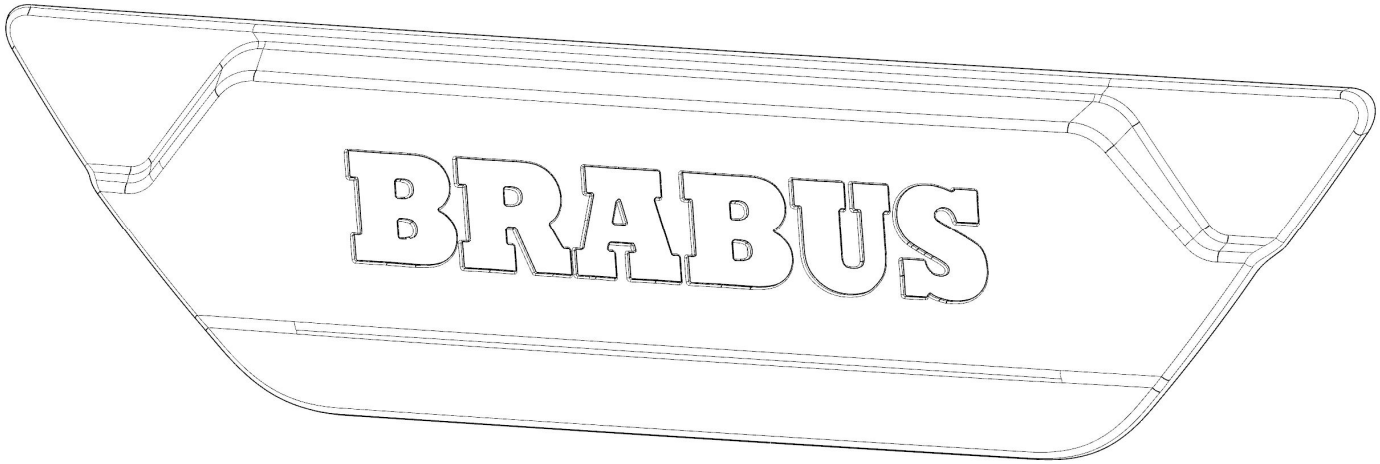
BRABUS rear door attachment, for G-Class W463A - modelyear 2019
ordernumber 464-845-000

BRABUS®



Installation manual

The product described in the instructions was developed, produced and checked considering the necessary safety requirements.
In order to ensure a proper and safe function and to rule out danger for persons and objects, this product must be installed appropriately.
Only trained, qualified staff, having the necessary technical experience and tools, should perform the installation.
Therefore you have to read and completely understand these instructions.
Before you start please check the content of the supplied parts as detailed below.

Hints for adherence of body parts

The add on-parts for the car body can be bonded using the delivered adhesive, or using PU window adhesive in connection with appropriate primer .

When using the delivered adhesive all bonding areas (those of the car body and those of the add on parts) have to be sanded and properly cleaned and disgreased.

We recommend to use Würth window-adhesive (e.g. Würth, window adhesive „Classic“ or „Pro“, article-nos.: WU89002310, WU89002330), in connection with acetone cleaner (e.g. Würth, article-no.: WU893460) and primer (e.g. Würth, article-No.: WU890024101).
The primer gets attached to the bonding areas of the car body and the add on parts by using special primer brushes (e.g. Würth, article-no.: WU891650). Attach the primer only in one direction. After the primer has flashed off, apply an even line of adhesive and bond the part to the car. Remove excessive adhesive using suitable cleaner (e.g. Würth, article-no.: WU89010063).

For fixation of the parts until the adhesive is completely hardened,
we recommend to use assembly suckers, (e.g. Würth, article-no.: WU069155210 )

Remove paint fog prior to painting!

Take care not to apply the primer to areas which are still visible after bonding, apply up to 5mm away from the markings!

