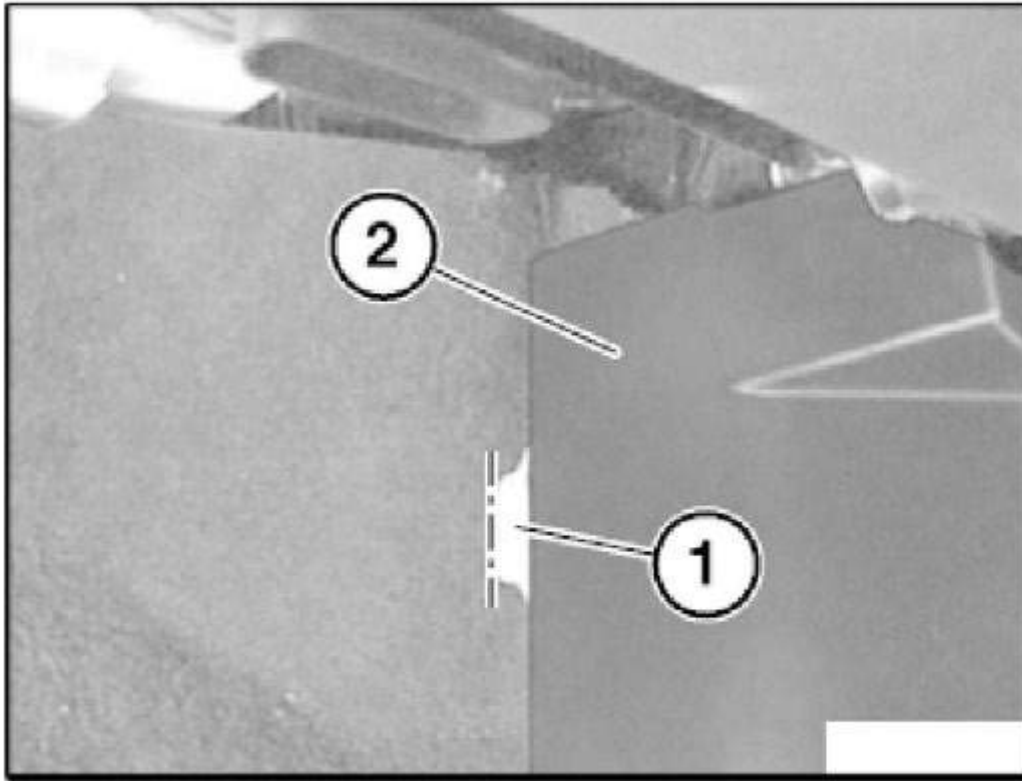


G03255955

Fig. 385: Identifying Clips In Side Trim Panel
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Insert guide (1) of side trim panel (2) into slot in carpet.



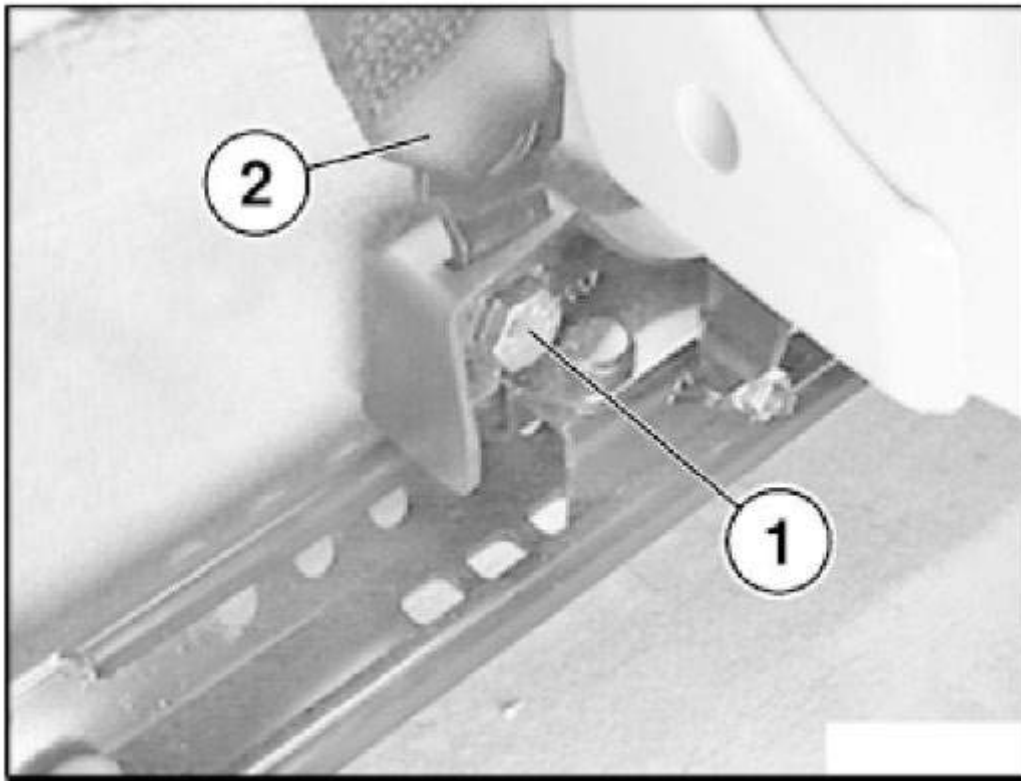
G03255956

Fig. 386: Inserting Guide Of Side Trim Panel Into Slot In Carpet
Courtesy of BMW OF NORTH AMERICA, INC.

**51 43 148 REMOVING AND INSTALLING OR REPLACING TRIM ON LEFT OR RIGHT DOOR
PILLAR (TOP)**

Move front seat upwards.

Release seatbelt screw (1) on front seat and feed out seatbelt strap (2).



G03255957

Fig. 387: Locating Seatbelt Screw And Strap
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Tightening torque, (45 N.m.).

Subsequent Work Is Described In:

Removing panel for door pillar (bottom). Refer to **51 43 150 REMOVING AND INSTALLING OR REPLACING TRIM FOR LEFT OR RIGHT DOOR PILLAR (BOTTOM)** .

51 43 150 REMOVING AND INSTALLING OR REPLACING TRIM FOR LEFT OR RIGHT DOOR PILLAR (BOTTOM)

Remove front entrance cover strip. Refer to **51 47 000 REMOVING AND INSTALLING/REPLACING THE FRONT (INSIDE) LEFT OR RIGHT ROCKER PANEL STRIP** .

Remove rear entrance cover strip (2).

Partially remove mocket from B-pillar finisher.

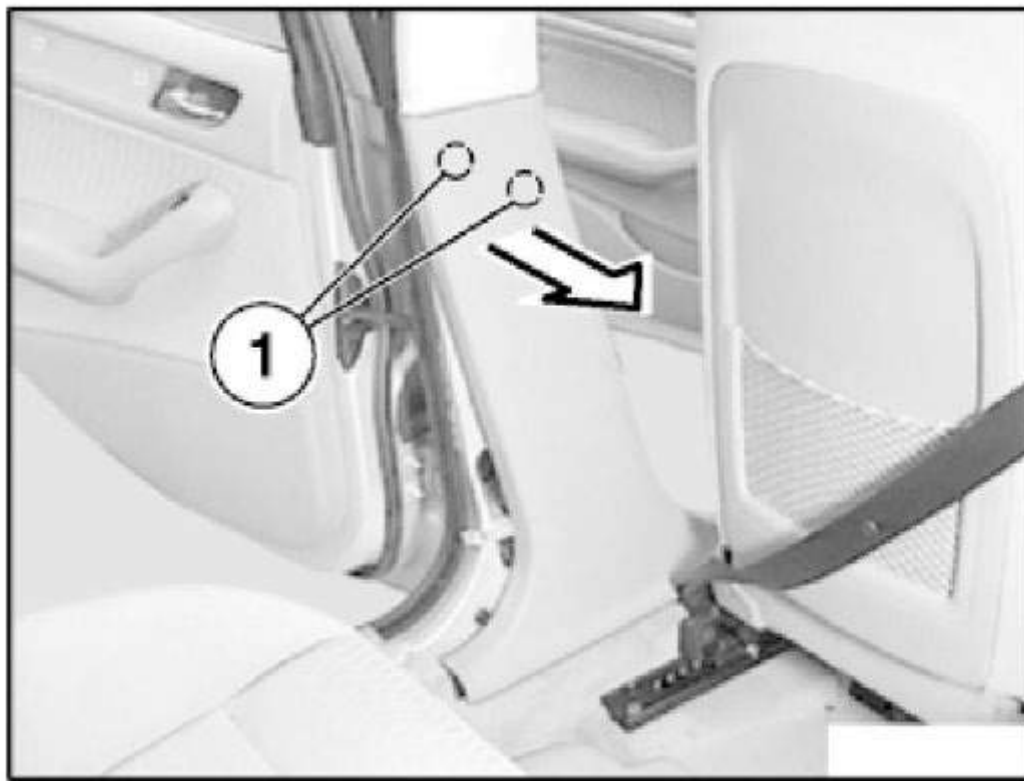
Unclip clips (1) in lower panel.



G03255958

Fig. 388: Unclipping Lower Clips In Lower Panel
Courtesy of BMW OF NORTH AMERICA, INC.

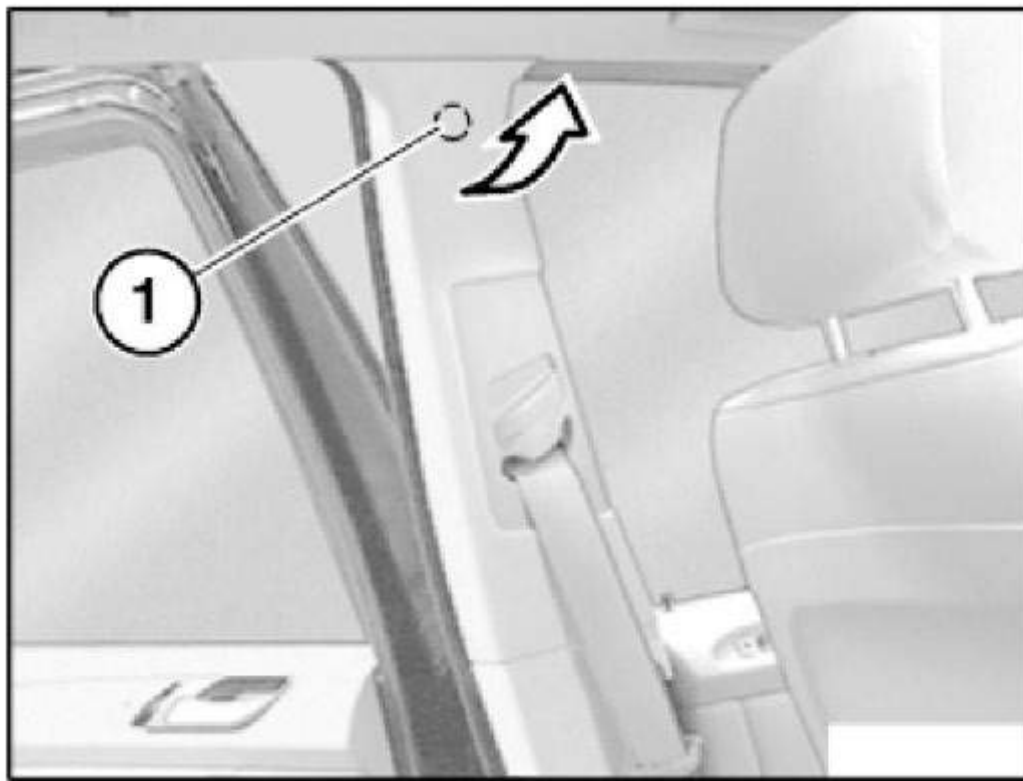
Unclip clips (1) in lower panel.



G03255959

Fig. 389: Unclipping Upper Clips In Lower Panel
Courtesy of BMW OF NORTH AMERICA, INC.

Unclip clip (1) in upper panel.



G03255960

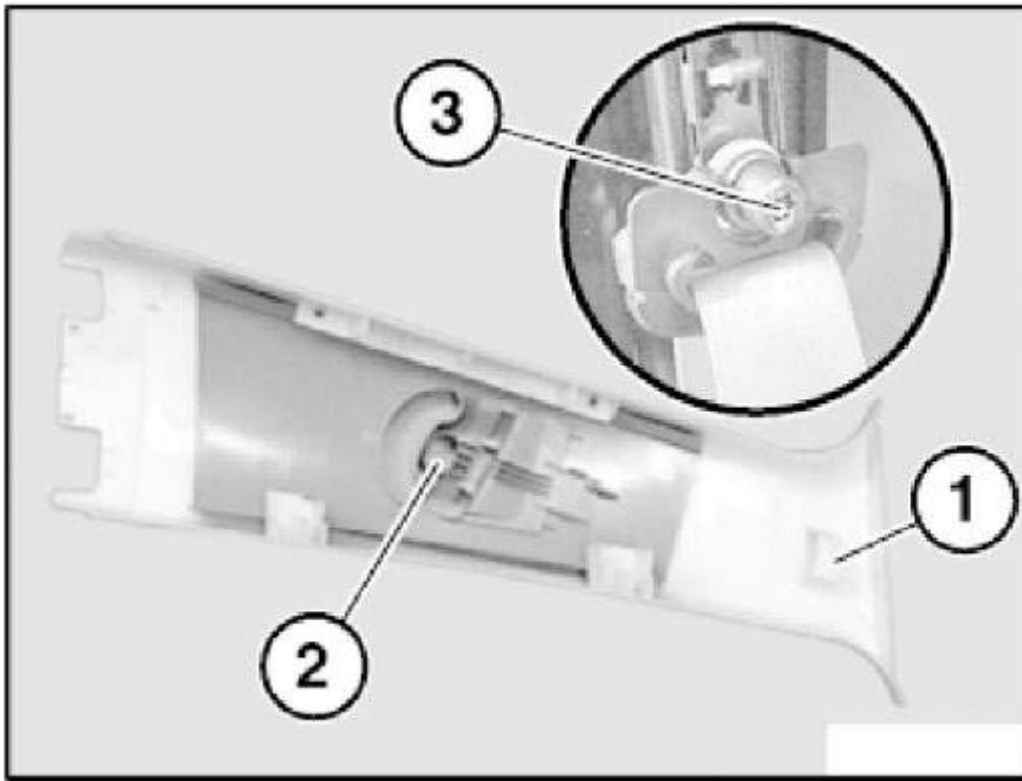
Fig. 390: Unclipping Clip In Upper Panel
Courtesy of BMW OF NORTH AMERICA, INC.

Tilt upper panel upwards as far as possible.

Installation:

If necessary, replace defective clip (1).

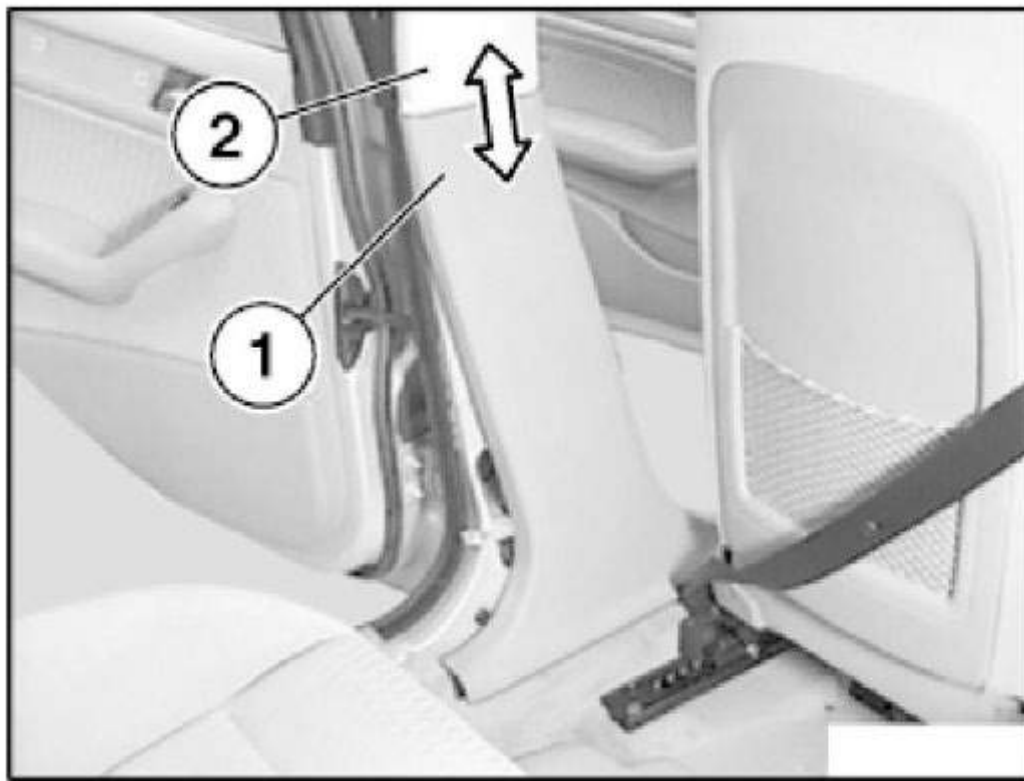
Belt adjustment fixture (2) must enclose head of belt screw (3).



G03255961

Fig. 391: Locating Belt Screw In Belt Adjustment Fixture
Courtesy of BMW OF NORTH AMERICA, INC.

Detach lower panel (1) carefully from upper panel (2).



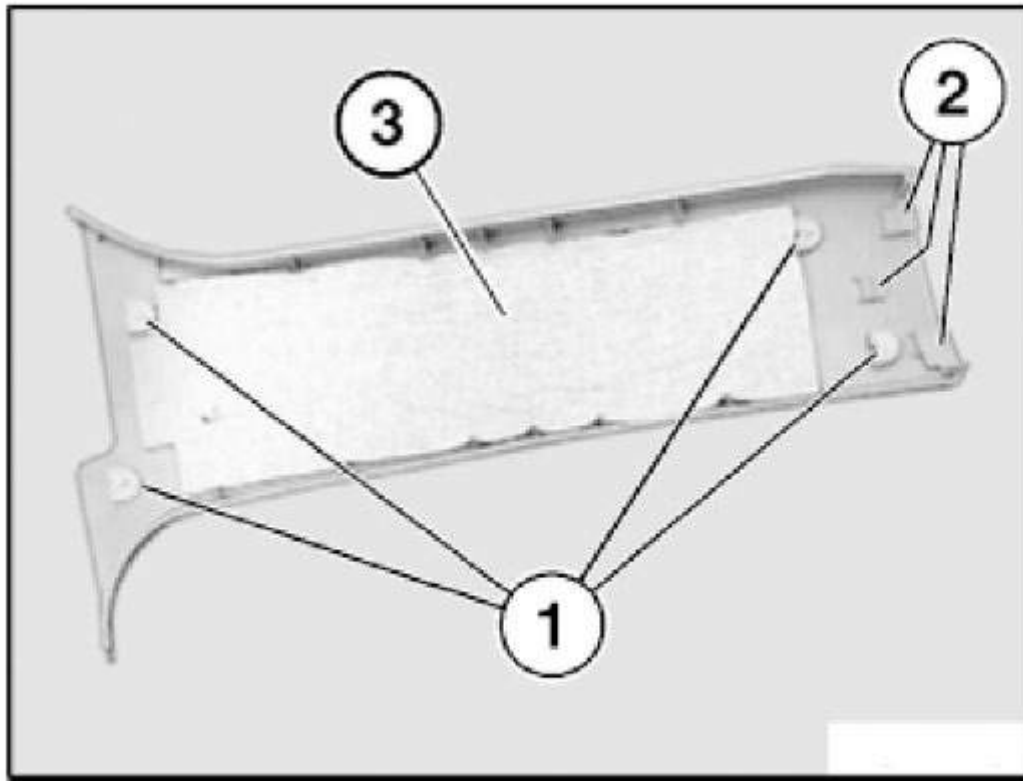
G03255962

Fig. 392: Detaching Lower Panel From Upper Panel
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

If necessary, replace defective clips (1).

Guides (2) on trim (3) must not be damaged.



G03255963

Fig. 393: Identifying Guides On Trim

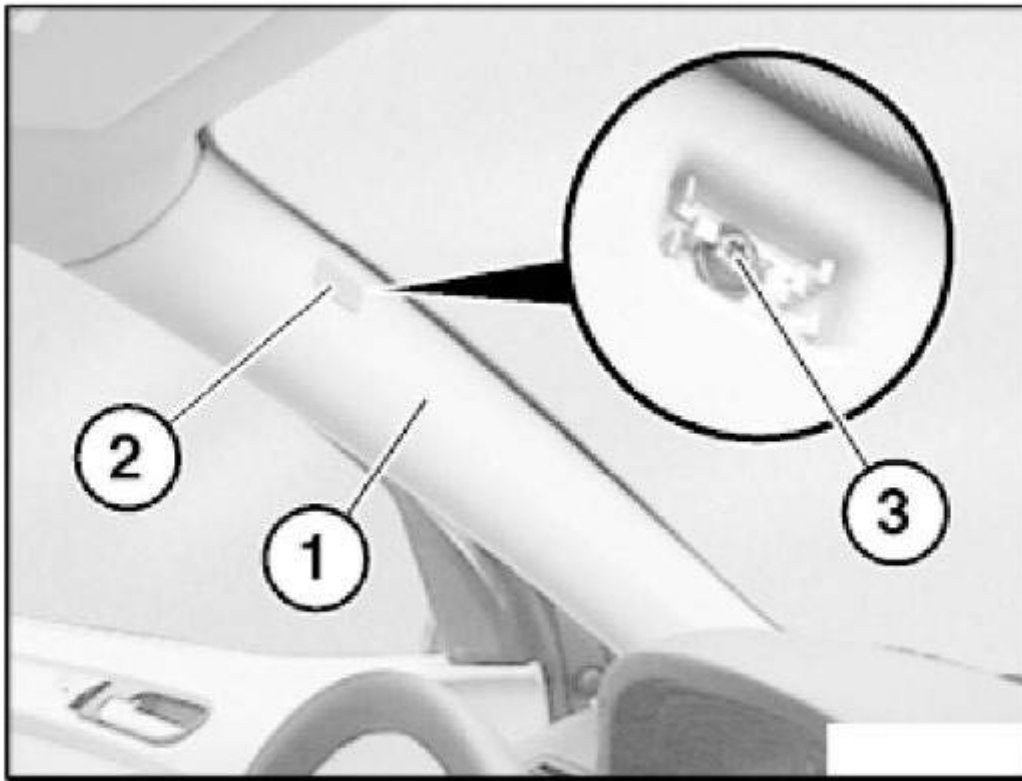
Courtesy of BMW OF NORTH AMERICA, INC.

51 43 201 REMOVING AND INSTALLING/REPLACING PANEL FOR ROOF PILLAR AT FRONT (A-PILLAR), LEFT OR RIGHT

WARNING: Follow safety instructions for working on cars with airbag systems. Refer to AIR BAG SAFETY PRECAUTIONS .

IMPORTANT: Do not use sharp-edged tools to remove trim (risk of damage to head air bag).

Detach mocket on outside in area of panel (1).



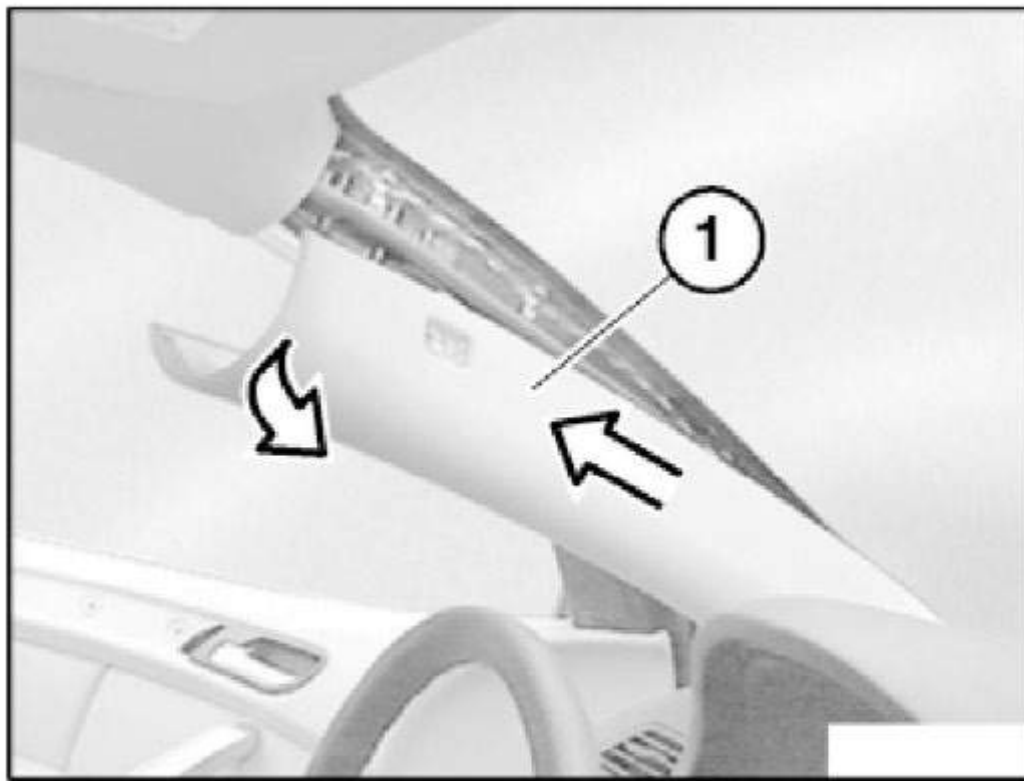
G03255964

Fig. 394: Detaching Mucket
Courtesy of BMW OF NORTH AMERICA, INC.

Remove plate (2).

Unscrew bolt (3).

Unclip panel (1) at top and detach towards top.



G03255965

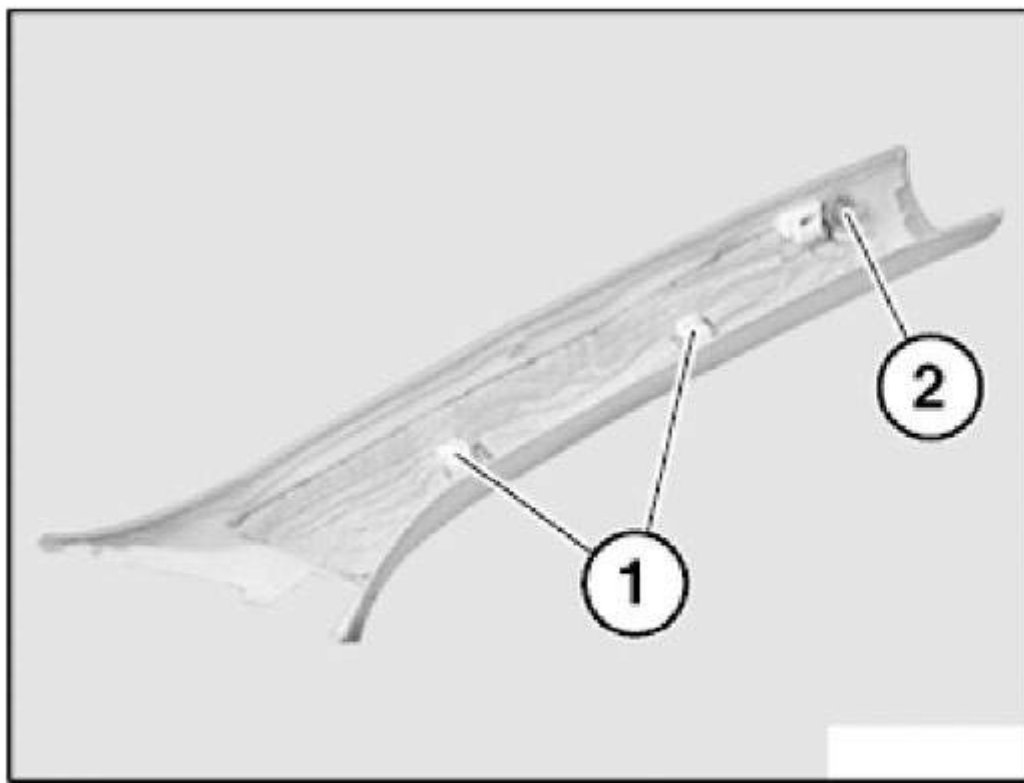
Fig. 395: Detaching Panel At Top

Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

If necessary, replace faulty clips (1).

Align plastic lug (2) to retainer in A-pillar.



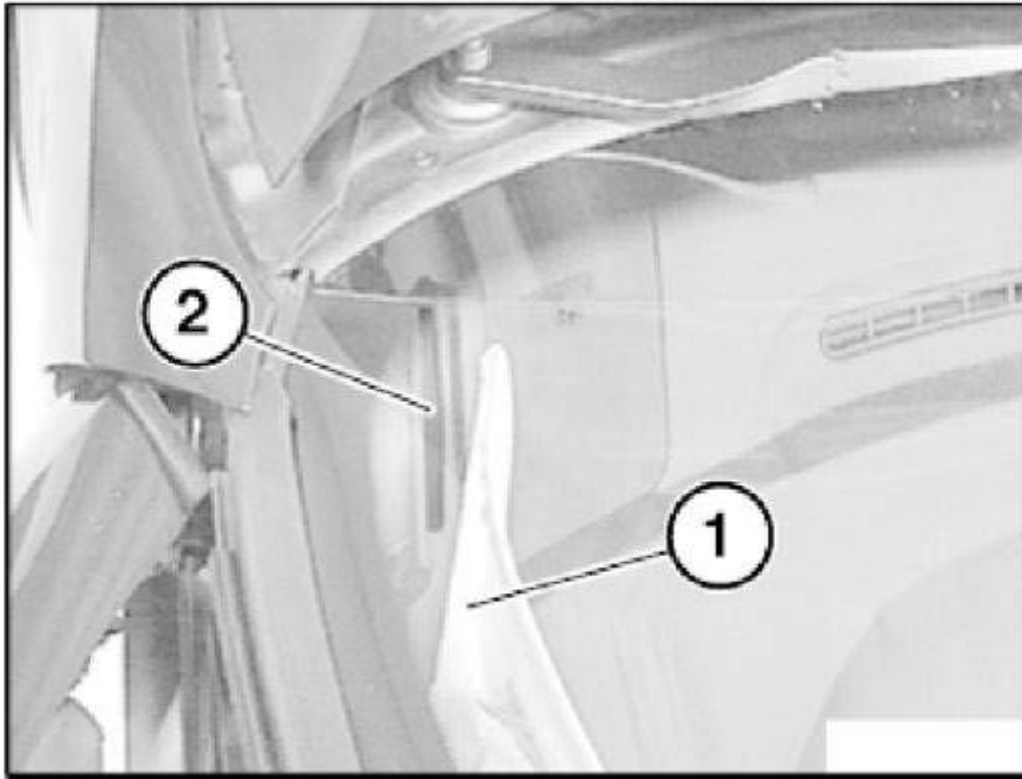
G03255966

Fig. 396: Locating Plastic Lug In Panel
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Viewing direction through windscreen:

Insert panel for roof pillar (1) into groove (2) of trim panel for instrument panel.



G03255967

Fig. 397: Locating Groove Of Trim Panel
Courtesy of BMW OF NORTH AMERICA, INC.

51 43 251 REMOVING AND INSTALLING/REPLACING TRIM PANEL FOR LEFT OR RIGHT REAR ROOF PILLAR (C-PILLAR)

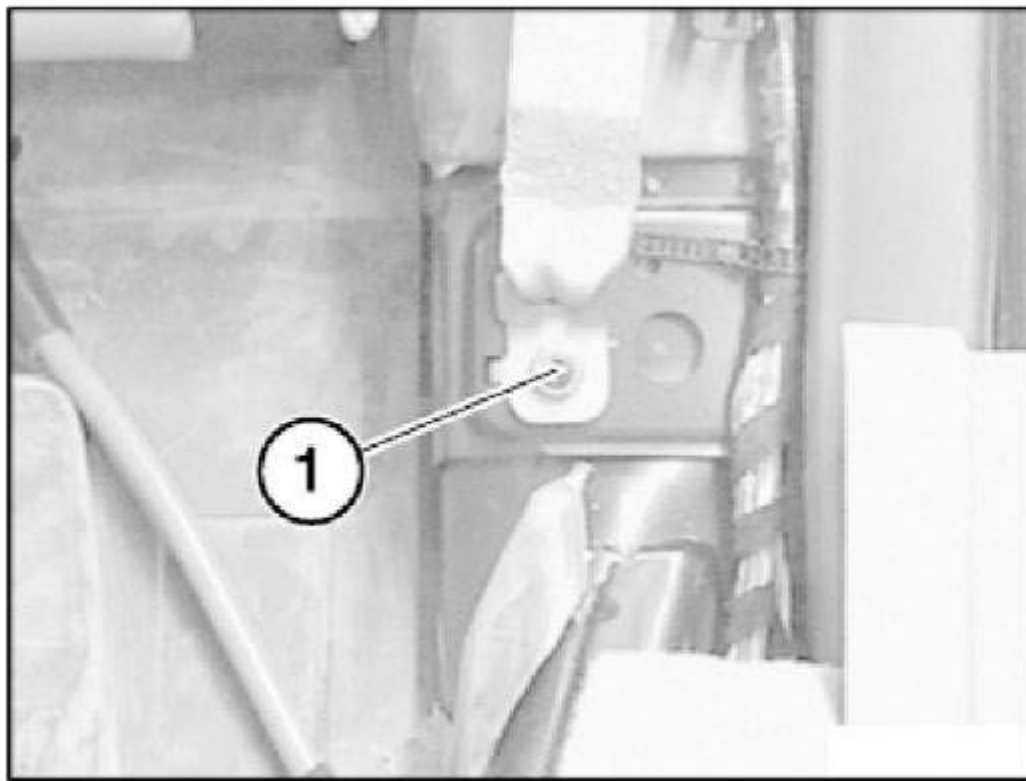
Remove rest side section on rear seat backrest. Refer to **52 26 008 REMOVING AND INSTALLING/REPLACING LEFT OR RIGHT SIDE SECTION OF REAR SEAT BACKREST (THROUGH-LOADING)** .

Remove rear seat.

Release belt nut (1).

Installation:

Tightening torque, (31 N.m.).

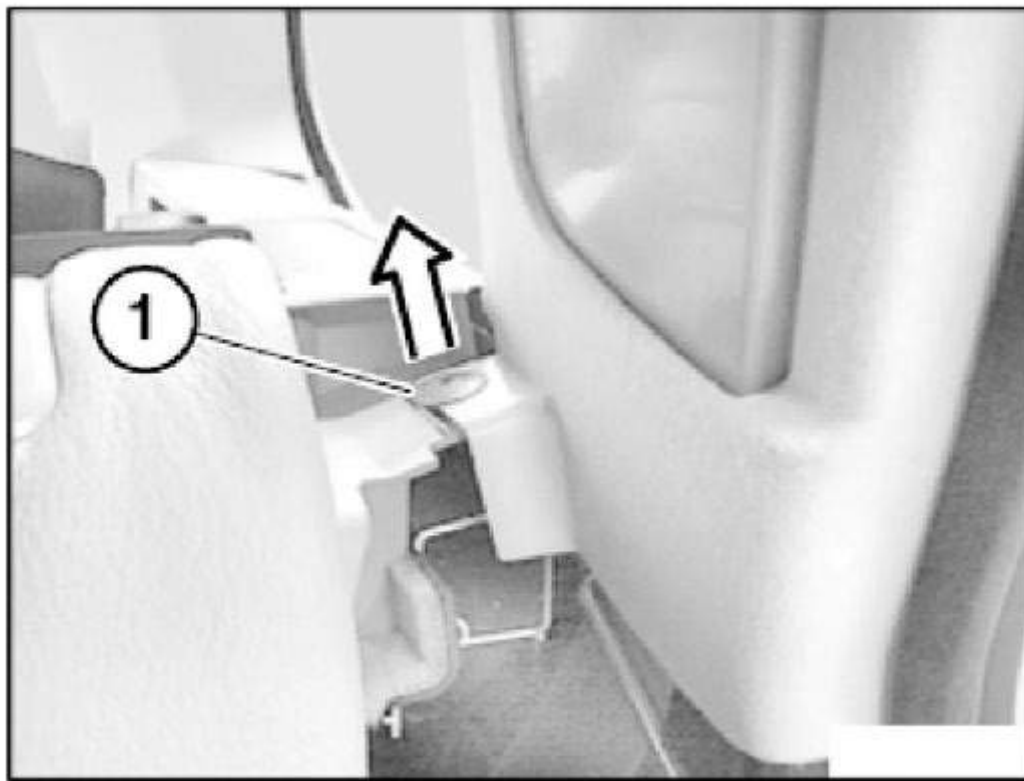


G03255968

Fig. 398: Locating Belt Nut

Courtesy of BMW OF NORTH AMERICA, INC.

Lift out expanding rivet (1).

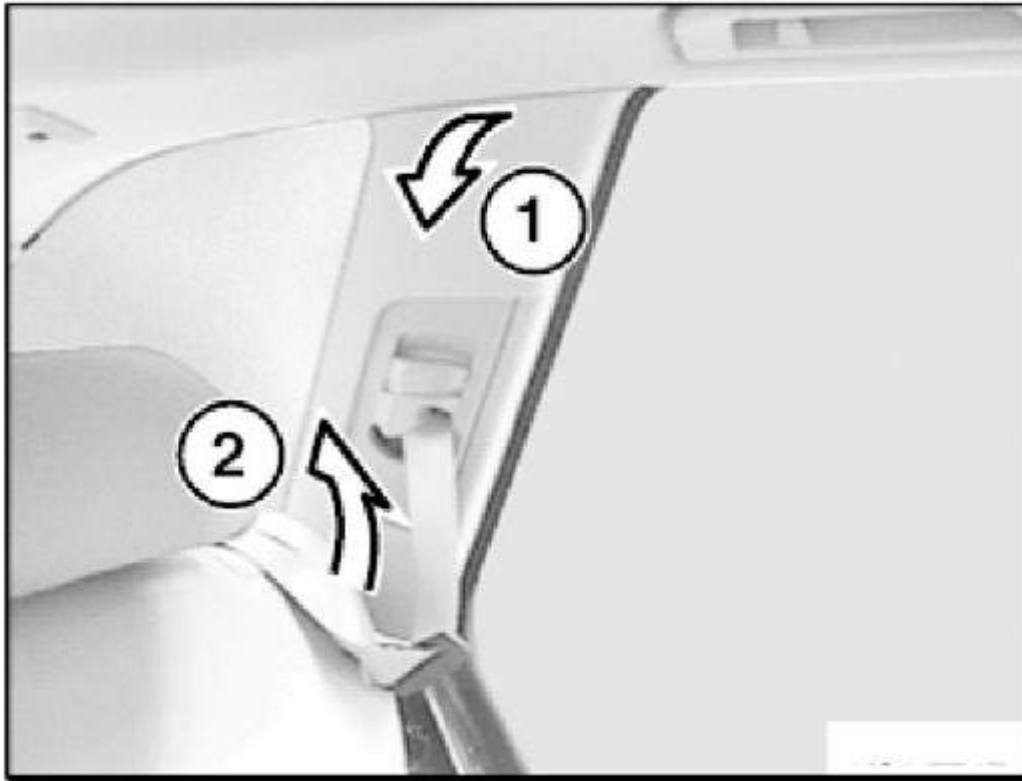


G03255969

Fig. 399: Lifting Out Expanding Rivet
Courtesy of BMW OF NORTH AMERICA, INC.

1. Unclip panel at top.
2. Pull out panel towards top.

Feed out seat belt.



