
SUBJECT: E-M Top Frame Breaking

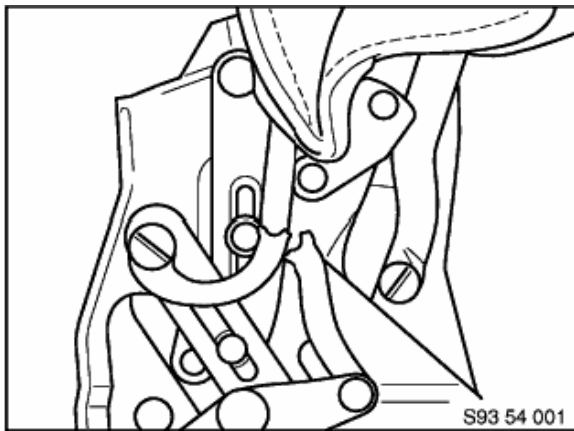
MODELS:

325i Convertible

Situation:

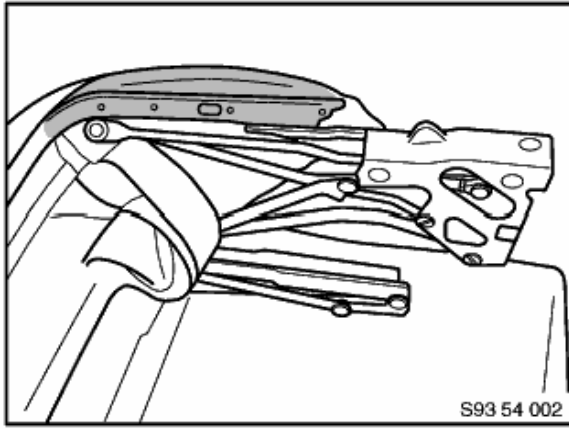
The additional arm welded to the rear window (number 5) bow of the EM soft top frame can break in the area of the screw hole. This area has been strengthened in production as of 11/92.

Since this arm was not available separately, replacement of the entire frame was the normal repair method in the past. However, the arm is now available as a replacement part.

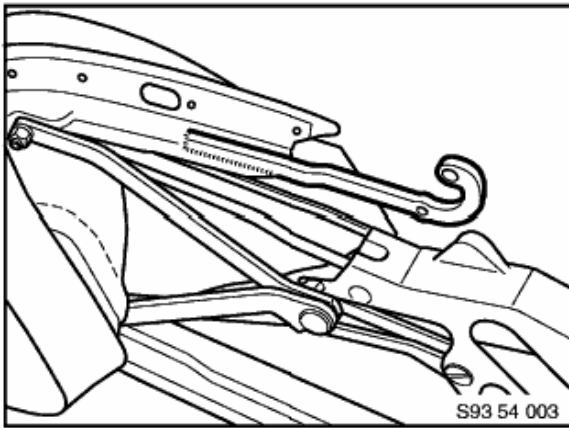


Procedure:

- Remove the top assembly from the vehicle and place on bench.
- Remove the number 5 bow seal and seal retaining rail.
- Carefully peel top material off of rear bow in area where welding will be done.
- Carefully cover top material and other areas with welding blankets to protect from grinding and welding sparks.



- Remove all sealant around broken arm.
- Remove slide arm mechanism.
- Using new arm as a guide, mark the frame assembly where the new arm will be welded on.
- Cut off welds on broken arm with grinding wheel and remove arm.
- Weld new arm into place.



- Clean up weld area, prime and paint.
- Re-glue the soft top material in place; reinstall seal rail and seal, and reinstall top.

Warranty Status:

Covered under the terms of the BMW New Car Warranty.

Defect Code: 54 34 25 13 00
 Labor Operation: 00 50 425
 Flat Rate Units: 41

Parts Allowance:	Part Number	Quantity
	54 34 8 112 782	1
	54 31 8 134 533	1

54 31 1 943 753
54 31 1 932 761

1
2