

# Part 573 Safety Recall Report

# 19V-601

**Manufacturer Name :** BMW of North America, LLC**Submission Date :** AUG 14, 2019**NHTSA Recall No. :** 19V-601**Manufacturer Recall No. :** NR**Manufacturer Information :**

Manufacturer Name : BMW of North America, LLC

Address : P.O. Box 1227

Westwood NJ 07675-1227

Company phone : 18005257417

**Population :**

Number of potentially involved : 32

Estimated percentage with defect : 100 %

**Vehicle Information :**

Vehicle 1 : 2019-2019 BMW X1 sDrive28i, X1 xDrive28i

Vehicle Type : LIGHT VEHICLES

Body Style : SUV

Power Train : GAS

**Descriptive Information :** Approximately 16 vehicles contain a steering gear tie rod end that may not have been assembled according to specifications.

**Basis for recall population determination:** Supplier production information was used to identify the start and end date of potentially affected steering gears which was then correlated with vehicle assembly information to determine the start date and the end date of potentially affected vehicles.

**Recall component difference to non-recall component:** The recall component contains a steering gear tie rod end that may not have been produced to specifications.

Production Dates : MAR 15, 2019 - APR 05, 2019

VIN Range 1 : Begin :

NR

End : NR

 Not sequential

Vehicle 2 : 2019-2019 BMW X2 xDrive28i

Vehicle Type : LIGHT VEHICLES

Body Style : SUV

Power Train : GAS

**Descriptive Information :** Approximately 1 vehicle contains a steering gear tie rod end that may not have been assembled according to specifications.

**Basis for recall population determination:** Supplier production information was used to identify the start and end date of potentially affected steering gears which was then correlated with vehicle assembly information to determine the start date and the end date of potentially affected vehicles.

Recall component difference to non-recall component: The recall component contains a steering gear tie rod end that may not have been produced to specifications.

Production Dates : MAR 13, 2019 - MAR 13, 2019

VIN Range 1 : Begin :

NR

End : NR

Not sequential

Vehicle 3 : 2019-2019 MINI Cooper S Convertible

Vehicle Type : LIGHT VEHICLES

Body Style : 2-DOOR

Power Train : GAS

Descriptive Information : Approximately 1 vehicle contains a steering gear tie rod end that may not have been assembled according to specifications.

Basis for recall population determination: Supplier production information was used to identify the start and end date of potentially affected steering gears which was then correlated with vehicle assembly information to determine the start date and the end date of potentially affected vehicles.

Recall component difference to non-recall component: The recall component contains a steering gear tie rod end that may not have been produced to specifications.

Production Dates : MAR 18, 2019 - MAR 18, 2019

VIN Range 1 : Begin :

NR

End : NR

Not sequential

Vehicle 4 : 2018-2018 BMW X1 sDrive28i, X1 xDrive28i

Vehicle Type : LIGHT VEHICLES

Body Style : SUV

Power Train : GAS

Descriptive Information : Approximately 3 vehicles may have been equipped during a service visit with a steering gear tie rod end that may not have been assembled according to specifications.

Basis for recall population determination: Supplier production information was used to identify the start and end date of potentially affected steering gears which was then correlated with vehicle service history information to determine the start date and the end date of potentially affected vehicles.

Recall component difference to non-recall component: The recall component contains a steering gear tie rod end that may not have been produced to specifications.

Production Dates : JUL 28, 2017 - NOV 25, 2017

VIN Range 1 : Begin :

NR

End : NR

Not sequential

Vehicle 5 : 2019-2019 MINI Cooper S Countryman, John Cooper Works Countryman

Vehicle Type : LIGHT VEHICLES

Body Style : SUV

Power Train : GAS

**Descriptive Information :** Approximately 11 vehicles contain a steering gear tie rod end that may not have been assembled according to specifications.