1. Unclip panel at top.
2. Pull out panel towards top.

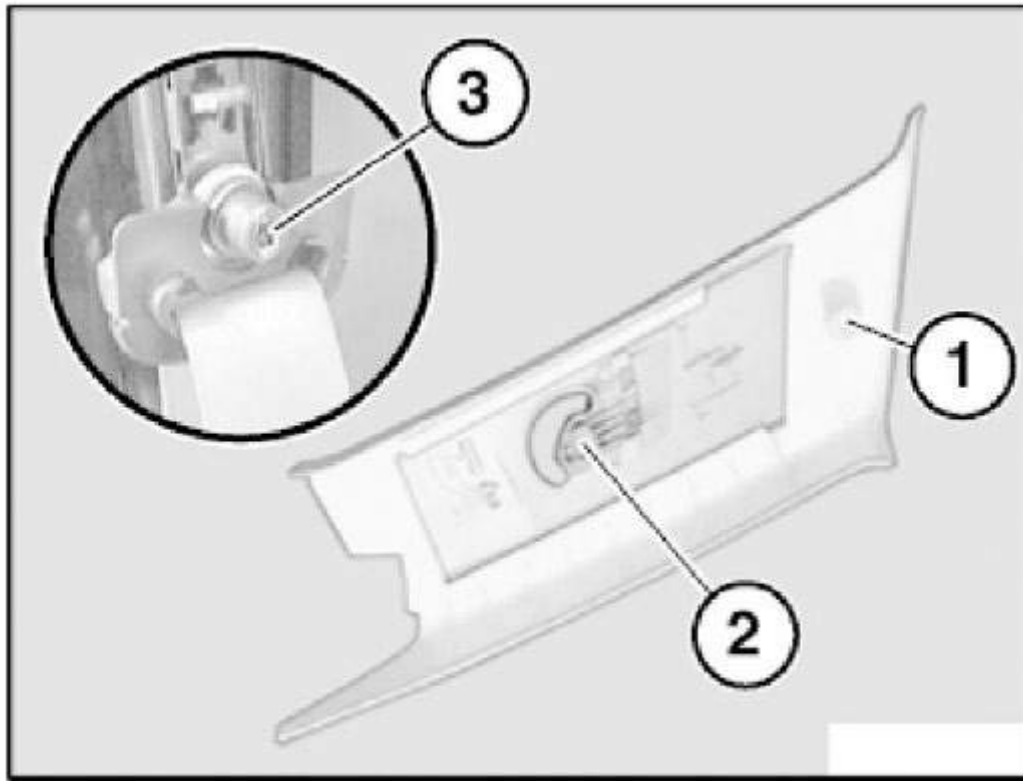
G03255970

Fig. 400: Unclipping Panel At Top And Removing
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

If necessary, replace defective clip (1).

Belt adjustment fixture (2) must enclose head of belt screw (3).



G03255971

Fig. 401: Identifying Bolt Screw In Adjustment Fixture

Courtesy of BMW OF NORTH AMERICA, INC.

51 43 252 REMOVING AND INSTALLING/REPLACING PANEL FOR REAR ROOF PILLAR (D-PILLAR), LEFT OR RIGHT

NOTE: For Special Tool identification, see **SPECIAL TOOLS - X5 (3.0i)** .

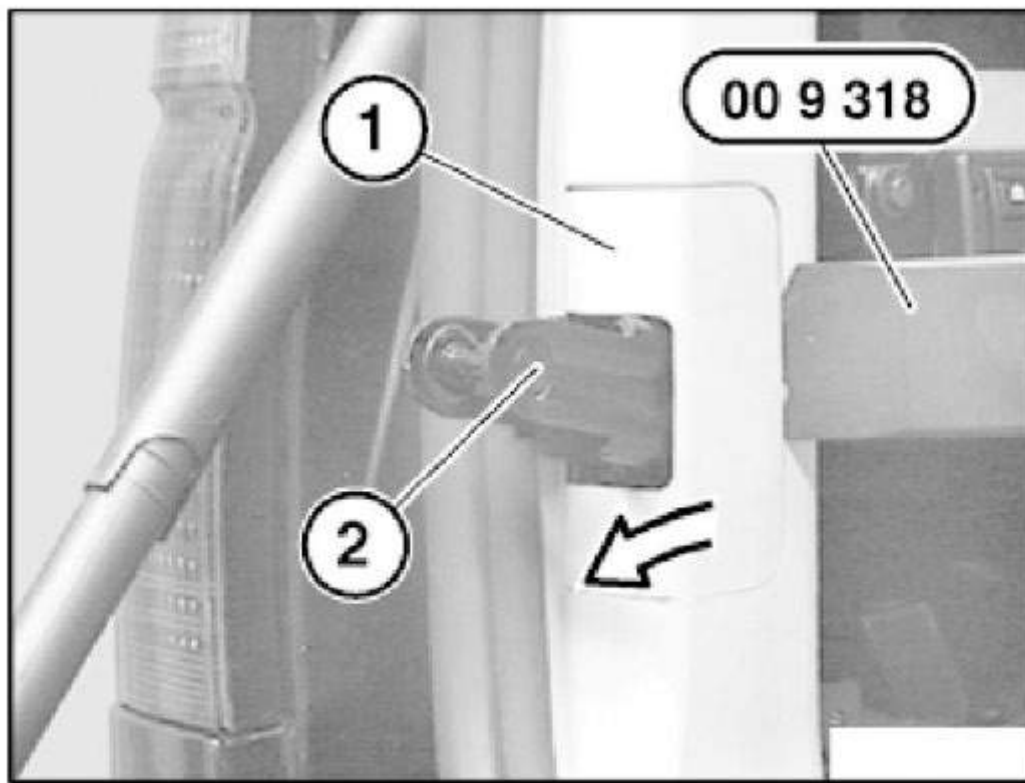
Special Tools Required:

- 00 9 318

Remove trim for tail panel at top. Refer to **51 46 050 REMOVING AND INSTALLING/REPLACING FINISHER FOR TOP OF REAR APRON** .

Lever out cover (1) on rear lid lock (2) with (universal wedge) special tool 00 9 318.

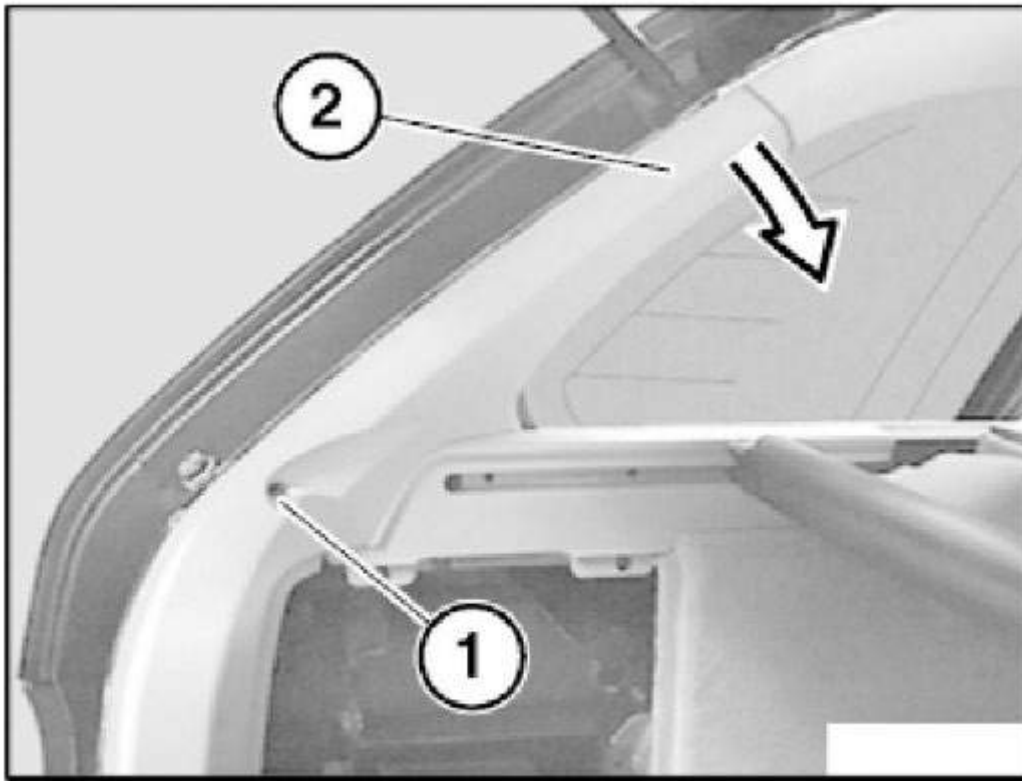
Detach rear lid rubber.



G03255972

Fig. 402: Removing Cover Using Assembly Wedge
Courtesy of BMW OF NORTH AMERICA, INC.

Release screw (1).



G03255973

Fig. 403: Releasing Screw For Rear Roof Pillar Panel
Courtesy of BMW OF NORTH AMERICA, INC.

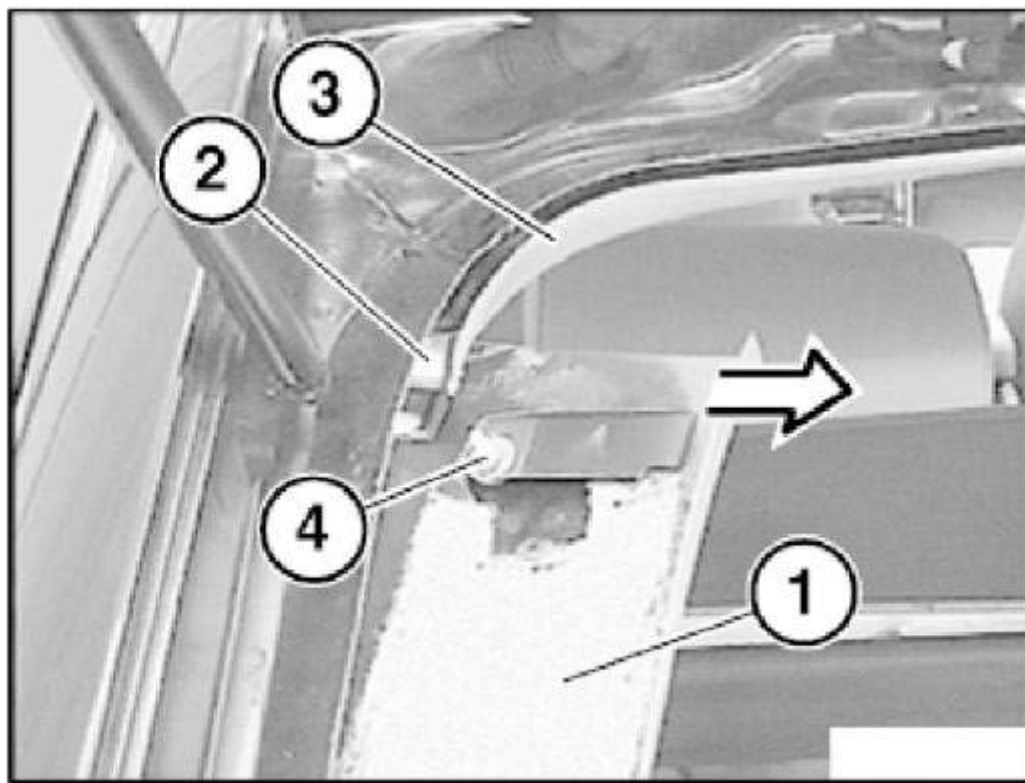
Detach panel (2) at top approx. 30 mm from roof pillar.

Pull panel (1) to one side.

Detach lug (2) from headliner (3).

Installation:

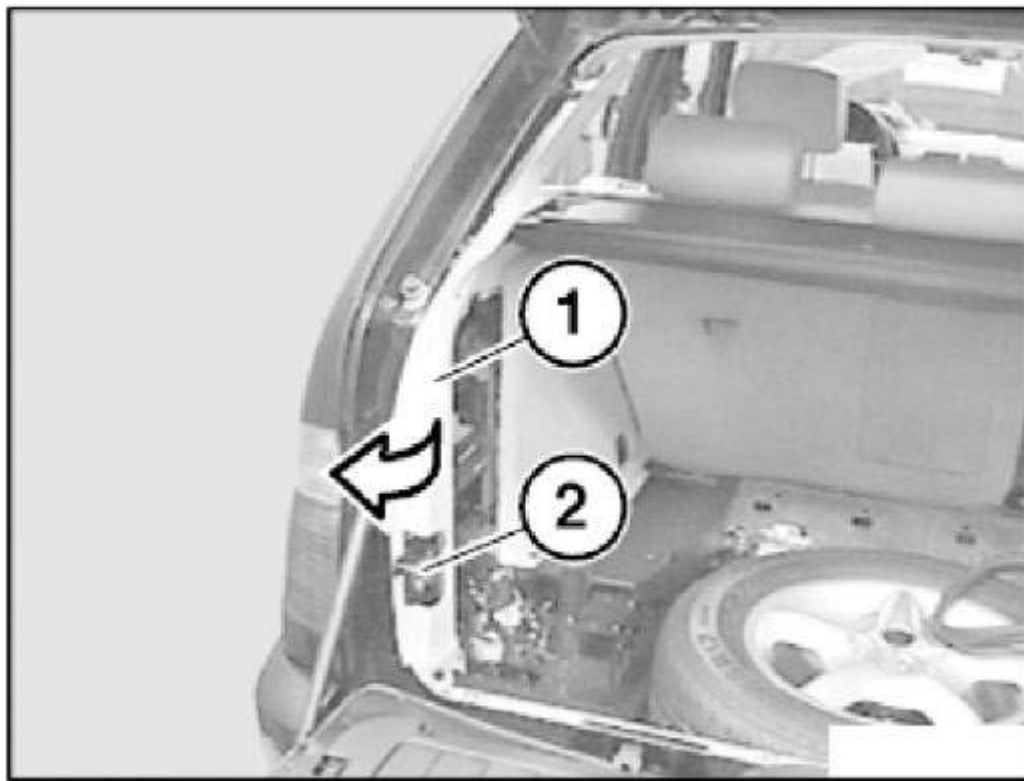
If necessary, replace faulty lug (2) or clip (4).



G03255974

Fig. 404: Aligning Panel To One Side
Courtesy of BMW OF NORTH AMERICA, INC.

Lift panel (1) over rear lid lock (2) and remove.

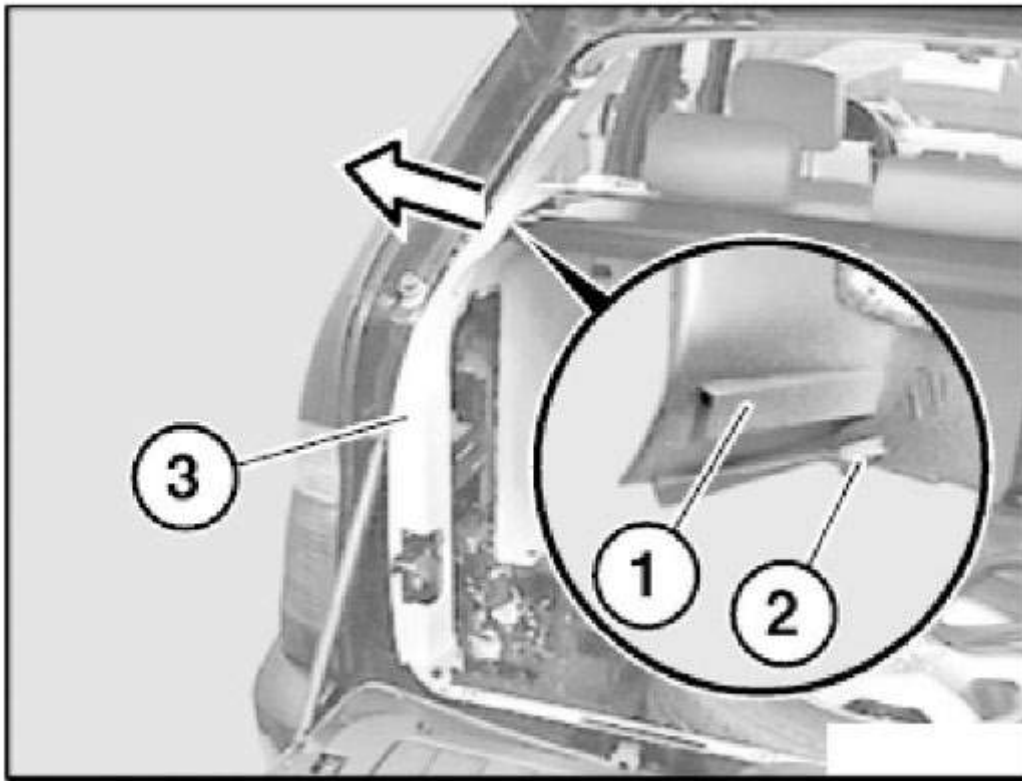


G03255975

Fig. 405: Lifting Panel Over Rear Lid Lock
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Make sure guide (1) and journal (2) are correctly seated on panel (3).



G03255976

Fig. 406: Checking Seating Of Guide And Journal
Courtesy of BMW OF NORTH AMERICA, INC.

ROOF TRIM PANEL

51 44 001 REMOVING AND INSTALLING/REPLACING HEADLINER (WITHOUT SLIDE/TILT SUNROOF)

Except for the steps relating to the slide/tilt sunroof, the work is identical to:

Removing and installing/replacing headliner (with slide/tilt sunroof). Refer to **51 44 011 REMOVING AND INSTALLING/REPLACING HEADLINER (WITH SLIDE/TILT SUNROOF)** .

51 44 011 REMOVING AND INSTALLING/REPLACING HEADLINER (WITH SLIDE/TILT SUNROOF)

Remove both sun visors and counter support. Refer to **51 16 080 REMOVING AND INSTALLING OR REPLACING SUN VISOR AND LEFT OR RIGHT COUNTER SUPPORT** .

Remove all grab handles. Refer to **51 16 480 REMOVING AND INSTALLING OR REPLACING FRONT GRAB HANDLE** .

Remove both panels for front roof pillar (A-pillar finishers). Refer to **51 43 201 REMOVING AND INSTALLING/REPLACING PANEL FOR ROOF PILLAR AT FRONT (A-PILLAR), LEFT OR RIGHT** .

Remove both panels for door pillar (top) (B-pillar finishers). Refer to **51 43 148 REMOVING AND INSTALLING OR REPLACING TRIM ON LEFT OR RIGHT DOOR PILLAR (TOP)** .

Remove both panels for rear roof pillar (C-pillar finishers). Refer to **51 43 251 REMOVING AND INSTALLING/REPLACING TRIM PANEL FOR LEFT OR RIGHT REAR ROOF PILLAR (C-PILLAR)** .

Remove both panels for rear roof pillar (D-pillar finishers). Refer to **51 43 252 REMOVING AND INSTALLING/REPLACING PANEL FOR REAR ROOF PILLAR (D-PILLAR), LEFT OR RIGHT** .

Remove bracket on headliner at front. Refer to **51 44 020 REMOVING AND INSTALLING/REPLACING BRACKET ON ROOF LINING AT FRONT** .

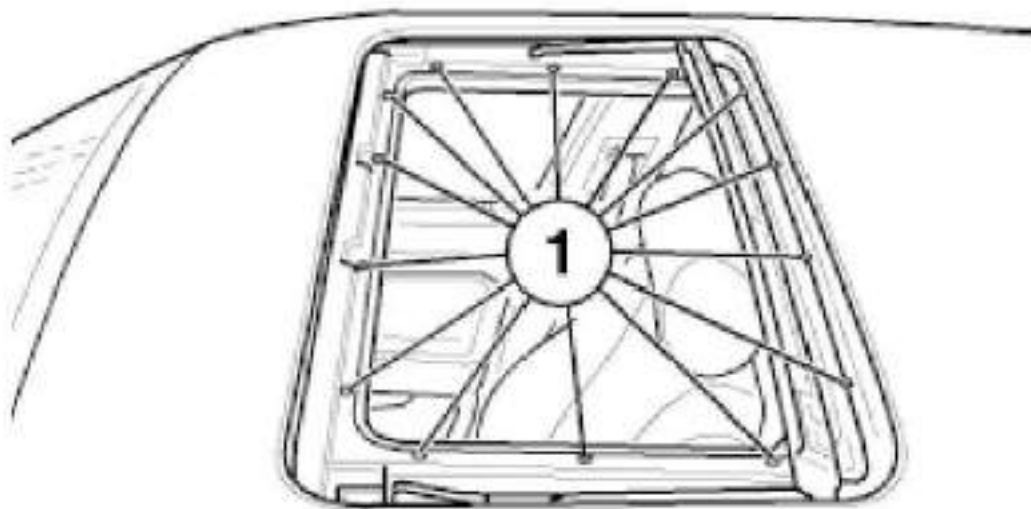
Remove front and rear head restraints. Refer to **52 13 390 REMOVING AND INSTALLING/REPLACING FRONT HEADREST (NORMAL/MANUAL)** .

Remove sunroof lid. Refer to **54 12 115 REMOVING AND INSTALLING GLASS SLIDING/TILTING SUNROOF LID** .

Remove front and rear ceiling light. Refer to **63 31 000 REMOVING AND INSTALLING/REPLACING COMPLETE CEILING LIGHT** .

Remove ultrasonic module. Refer to **65 75 565 REMOVING AND INSTALLING/REPLACING ULTRASOUND MODULE** .

Release screws (1).



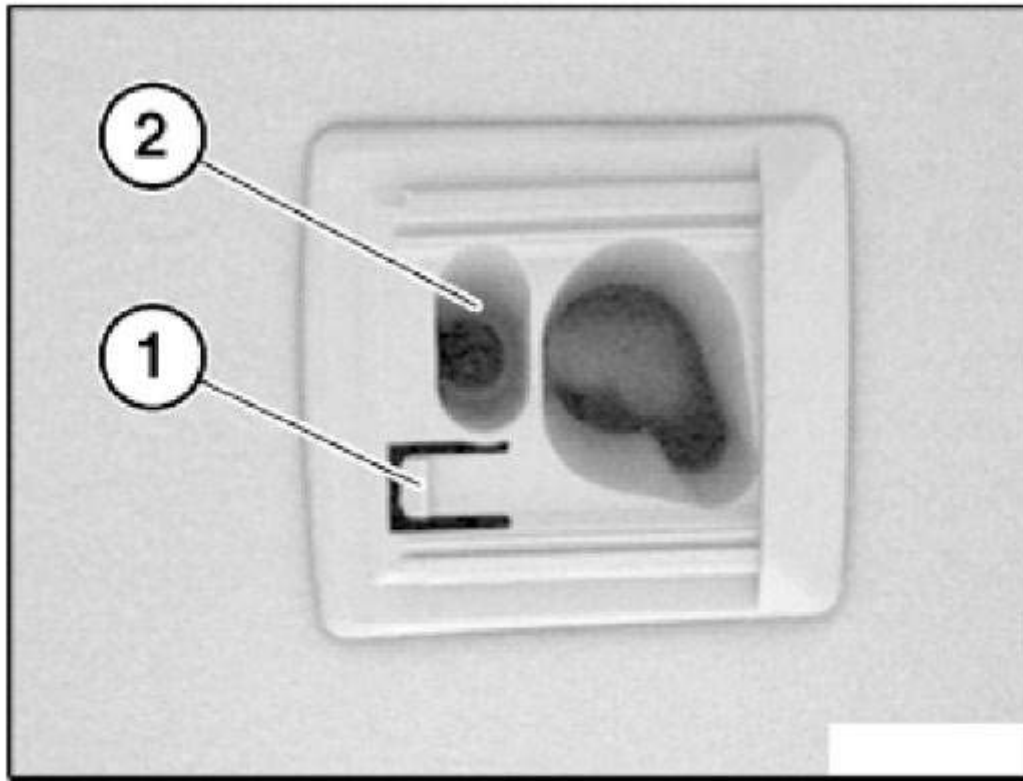
G03255977

Fig. 407: Identifying Screw Locations
Courtesy of BMW OF NORTH AMERICA, INC.

If necessary, remove all dividing net mounts:

Detach trims of covers for dividing net mount over lock (1) completely.

Release screw (2) and remove dividing net mounts.



G03255978

Fig. 408: Identifying Cover Trim For Dividing Net Mounts
Courtesy of BMW OF NORTH AMERICA, INC.

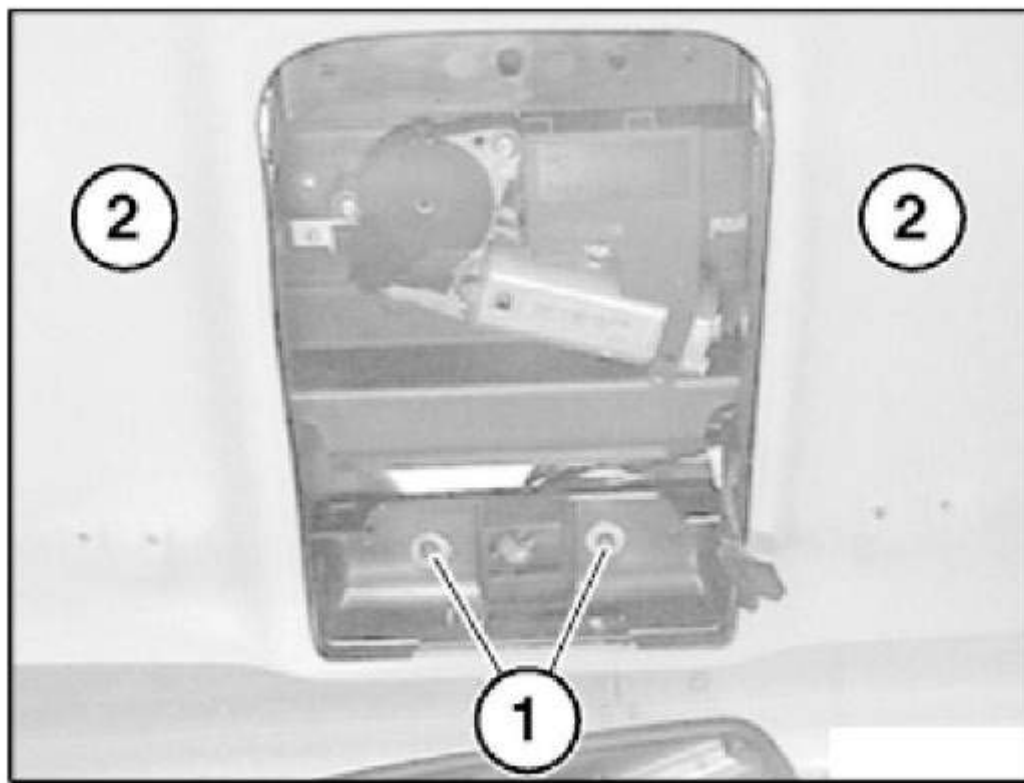
Installation:

Observe position specifications on reverse side of covers (RR, FR, RL, FL).

- Move both front seat backrests as far back as possible.
- Removing roller cover from luggage compartment, refer to Owner's Handbook.
- Fold both rear-seat backrests forward.
- Pull off mucket of front and rear doors.

CAUTION: The following tasks must be carried out with a second person assisting:
Support headliner at front.

Release screws (1) under bracket on headliner (2).

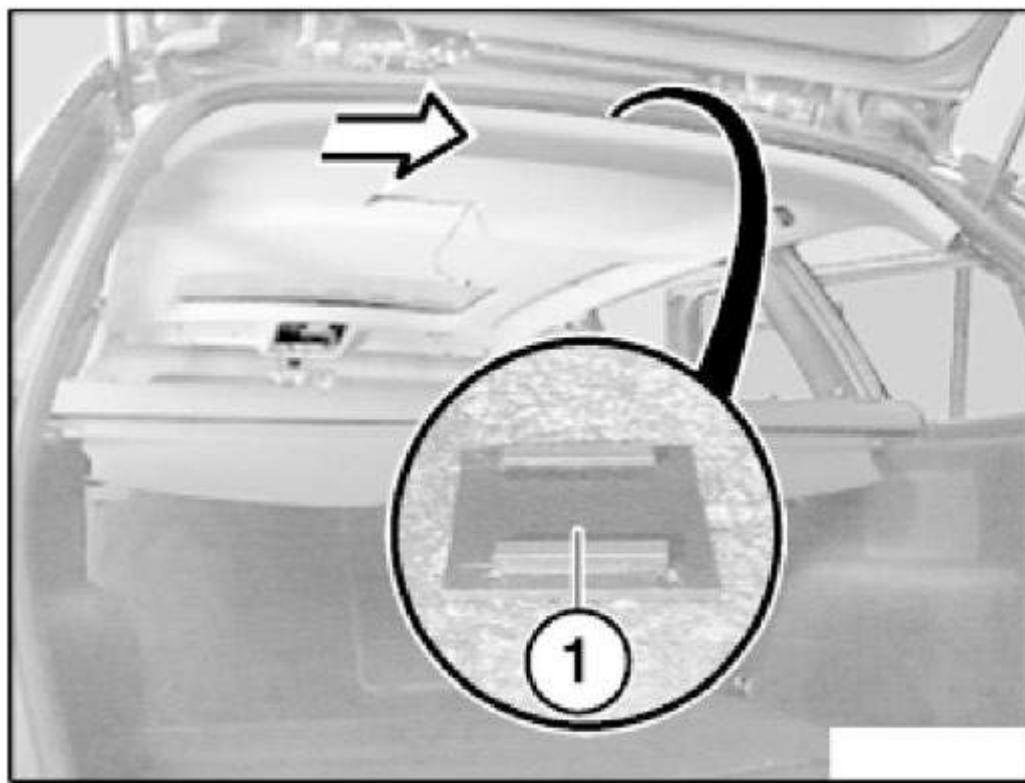


G03255979

Fig. 409: Releasing Screws Under Bracket On Headliner
Courtesy of BMW OF NORTH AMERICA, INC.

Press headliner at rear to one side and in so doing slide three guides (1) out of sliding clips in body.

Turn headliner and remove towards rear.



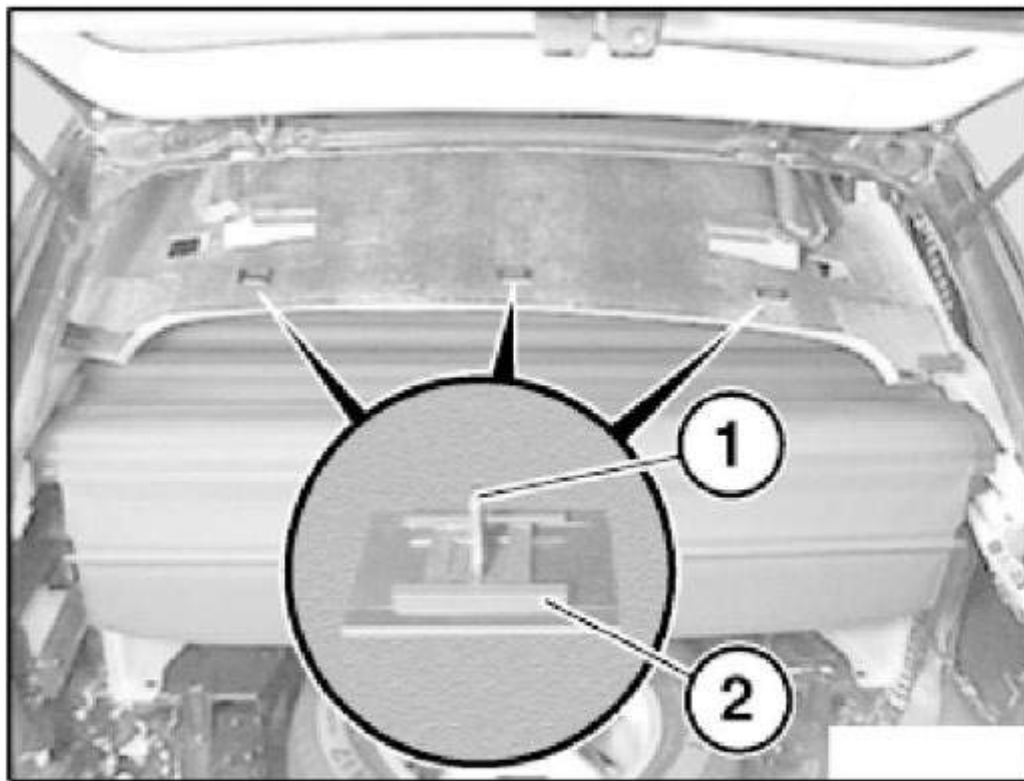
G03255980

Fig. 410: Aligning Headliner To One Side And Sliding Guides Out Of Clips
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Pull sliding clips (1) out of retainers in body roof lining and slide into guides (2) of headliner.

If necessary, replace metal retainers in body roof lining.



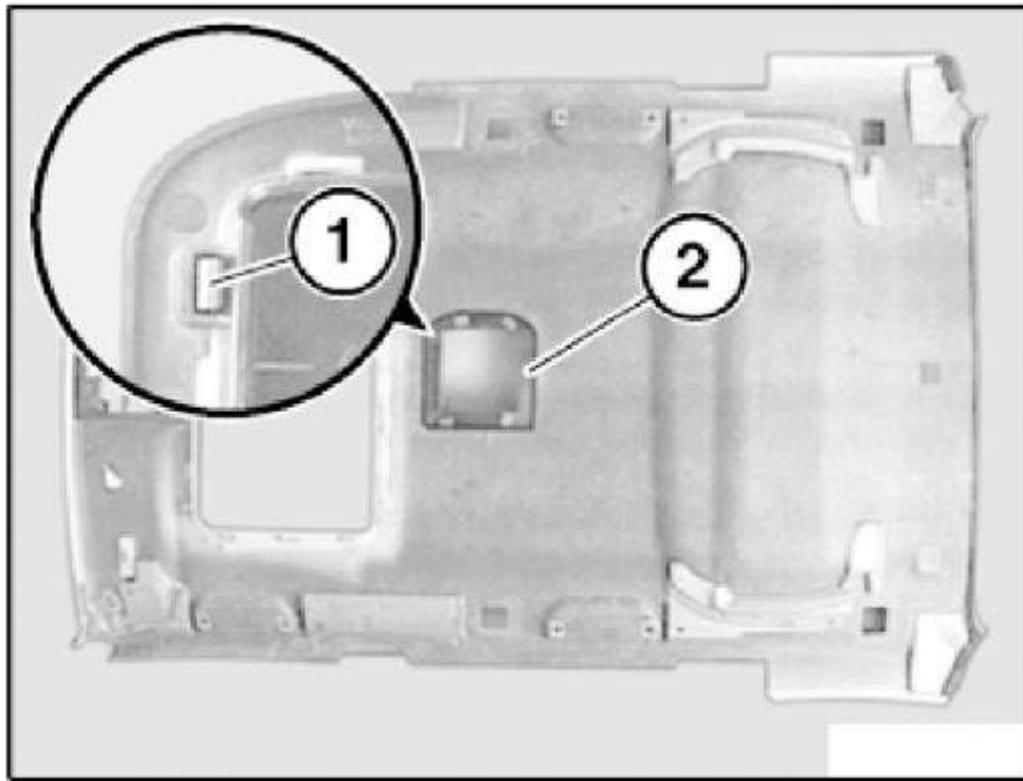
G03255981

Fig. 411: Removing Sliding Clips Out Of Retainers In Body Roof Lining
Courtesy of BMW OF NORTH AMERICA, INC.

Replacement Only:

Open locks (1) on frame (2) for ultrasonic module all round.

Remove frame halves.



G03255982

Fig. 412: Opening Locks On Frame For Ultrasonic Module
Courtesy of BMW OF NORTH AMERICA, INC.

51 44 013 REMOVING AND INSTALLING ROOF LINER (ON VERSION WITH PANORAMA SUNROOF)

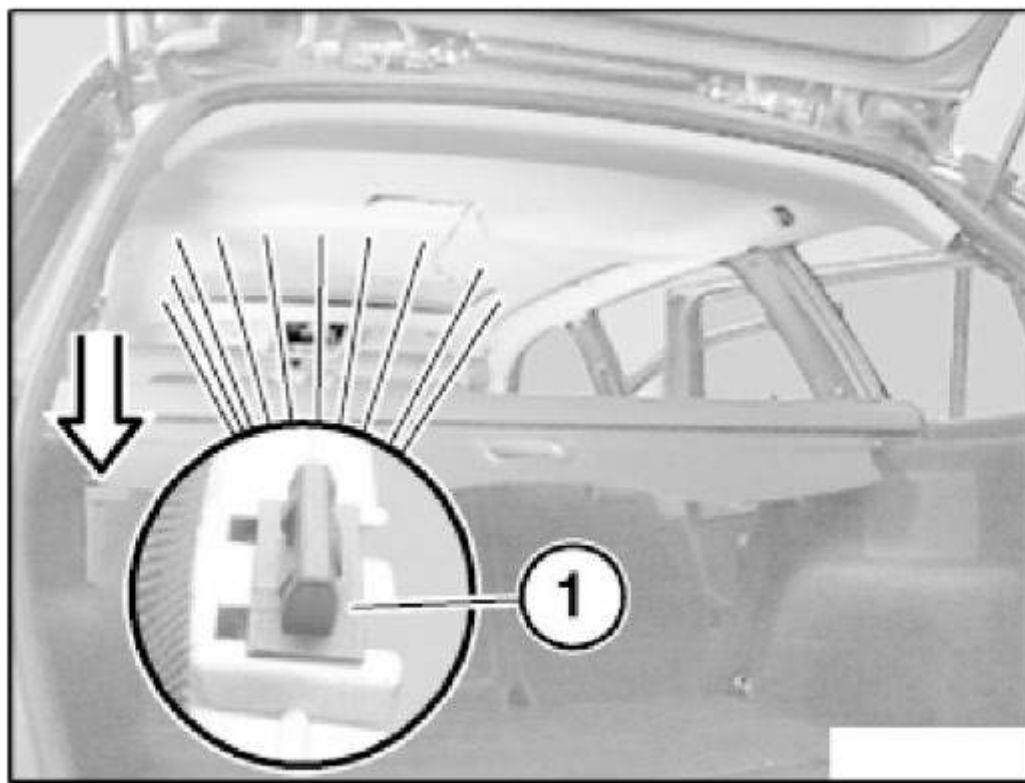
Operation is identical up to work steps for panorama sunroof to:

Removing and installing/replacing roofliner (with slide/tilt sunroof). Refer to **51 44 011 REMOVING AND INSTALLING/REPLACING HEADLINER (WITH SLIDE/TILT SUNROOF)** .

IMPORTANT: The following tasks must be carried out with a second person assisting: Unclip clips (1) in sunroof frame area towards bottom.

Extend rear roofliner towards bottom out of guide.

Turn headliner and remove towards rear.



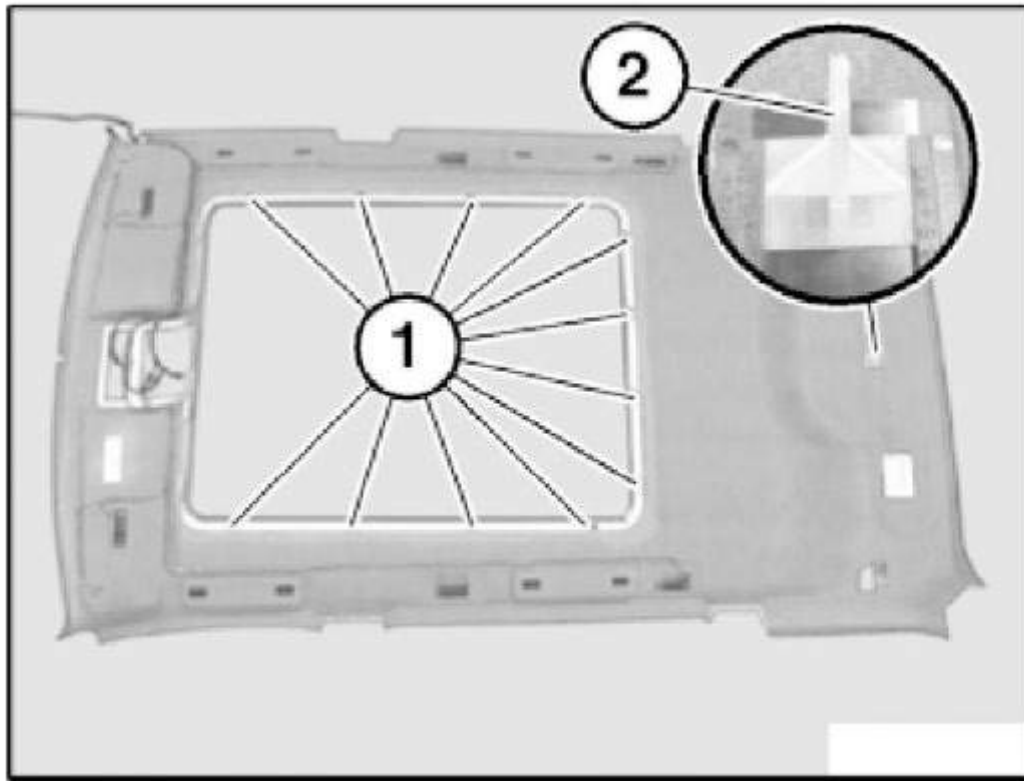
G03255983

Fig. 413: Locating Clips In Sunroof Frame
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Clips (1) and guide (2) must not be damaged.

