



SI B 63 08 07  
Lights

September 2007  
Technical Service

This Service Information bulletin supersedes S.I. B63 08 07 **dated June 2007**.

**NEW** designates changes to this revision

## SUBJECT

### Rear Lamp Repair

## MODEL

E53 (X5)

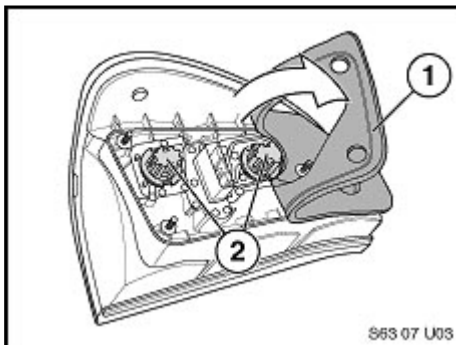
## SITUATION

Instead of replacement, most failed rear lamps may be repaired.

A typical lamp fails because the circuit board heats sufficiently during extended use to soften the plastic circuit board supports. Because of pressure from the bulb holder contact, the circuit board contact surface is pushed away as the plastic supports collapse, eventually causing an open circuit.

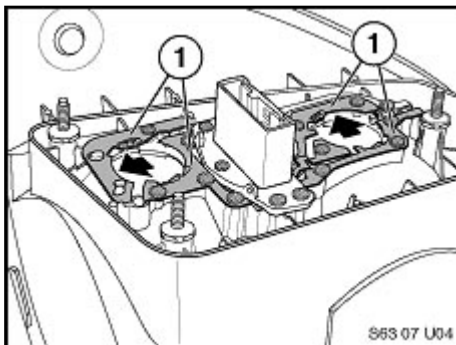
## PROCEDURE

First, confirm that the lamp is suitable for repair - Visually check the lamp for damage, particularly on the lens surface for cracks, chips etc., for water related corrosion damage particularly on the electrical connector, and for excessive erosion at the bulb holder/contact plate (e.g. contact plate burnt through). Lamps with this type of damage cannot be repaired.

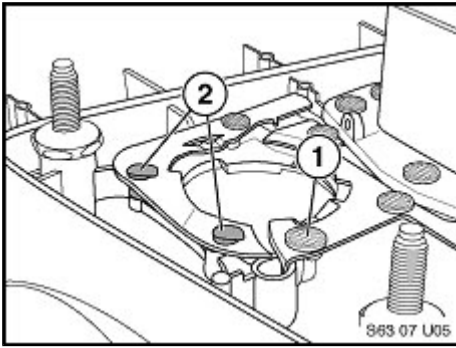


- a. Peel away gasket (1) as shown, taking care not to damage it during the removal process.

Remove the bulb holders (2).  
Put both the gasket and bulb holders on one side for re-use later.



- b. Inspect the circuit board contact surfaces at both locations (1) for evidence of distortion.



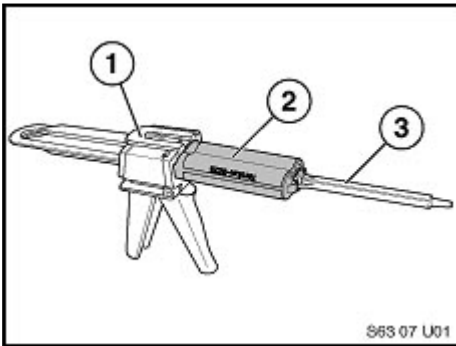
c. A distorted circuit board can generally be identified by misshapen circuit board supports. Typically, check where the supports are hot staked:

(1) = OK, (2) = Not OK.

In addition, the circuit board contact surface can be seen to have moved out of position (The surfaces where the bulb holder is attached must all be at the same level)

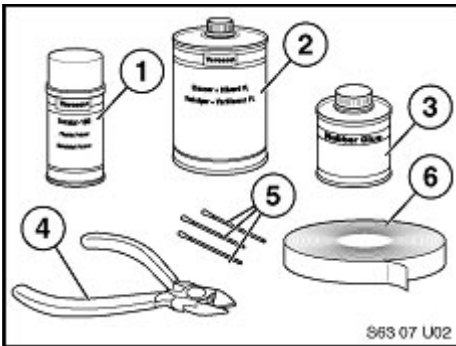
Lamps that have failed for a distorted circuit board contact surface(s) may be repaired using the following procedure:

**Perform the repair in a well ventilated area away from open flame. Observe safety precautions marked on containers. Use protective eyeglasses and gloves.**

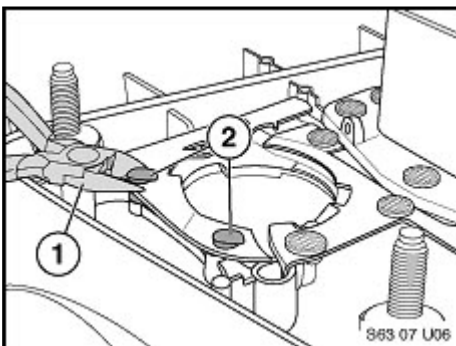


1. The repair requires the use of components from the BMW Plastic Repair Kit P/N 51 91 0 398 655 (Refer to [SI B04 42 06](#)). Items from the kit are marked \*

- \* Application gun (1)
- \* Adhesive cartridge (2)
- \* Mixing tip (3)



- \* Teroson Terokal-150 primer (1)
  - \* Teroson cleaner/thinner (2)
- Additional items that are required:
- Wirth Rubber Glue (3)
  - Diagonal cutters (4)
  - Cotton buds (5)
  - Masking tape (6)



2. Using diagonal cutter (1), remove the top of the misshapen circuit board supports (2).