**Basis for recall population determination:** Supplier production information was used to identify the start and end date of potentially affected steering gears which was then correlated with vehicle assembly information to determine the start date and the end date of potentially affected vehicles.

**Recall component difference to non-recall component:** The recall component contains a steering gear tie rod end that may not have been produced to specifications.

Production Dates : MAR 15, 2019 - APR 08, 2019

VIN Range 1 : Begin :

NR

End : NR

Not sequential

## Description of Defect :

**Description of the Defect :** This safety recall involves the steering gear. During production at the sub-supplier, the steering gear tie rod end may not have been produced to specifications. Specifically, it may not have been assembled with a required spherical washer. Over time, this could lead to excessive wear of the tie rod end and eventually cause the tire rod to break.

FMVSS 1 : NR

FMVSS 2 : NR

**Description of the Safety Risk :** If the tie rod broke, this would lead to a loss of wheel guidance, increasing the risk of a crash.

**Description of the Cause :** NR

**Identification of Any Warning that can Occur :** NR

## Supplier Identification :

### Component Manufacturer

Name : Nexteer Automotive

Address : Wilhelm-Wagenfeld Str. 28  
Munich FOREIGN STATES 80807  
Country : Germany

## Chronology :

In early April, during the axle subassembly process at a vehicle assembly plant, a missing spherical washer was noticed when removing a plastic cap from the steering tie rod end. An inspection of 7,045 steering gears before assembly was performed which resulted in the identification of 3 additional suspect components.

A test program and engineering review was initiated to assess the durability of a tie rod end without the spherical washer. Suspect parts were tested to simulate and assess vehicle service life endurance.

In April and May, a review of the supplier's and sub-supplier's production processes was conducted. The supplier's and sub-supplier's production records involving tightening torques and torque curves of the tie rod assembly process were reviewed.

In early June, this review pointed to possible process fault in the monitoring system of the tie rod end assembly station during a specific production period. Further reviews enabled identification of the suspect tie rod serial numbers and associated production dates.

In early July, the results of the durability test program indicated that, over the service life of the vehicle, the tie rod could be subject to excessive wear and eventually break.

Vehicle manufacturing and Tier-1/Tier-2 supplier production records were examined in order to determine the number, and production dates, of potentially affected vehicles.

On August 7, 2019, BMW decided to conduct a voluntary recall.

BMW has not received any reports, nor is BMW otherwise aware, of any accidents or injuries related to this issue.

## Description of Remedy :

Description of Remedy Program : The steering gear tie rods will be inspected and, if necessary, affected tie rods and ball joints will be replaced.

Owners will be notified by First Class mail and instructed to take their vehicle to an authorized BMW center to have the remedy performed for free. If this condition were to occur to a potentially affected vehicle prior to the recall, the remedy would be covered by the BMW New Vehicle Limited Warranty program. Therefore, reimbursement for a pre-notification remedy re Part 573.13 and Part 577.11 is not necessary.

How Remedy Component Differs from Recalled Component : Part numbers are as follows:  
X1 -tie rod (left/right): 31 21 6 876 645/646 // ball joint (left/right): 32 10 6 869 424/425  
X2 - tie rod (left/right): 31 21 6 876 853/854 // ball joint (left/right): same as X1  
Cooper Convertible - tie rod (left/right): 32 21 6 876 643/644 // ball joint (left/right): 32 10 6 854 734/737  
Cooper Countryman - tie rod (left/right): 32 21 6 876 645/646 // ball joint (left/right): 32 10 6 869 424/425

Identify How/When Recall Condition was Corrected in Production : NR

### Recall Schedule :

Description of Recall Schedule : Notification to dealers is expected to begin and end on August 14, 2019.  
Notification to owners is expected to begin and end on October 7, 2019.

Planned Dealer Notification Date : AUG 14, 2019 - AUG 14, 2019

Planned Owner Notification Date : OCT 07, 2019 - OCT 07, 2019

\* NR - Not Reported