If necessary, replace clips (1) and guide (2).



G03255984

Fig. 414: Identifying Clips And Guide
Courtesy of BMW OF NORTH AMERICA, INC.

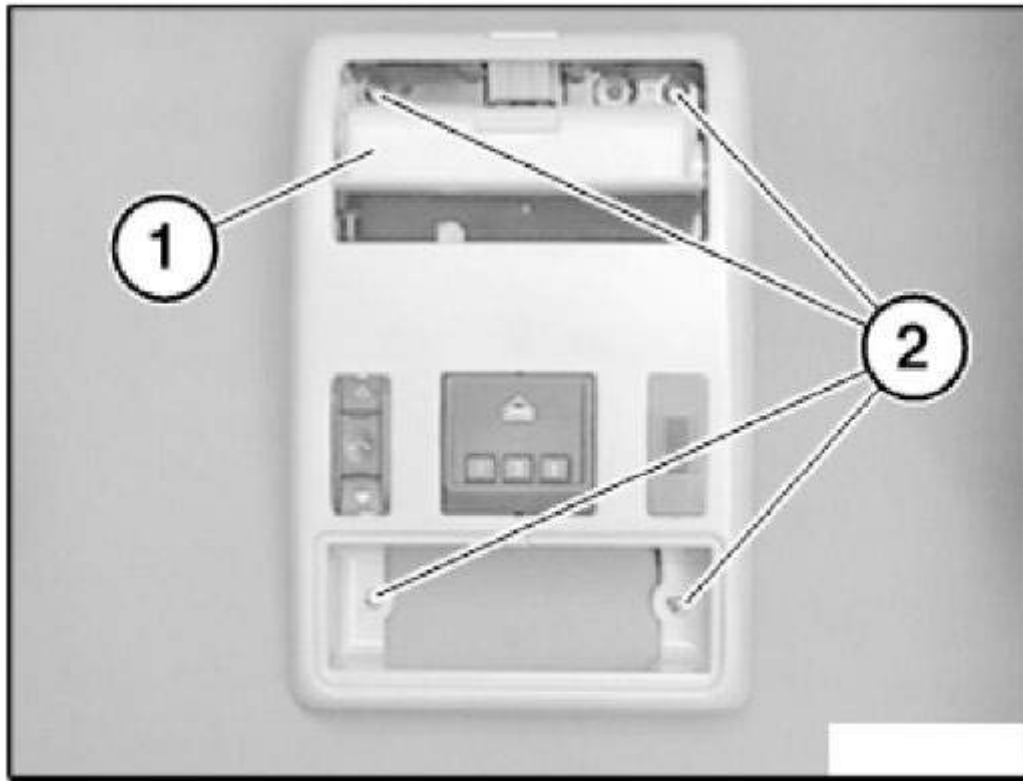
51 44 020 REMOVING AND INSTALLING/REPLACING BRACKET ON ROOF LINING AT FRONT

Remove lighting. Refer to **63 31 000 REMOVING AND INSTALLING/REPLACING COMPLETE CEILING LIGHT** .

Open glasses compartment (1).

Unfasten screws (2).

Lower bracket, disconnect plug connections and remove bracket.



G03255985

Fig. 415: Identifying Glasses Compartment
Courtesy of BMW OF NORTH AMERICA, INC.

REPLACEMENT ONLY:

Remove switch for slide/tilt sunroof. Refer to **61 31 175 REMOVING AND INSTALLING/REPLACING SWITCH FOR SLIDE/TILT SUNROOF** .

Remove remote control for garage door opening. Refer to **61 31 405 REMOVING AND INSTALLING/REPLACING REMOTE CONTROL FOR GARAGE DOOR OPENING** .

Remove hands-free microphone. Refer to **84 11 550 REMOVING AND INSTALLING/REPLACING HANDS-FREE MICROPHONE** .

INSTRUMENT CLUSTER TRIM PANEL

51 45 030 REMOVING AND INSTALLING INSTRUMENT PANEL TRIM

2001 BMW X5 30i

2001-2003 ACCESSORIES AND EQUIPMENT Exterior/Interior Trim - Repair Instructions - X5 (3.0i) E53

Disconnect battery negative lead. Refer to **12 00 ... INSTRUCTIONS FOR DISCONNECTING AND CONNECTING BATTERY** .

Remove both panels for front roof pillar. Refer to **51 43 201 REMOVING AND INSTALLING/REPLACING PANEL FOR ROOF PILLAR AT FRONT (A-PILLAR), LEFT OR RIGHT** .

Remove light switch unit. Refer to **61 31 033 REMOVING AND INSTALLING LIGHT SWITCH UNIT** .

Remove complete instrument carrier. Refer to **62 21 000 REMOVING AND INSTALLING COMPLETE INSTRUMENT CARRIER** .

Remove fixture for steering column switch. Refer to **61 31 005 REMOVING AND INSTALLING/REPLACING FIXTURE FOR STEERING COLUMN STALK** .

Remove center fresh air grill. Refer to **64 22 161 REMOVING AND INSTALLING/REPLACING FRESH-AIR GRILL CENTER** .

Remove radio receiver. Refer to **65 11 030 REMOVING AND INSTALLING / REPLACING RADIO RECEIVER** or **65 52 010 REMOVING AND INSTALLING ON-BOARD MONITOR** .

Remove airbag module on passenger side. Refer to **PASSENGER-SIDE AIR BAG MODULE** for year model 2001, **PASSENGER-SIDE AIR BAG MODULE** for year model 2002, and **PASSENGER-SIDE AIR BAG MODULE** for year model 2003.

Remove center console. Refer to **51 16 200 REMOVING AND INSTALLING CENTER CONSOLE** .

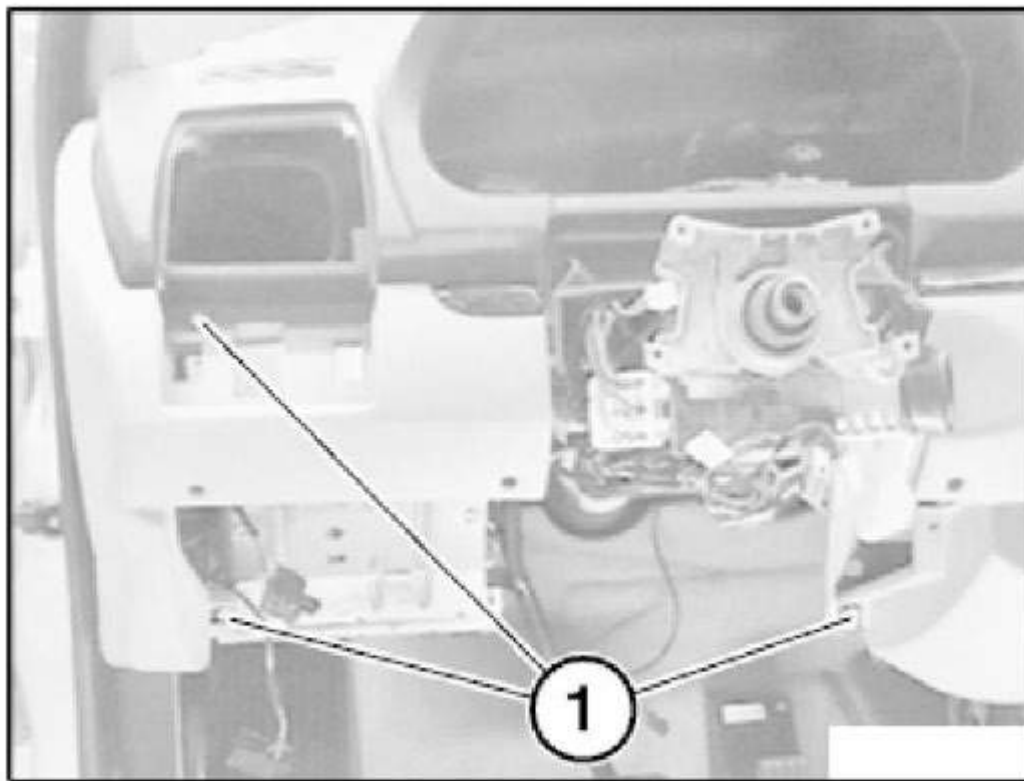
Remove lower left trim from instrument panel. Refer to **51 45 180 REMOVING AND INSTALLING TRIM FOR INSTRUMENT PANEL, BOTTOM LEFT**

Remove right glovebox. Refer to **51 16 360 REMOVING AND INSTALLING RIGHT GLOVE BOX** .

Remove all clipped finishers (decorative strips on panel for instrument panel). Refer to **51 16 221 REPLACING A CLIPPED FINISHER (DECORATIVE STRIP ON PANEL FOR INSTRUMENT PANEL, FRONT OR REAR DOOR)** .

Release screws (1).

Disconnect plug connection for speaker.

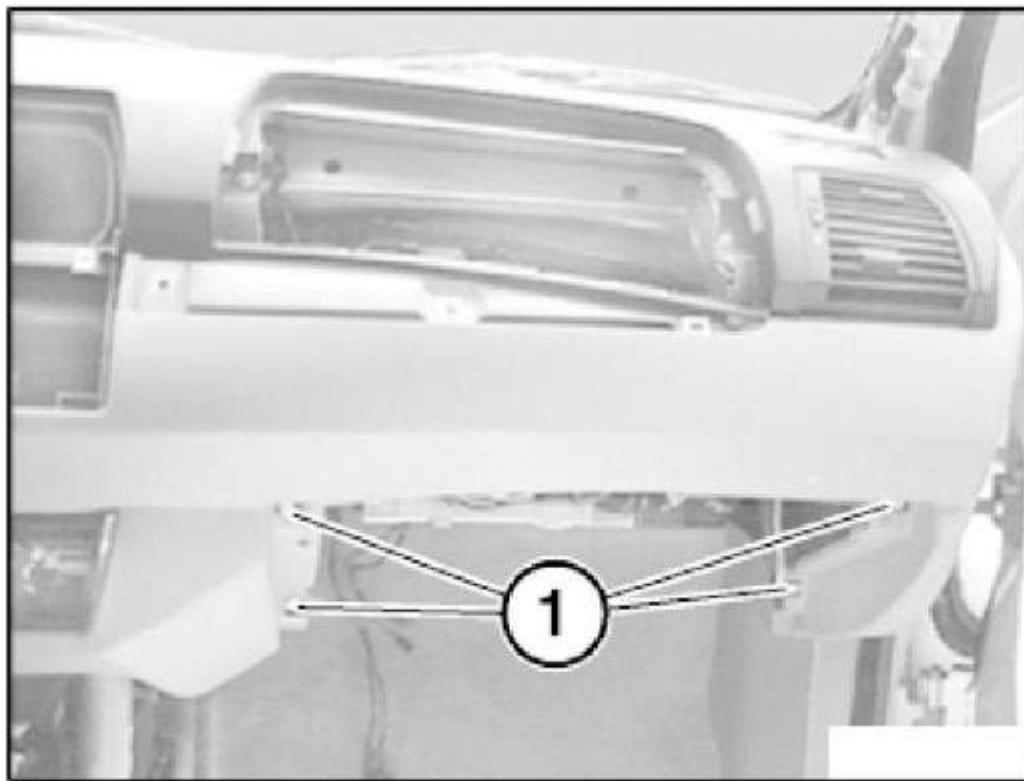


G03255986

Fig. 416: Disconnecting Plug Connection For Speaker
Courtesy of BMW OF NORTH AMERICA, INC.

Release screws (1).

Disconnect plug connection for speaker.



G03255987

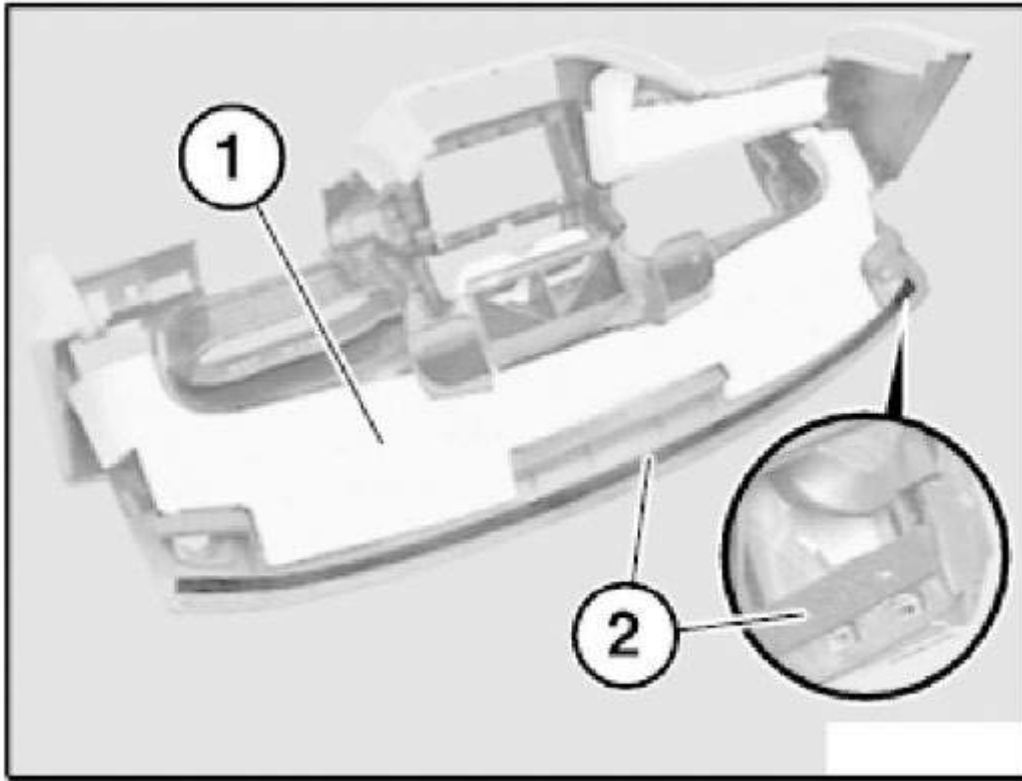
Fig. 417: Releasing Speaker Screws

Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Anti-drumming lining (1) must be correctly stuck on.

Foam strip (2) must be correctly stuck on.



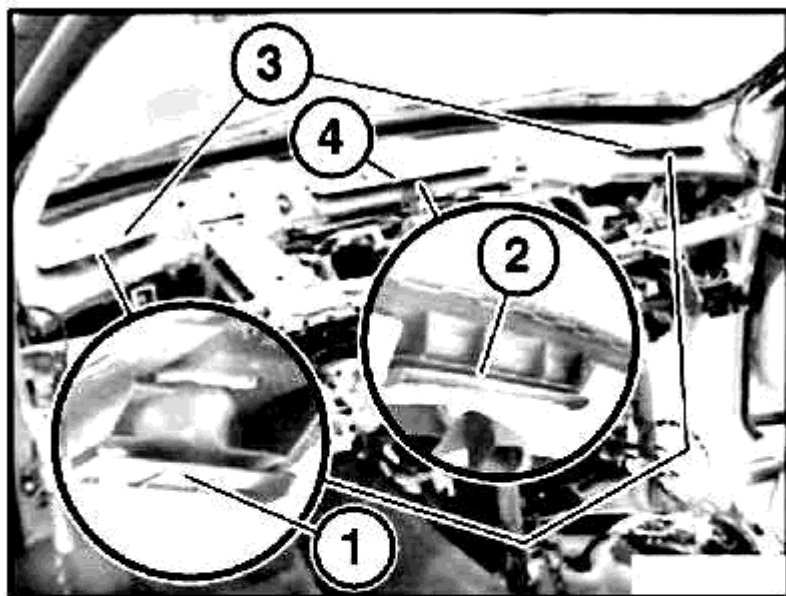
G03255988

Fig. 418: Identifying Anti-Drumming Lining And Foam Strip
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Push fixtures (1) and (2) onto guide plates (3) and (4).

1. Fixture on instrument panel, outside.
2. Fixture on instrument panel, center.
3. Guide plate on body, outside.
4. Guide plate on body, center.



1. Fixture on instrument panel, outside
2. Fixture on instrument panel, center
3. Guide plate on body, outside
4. Guide plate on body, center

G03255989

Fig. 419: Locating Fixtures And Guide Plates
Courtesy of BMW OF NORTH AMERICA, INC.

51 45 031 REPLACING INSTRUMENT PANEL TRIM

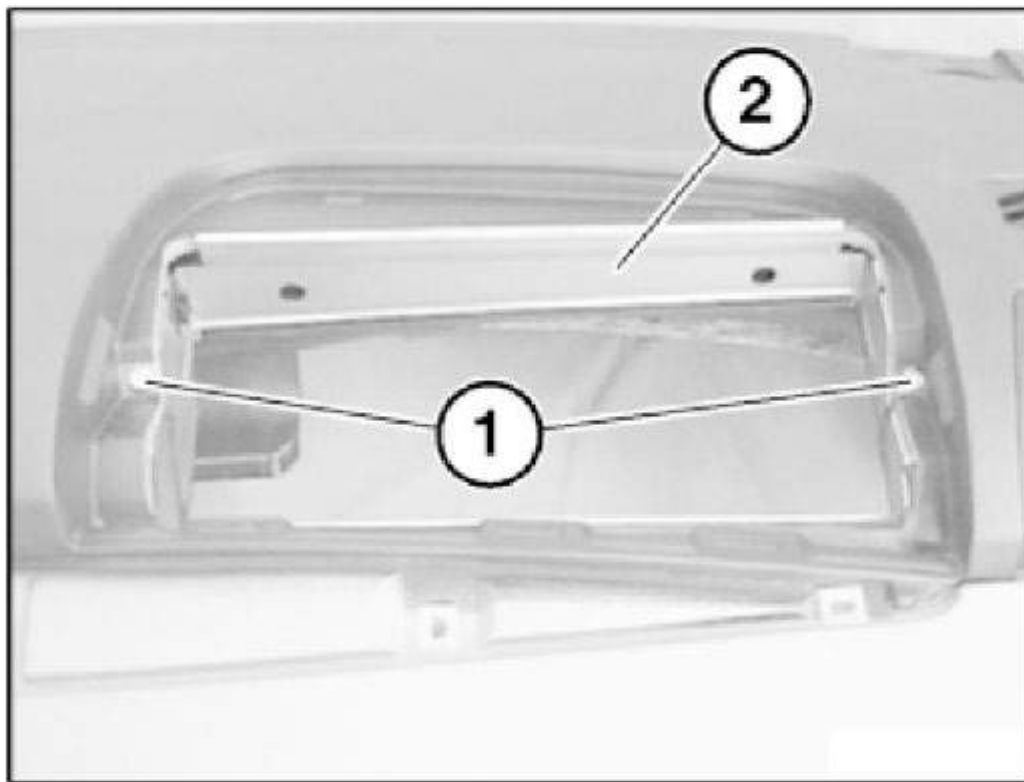
Remove trim for instrument panel. Refer to **51 45 030 REMOVING AND INSTALLING INSTRUMENT PANEL TRIM** .

Remove speakers (in instrument panel) on left and right. Refer to **65 13 050 REMOVING AND INSTALLING/REPLACING SPEAKER (IN INSTRUMENT PANEL, LEFT OR RIGHT)** .

Remove decorative strip next to light switch and radio. Refer to **51 16 221 REPLACING A CLIPPED FINISHER (DECORATIVE STRIP ON PANEL FOR INSTRUMENT PANEL, FRONT OR REAR DOOR)** .

Remove right fresh air nozzle. Refer to **64 22 136 REMOVING AND INSTALLING/REPLACING RIGHT FRESH-AIR GRILL** .

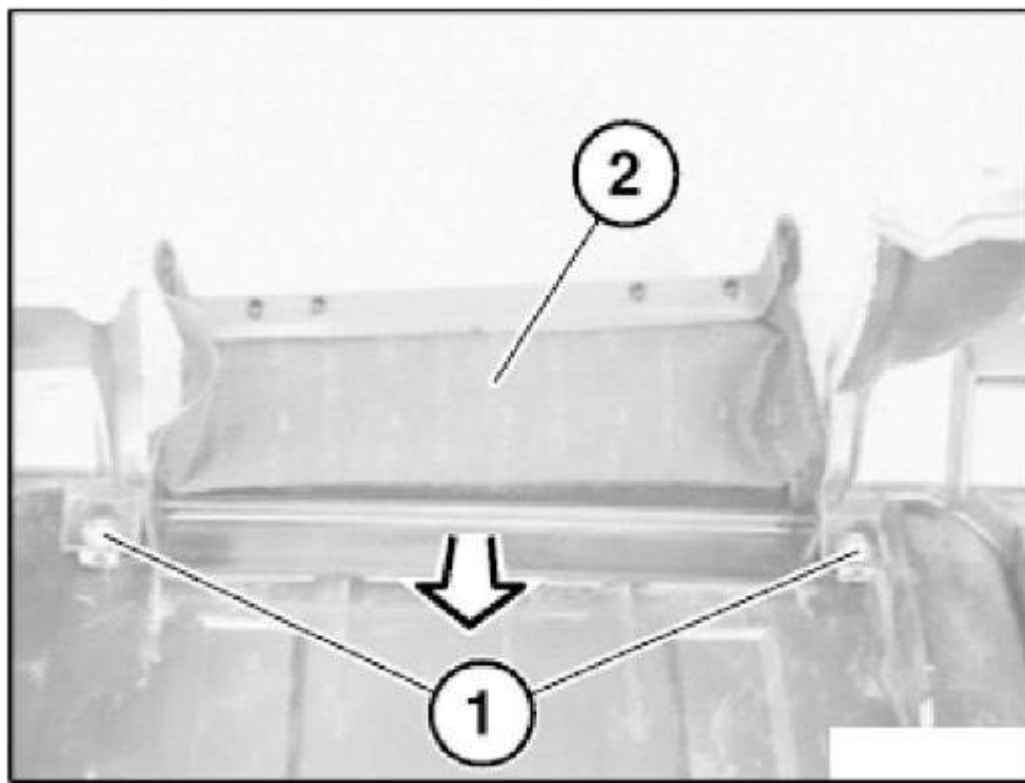
Release screws (1) and remove frame (2) for passenger airbag.



G03255990

Fig. 420: Releasing Screws And Removing Frame For Passenger Airbag
Courtesy of BMW OF NORTH AMERICA, INC.

Slacken screws (1) and remove cover (2) for steering column.

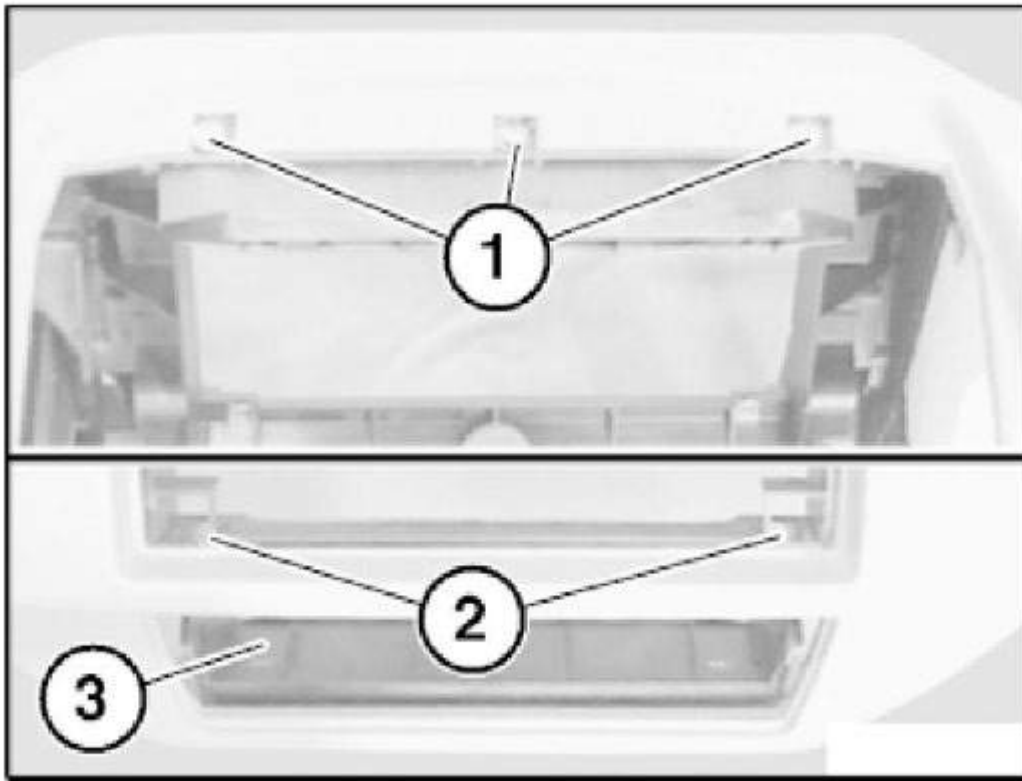


G03255991

Fig. 421: Removing Cover For Steering Column
Courtesy of BMW OF NORTH AMERICA, INC.

Release screws (1) from below.

Release screws (2) from above and remove frame (3) for heating controls.

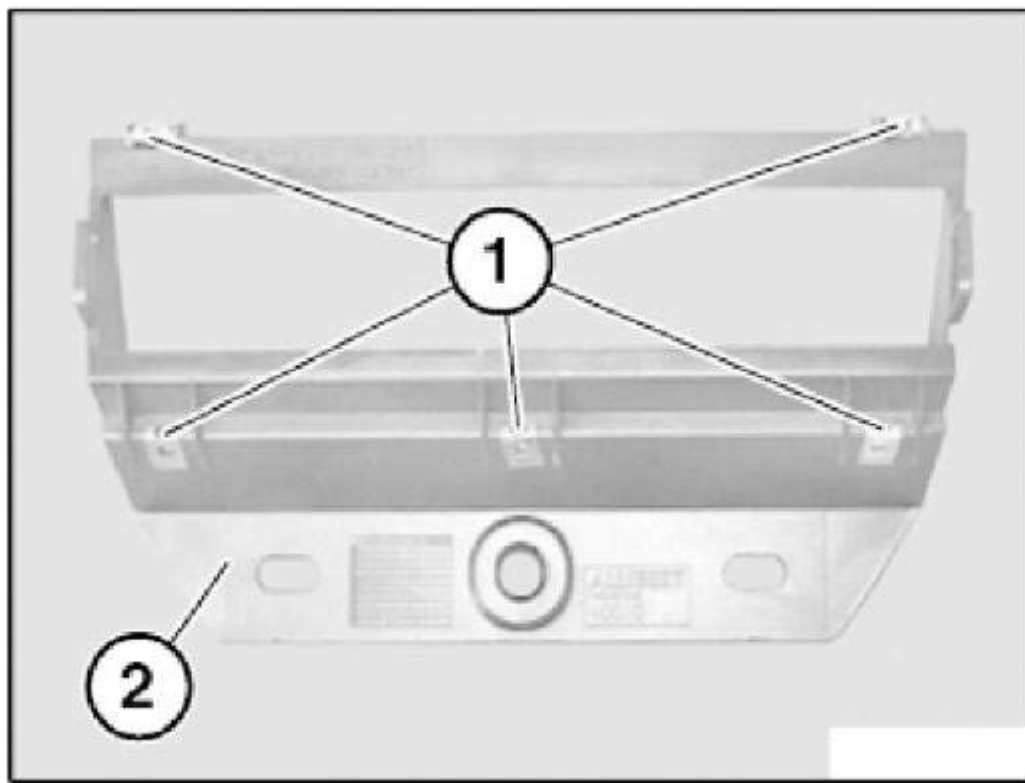


G03255992

Fig. 422: Releasing Screws And Removing Frame For Heating Controls
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

If necessary, replace faulty metal nuts (1) on frame (2) for heating controls.



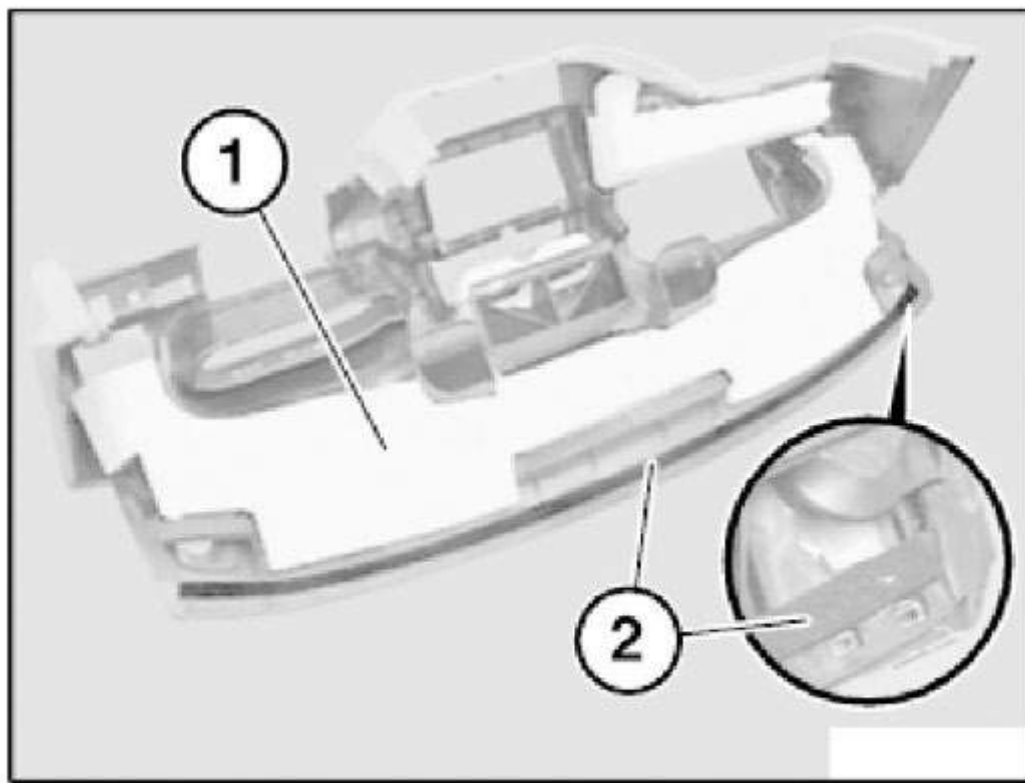
G03255993

Fig. 423: Locating Metal Nuts On Frame For Heating Controls
Courtesy of BMW OF NORTH AMERICA, INC.

Detach anti-drumming coating (1) until air ducts can be removed at side.

Installation:

Foam strip (2) must be correctly fitted.



G03255994

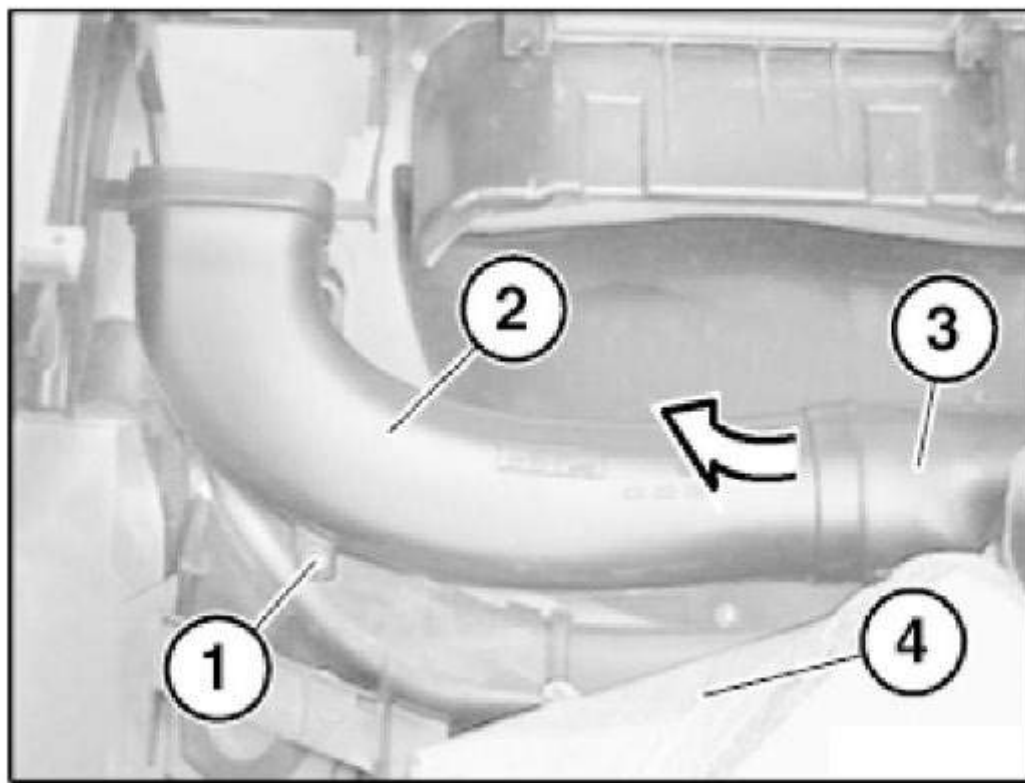
Fig. 424: Detaching Anti-Drumming Coating And Foam Strip
Courtesy of BMW OF NORTH AMERICA, INC.

Release left/right screws (1).

Detach air duct (2) on left/right from center air duct (3).

Installation:

Re-attach anti-drumming coating (4) to air duct (2).



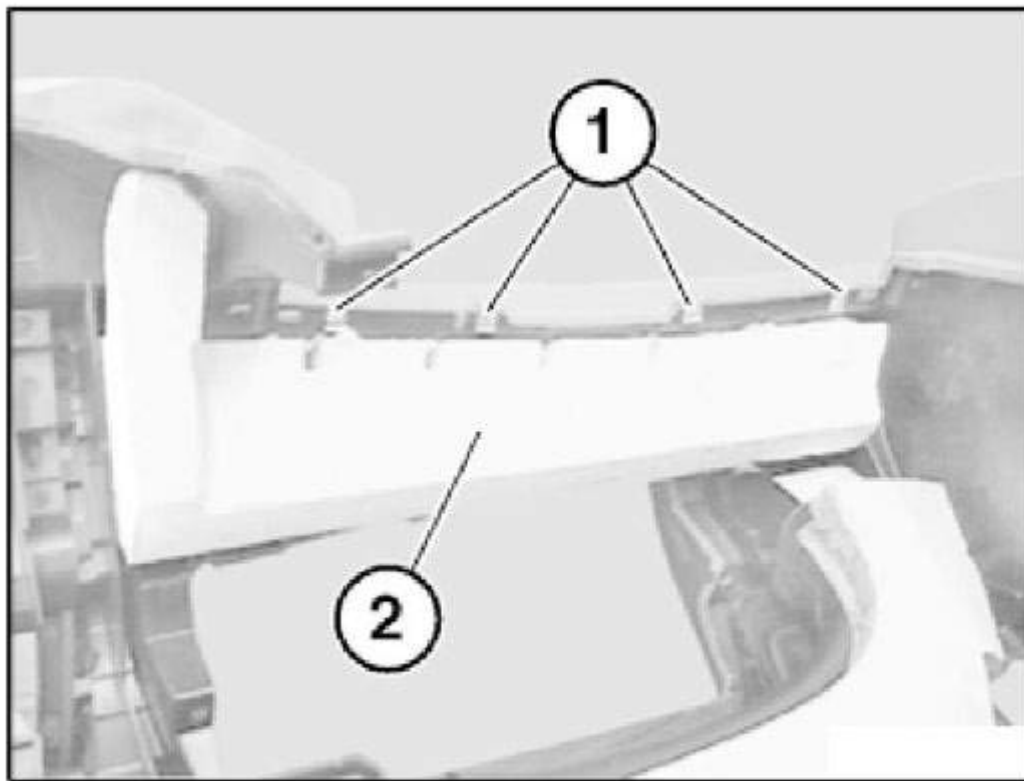
G03255995

Fig. 425: Identifying Left/Right Air Ducts
Courtesy of BMW OF NORTH AMERICA, INC.

Remove metal nuts (1).

Installation:

Styrofoam block (2) must be correctly fitted.



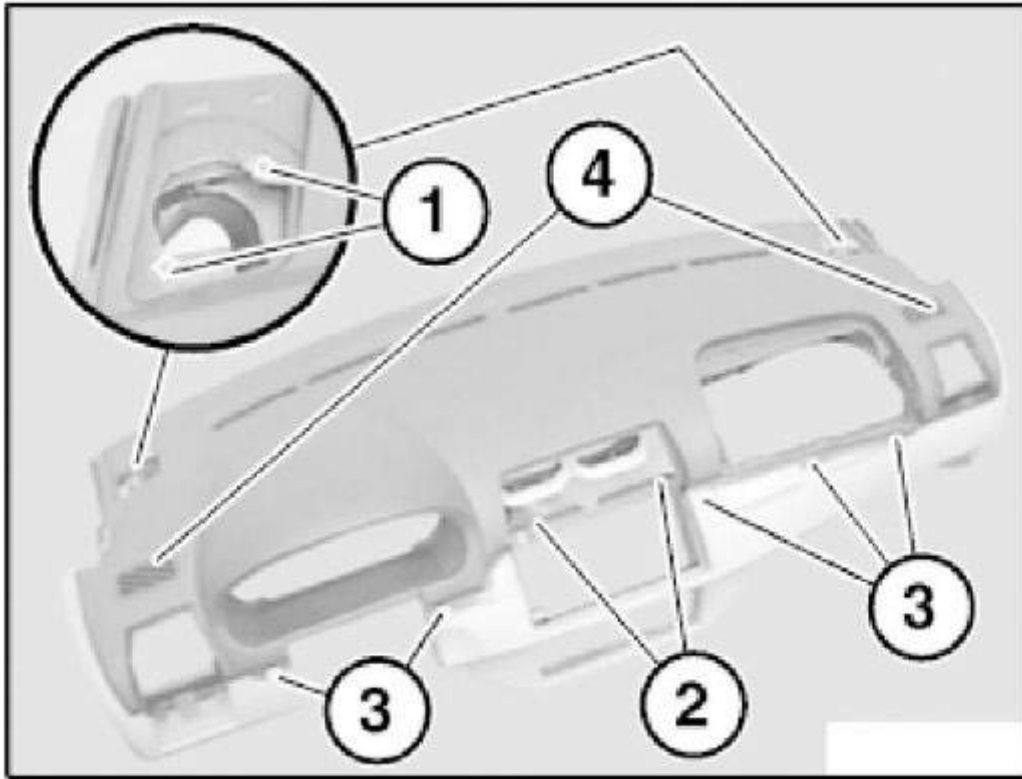
G03255996

Fig. 426: Locating Metal Nuts And Styrofoam Block
Courtesy of BMW OF NORTH AMERICA, INC.

Remove metal nuts (1) for left/right speakers.

Remove fasteners (3) for decorative strips.

Unclip fresh-air grill (4) on left/right.



G03255997

Fig. 427: Removing Metal Nuts For Left/Right Speakers

Courtesy of BMW OF NORTH AMERICA, INC.

51 45 055 REMOVING AND INSTALLING/REPLACING AIRBAG COVER ON PASSENGER SIDE

Operation Is Identical To:

Remove airbag module on passenger side. Refer to **51 45 055 REMOVING AND INSTALLING/REPLACING AIRBAG COVER ON PASSENGER SIDE** .

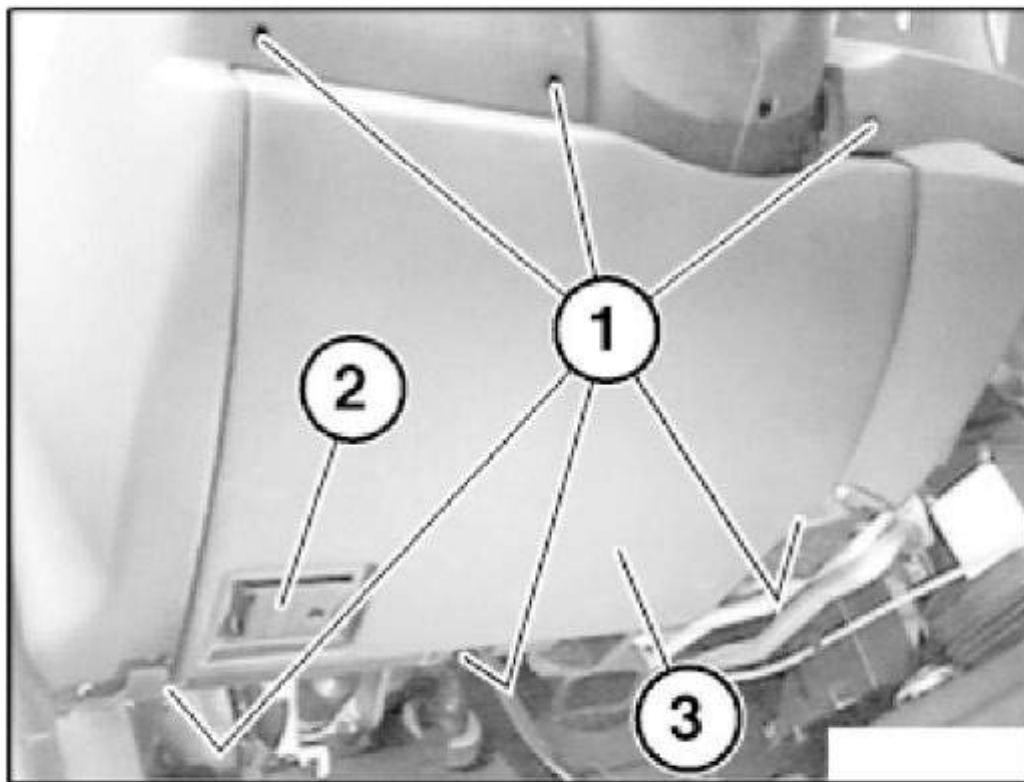
51 45 180 REMOVING AND INSTALLING TRIM FOR INSTRUMENT PANEL, BOTTOM LEFT

Remove trim for pedal assembly. Refer to **51 45 185 REMOVING AND INSTALLING/REPLACING TRIM FOR PEDAL ASSEMBLY** .

Release screws (1).

Disconnect plug connection for OBD socket (2).

Unclip rubber gaiter from steering wheel trim and remove trim (2).

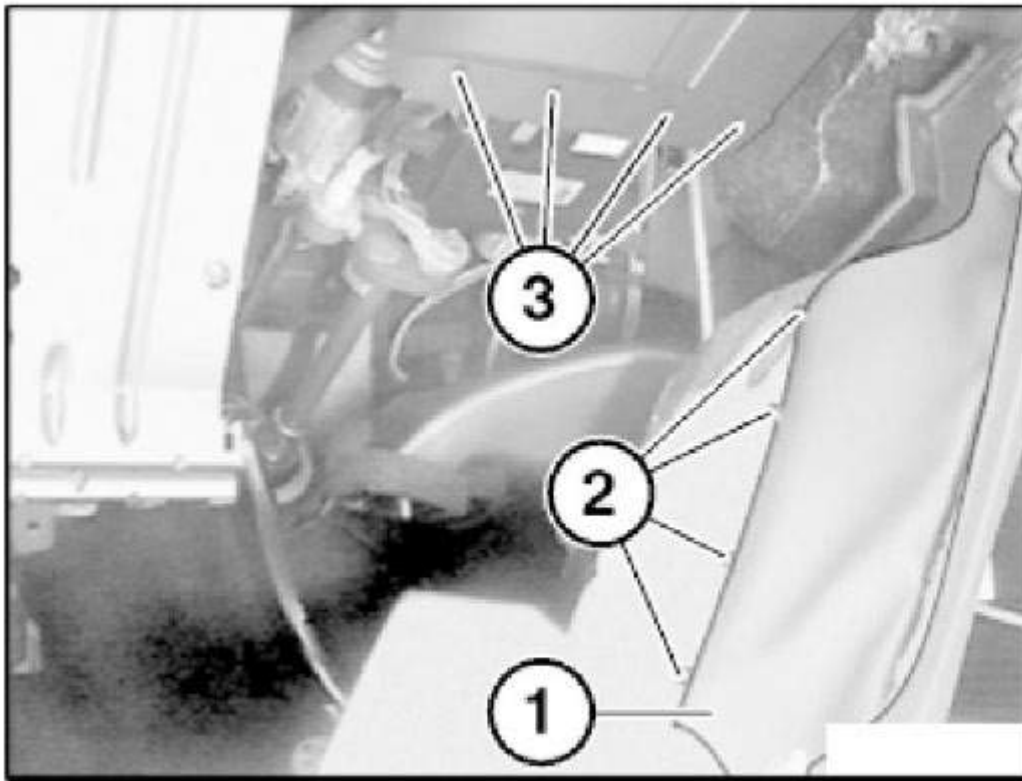


G03255998

Fig. 428: Disconnecting Plug Connection For OBD Socket
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Clip rubber gaiter (1) correctly with clips (1) into fixtures (3) in steering wheel trim.



G03255999

Fig. 429: Clipping Rubber Gaiter Correctly With Clips Into Fixtures In Steering
Courtesy of BMW OF NORTH AMERICA, INC.

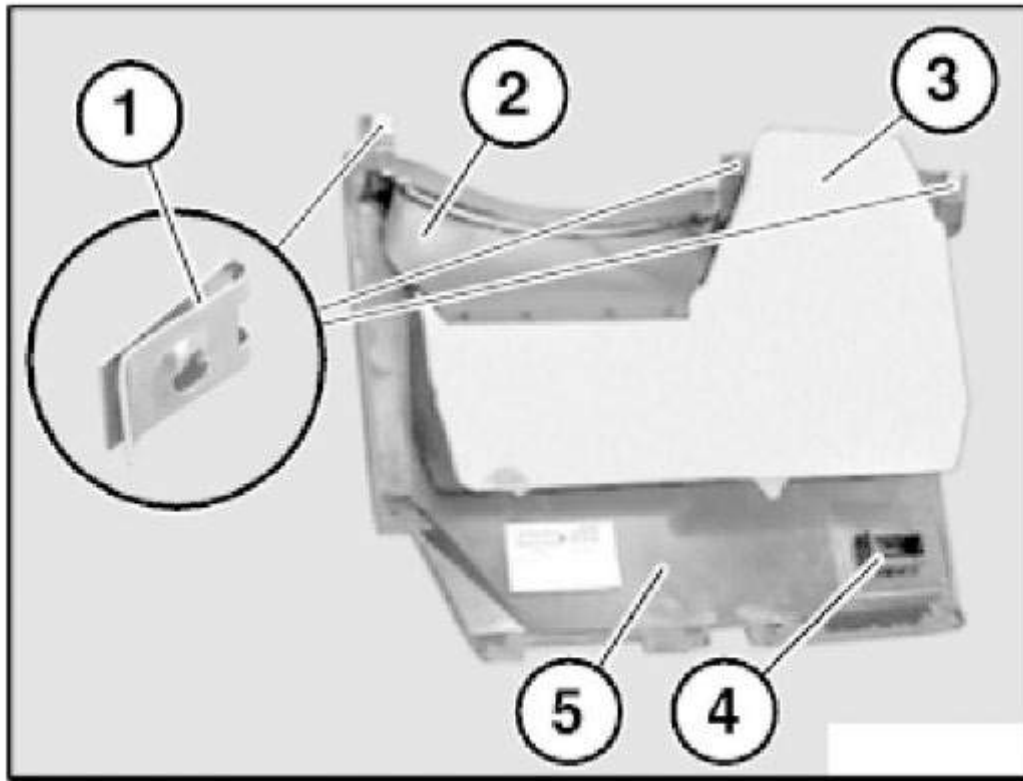
Installation:

If necessary, replace faulty metal nuts (1).

Rubber gaiter (2) and styrofoam (3) must not be damaged.

Replacement Only:

Remove OBD socket (4) from trim (5).



G03256000

Fig. 430: Clipping Rubber Gaiter With Clips Into Steering Wheel Trim
Courtesy of BMW OF NORTH AMERICA, INC.

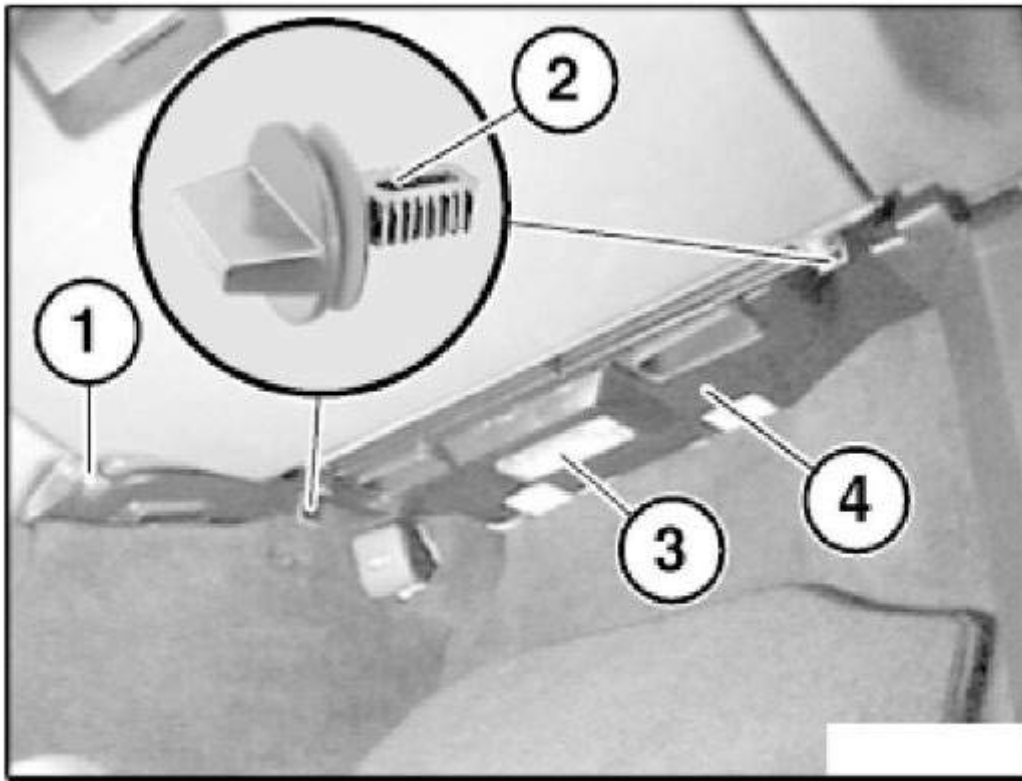
**51 45 181 REMOVING AND INSTALLING/REPLACING TRIM FOR INSTRUMENT PANEL,
BOTTOM RIGHT**

Release screw (1).

Turn toggle (2) and remove.

Lower trim (4) a little and disconnect plug connection for footwell light (3).

Remove bottom right trim (4) for instrument panel.



G03256001

Fig. 431: Replacing Trim For Instrument Panel, Bottom Right
Courtesy of BMW OF NORTH AMERICA, INC.

Replacement Only:

Lever out footwell light (3).

51 45 185 REMOVING AND INSTALLING/REPLACING TRIM FOR PEDAL ASSEMBLY

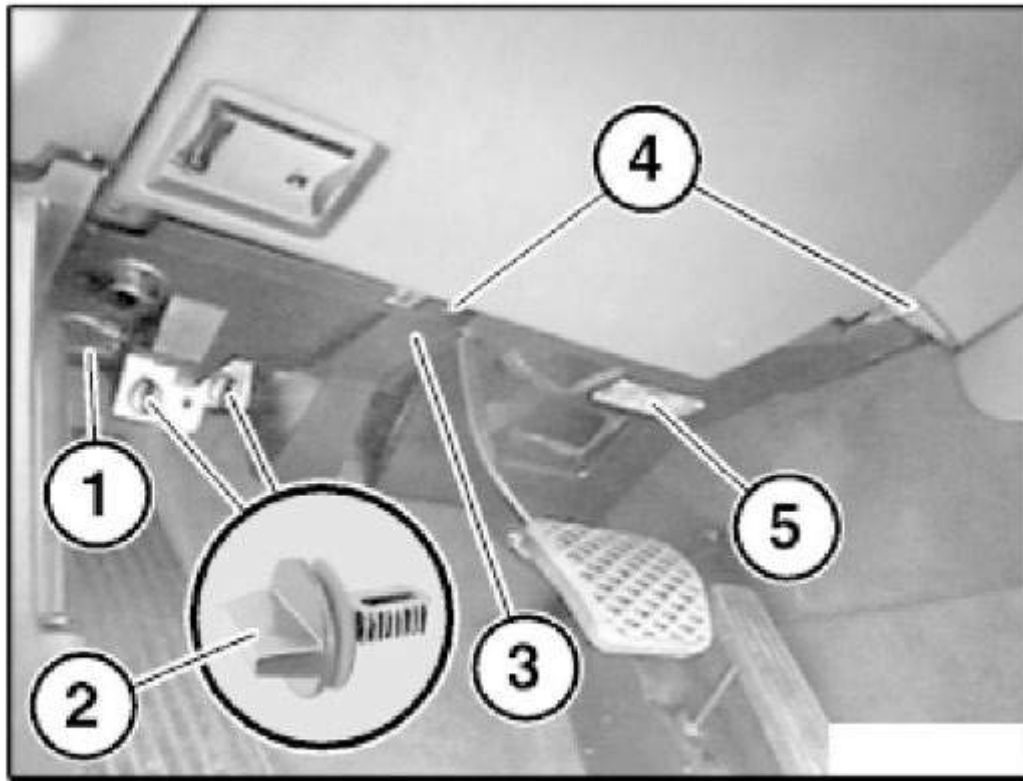
Unlock gong (1) and remove from trim (3).

Release screws (4).

Turn toggle (2) and remove.

Lower trim (3) a little and disconnect plug connection for footwell light (5).

Remove trim (3).



G03256002

Fig. 432: Removing Trim For Pedal Assembly
Courtesy of BMW OF NORTH AMERICA, INC.

Replacement Only:

Lever out footwell light (5).

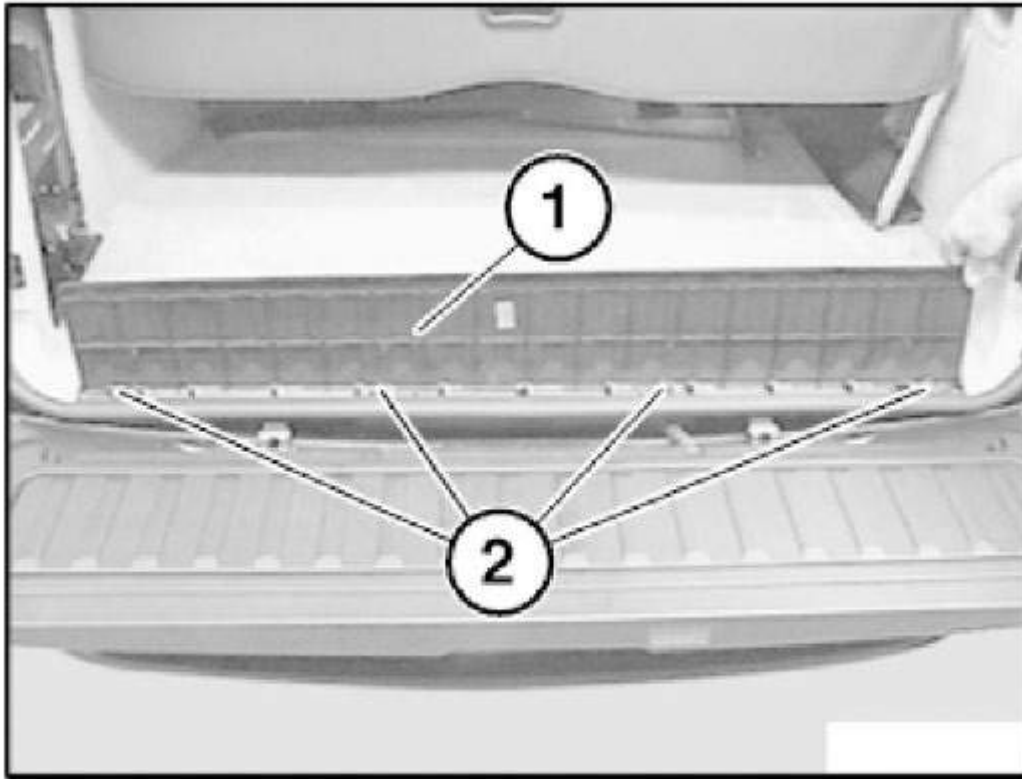
PARCEL SHELF TRIM PAN/ROLLER SUN BLIND

51 46 050 REMOVING AND INSTALLING/REPLACING FINISHER FOR TOP OF REAR APRON

Remove luggage compartment floor trim panel. Refer to **51 47 101 REMOVING AND INSTALLING/REPLACING LUGGAGE COMPARTMENT FLOOR TRIM PANEL** .

Remove flaps in luggage compartment trim panel on left and right. Refer to **51 47 172 REMOVING AND INSTALLING/REPLACING FLAP IN LUGGAGE COMPARTMENT TRIM, LEFT OR RIGHT** .

Raise trim (1) and release screws (2).

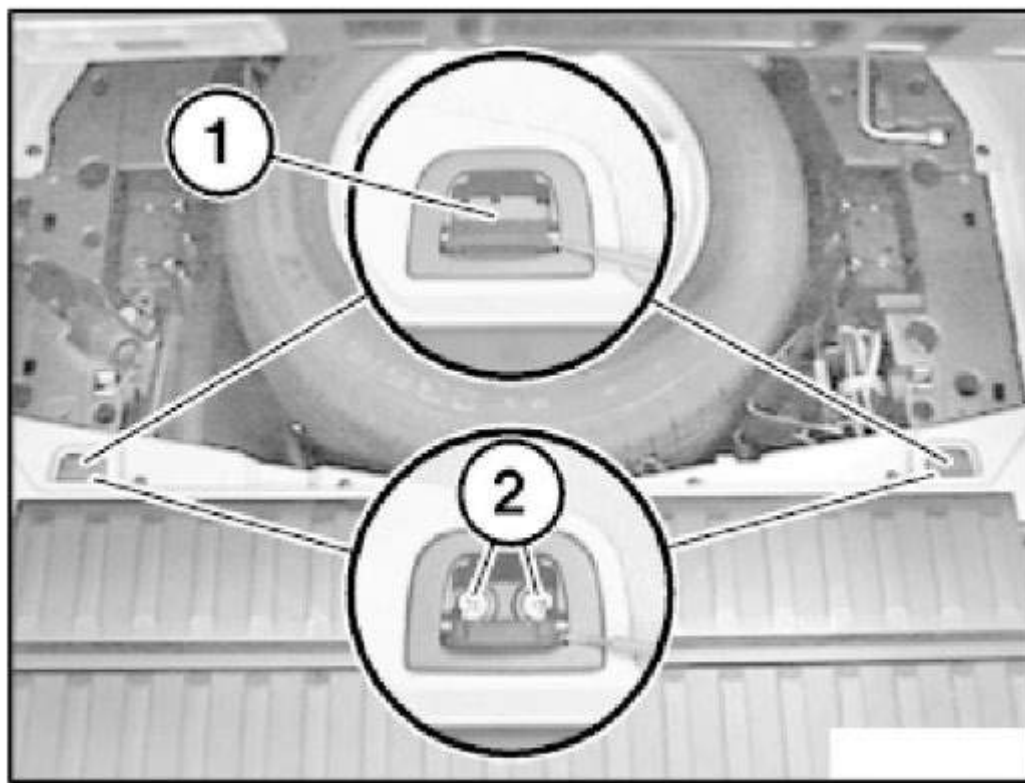


G03256003

Fig. 433: Raising Trim And Releasing Screws
Courtesy of BMW OF NORTH AMERICA, INC.

Lever out trim (1) in lashing eyes on opening.

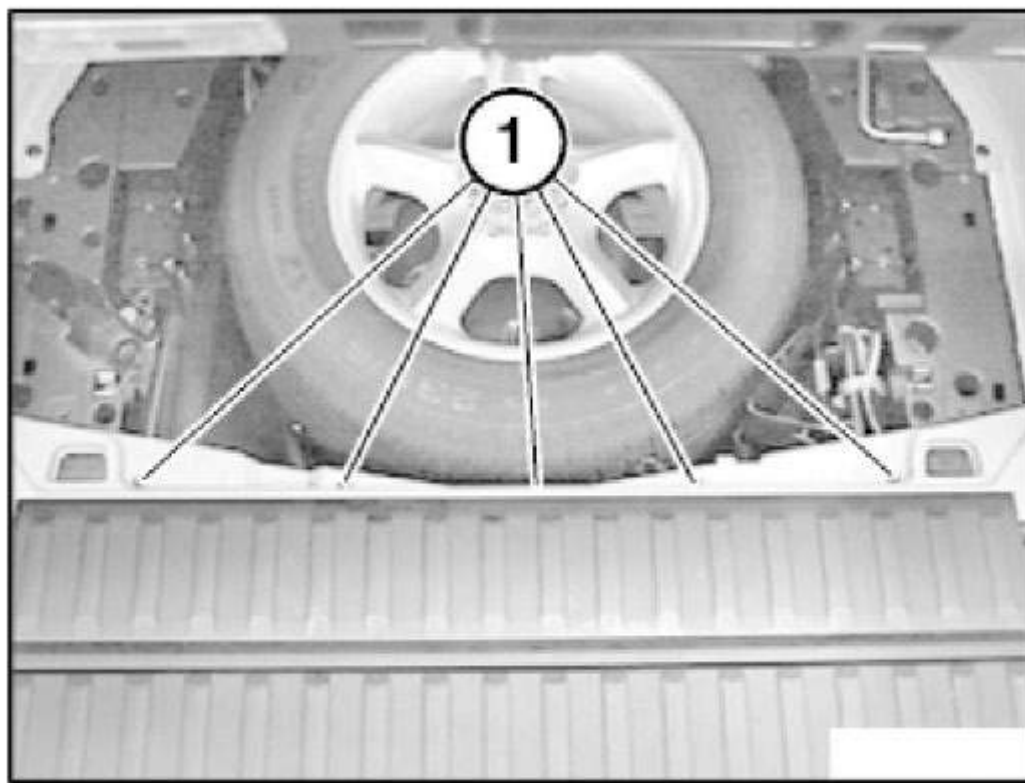
Release screws (2) and lever out lashing eyes.



G03256004

Fig. 434: Releasing Screws And Levering Out Lashing Eyes
Courtesy of BMW OF NORTH AMERICA, INC.

Release screws (1).



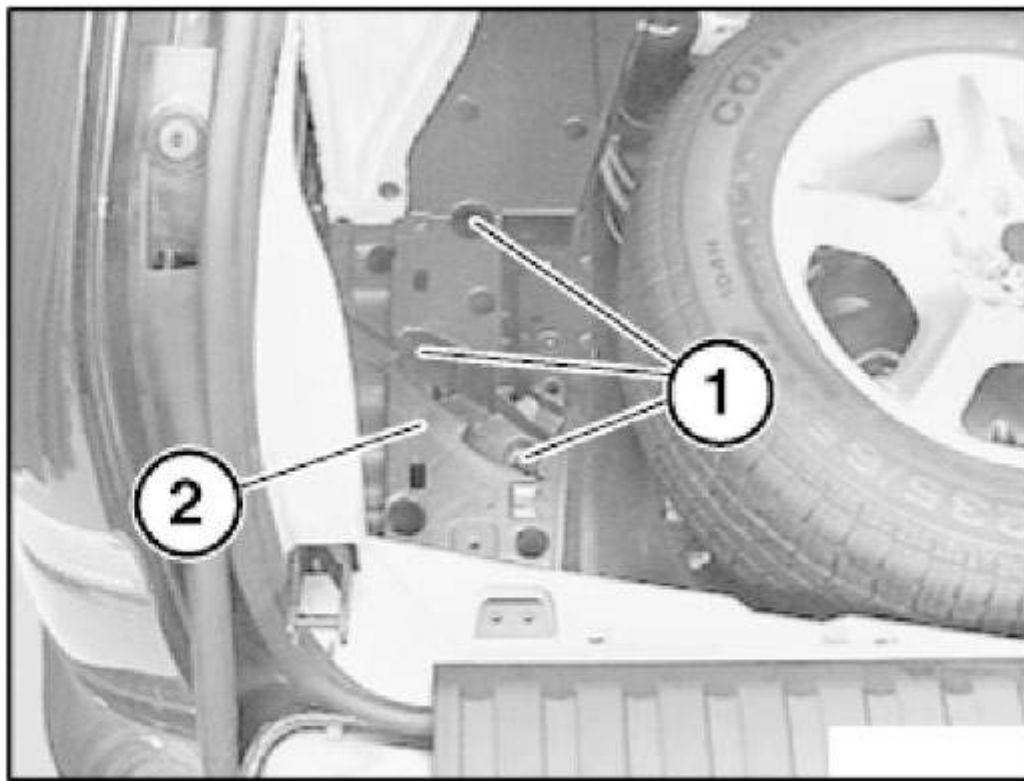
G03256005

Fig. 435: Locating Screw In Trim

Courtesy of BMW OF NORTH AMERICA, INC.

Release screws (1) on cover (2).

Lift off cover (2).



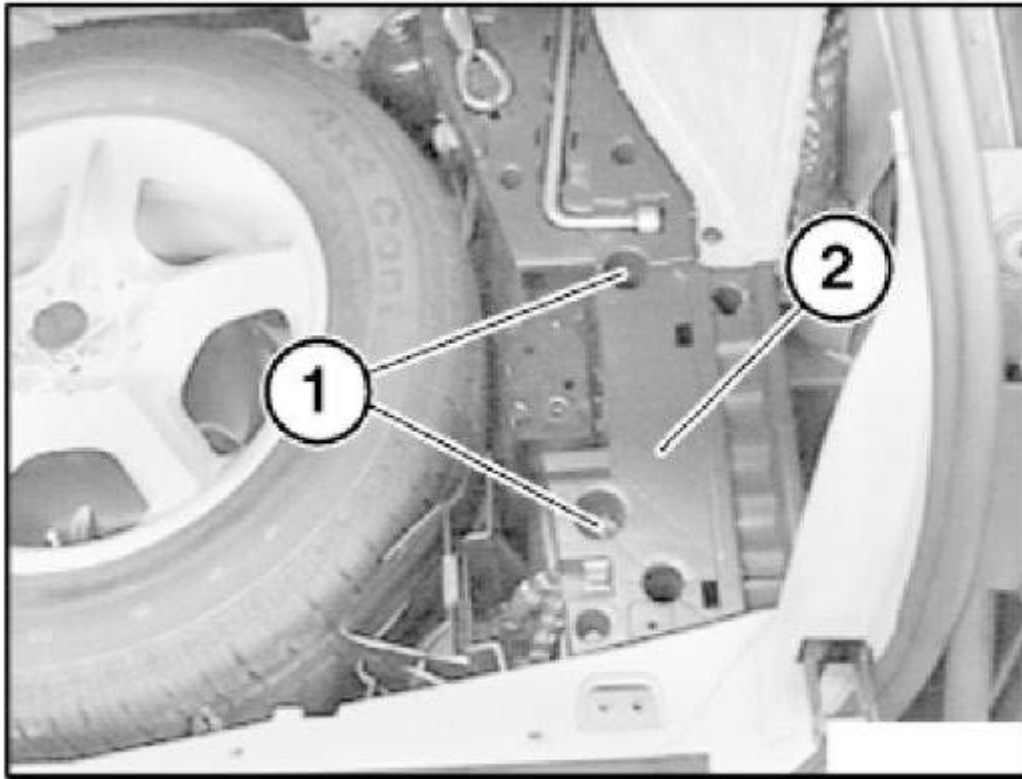
G03256006

Fig. 436: Releasing Screws On Cover
Courtesy of BMW OF NORTH AMERICA, INC.

Release screws (1) on cover (2).

Lift off cover (2).

Remove trim on tail panel.



G03256007

Fig. 437: Removing Trim On Tail Panel
Courtesy of BMW OF NORTH AMERICA, INC.

FLOOR/LUGGAGE/ENG. COMP TR. PANEL

51 46 050 REMOVING AND INSTALLING/REPLACING FINISHER FOR TOP OF REAR APRON

Operation is identical to: **51 46 050 REMOVING AND INSTALLING/REPLACING FINISHER FOR TOP OF REAR APRON** .

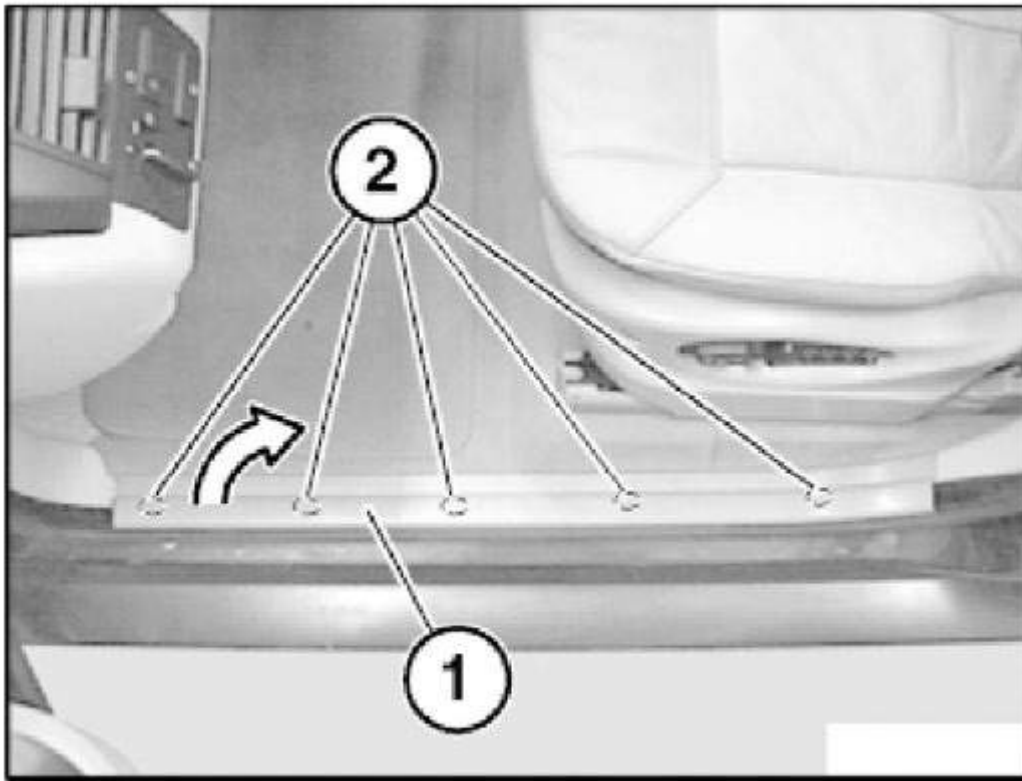
51 47 000 REMOVING AND INSTALLING/REPLACING THE FRONT (INSIDE) LEFT OR RIGHT ROCKER PANEL STRIP

CAUTION: Risk of breakage to connecting lug on B-pillar trim panel. Do not raise entrance cover strip (1) over entire length simultaneously.

Raise entrance cover strip (1) from front to rear and detach with clips (2) from floor plate.

Detach entrance cover strip (1) from B-pillar trim panel at bottom towards front.

If necessary, lift clips off floor plate.



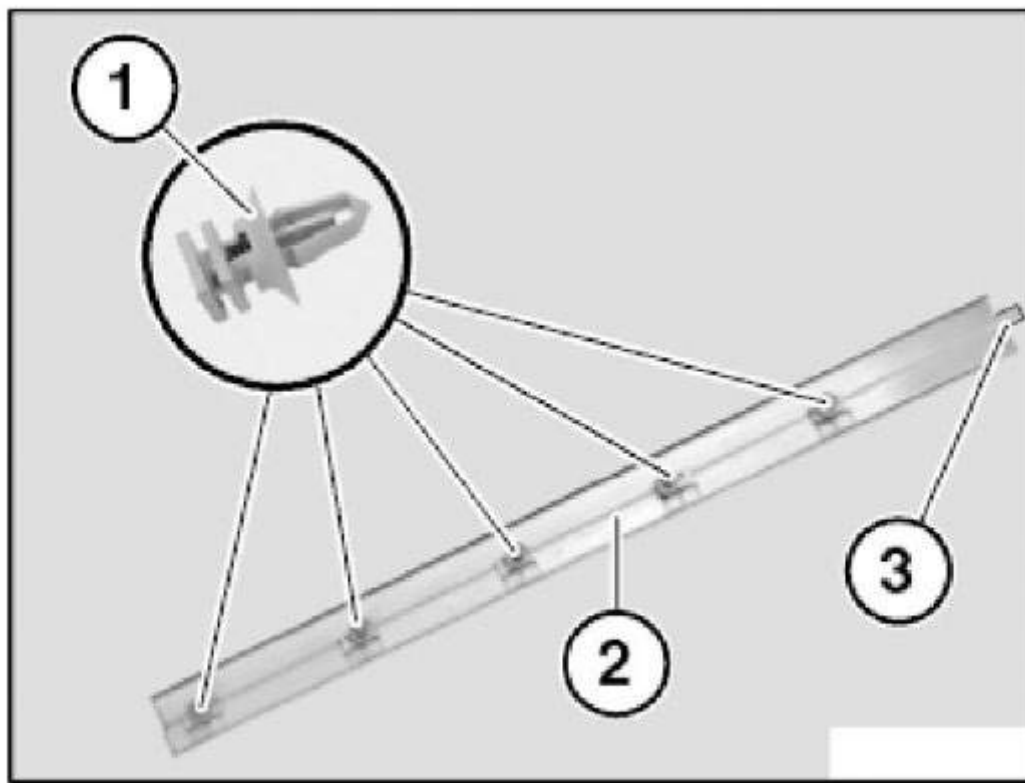
G03256013

Fig. 438: Locating Clips On Floor Plate
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

If necessary, replace defective clips (1).

Connecting lug (3) of entrance cover strip (2) must not be damaged.



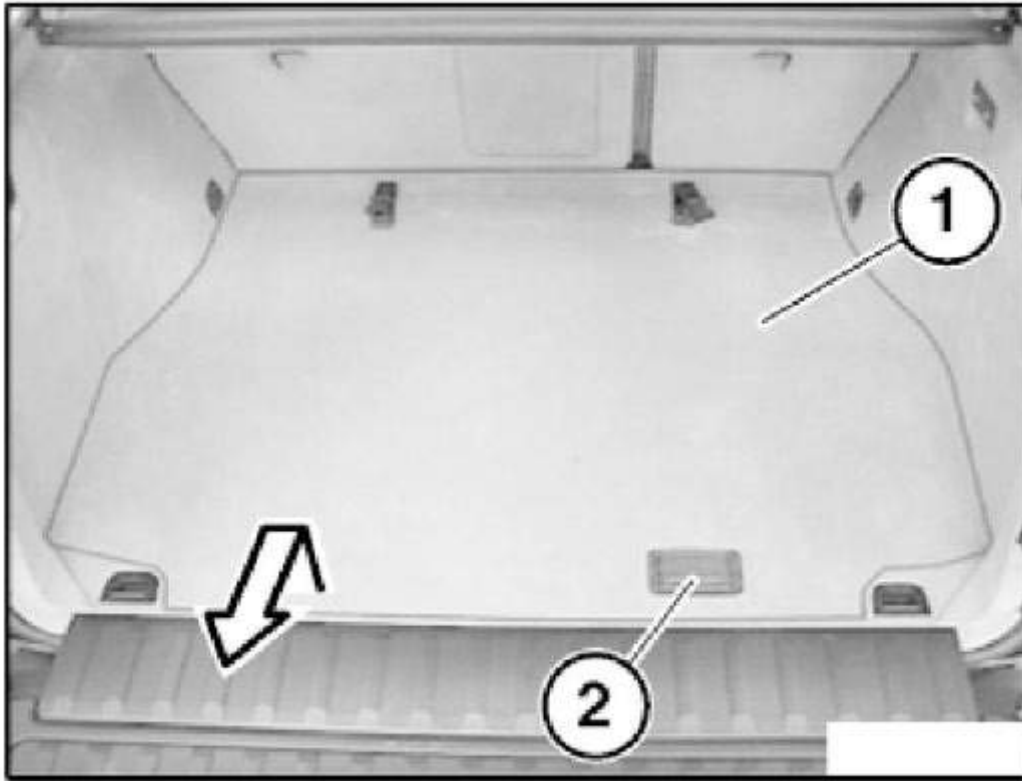
G03256014

Fig. 439: Identifying Clips For Entrance Cover Strip
Courtesy of BMW OF NORTH AMERICA, INC.

51 47 101 REMOVING AND INSTALLING/REPLACING LUGGAGE COMPARTMENT FLOOR TRIM PANEL

Open trunk lid.

Unlock luggage compartment floor trim panel (1) at handle (2) and remove.



G03256015

Fig. 440: Unlocking Luggage Compartment Floor Trim Panel At Handle
Courtesy of BMW OF NORTH AMERICA, INC.

51 47 151 REMOVING AND INSTALLING/REPLACING TRUNK WHEEL HOUSING TRIM, LEFT

Remove inside window cavity cover strip for door window, rear left. Refer to **51 37 261 REMOVING AND INSTALLING/REPLACING WINDOW CAVITY COVER STRIP FOR DOOR WINDOW, REAR LEFT OR RIGHT** .

Subsequent removal is described in:

Removing right luggage compartment wheel arch trim. Refer to **51 47 161 REMOVING AND INSTALLING/REPLACING RIGHT TRUNK WHEEL ARCH TRIM** .

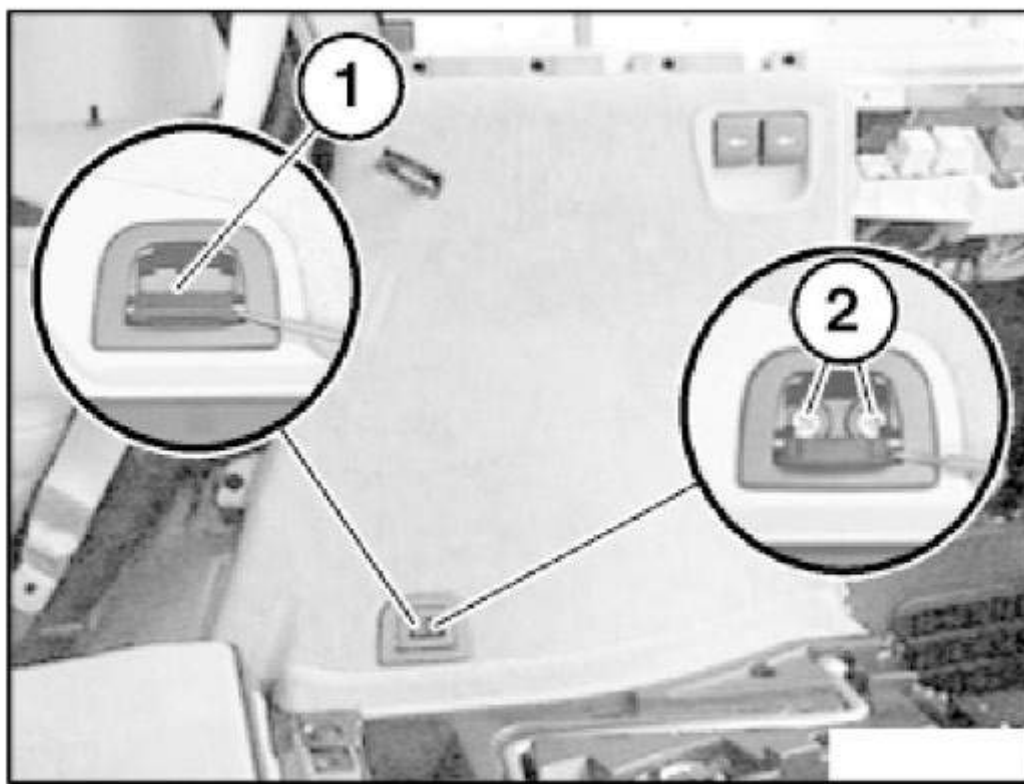
51 47 161 REMOVING AND INSTALLING/REPLACING RIGHT TRUNK WHEEL ARCH TRIM

Remove inside window cavity cover strip for door window, rear right. Refer to **51 37 261 REMOVING AND INSTALLING/REPLACING WINDOW CAVITY COVER STRIP FOR DOOR WINDOW, REAR**

LEFT OR RIGHT .

Lever out cover plate (1) in lashing eye.

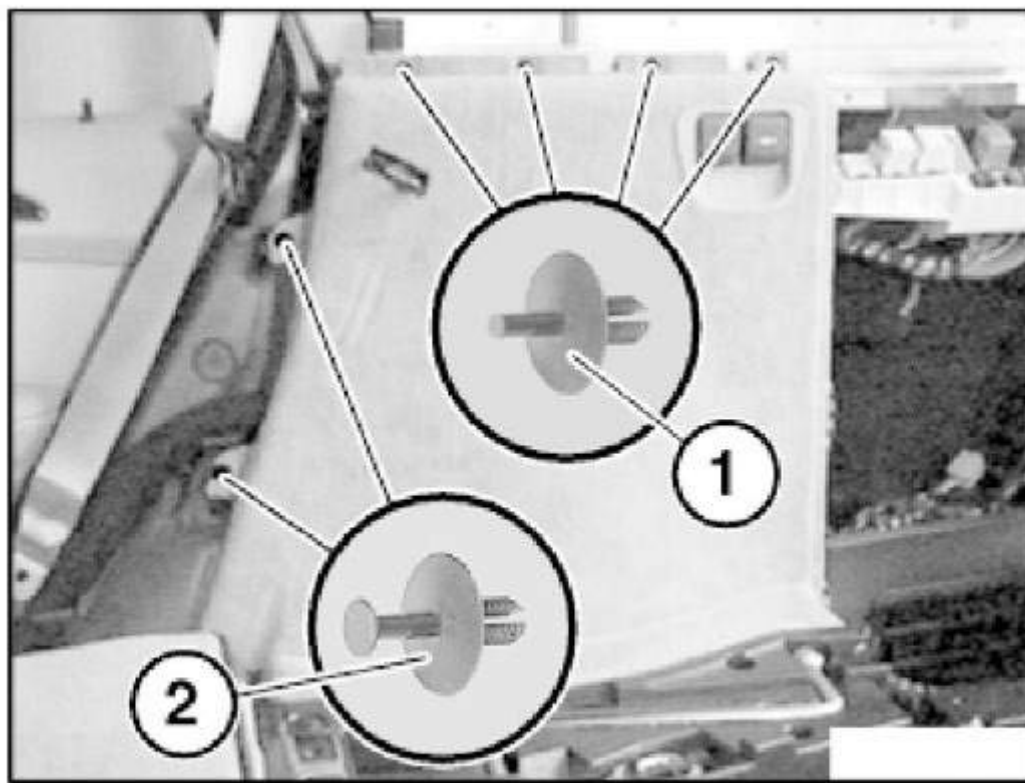
Unfasten screws (2).



G03256016

Fig. 441: Removing Cover Plate And Retaining Screws
Courtesy of BMW OF NORTH AMERICA, INC.

Release expansion rivets (1) and (2).



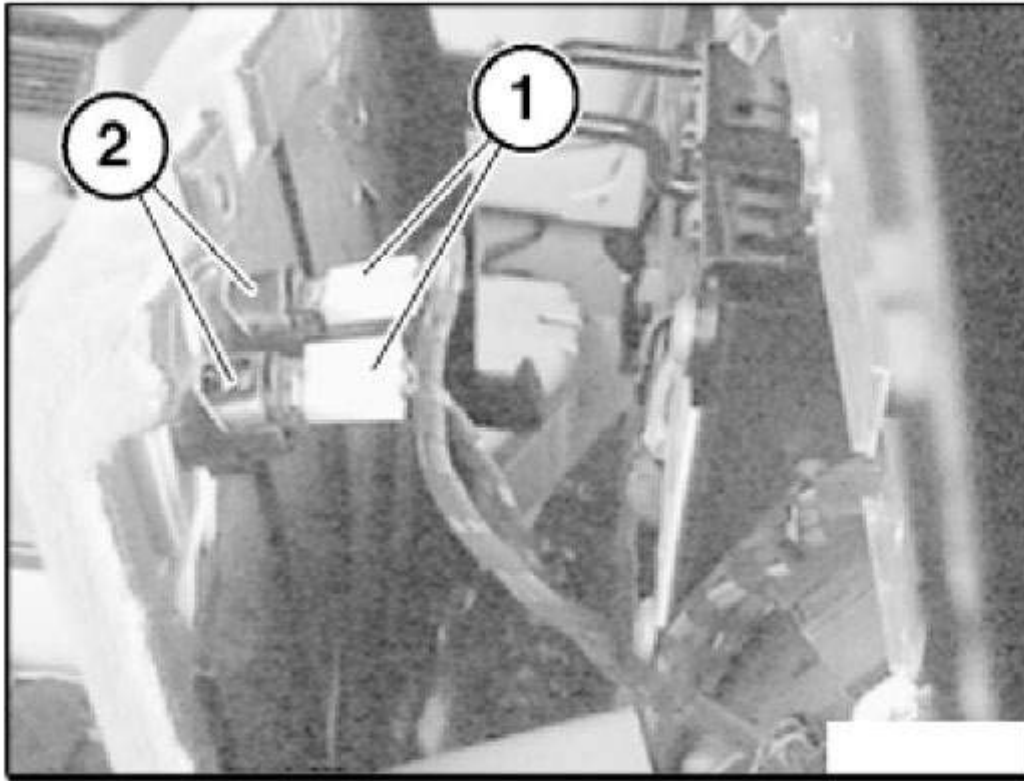
G03256017

Fig. 442: Releasing Expansion Rivets

Courtesy of BMW OF NORTH AMERICA, INC.

Disconnect plug connections (1) on both 12 V sockets (2).

Removing right luggage compartment wheel arch trim.



G03256018

Fig. 443: Disconnecting Plug Connections
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Check catch of socket housing in luggage compartment wheel arch trim.

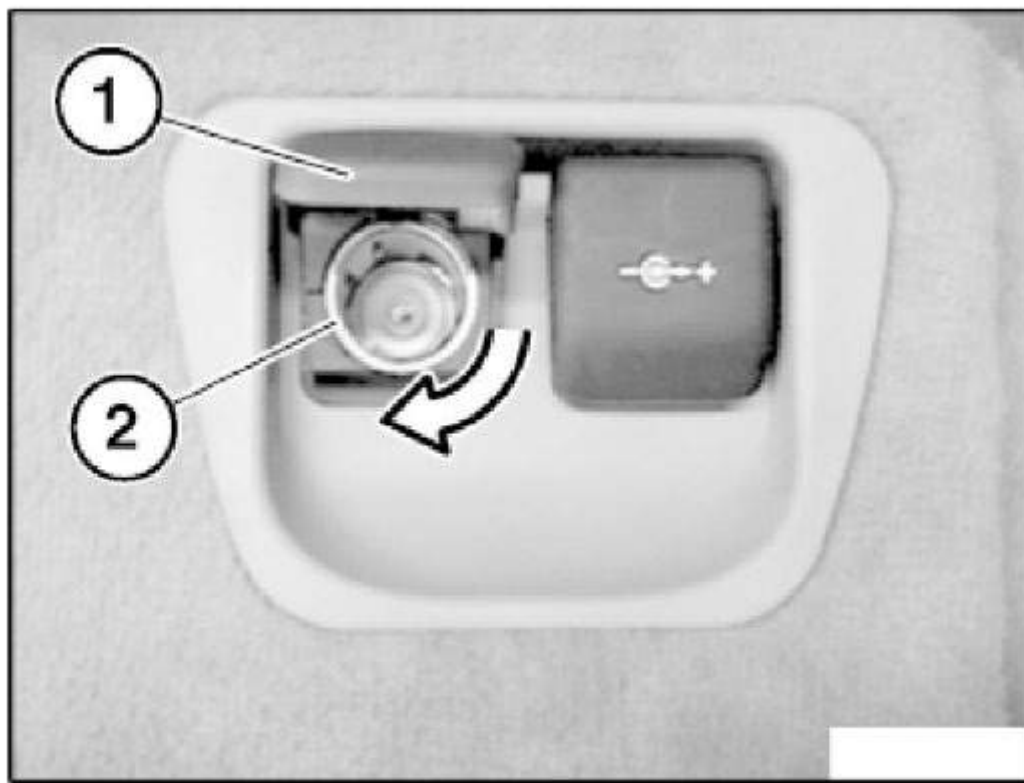
If necessary, replace 12 V sockets.

Replacing 12 V Sockets:

Open cover (1) of socket housing.

Turn socket insert (2) approx. 30° to right.

Turn socket insert (2) under tension back into initial position and pull out of socket housing.



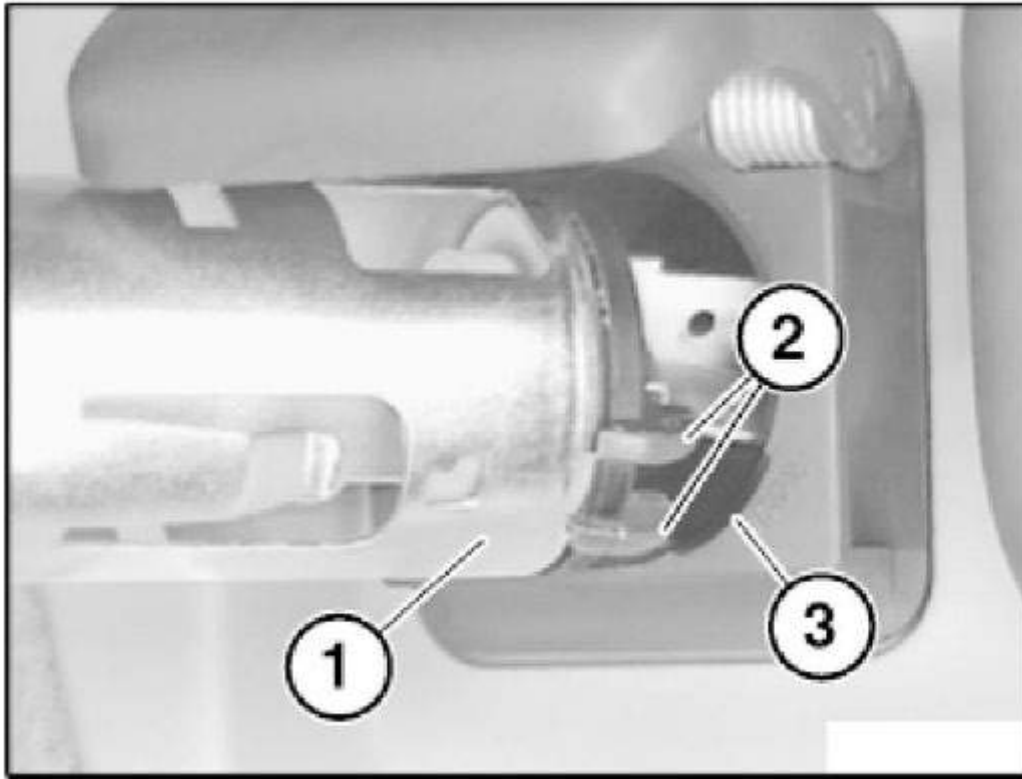
G03256019

Fig. 444: Replacing 12 V Sockets

Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

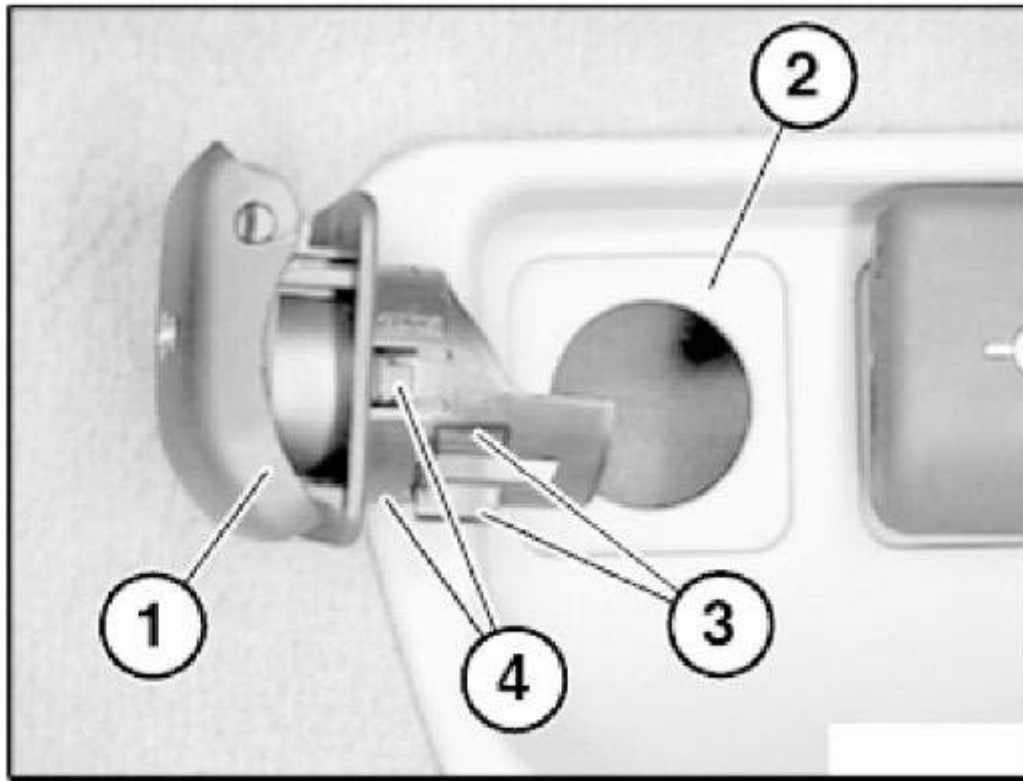
Align socket insert (1) with retaining lugs (2) to groove (3) of socket housing and slide in until it is felt snapping into place.



G03256020

Fig. 445: Aligning Socket Insert With Retaining Lugs
Courtesy of BMW OF NORTH AMERICA, INC.

Pull socket housing (1) approx. 5 mm out of wheel arch trim (2) and tilt out to right at bottom.



G03256021

Fig. 446: Removing Socket Housing

Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

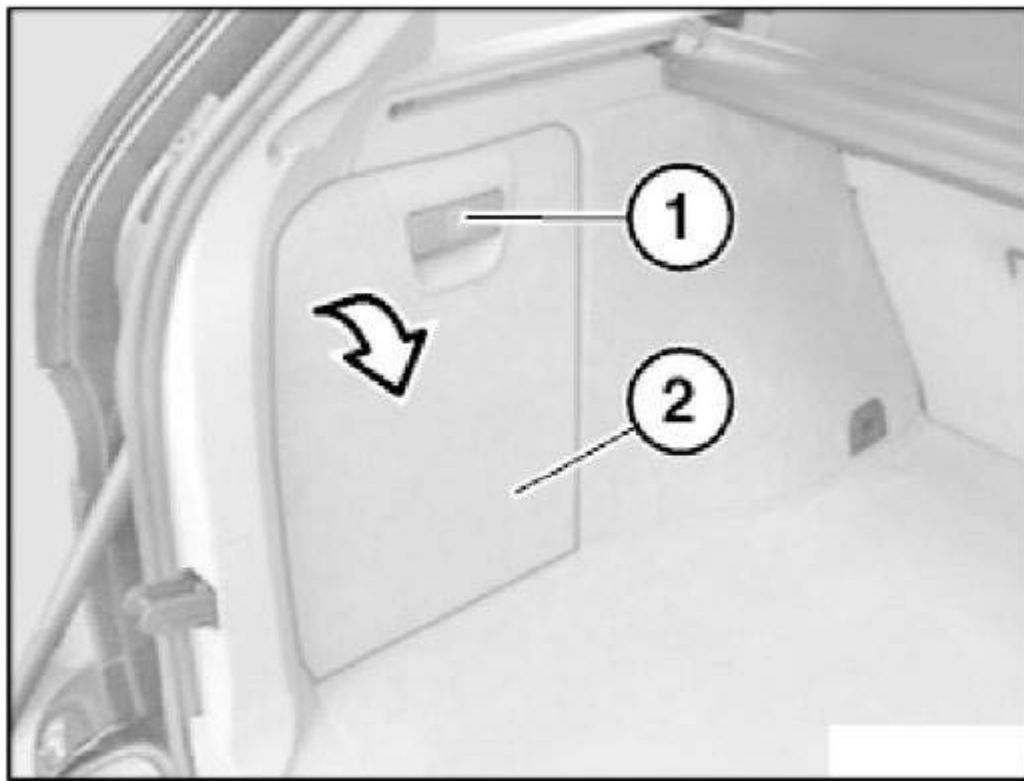
Insert socket housing with plastic lugs (3) into wheel arch trim and lock with retaining lugs (4).

51 47 172 REMOVING AND INSTALLING/REPLACING FLAP IN LUGGAGE COMPARTMENT TRIM, LEFT OR RIGHT

Left Side:

Press release button (1).

Open flap (2) and remove.



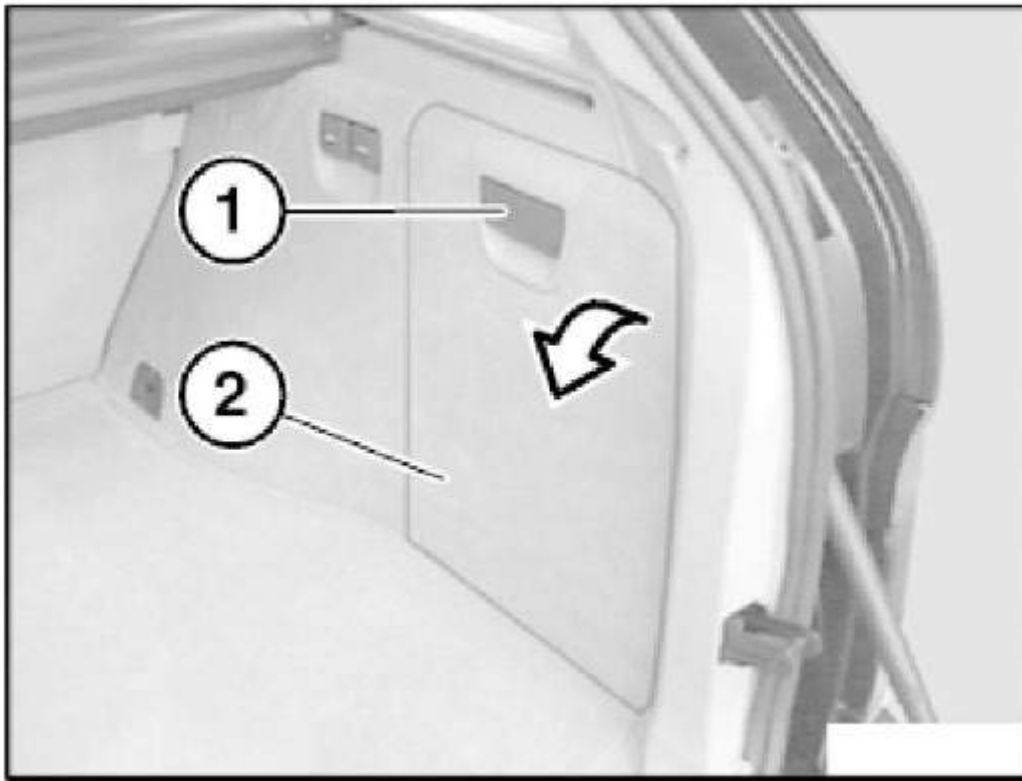
G03256022

Fig. 447: Removing Flap On Left Side
Courtesy of BMW OF NORTH AMERICA, INC.

Right Side:

Press release button (1).

Open flap (2) and remove.



G03256023

Fig. 448: Removing Flap On Right Side
Courtesy of BMW OF NORTH AMERICA, INC.

51 47 490 REMOVING AND INSTALLING/REPLACING FRONT ASSEMBLY UNDERSIDE PROTECTION

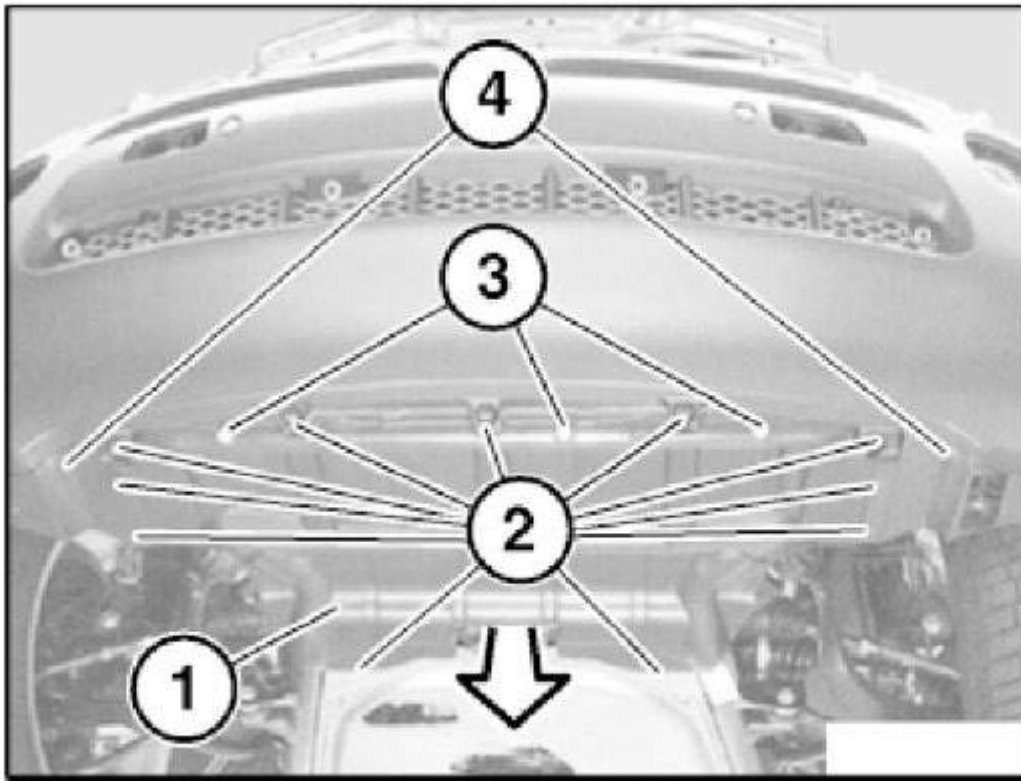
Unfasten screws (2 and 3).

Pull forward assembly underside protection (1) under bumper trim and wheel arch trims (4) on left/right.

Installation:

Make sure wheel arch trims (4) on left/right are correctly seated.

Center underside protection (1) and tighten down screws (2 and 3).

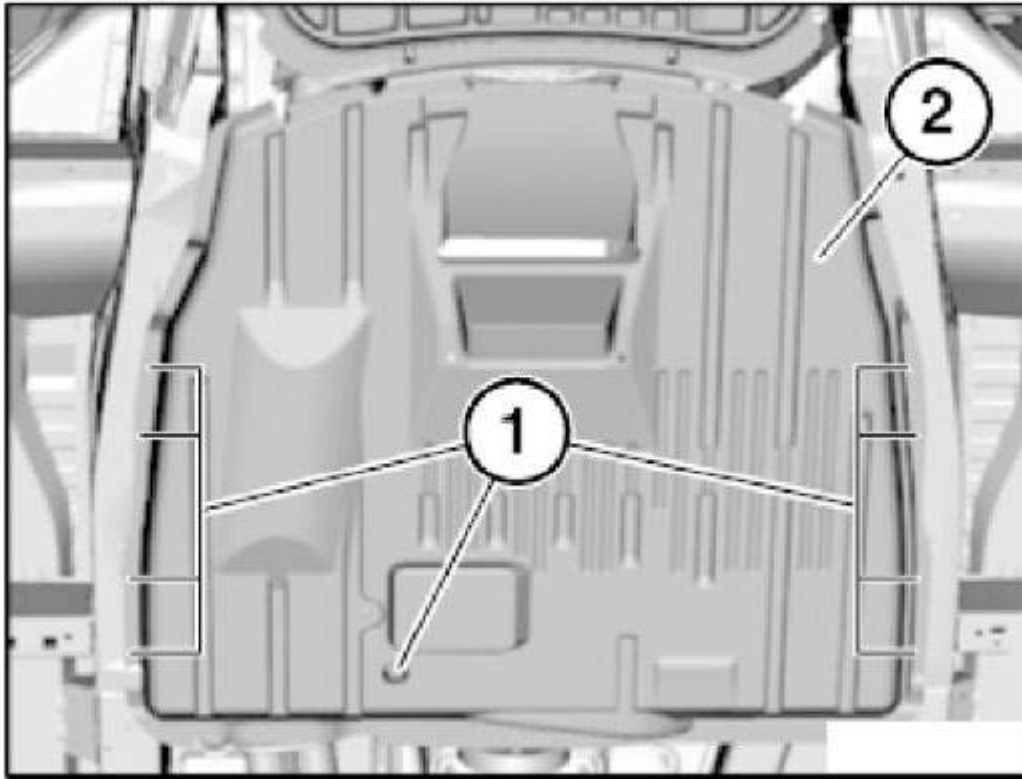


G03256024

Fig. 449: Removing Forward Assembly Underside Protection And Retaining Screws
Courtesy of BMW OF NORTH AMERICA, INC.

51 47 491 REMOVING AND INSTALLING/REPLACING REAR UNDERBODY PROTECTION

NOTE: Illustration shows one example only. Differences in detail may be possible in the different engine variants.



G03256025

Fig. 450: Removing Rear Underbody Protection
Courtesy of BMW OF NORTH AMERICA, INC.

Release screws (1).

Remove underbody protection (2).

Installation:

Ensure correct seating.

Center underbody protection (2) and tighten down all screws.

FRONT LID INSULATION LINING

**51 48 ... REMOVING AND INSTALLING/REPLACING SOUND INSULATION IN FRONT DOOR,
LEFT OR RIGHT**

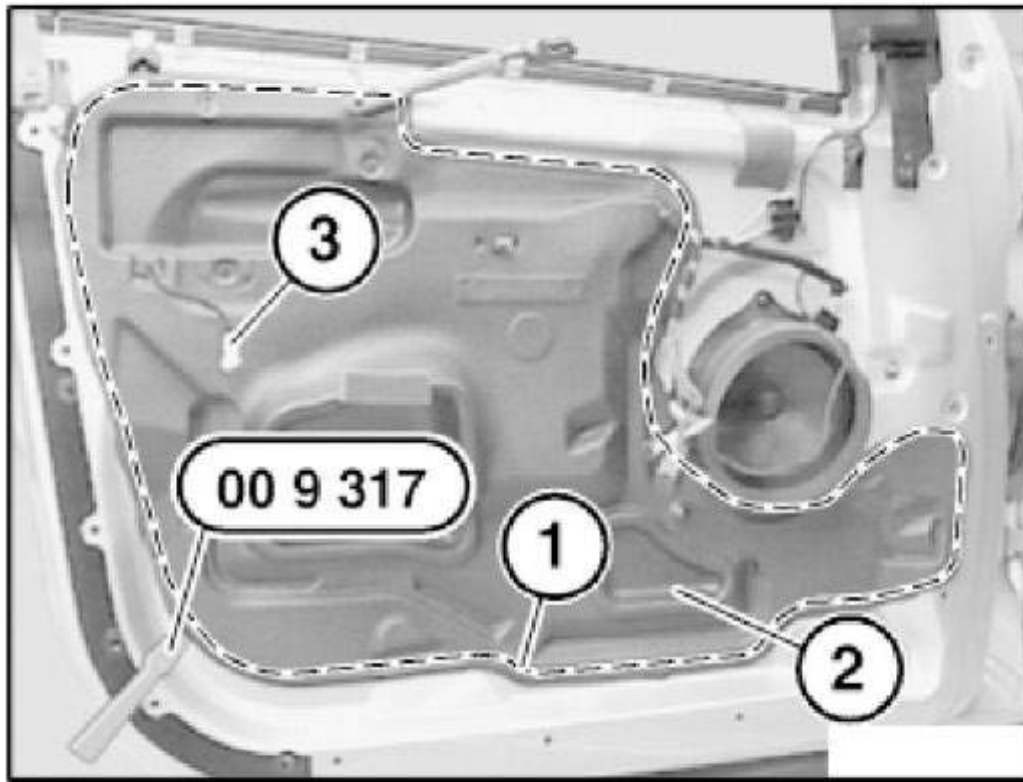
NOTE: For Special Tool identification, see **SPECIAL TOOLS - X5 (3.0i) .**

Special Tools Required:

- 00 9 317

Remove front door trim panel. Refer to **51 41 000 REMOVING AND INSTALLING LEFT OR RIGHT FRONT DOOR TRIM PANEL .**

If necessary, remove airbag module in front door. Refer to **SIDE AIR BAG MODULE** for year model 2001, **SIDE AIR BAG MODULE** for year model 2002, or **SIDE AIR BAG MODULE** for year model 2003.



G03256026

Fig. 451: Using Assembly Wedge To Remove Sealing Bead Of Sound Insulation
Courtesy of BMW OF NORTH AMERICA, INC.

Using special tool 00 9 317 (trim panel wedge), lever out sealing bead (1) of sound insulation (2) completely or if necessary partially.

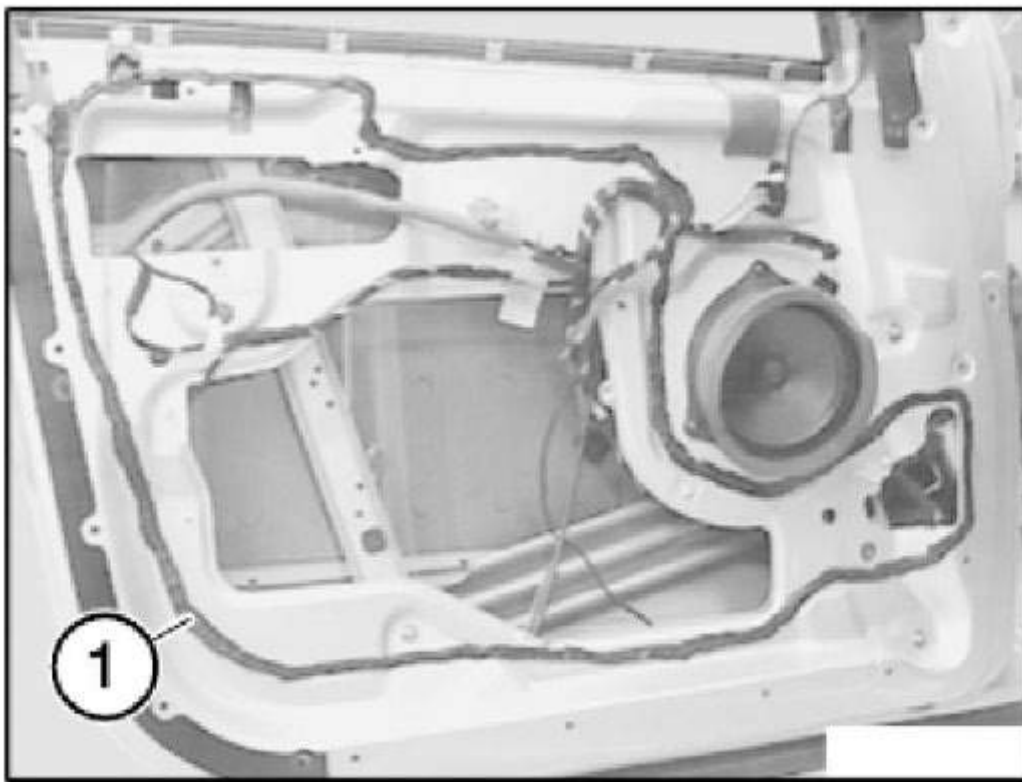
Feed airbag lead (3) out of sound insulation (2).

Installation:

In event of replacement or partial detachment, lay butylene tape on inner door plate or sound insulation.

Seal cable penetrations with butylene tape.

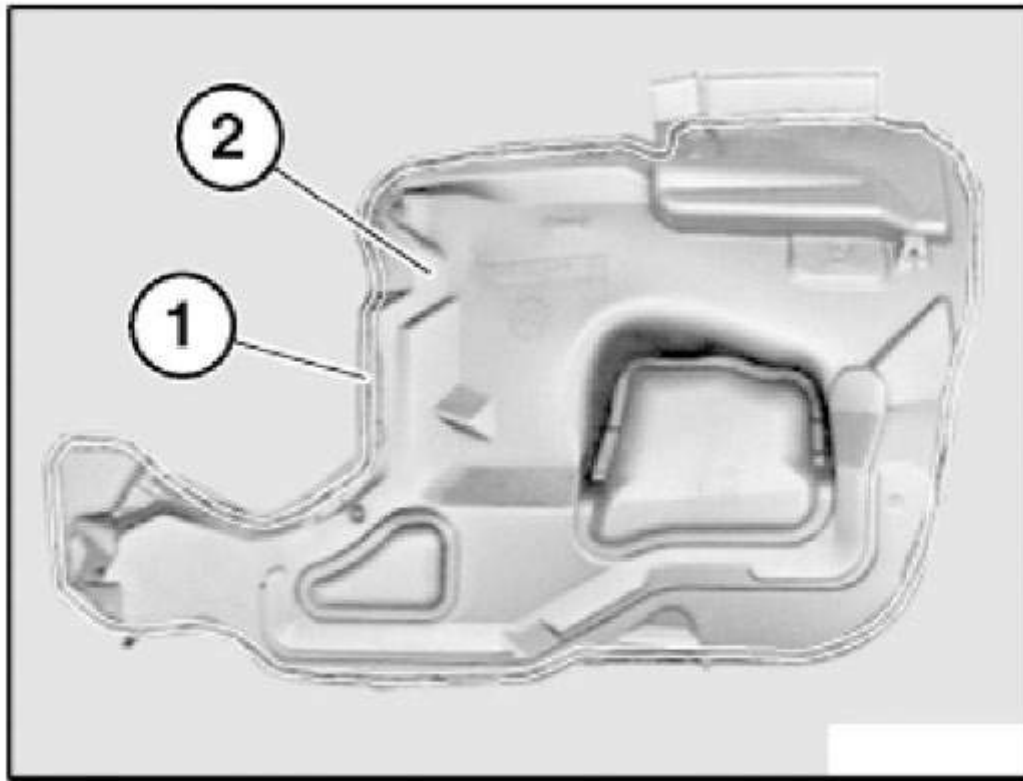
NOTE: **Position of butylene tape (1) on inner door plate.**



G03256027

Fig. 452: Aligning Butylene Tape On Inner Door Plate
Courtesy of BMW OF NORTH AMERICA, INC.

NOTE: **Position of butylene tape (1) on sound insulation (2).**



G03256028

Fig. 453: Positioning Of Butylene Tape On Sound Insulation
Courtesy of BMW OF NORTH AMERICA, INC.

Clean specified adhesive area with adhesive cleaner.

Air drying time: 1 minute.

CAUTION: The adhesive areas must be dry and free from dust and grease. After cleaning, do not touch the adhesive areas with bare hands.

Lay single row of 6 mm dia. butylene tape or double row of 3 mm dia. tape in specified adhesive area.

Heat butylene tape (hot air blower) and press down firmly on sound insulation all around.

Contact pressure with hand roller: approx. 30 N/cm².

Manual contact pressure: approx. 10 N/cm².

NOTE: Firm thumb pressure has approx. 50 N/cm² .

51 48 ... REMOVING AND INSTALLING/REPLACING SOUND INSULATION IN REAR DOOR, LEFT OR RIGHT

NOTE: For Special Tool identification, see **SPECIAL TOOLS - X5 (3.0i)** .

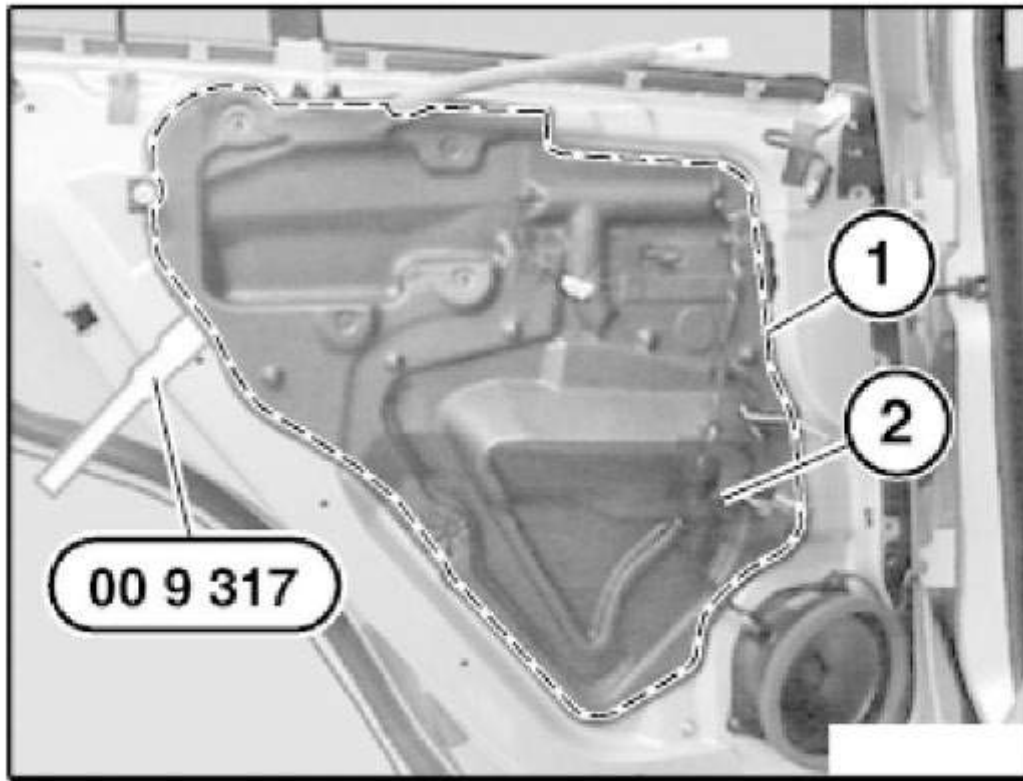
Special Tools Required:

- 00 9 317

Remove rear door trim panel. Refer to **51 42 000 REMOVING AND INSTALLING REAR LEFT OR RIGHT DOOR TRIM PANEL** .

If necessary, remove airbag module in rear door.

Using special tool 00 9 317 (trim panel wedge), lever out sealing bead (1) of sound insulation (2) completely or if necessary partially.



G03256029

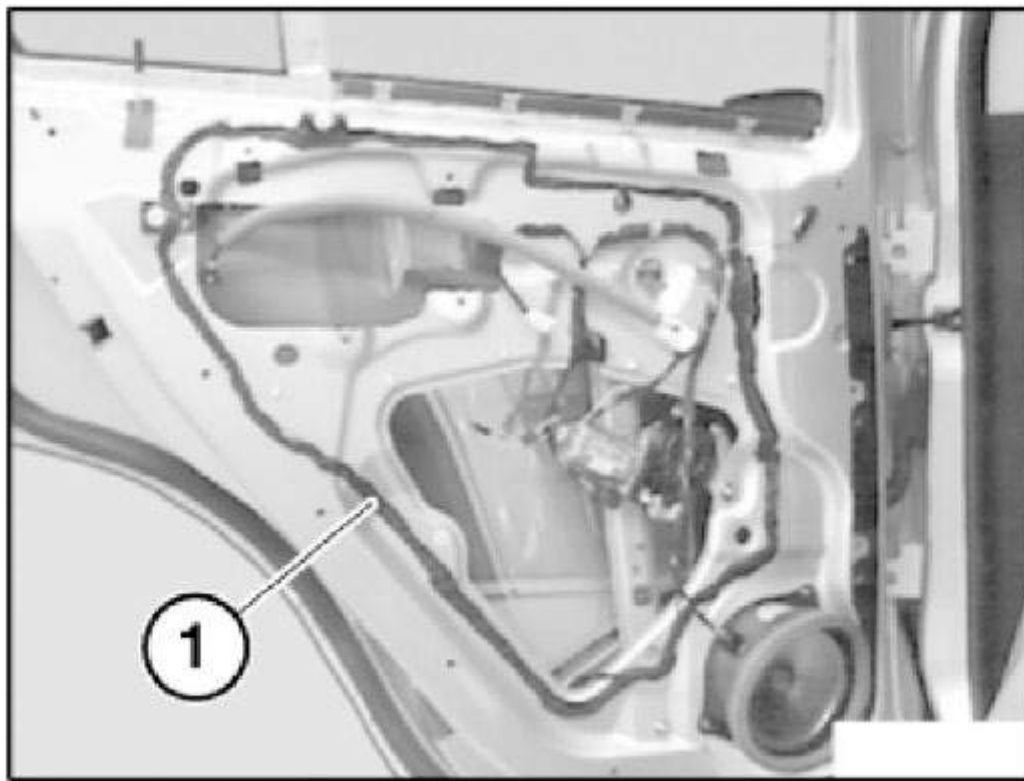
Fig. 454: Using Assembly Wedge To Remove Sealing Bead Of Sound Insulation
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

In event of replacement or partial detachment, lay butylene tape on inner door plate or sound insulation.

Seal cable penetrations with butylene tape.

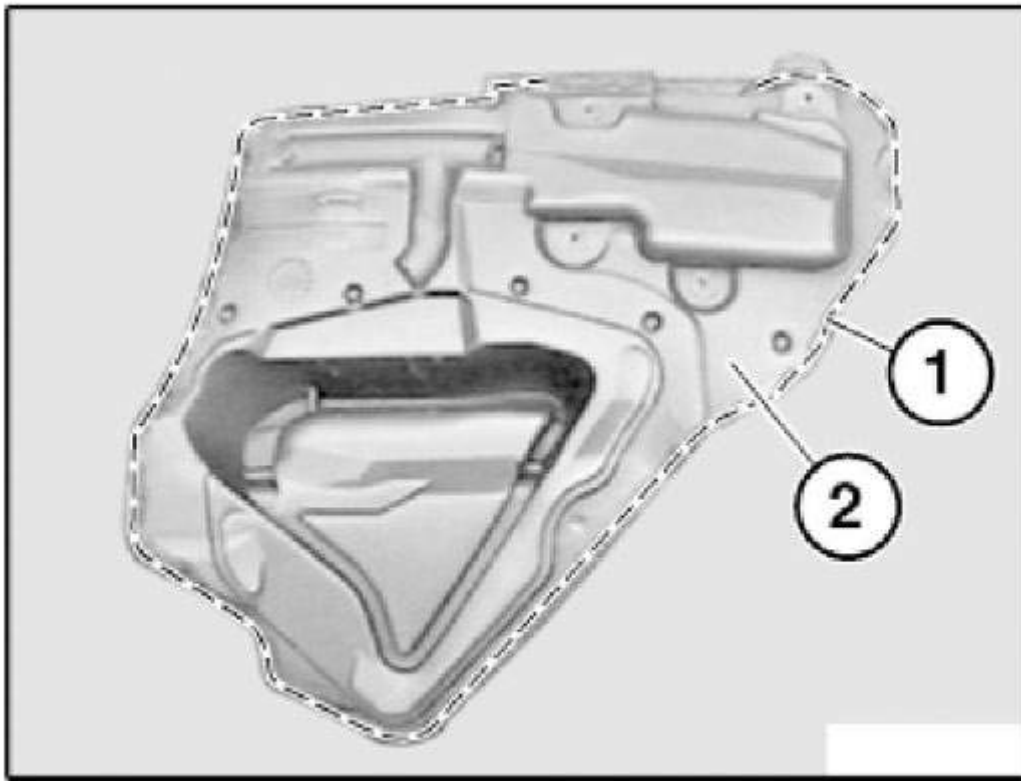
NOTE: **Position of butylene tape (1) on inner door plate.**



G03256030

Fig. 455: Aligning Of Butylene Tape On Inner Door Plate
Courtesy of BMW OF NORTH AMERICA, INC.

NOTE: **Position of butylene tape (1) on sound insulation (2).**



G03256031

Fig. 456: Positioning Of Butylene Tape On Sound Insulation
Courtesy of BMW OF NORTH AMERICA, INC.

Clean specified adhesive area with adhesive cleaner.

Air drying time: 1 minute.

CAUTION: The adhesive areas must be dry and free from dust and grease. After cleaning, do not touch the adhesive areas with bare hands.

Lay single row of 6 mm dia. butylene tape or double row of 3 mm dia. tape in specified adhesive area.

Heat butylene tape (hot air blower) and press down firmly on sound insulation all around.

Contact pressure with hand roller: approx. 30 N/cm^2 .

Manual contact pressure: approx. 10 N/cm^2 .

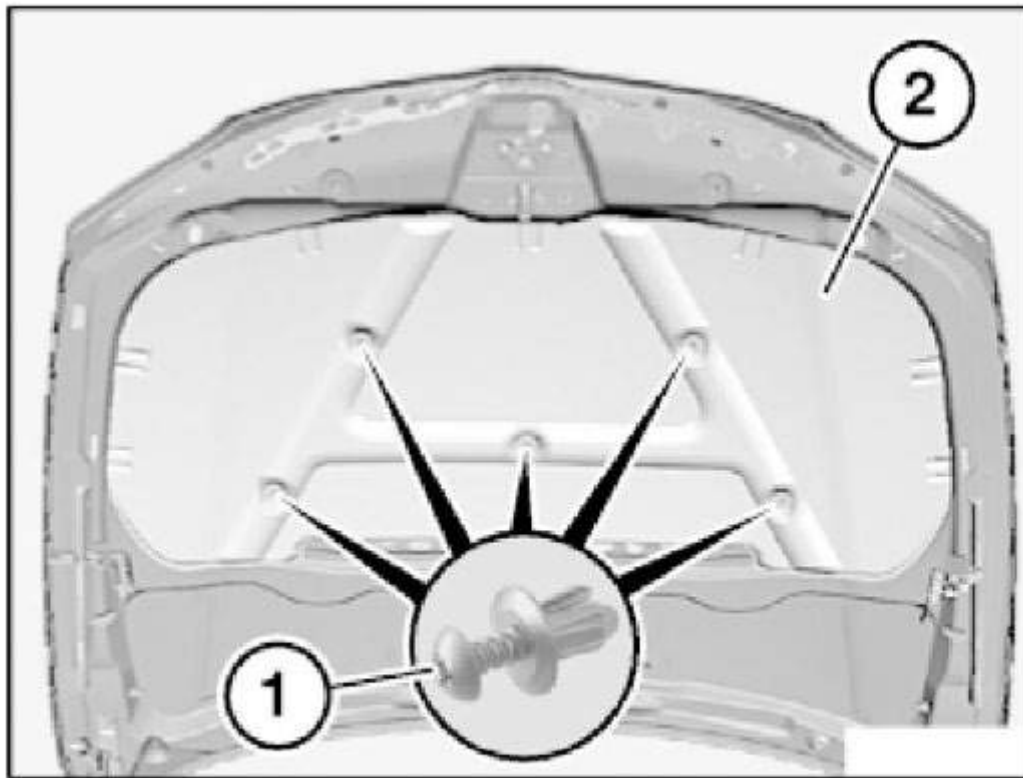
NOTE: Firm thumb pressure has approx. 50 N/cm² .

51 48 001 REMOVING AND INSTALLING/REPLACING INSULATION LINING ON HOOD/BONNET

NOTE: Illustration created using the E87 as an example. There may be differences in detail in the case of other vehicle models.

Release threaded rivets (1) on insulation lining (2).

Remove insulation lining (2).



G03256032

Fig. 457: Releasing Insulation Lining And Threaded Rivets
Courtesy of BMW OF NORTH AMERICA, INC.

REAR LID TRIM PANEL

51 49 050 REMOVING AND INSTALLING/REPLACING LOWER TRIM FOR REAR LID UPPER SECTION

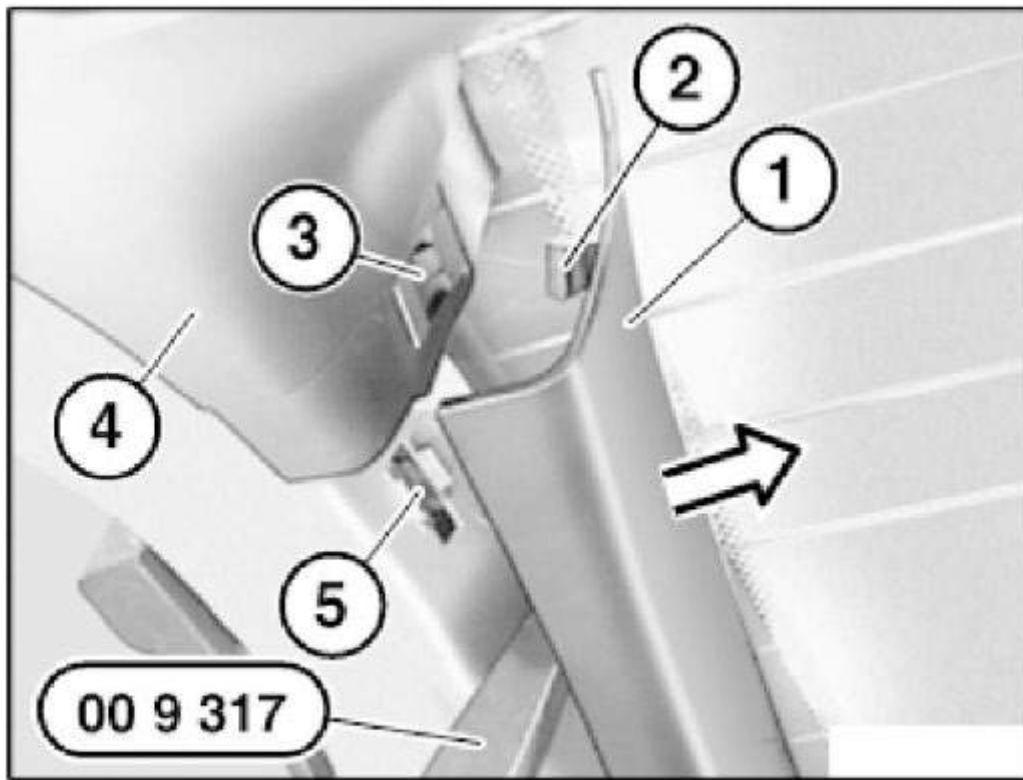
NOTE: For Special Tool identification, see **SPECIAL TOOLS - X5 (3.0i)** .

Special Tools Required:

- 00 9 317

Remove trunk lamps (in rear lid upper section). Refer to **63 31 080 REMOVING AND INSTALLING/REPLACING LUGGAGE COMPARTMENT LIGHT (IN REAR LID, TOP)** .

Using special tool 00 9 317, lever out side trim (1) on left/right with clip (2) from retainer (3) in lower trim (4).



G03256033

Fig. 458: Using Assembly Wedge To Remove Left/Right Side Trim
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

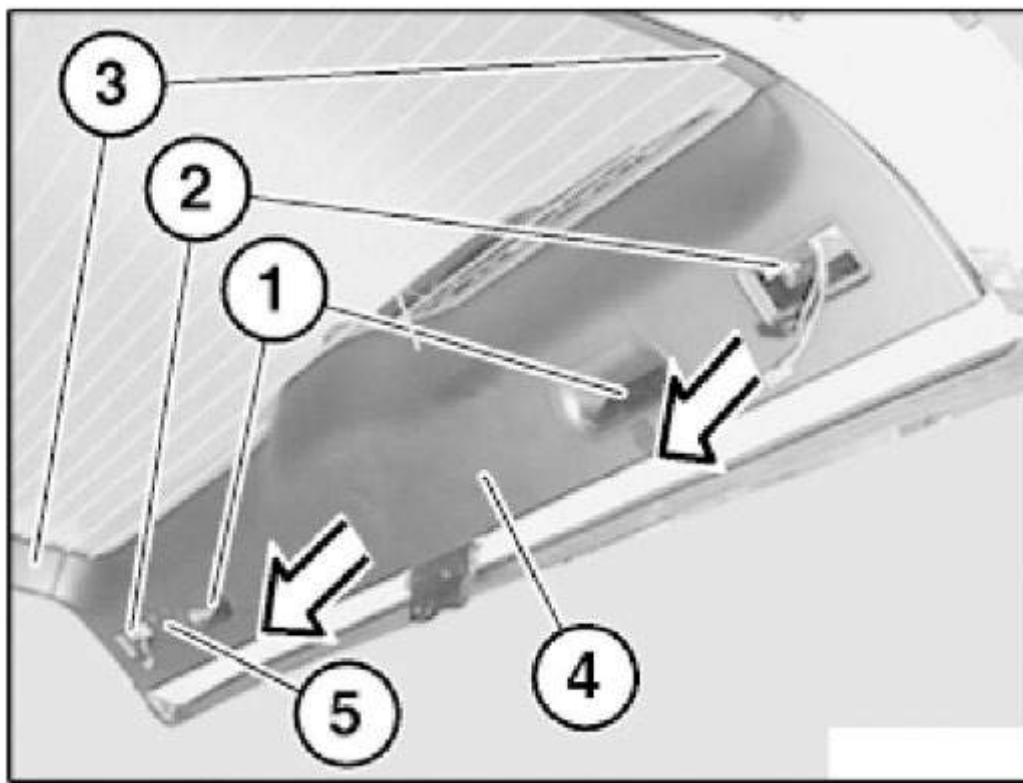
If necessary, replace faulty retainer (5).

Remove protective caps (1) and release screws underneath.

Release screws (2).

Lever out side trims (3) and clip out lower trim (4).

Feed emergency actuator (5) out of trim (4).

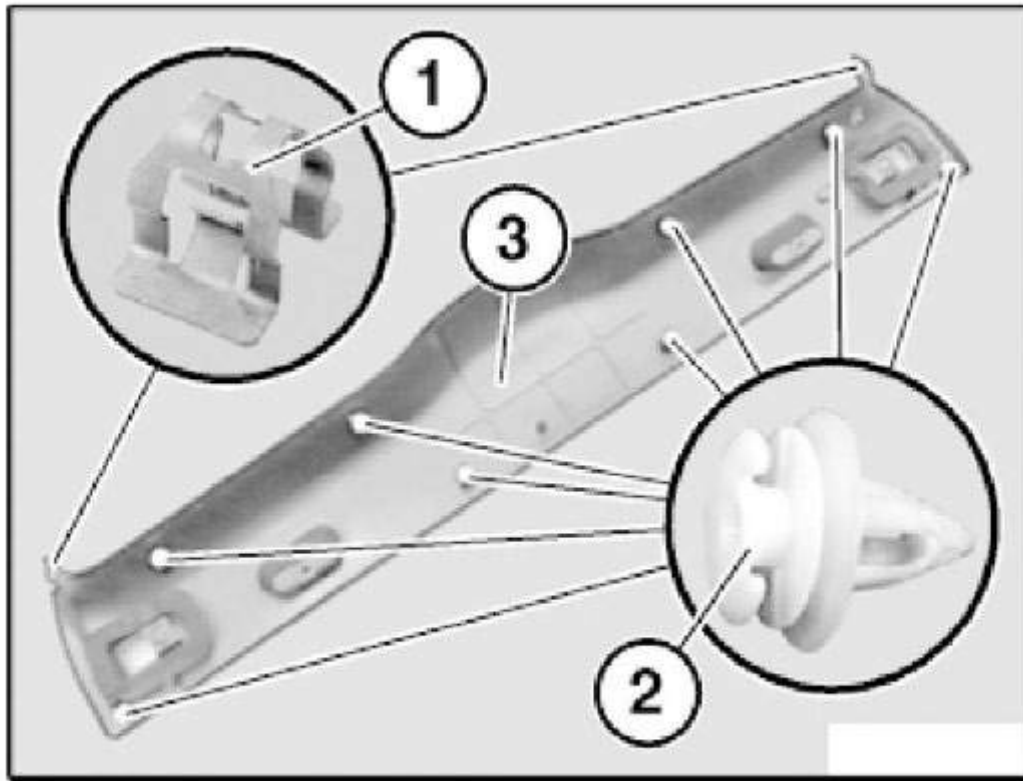


G03256034

Fig. 459: Removing Protective Caps And Releasing Screws Underneath
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

If necessary, replace faulty retainers (1) and clips (2) in trim (3).



G03256035

Fig. 460: Replacing Retainers And Clips In Trim
Courtesy of BMW OF NORTH AMERICA, INC.

51 49 053 REMOVING AND INSTALLING/REPLACING SIDE TRIM FOR REAR LID UPPER SECTION

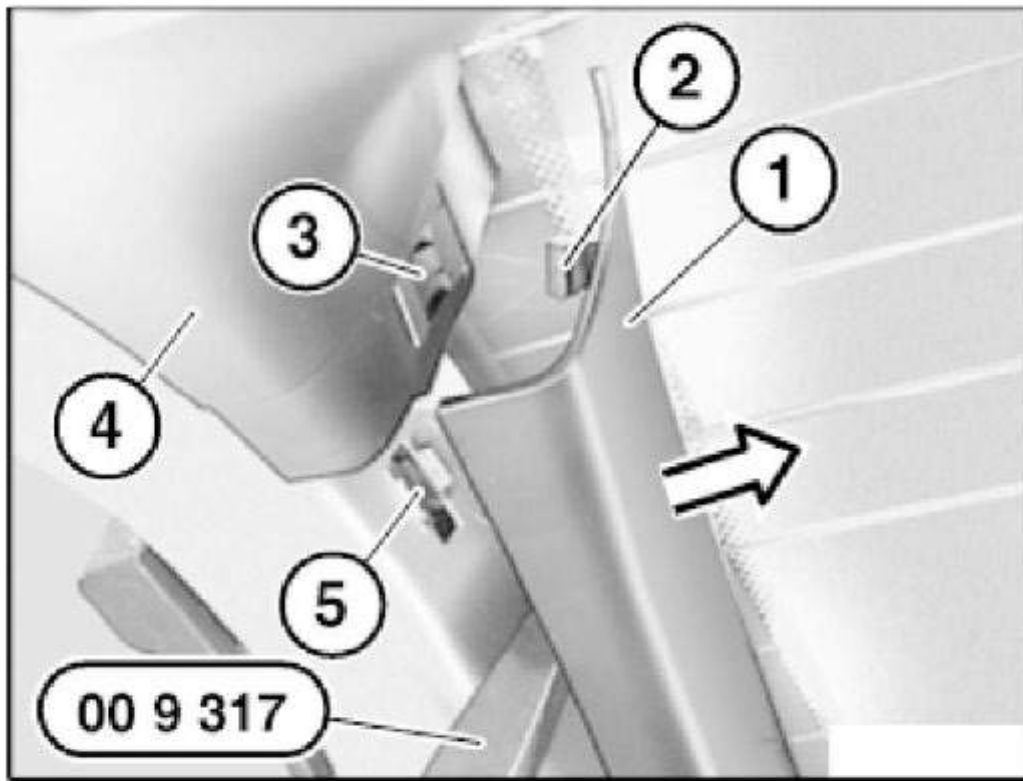
NOTE: For Special Tool identification, see **SPECIAL TOOLS - X5 (3.0i) .**

Special Tools Required:

- 00 9 317

Open rear lid at top.

Using special tool 00 9 317, lever out side trim (1) on left/right with clip (2) from retainer (3) in lower trim (4).



G03256036

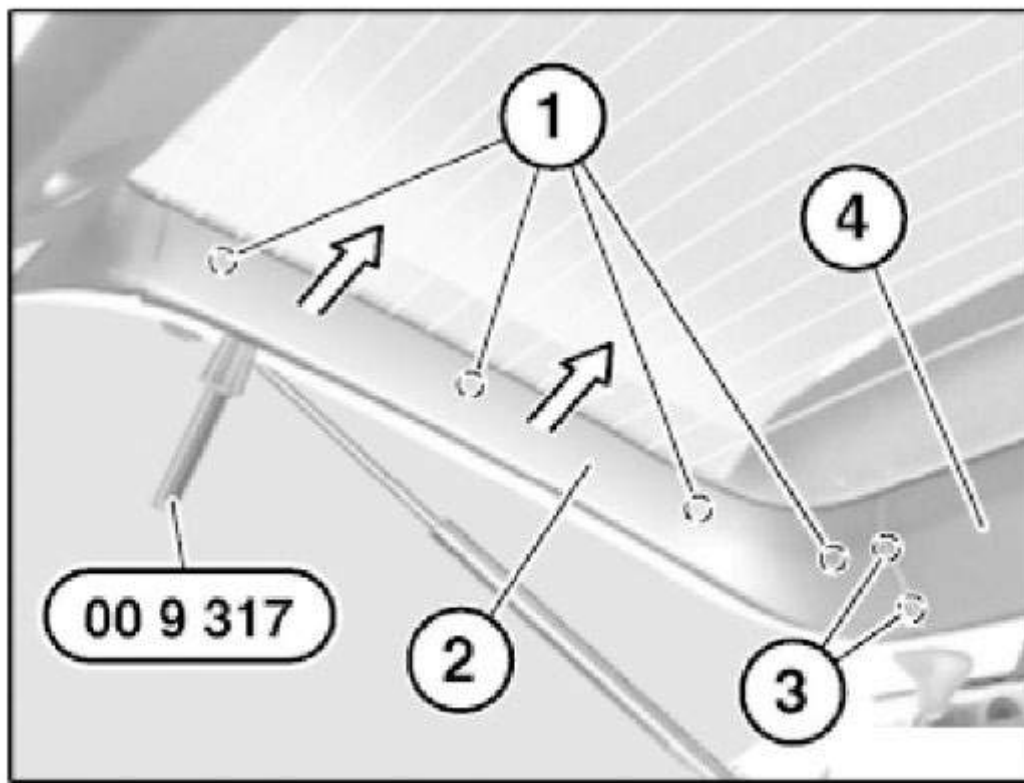
Fig. 461: Using Assembly Wedge To Release Side Trim On Left/Right
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

If necessary, replace faulty retainer (5).

With special tool 00 9 317, unclip clips (1) in side trim (2).

Feed trim (2) out of swallow-tail guides (3) in upper trim (4) and remove.



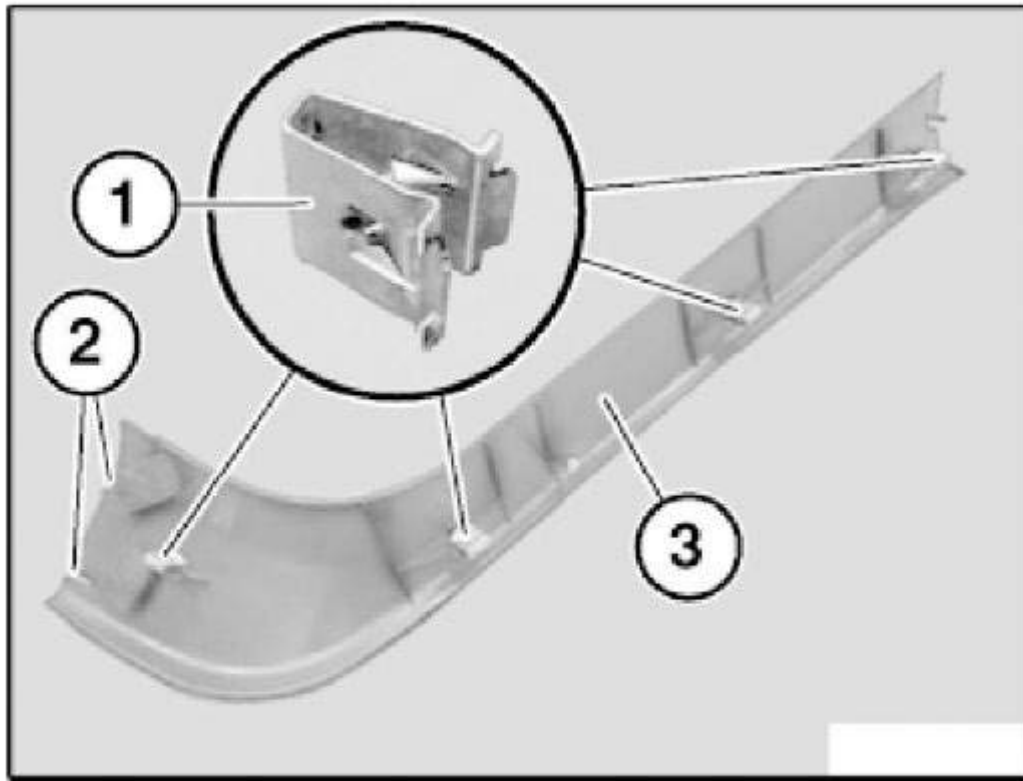
G03256037

Fig. 462: Using Special Tool Remove Clips From Side Trim
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

If necessary, detach clips (1) from trim (3) and insert in rear lid.

Mounts (2) must not be damaged.



G03256038

Fig. 463: Detaching Clips From Trim And Inserting In Rear Lid
Courtesy of BMW OF NORTH AMERICA, INC.

51 49 056 REMOVING AND INSTALLING/REPLACING UPPER TRIM FOR REAR LID UPPER SECTION

NOTE: For Special Tool identification, see **SPECIAL TOOLS - X5 (3.0i) .**

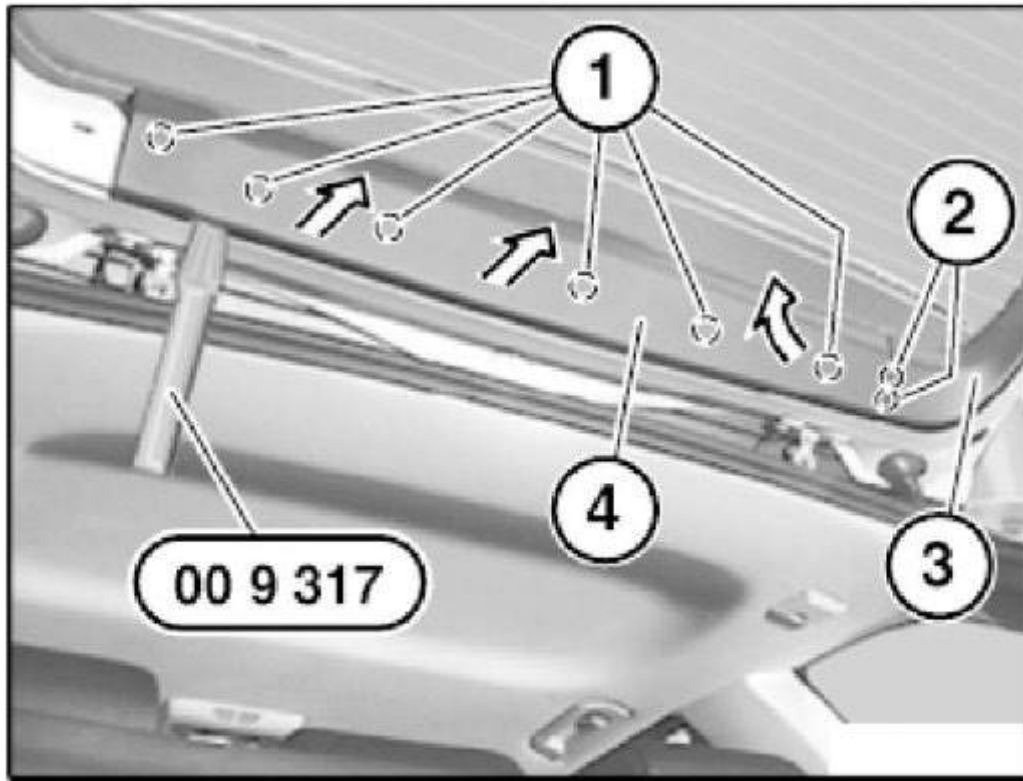
Special Tools Required:

- 00 9 317

Remove side trim for rear lid upper section. Refer to **51 49 053 REMOVING AND INSTALLING/REPLACING SIDE TRIM FOR REAR LID UPPER SECTION .**

With special tool 00 9 317, unclip clips (1) in upper trim (4).

Feed trim (4) with swallow-tail guides (2) out of side trim (3).



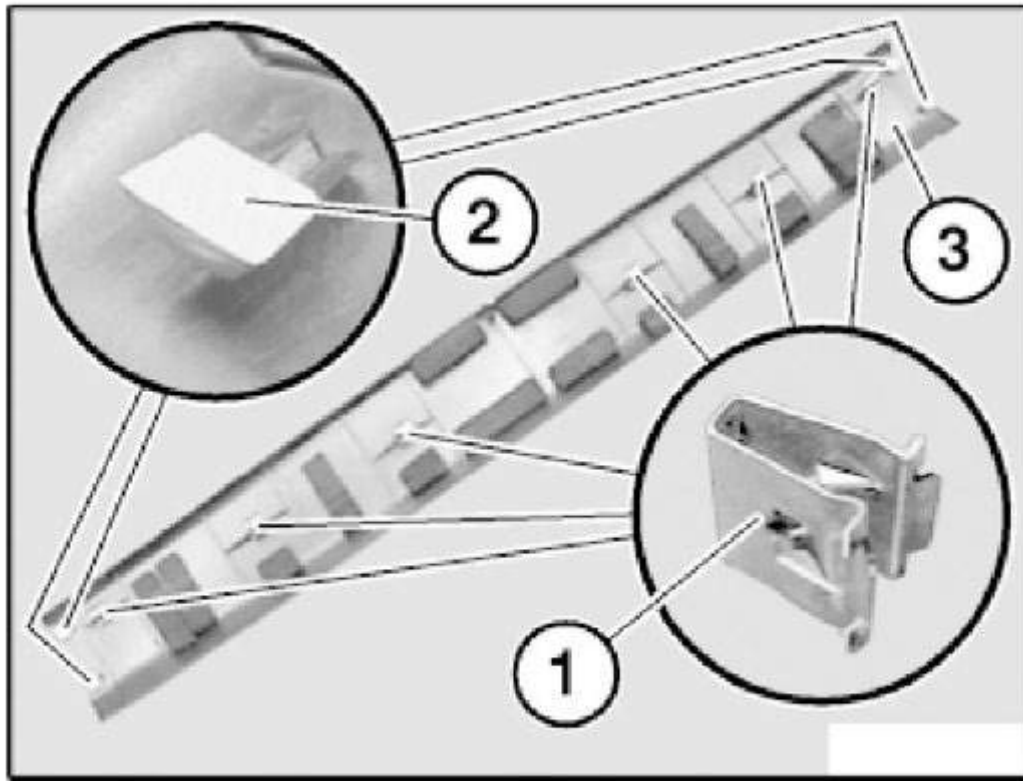
G03256039

Fig. 464: Using Assembly Wedge Release Clips In Upper Trim
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

If necessary, detach clips (1) from trim (3) and insert in rear lid.

Swallow-tail guides (2) must not be damaged.



G03256040

Fig. 465: Detaching Clips From Trim

Courtesy of BMW OF NORTH AMERICA, INC.

51 49 060 REMOVING AND INSTALLING/REPLACING ALL TRIMS FOR REAR LID UPPER SECTION

Operation Is Described In:

Removing both side trims for rear lid upper section. Refer to **51 49 053 REMOVING AND INSTALLING/REPLACING SIDE TRIM FOR REAR LID UPPER SECTION** .

Removing upper trim for rear lid upper section. Refer to **51 49 056 REMOVING AND INSTALLING/REPLACING UPPER TRIM FOR REAR LID UPPER SECTION** .

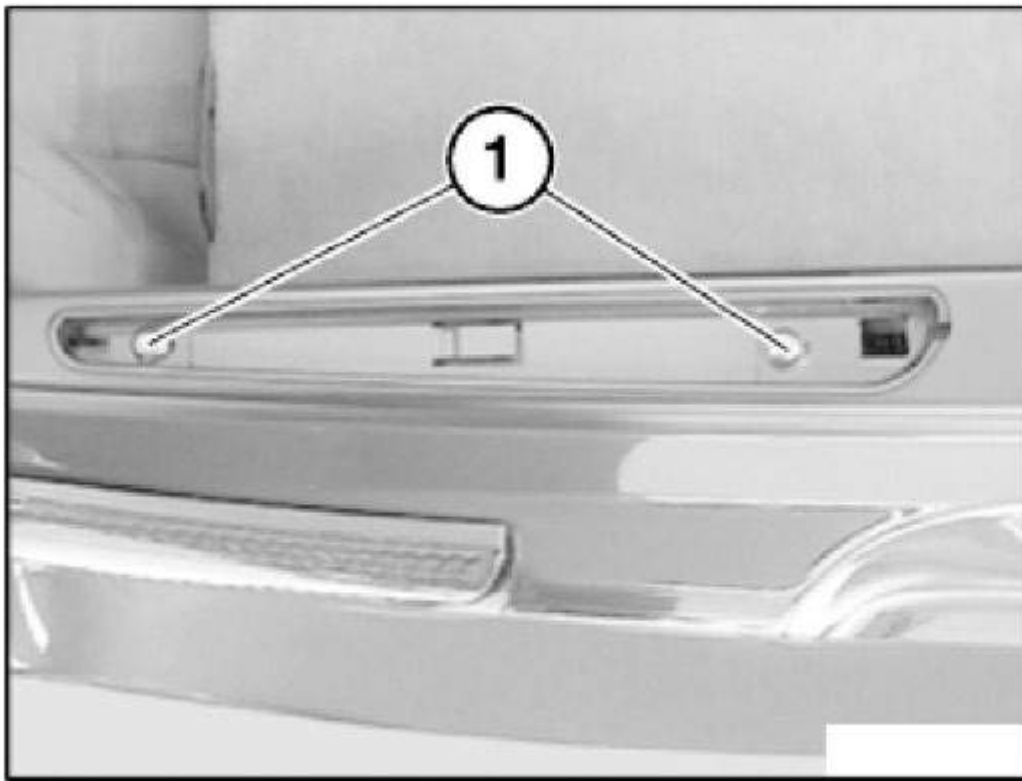
Removing lower trim for rear lid upper section. Refer to **51 49 050 REMOVING AND INSTALLING/REPLACING LOWER TRIM FOR REAR LID UPPER SECTION** .

51 49 080 REMOVING AND INSTALLING/REPLACING COVER FOR LOADING SILL (ON REAR

LID LOWER SECTION)

Remove rear reflector (in rear lid lower section). Refer to **63 14 120 REMOVING AND INSTALLING/REPLACING REAR REFLECTOR (ON REAR LID LOWER SECTION)** .

Release left/right screws (1).

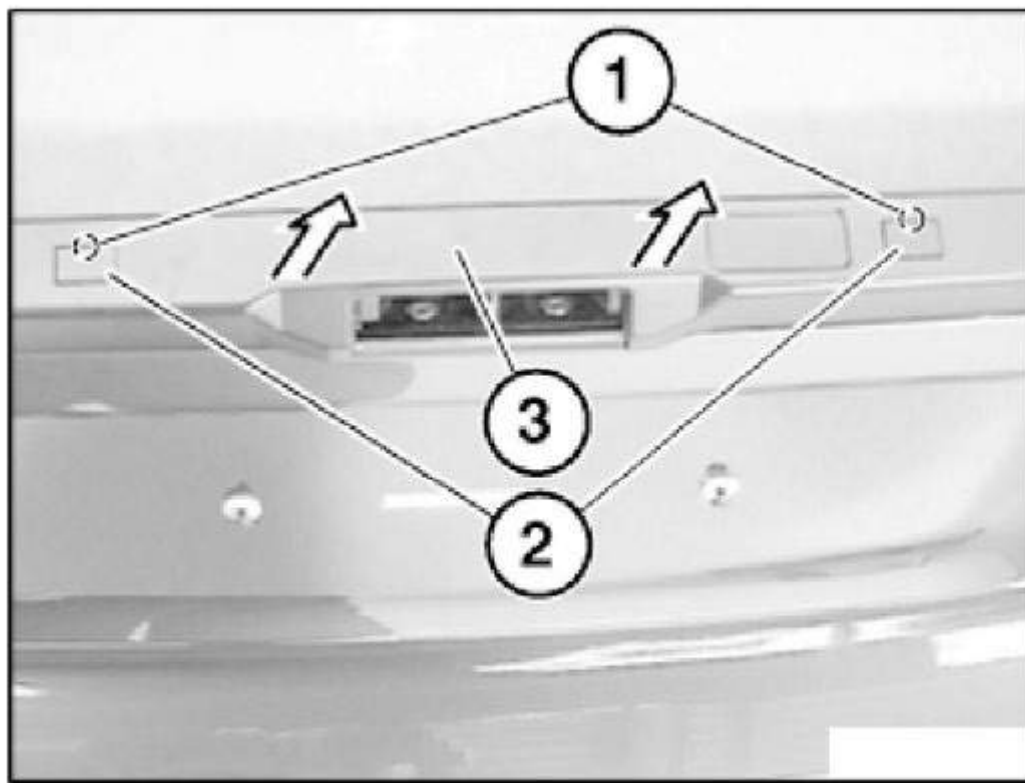


G03256041

Fig. 466: Releasing Left/Right Screws
Courtesy of BMW OF NORTH AMERICA, INC.

Using a small screwdriver, lever out covers (2) by means of chamfers (1) and release screw underneath.

Pull off cover (3) for loading sill.

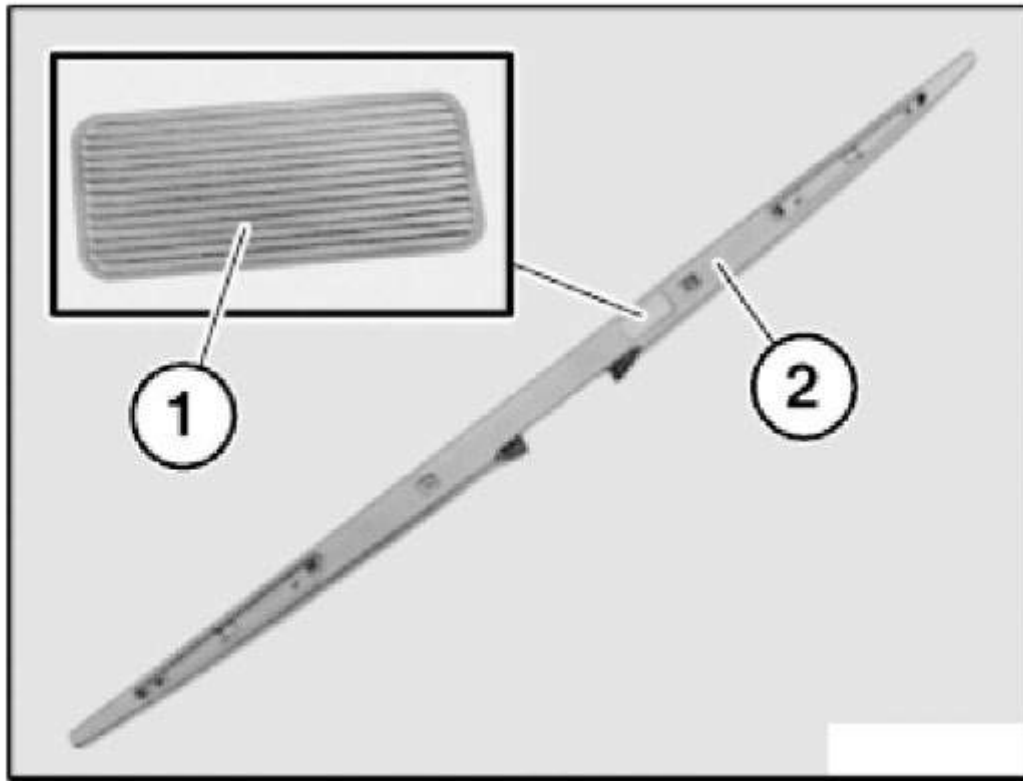


G03256042

Fig. 467: Levering Out Covers Using Screwdriver
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

If necessary, replace faulty cover (1) for button on cover (2) for loading sill.



G03256043

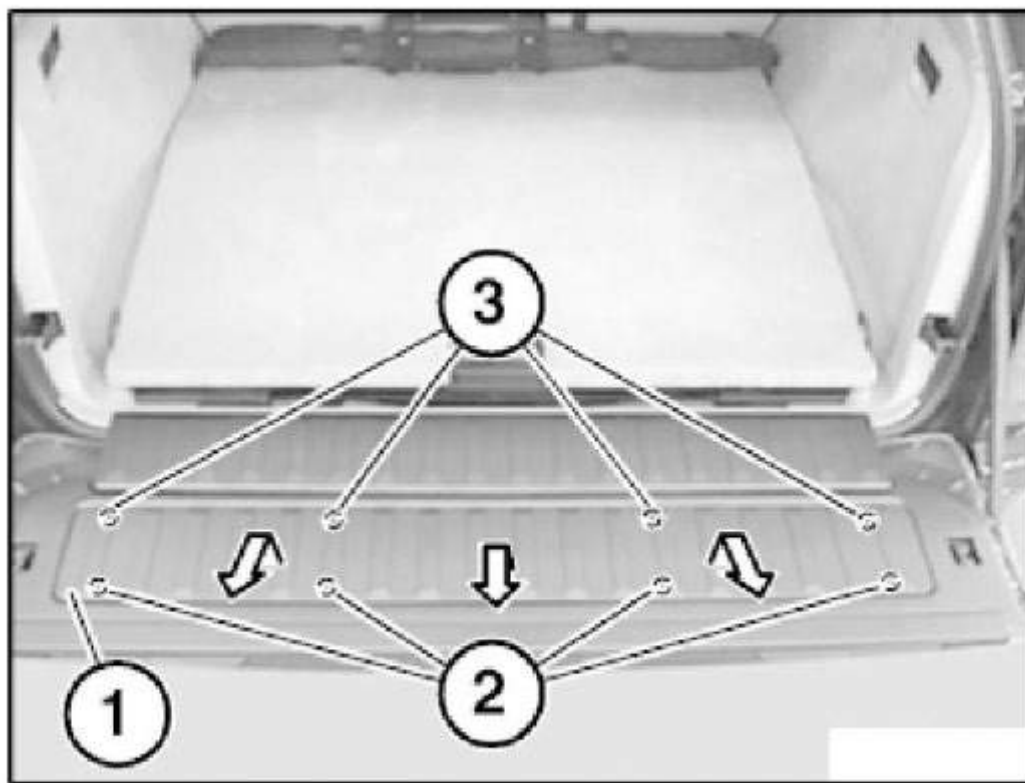
Fig. 468: Replacing Faulty Cover

Courtesy of BMW OF NORTH AMERICA, INC.

51 49 085 REMOVING AND INSTALLING/REPLACING INSERT FOR TRIM ON REAR LID LOWER SECTION

Open rear lid lower section.

Lever rear insert (1) upwards out of retainers (2) and pull towards rear out of guides (3).

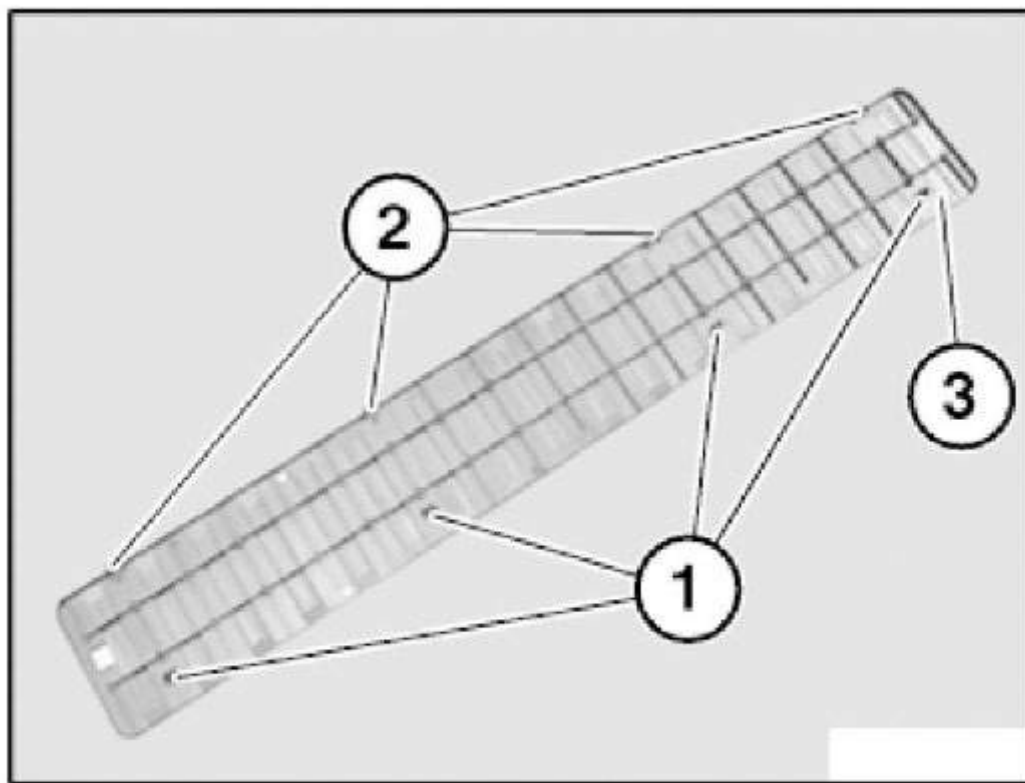


G03256044

Fig. 469: Levering Rear Insert Upwards Out Of Retainers
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Mounts (1) and guides (2) on insert (3) must not be damaged.

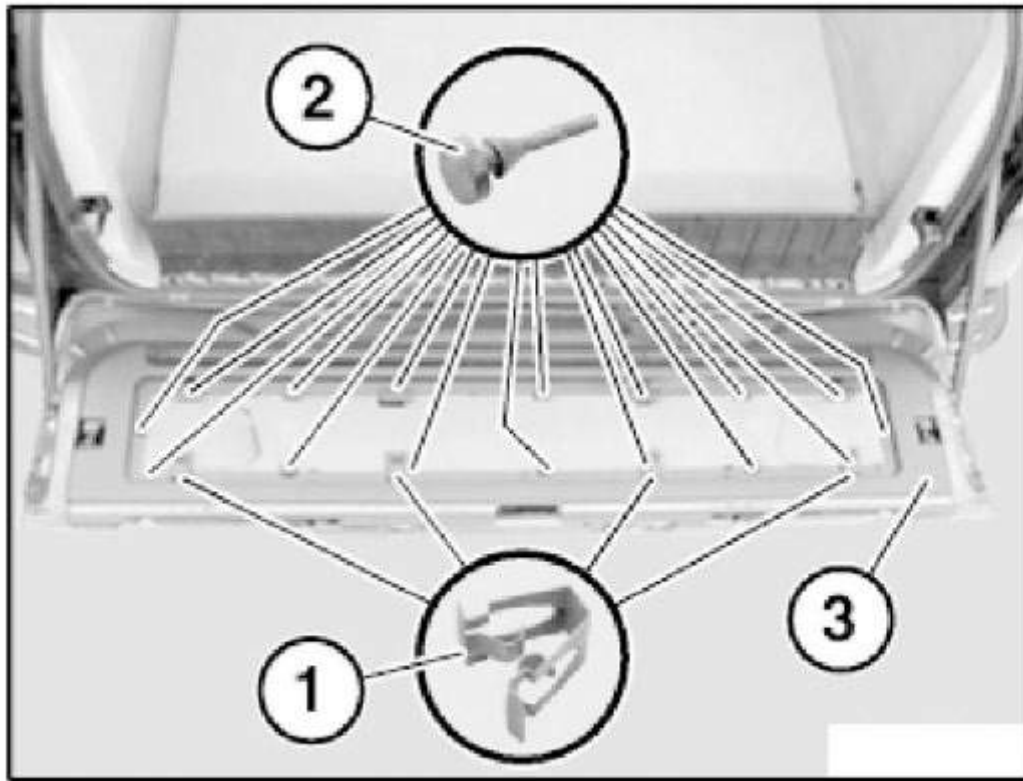


G03256045

Fig. 470: Checking Mounts And Guides
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

If necessary, replace faulty retainers (1) and rubber parts (2) on rear lid lower section (3).



G03256046

Fig. 471: Identifying Retainers And Rubber Parts
Courtesy of BMW OF NORTH AMERICA, INC.

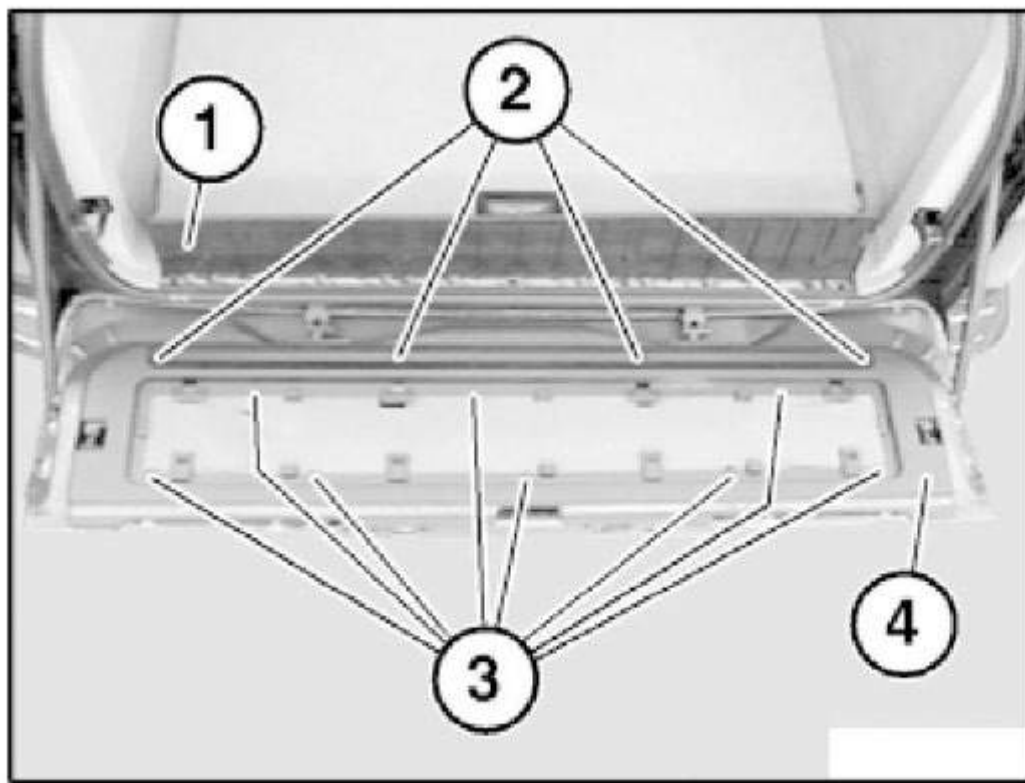
51 49 090 REMOVING AND INSTALLING/REPLACING TRIM FOR REAR LID LOWER SECTION

Remove cover for loading sill. Refer to **51 49 080 REMOVING AND INSTALLING/REPLACING COVER FOR LOADING SILL (ON REAR LID LOWER SECTION)** .

Remove insert for trim on rear lid lower section. Refer to **51 49 085 REMOVING AND INSTALLING/REPLACING INSERT FOR TRIM ON REAR LID LOWER SECTION** .

Raise cover (1) and release screws (2).

Release screws (3) and remove trim (4).

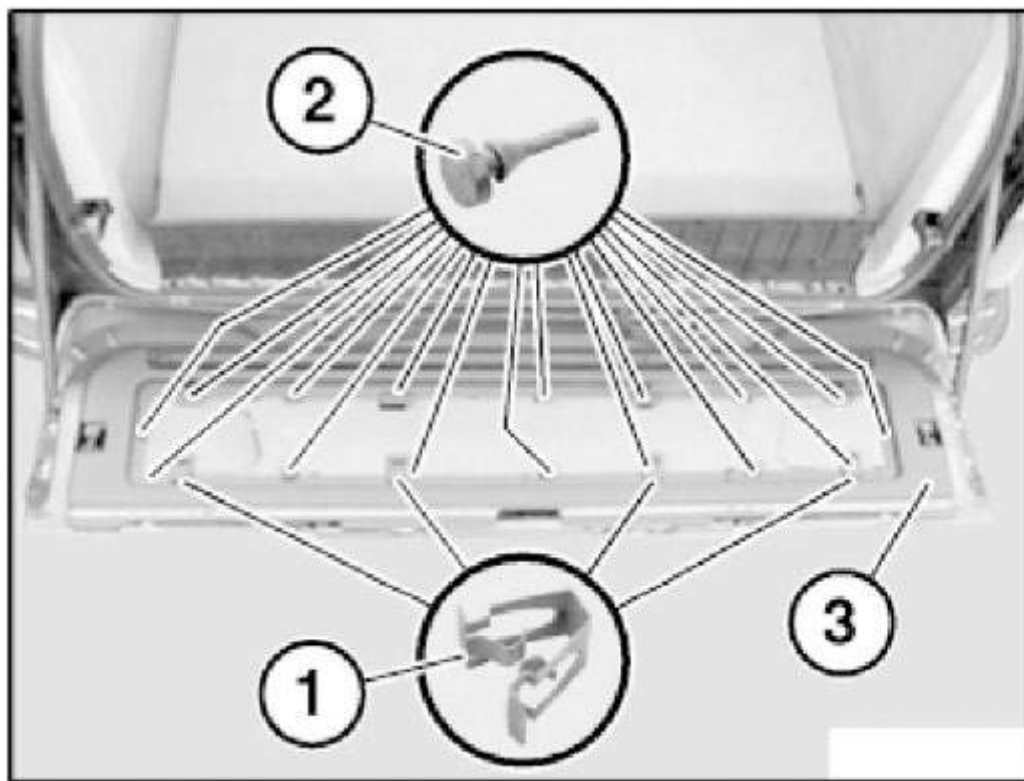


G03256047

Fig. 472: Raising Cover And Releasing Screws
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

If necessary, replace faulty retainers (1) and rubber parts (2) on rear lid lower section (3).

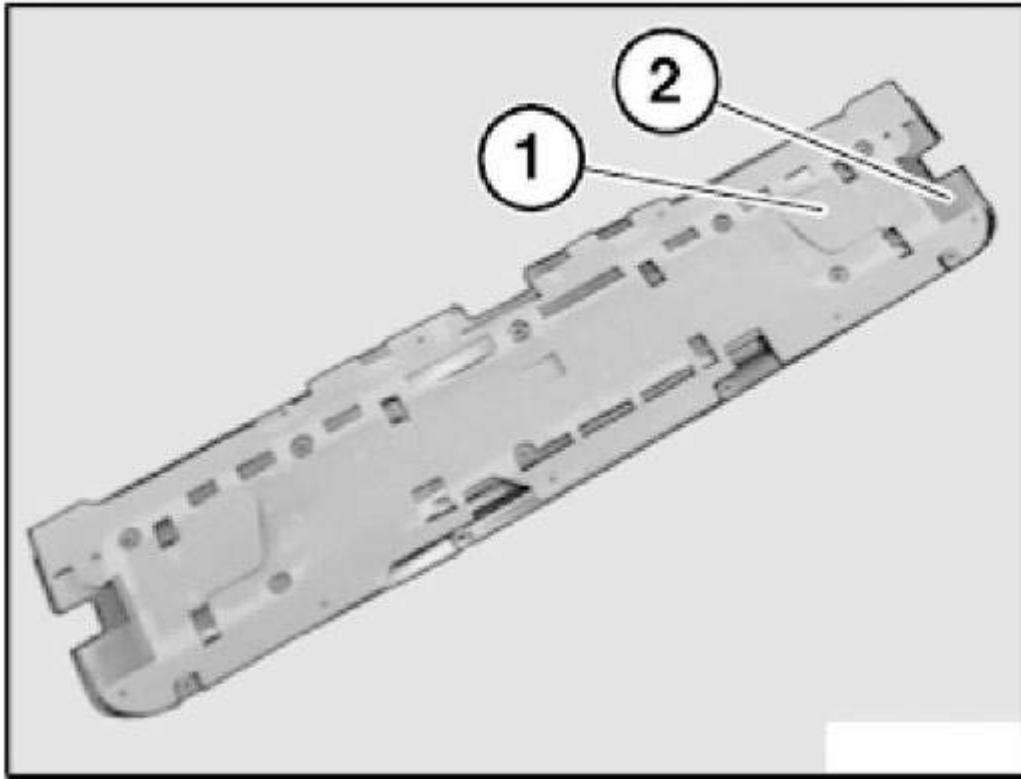


G03256048

Fig. 473: Identifying Retainers And Rubber Parts
Courtesy of BMW OF NORTH AMERICA, INC.

Replacement Only:

Remove insulating mat (1) from old trim (2) and insert in new trim.



G03256049

Fig. 474: Removing Insulating Mat
Courtesy of BMW OF NORTH AMERICA, INC.

LOOSE BODY PARTS

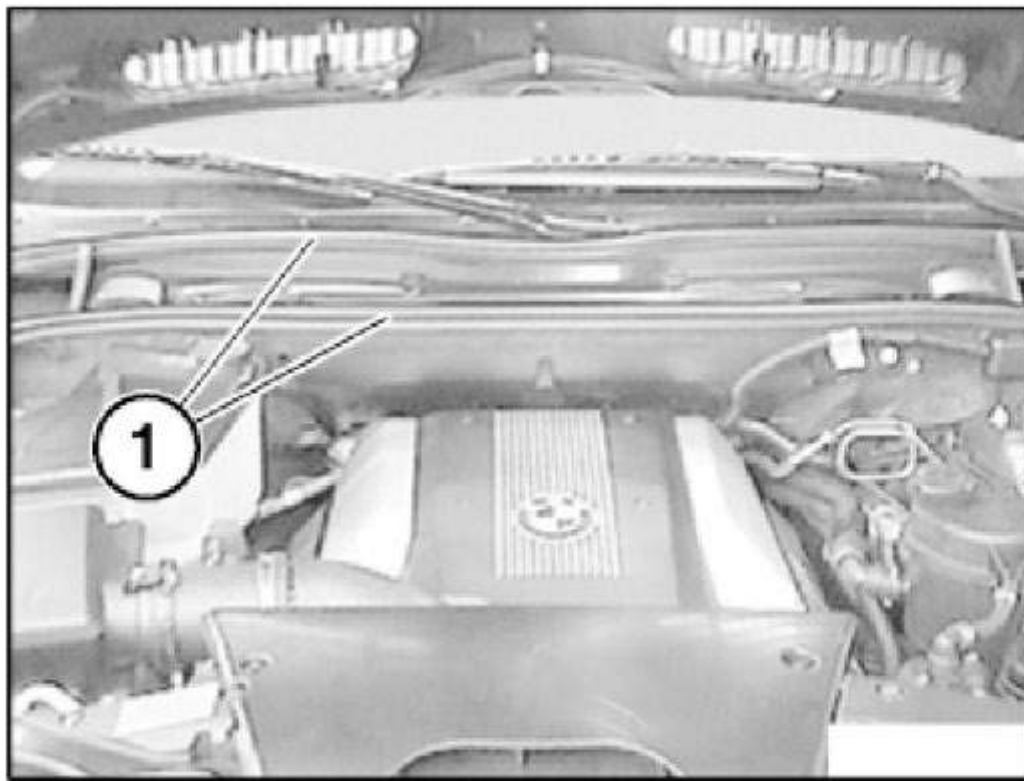
51 13 115 REMOVING AND INSTALLING/REPLACING COWL PANEL COVER

Remove both windshield wiper arms. Refer to **61 61 100 REMOVING AND INSTALLING/REPLACING BOTH WINDSHIELD WIPER ARMS** .

Detach seals (1).

2001 BMW X5 30i

2001-2003 ACCESSORIES AND EQUIPMENT Exterior/Interior Trim - Repair Instructions - X5 (3.0i) E53



G03256050

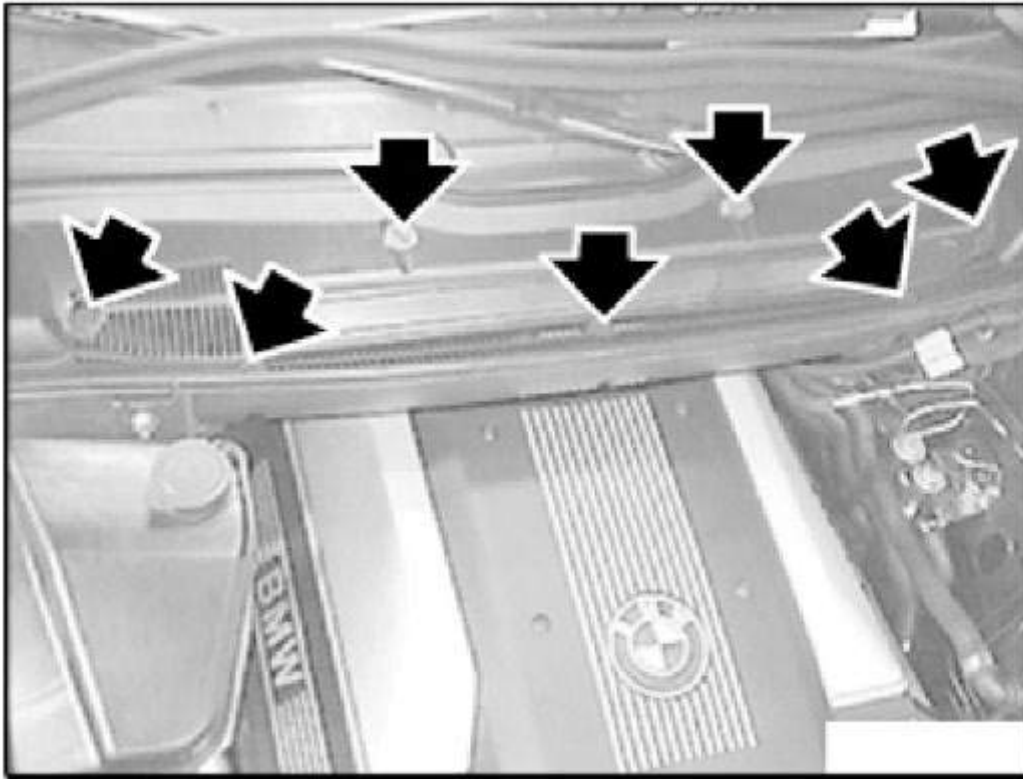
Fig. 475: Detaching Seals

Courtesy of BMW OF NORTH AMERICA, INC.

Turn tommy bar through 90° and lift off cover.

2001 BMW X5 30i

2001-2003 ACCESSORIES AND EQUIPMENT Exterior/Interior Trim - Repair Instructions - X5 (3.0i) E53



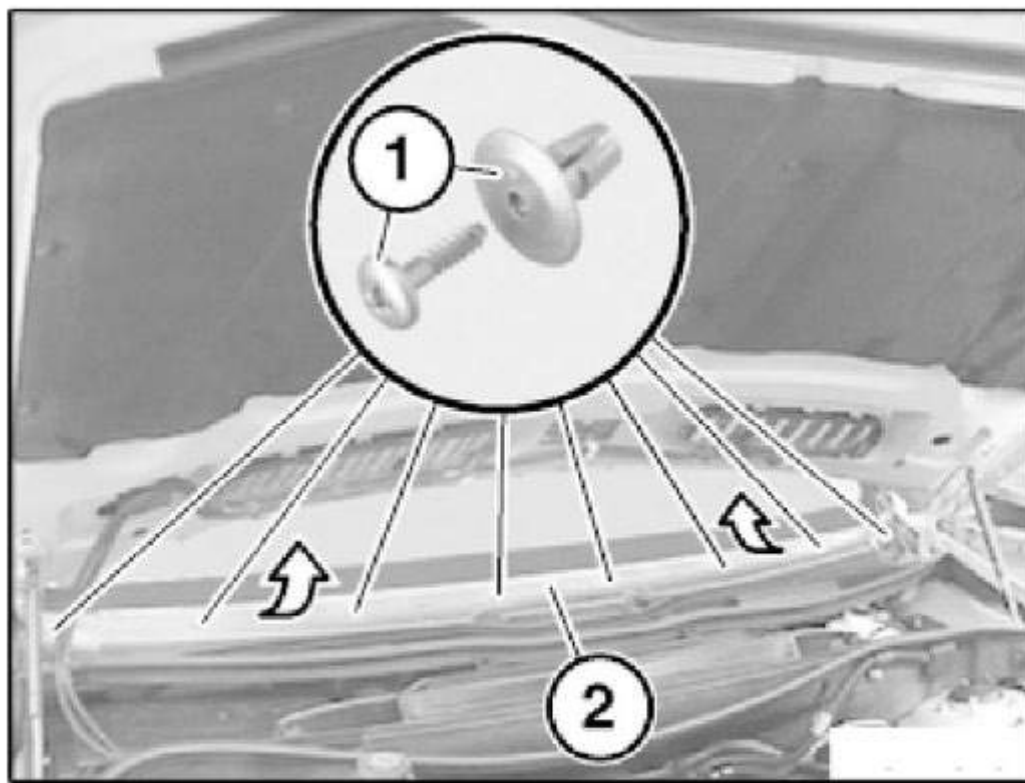
G03256051

Fig. 476: Lifting Off Cover

Courtesy of BMW OF NORTH AMERICA, INC.

Release expansion rivets (1).

Remove cover (2) for cowl panel.

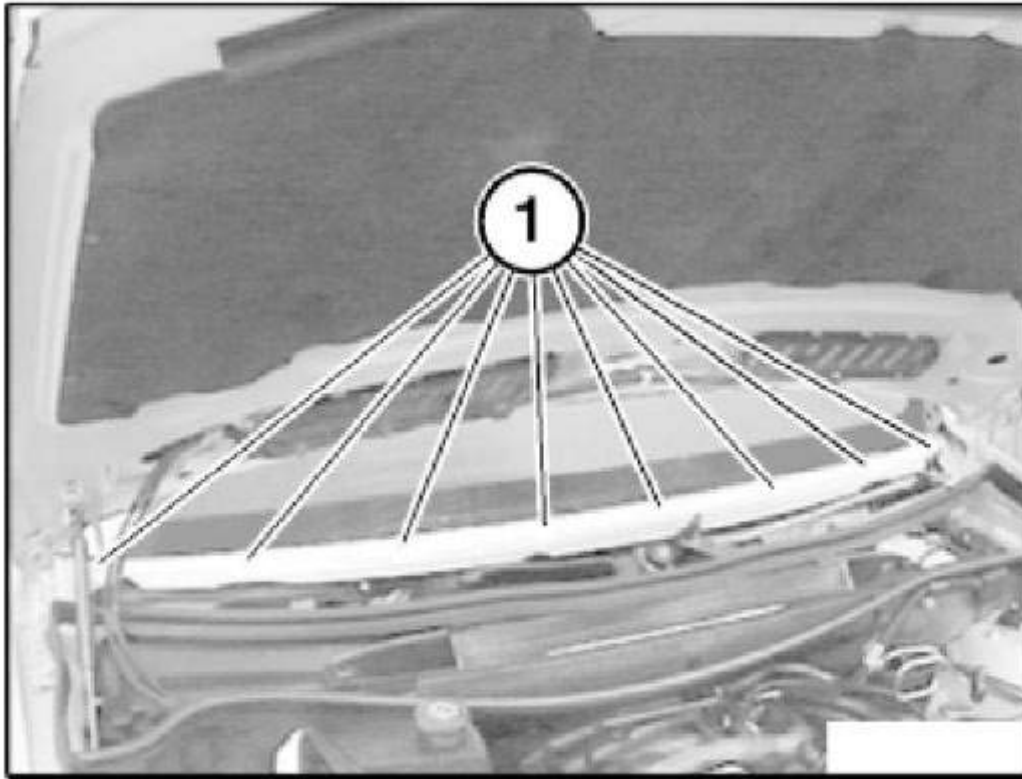


G03256052

Fig. 477: Identifying Expansion Rivets
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

If necessary, replace defective grommets (1).



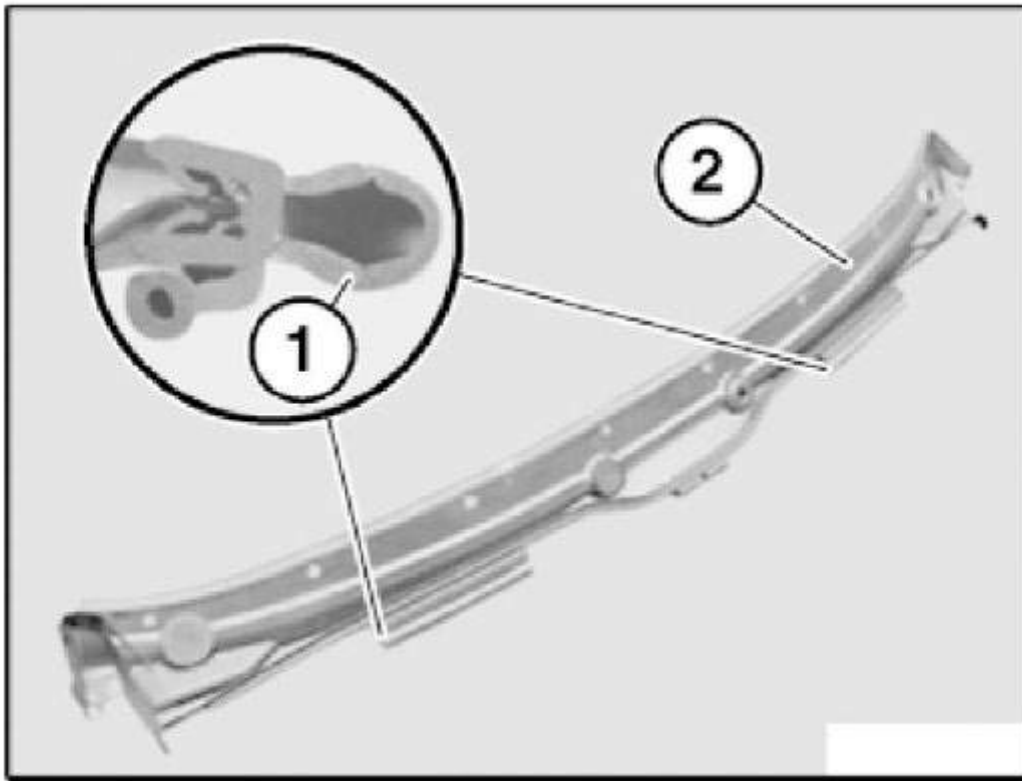
G03256053

Fig. 478: Locating Grommets

Courtesy of BMW OF NORTH AMERICA, INC.

Only Replacement:

If necessary, detach seals (1) from cover (2).



G03256054

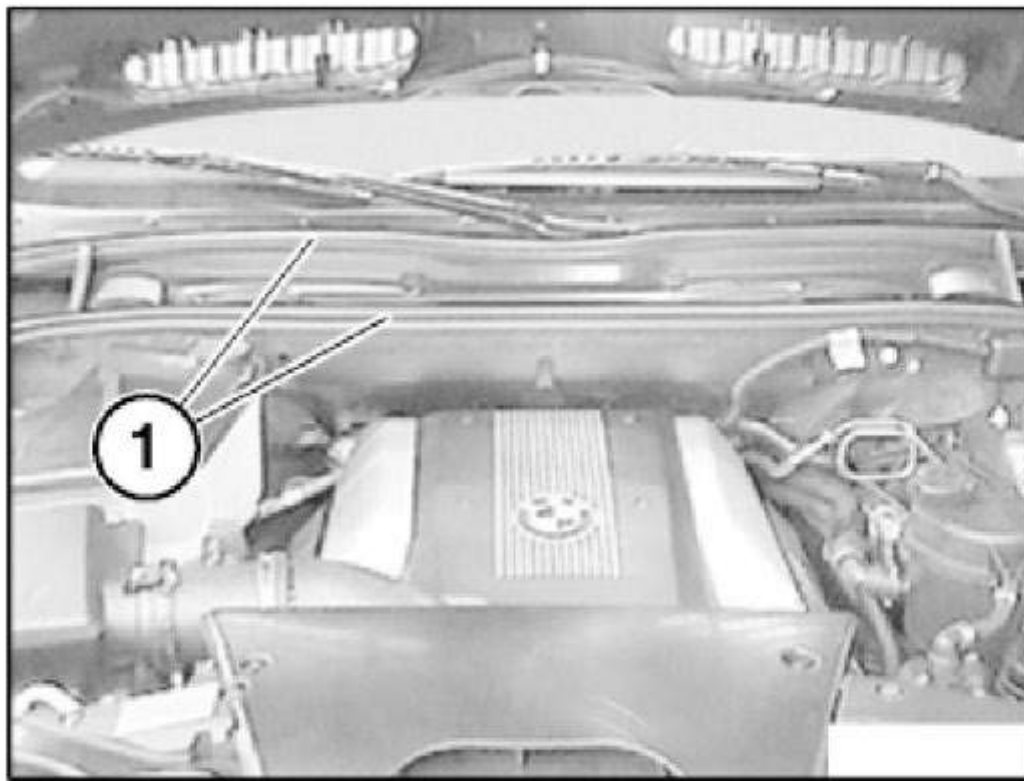
Fig. 479: Detaching Seals From Cover
Courtesy of BMW OF NORTH AMERICA, INC.

51 71 080 REMOVING AND INSTALLING/REPLACING HEATER BULKHEAD

Detach sealing strips (1).

2001 BMW X5 30i

2001-2003 ACCESSORIES AND EQUIPMENT Exterior/Interior Trim - Repair Instructions - X5 (3.0i) E53



G03256055

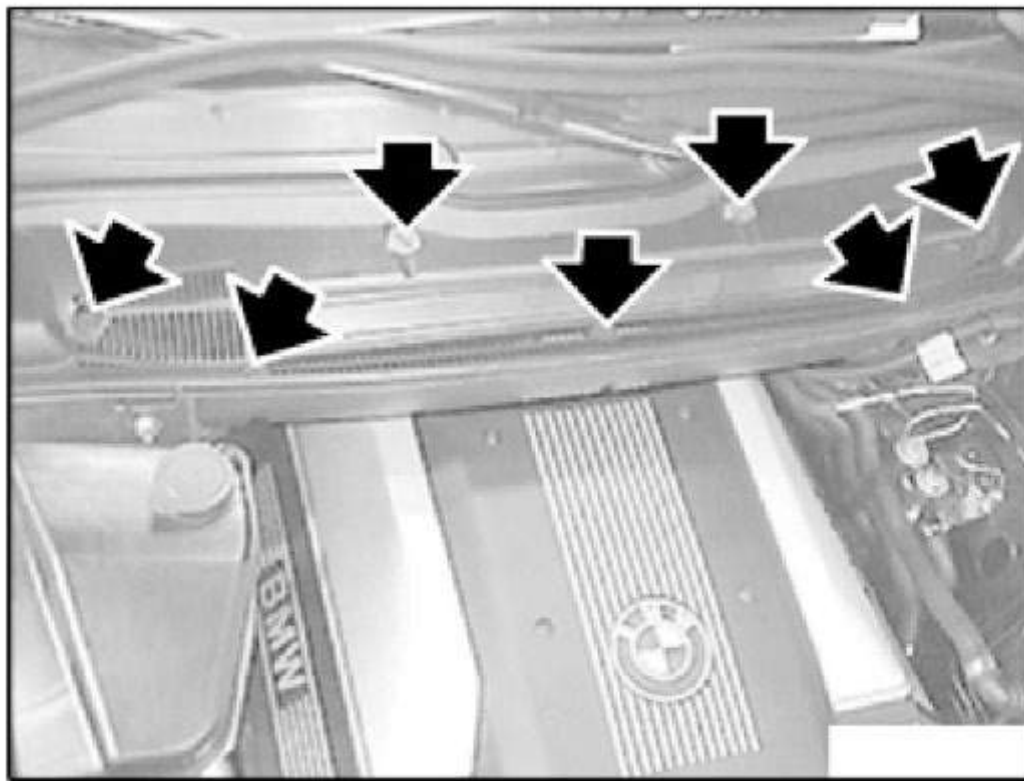
Fig. 480: Detaching Sealing Strips

Courtesy of BMW OF NORTH AMERICA, INC.

Turn toggles through approx. 90°.

2001 BMW X5 30i

2001-2003 ACCESSORIES AND EQUIPMENT Exterior/Interior Trim - Repair Instructions - X5 (3.0i) E53



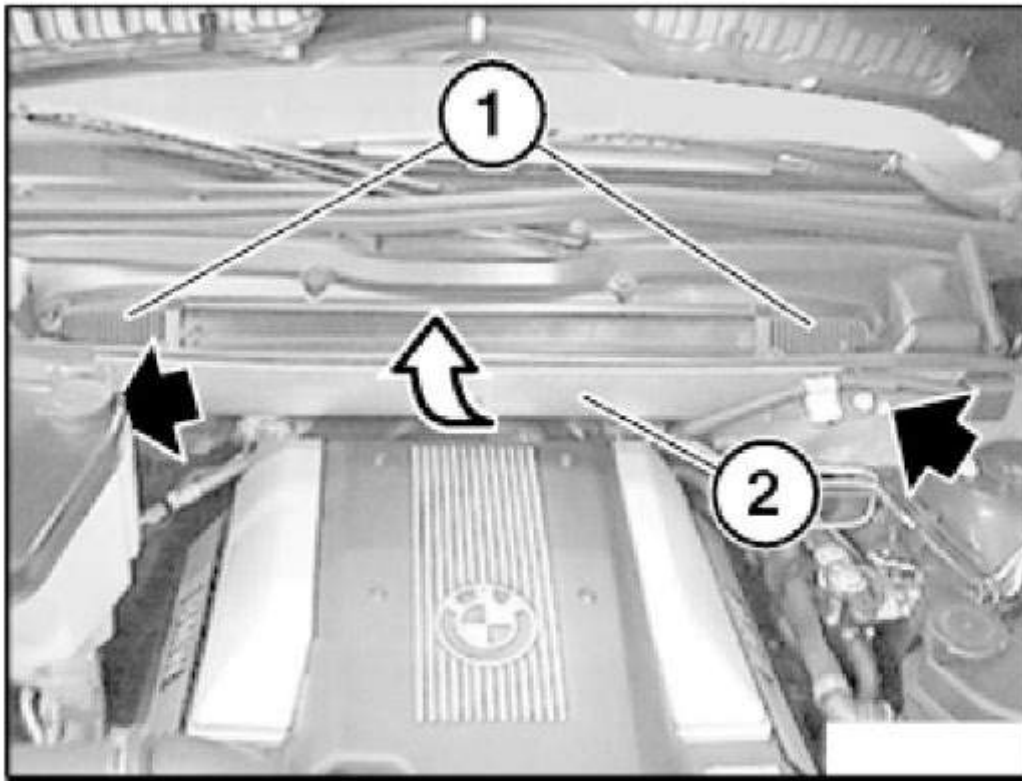
G03256056

Fig. 481: Turning Toggles Through Approx. 90°
Courtesy of BMW OF NORTH AMERICA, INC.

Lift out cover (1).

Unfasten screws.

Pull out heater bulkhead (2).



G03256057

Fig. 482: Pulling Out Heater Bulkhead
Courtesy of BMW OF NORTH AMERICA, INC.

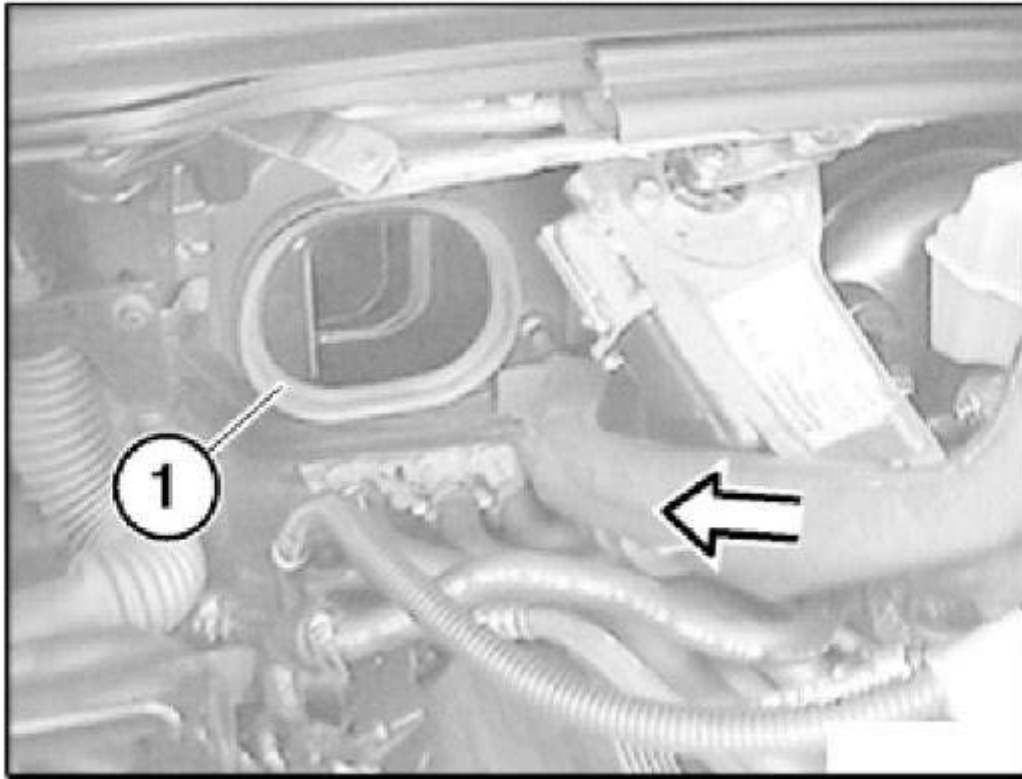
Installation:

Check rubber seals (1) on left and right and replace if necessary.

Coat rubber seals (1) on left and right with rubber protection coating agent.

Heater bulkhead is guided at sides via guide channels.

Clean guide channels and coat with rubber protection coating agent.



G03256058

Fig. 483: Checking Rubber Seals

Courtesy of BMW OF NORTH AMERICA, INC.

51 71 378 REMOVING AND INSTALLING/REPLACING UNDERRIDE PROTECTION

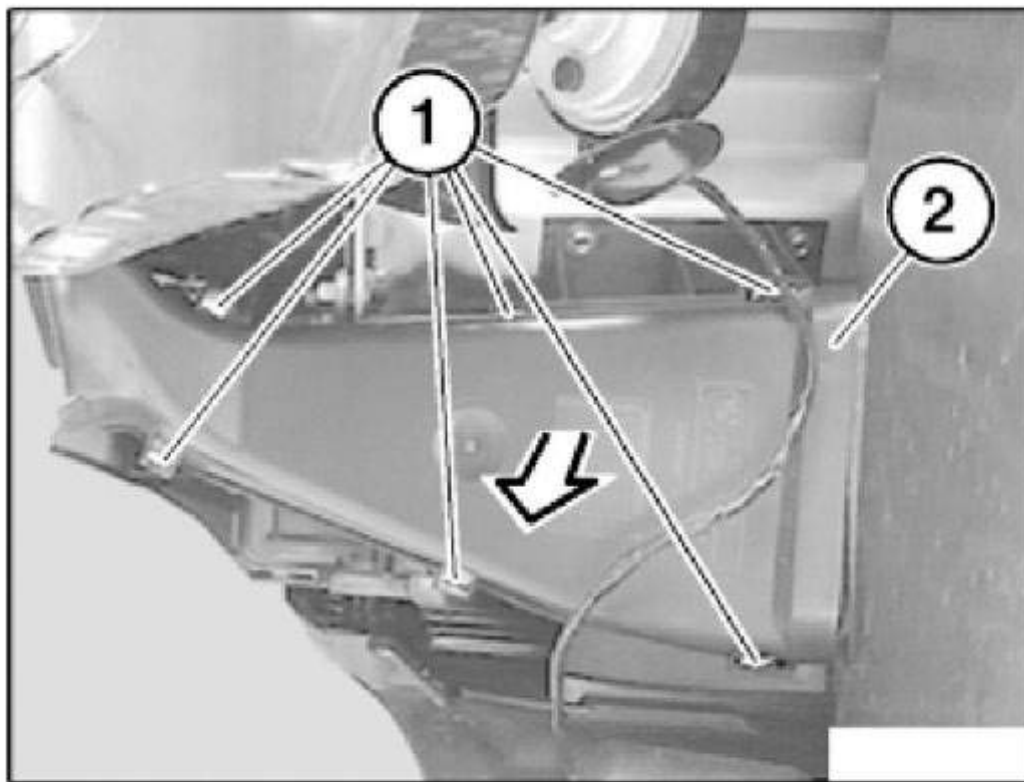
Necessary Preliminary Tasks:

- Remove front bumper trim. Refer to **51 11 156 REMOVING AND INSTALLING FRONT BUMPER TRIM (FROM 10/03)** or **51 11 156 REMOVING AND INSTALLING FRONT BUMPER TRIM (UP TO 10/03)** .
- Remove front underbody protection. Refer to **51 47 490 REMOVING AND INSTALLING/REPLACING FRONT ASSEMBLY UNDERSIDE PROTECTION** .

NOTE: The operation is described on the left side; proceed in the same way for the right side.

Version Up To 10/03:

Lever out catches (1) and detach brake air duct (2).

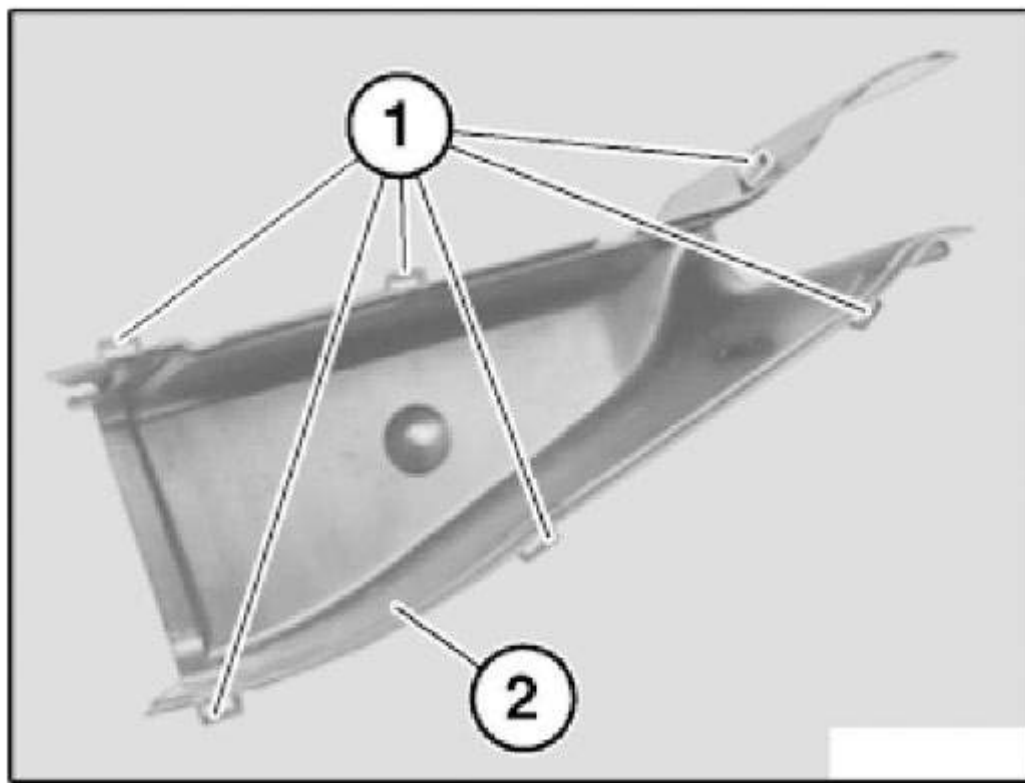


G03256059

Fig. 484: Levering Out Catches And Detaching Brake Air Duct
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Fixtures (1) on brake air duct (2) must not be damaged.



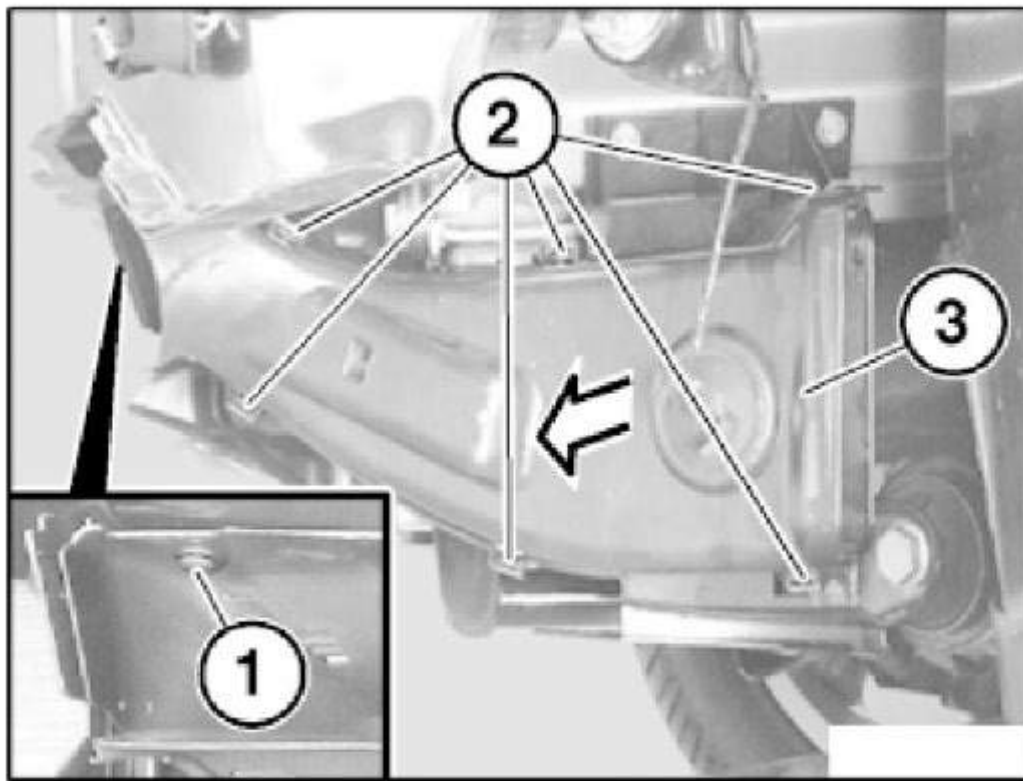
G03256060

Fig. 485: Identifying Fixtures On Brake Air Duct
Courtesy of BMW OF NORTH AMERICA, INC.

Build Date From 10/03:

Release expansion rivet (1).

Lever out catches (2) and detach brake air duct (3).



G03256061

Fig. 486: Levering Out Catches And Detaching Brake Air Duct
Courtesy of BMW OF NORTH AMERICA, INC.

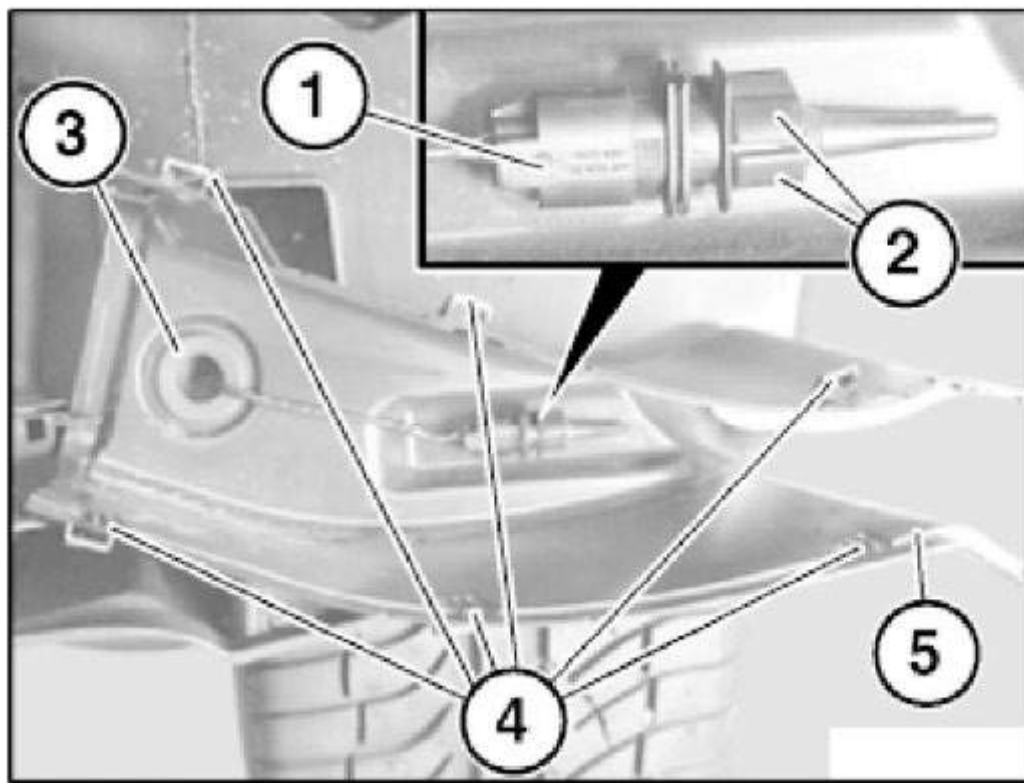
Installation:

Fixtures (4) on brake air duct (5) must not be damaged.

Left only:

Lever temperature sensor (1) out of fixture (2).

Pull temperature sensor (1) with cable grommet (3) out of brake air duct (5).



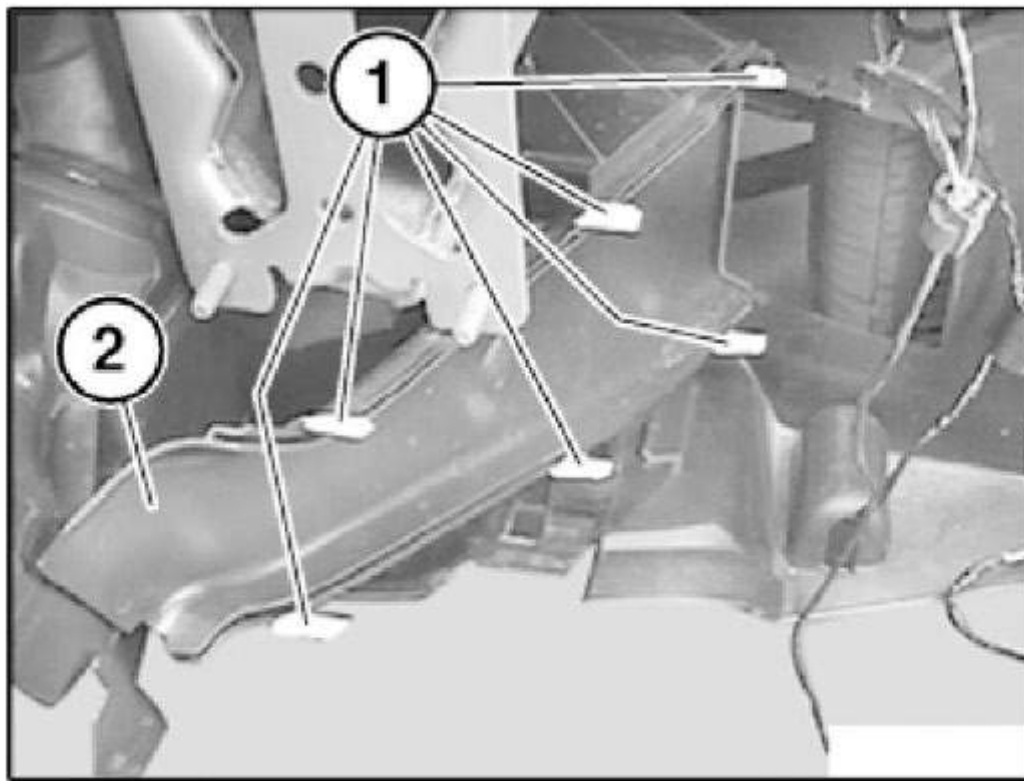
G03256062

Fig. 487: Identifying Temperature Sensor
Courtesy of BMW OF NORTH AMERICA, INC.

All Build Versions:

Installation:

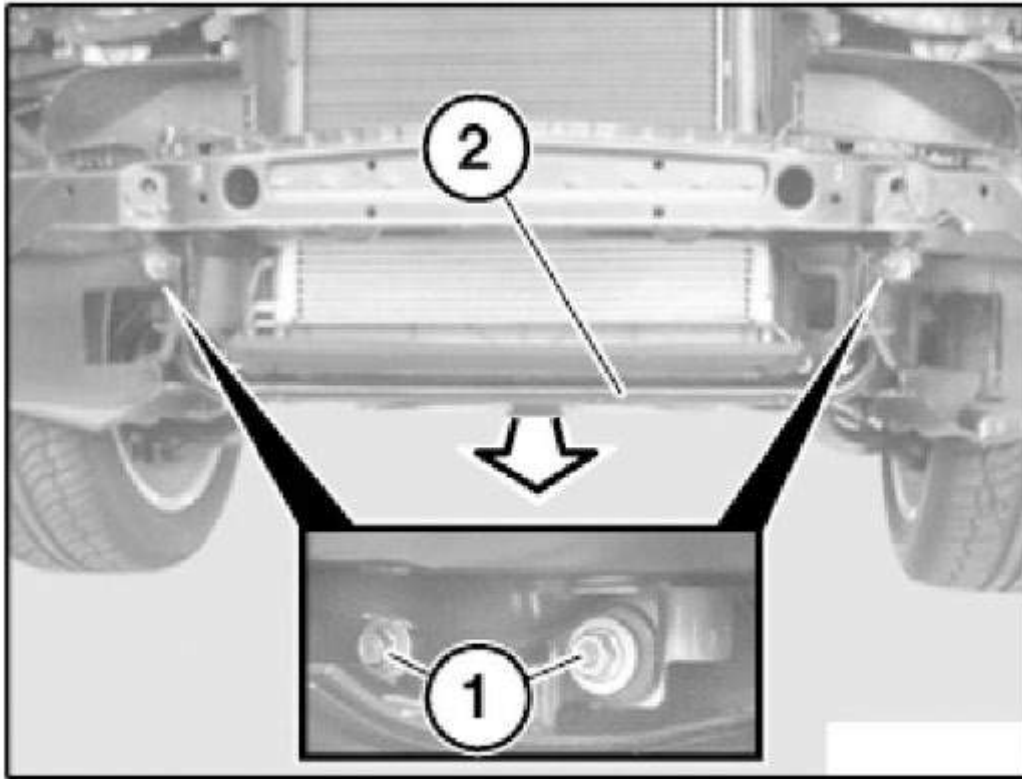
Catches (1) on brake air duct (2) must not be damaged.



G03256063

Fig. 488: Installing Brake Air Duct
Courtesy of BMW OF NORTH AMERICA, INC.

Release nuts (1) and remove underride protection (2) in direction of arrow.

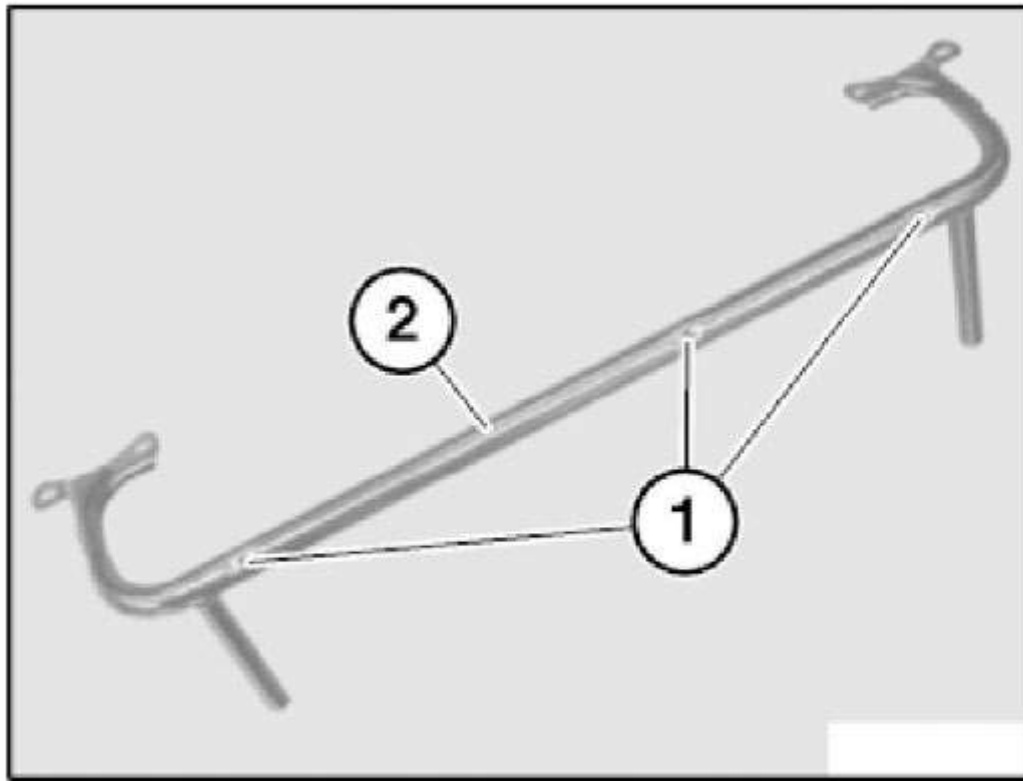


G03256064

Fig. 489: Removing Underride Protection
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Nuts (1) on underride protection (2) must not be damaged.



G03256065

Fig. 490: Installing Underride Protection
Courtesy of BMW OF NORTH AMERICA, INC.

51 71 407 REPLACING REAR SPOILER

Operation is identical to:

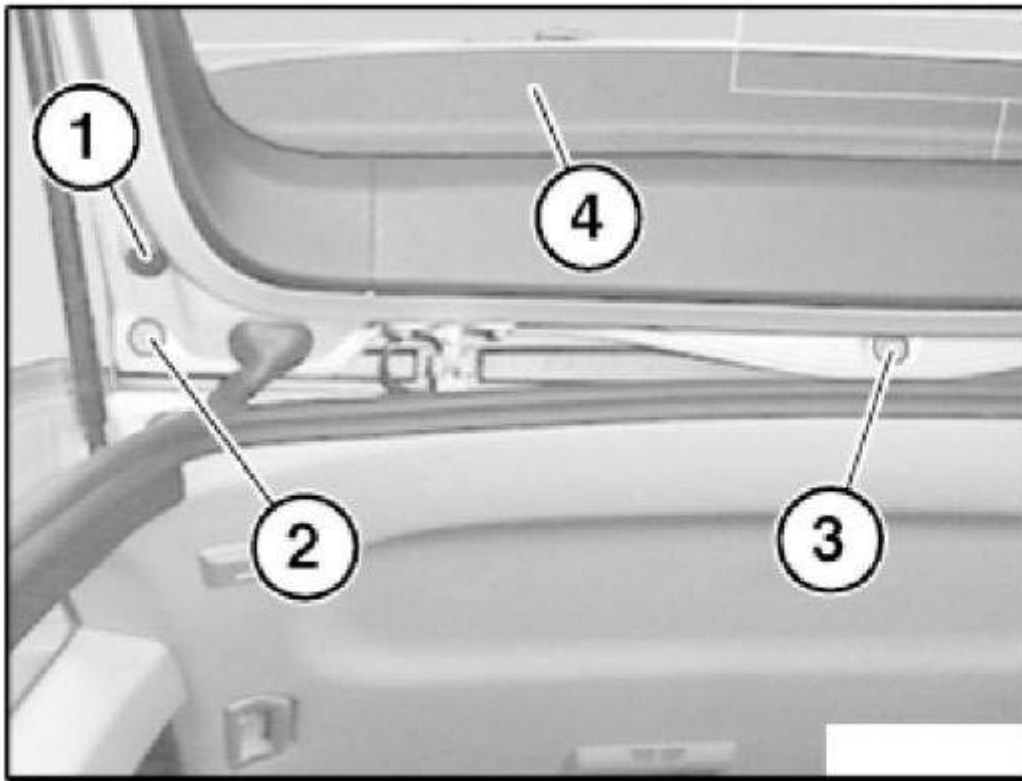
Removing rear spoiler. Refer to **51 71 412 REMOVING AND INSTALLING REAR SPOILER** .

51 71 412 REMOVING AND INSTALLING REAR SPOILER

Lever out covers (1) on left/right and release screw underneath.

Release screws (2) on left/right and screw (3).

Remove rear spoiler and set down on a clean surface.



G03256066

Fig. 491: Levering Out Covers

Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

If necessary, make a note of number of shims on screws (2) and (3) and refit them during installation at same position.

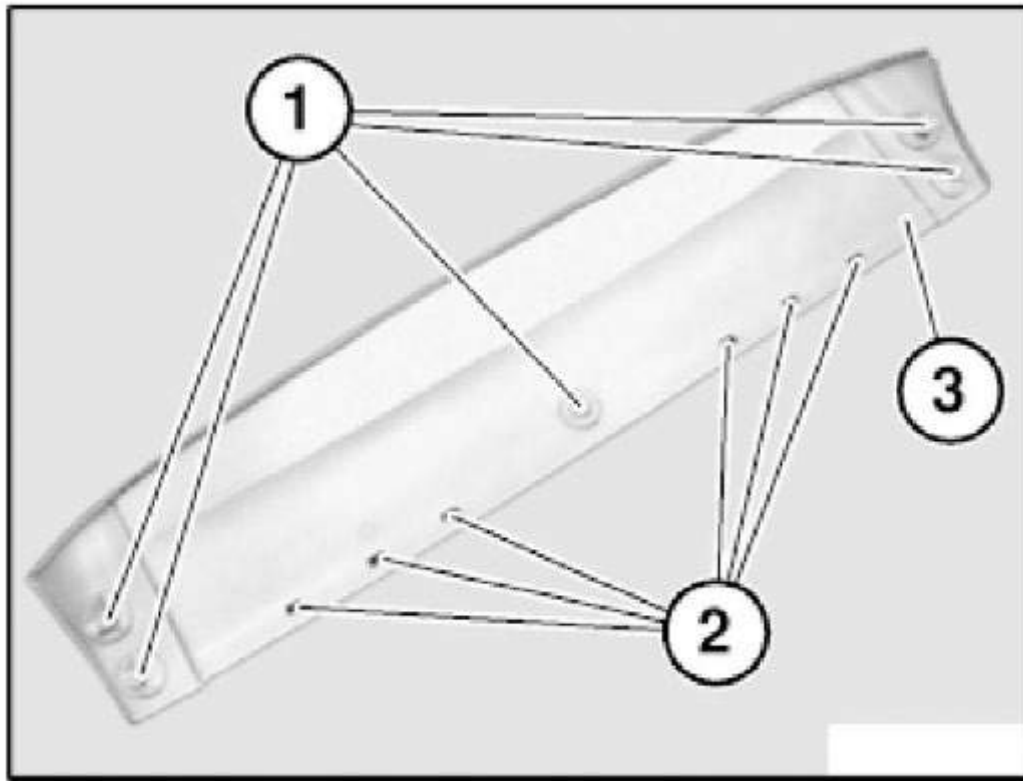
Tighten screw (3) first.

Tightening torque, (3 N.m.).

Installation:

Threads (1) on rear spoiler (3) must not be damaged.

If necessary, replace faulty tapes (2) (dual-lock tape).



G03256067

Fig. 492: Installing Rear Spoiler

Courtesy of BMW OF NORTH AMERICA, INC.

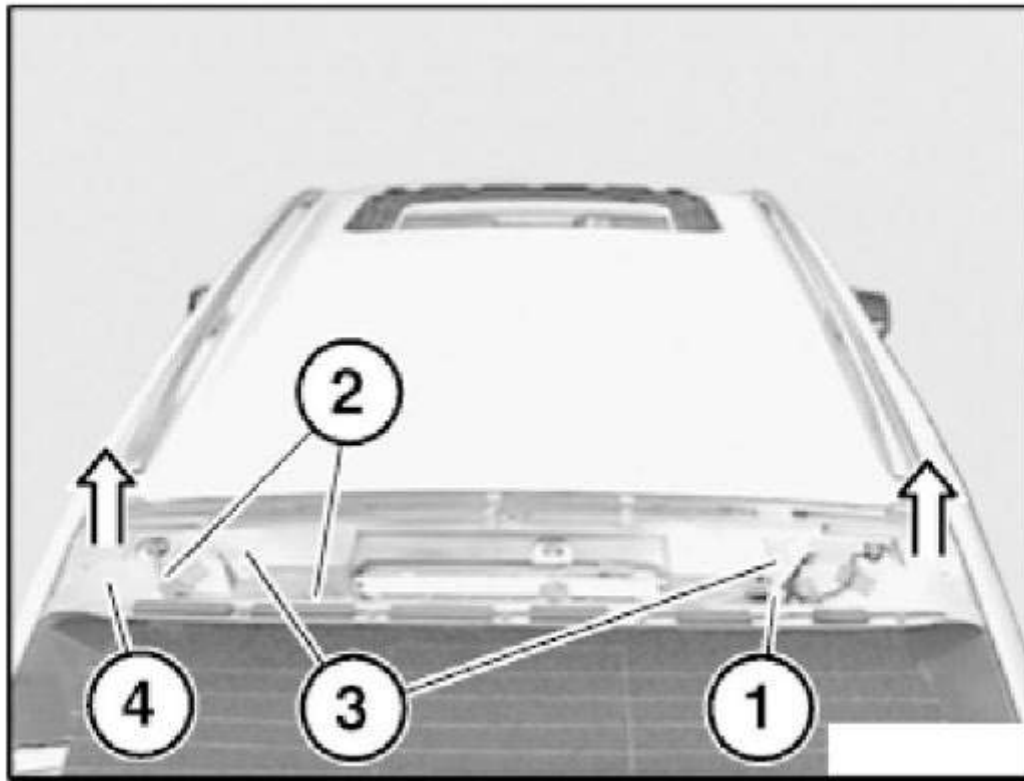
51 71 415 REMOVING AND INSTALLING REAR SPOILER LOWER SECTION**Necessary Preliminary Tasks:**

- Remove rear spoiler. Refer to **51 71 412 REMOVING AND INSTALLING REAR SPOILER**.
- Disconnect plug connection for antenna (AM pickup). Refer to **65 24 010 REMOVING AND INSTALLING/REPLACING ANTENNA AMPLIFIER (REAR LID UPPER SECTION)**.

Disconnect plug connection (1) for auxiliary brake light and expose lead.

Detach water hose (2) from jet nozzle and expose.

Release nuts (3) and remove rear spoiler lower section (4).



G03256068

Fig. 493: Detaching Water Hose From Jet Nozzle
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Fit attachment parts. Refer to **51 71 417 REPLACING REAR SPOILER LOWER SECTION** .

Tightening torque, (3 N.m.).

51 71 417 REPLACING REAR SPOILER LOWER SECTION

Necessary Preliminary Tasks:

- Remove rear spoiler lower section. Refer to **51 71 415 REMOVING AND INSTALLING REAR SPOILER LOWER SECTION** .
- Remove antenna (AM pickup). Refer to **65 24 100 REMOVING AND INSTALLING/REPLACING ANTENNA (AM SENSOR)** .

2001 BMW X5 30i

2001-2003 ACCESSORIES AND EQUIPMENT Exterior/Interior Trim - Repair Instructions - X5 (3.0i) E53

- Remove additional brake light. Refer to **63 25 000 REMOVING AND INSTALLING/REPLACING ADDITIONAL STOP LIGHT** .

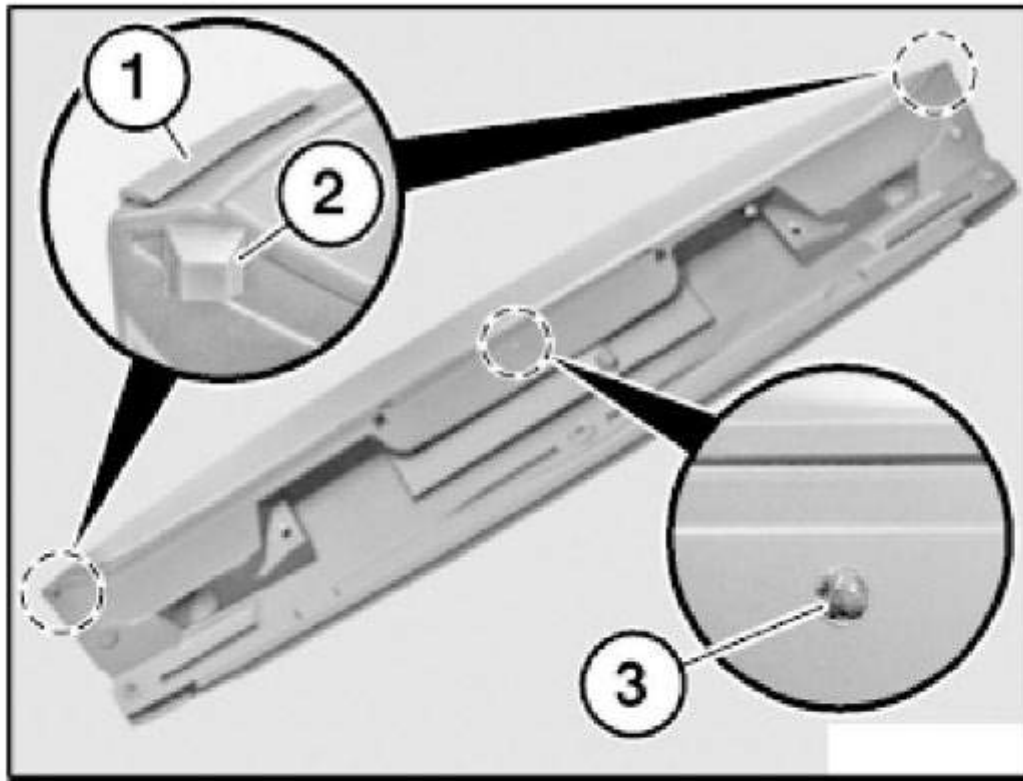
Attachment Parts On Underside Of Rear Spoiler Lower Section:

Attach muckets (1) on left/right.

Stick on buffers (2) on left/right.

Stick on stop buffer (3) in middle.

1. Mucket 45 mm long.
2. Buffer 5.8 mm high.
3. Stop buffer 2.2 mm high.



- 1 Mucket 45 mm long
- 2 Buffer 5.8 mm high
- 3 Stop buffer 2.2 mm high

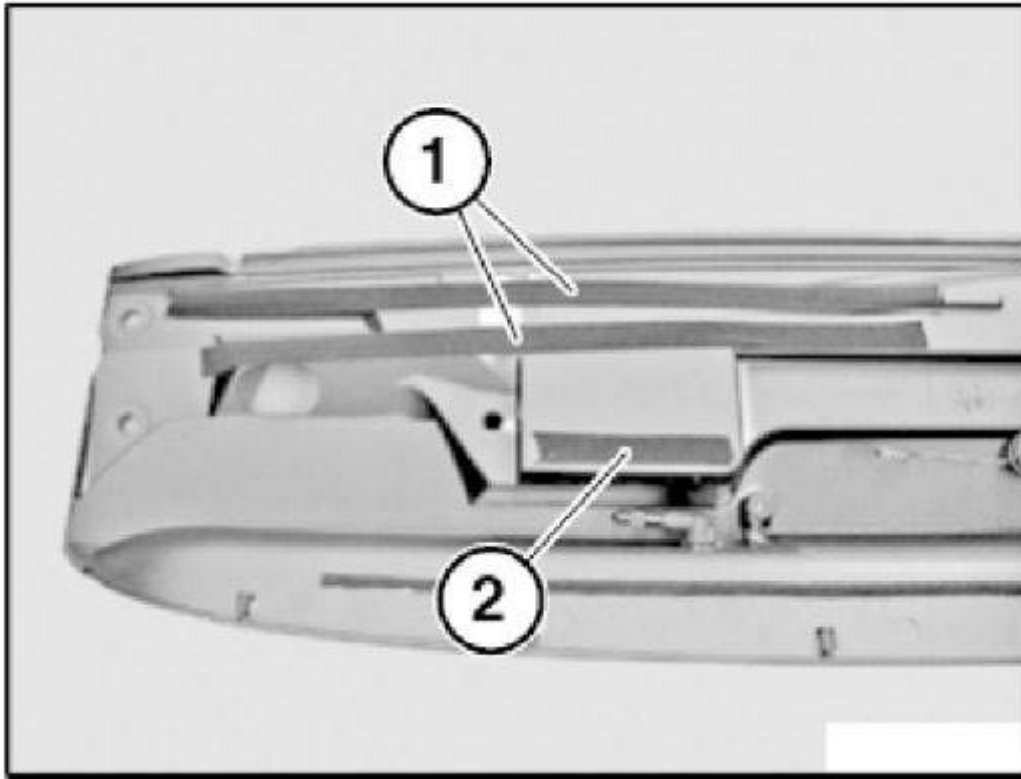
G03256069

Fig. 494: Identifying Rear Spoiler Lower Section
Courtesy of BMW OF NORTH AMERICA, INC.

Attachment Parts On Upper Side Of Rear Spoiler Lower Section:

Stick on felt strips (1 and 2) on left/right.

- 1. 430 mm long.
- 2. 100 mm long.



1 430 mm long

2 100 mm long

G03256070

Fig. 495: Identifying Upper Side Of Rear Spoiler Lower Section
Courtesy of BMW OF NORTH AMERICA, INC.

Installation:

Adjust spray nozzle for rear window wiper. Refer to **61 62 110 REMOVING AND INSTALLING / REPLACING SPRAY NOZZLE FOR REAR WINDOW WASHER UNIT** .

SPECIAL TOOL SETUP

Model Series	Special Tool
E53, E85, E60, E61, E63, E64, E87	51 2 170

2001 BMW X5 30i

2001-2003 ACCESSORIES AND EQUIPMENT Exterior/Interior Trim - Repair Instructions - X5 (3.0i) E53

TOOLS FOR CUTTING THROUGH ADHESIVE BEAD

Type	Model	Order/Part Number
Special cutter (manufacturer: Fein) with oscillating blade.	Pneumatically operated. Electrically operated.	81 43 9 429 183 81 43 9 427 786
BMW blade set.	All required blades.	81 43 9 428 596
Blade (U-shape).	19.5 mm ⁽¹⁾ .	6 39 03 118 01 3
	24 mm.	6 39 03 076 01 6
	36 mm.	6 39 03 079 01 2
	45 mm.	6 39 03 154 01 0
Blade (straight with stop roller).	16 to 35 mm (adjustable).	6 39 03 143 01 3
	10 mm (fixed) ⁽¹⁾ .	6 39 03 189 01 0
	14 mm (fixed).	6 39 03 082 01 6
"Roll Out 2000", refer to 51 31 ... REMOVING WINDSCREEN WITH "ROLL OUT 2000" .	Wire cutting system ⁽¹⁾ .	81 62 0 301 76 8
Scalpel	For heavy-duty applications ⁽¹⁾ .	
Handles for cutting wire.	Self-locking ⁽¹⁾ .	Special tool 51 3 270
(1) Not included in BMW blade set		

TOOLS FOR CUTTING THROUGH ADHESIVE BEAD

Glue	Treatment
Bonding and sealing compound for car window glass.	a. Clean with spirit (available in pharmacies). b. Observe an air drying time of at least 1 minute (at least 15 minutes when applied to residual bead). c. Apply "Paint Activator A" to paint and residual bead. d. Observe an air drying time of at least 1 minute (at least 10 minutes when applied to residual bead).

TREATMENT OF GLASS CERAMIC SURFACE

Adhesive (With Part Numbers)	Treatment
Hot cementing: ○ BMW 83 19 0 147 370, MINI 83 19 0 147 372 Cold cementing: ○ BMW 83 19 0 147 369, MINI 83 19 0 147 371	a. Clean with spirit (available in pharmacies). b. Observe an air drying time of at least 1 minute. c. Apply a thin coating of "Glass Activator 1". d. Observe an air drying time of at least 10

2001 BMW X5 30i

2001-2003 ACCESSORIES AND EQUIPMENT Exterior/Interior Trim - Repair Instructions - X5 (3.0i) E53

Adhesive cartridge:

minutes.

- BMW 83 19 0 152 031, MINI 83 19 0 152 032

EFFECT OF DIFFERING ADHESIVE QUANTITIES

Too Little Adhesive:	Too Much Adhesive:
○ Windscreen rests too low in body cutout. ○ Strains/tensions may occur (windscreen breakage). ○ Insufficient squeezing of adhesive bead (leaking).	○ Windscreen rests too high in body cutout. ○ Wind noise may occur. ○ Strains/tensions may occur (windscreen breakage). ○ Fouling of add-on parts by emerging adhesive. ○ Adhesive on uninsulated strainer pressure lines of antenna(s) (interference of reception).

GLUES AND THEIR MINIMUM HARDENING TIMES

Glue.	Minimum hardening time "without passenger airbag" (after which vehicle can be moved).	Minimum hardening time "with passenger airbag" (countries where seatbelt use is not required by law).
Hot processing with accelerator.	2 hours.	3 hours ⁽¹⁾ .
Cold processing.	9 hours.	20 hours ⁽¹⁾ .
(1) Vehicles with passenger airbag:		