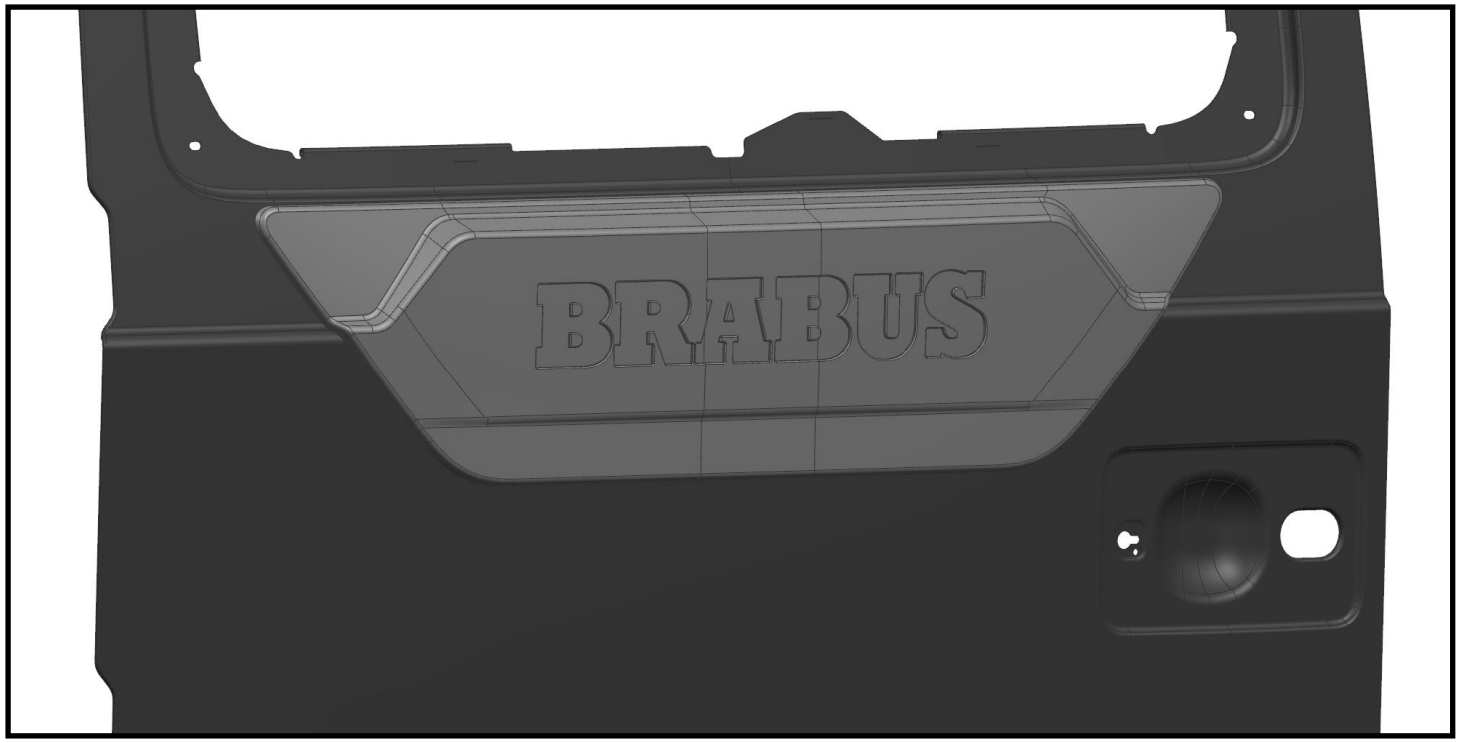
Regard to bonding hints and make sure the bonding areas are clean, free of grease and free of paint.

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shipment BRABUS:

464-845-000

1x rear door attachment	464-845-001
1x adhesive set 80ml	B28/000-8



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***Preparation*:**

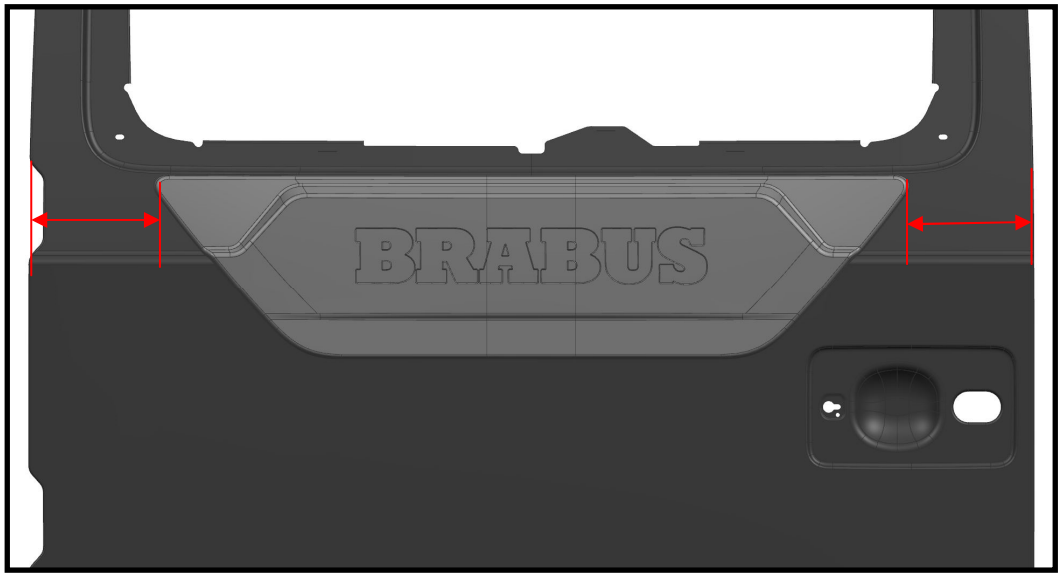
- The spare wheel covers, the spare wheel itself and the spare wheel brackets have to be disassembled according to the Mercedes-Benz workshop information system (WIS).

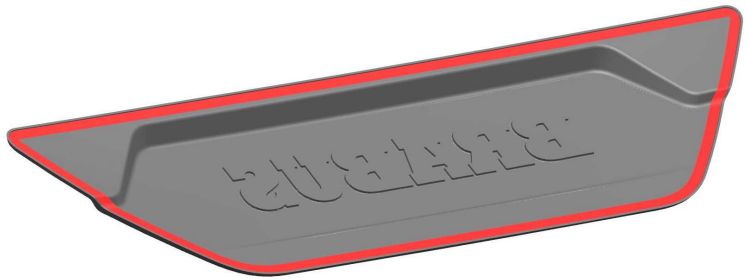


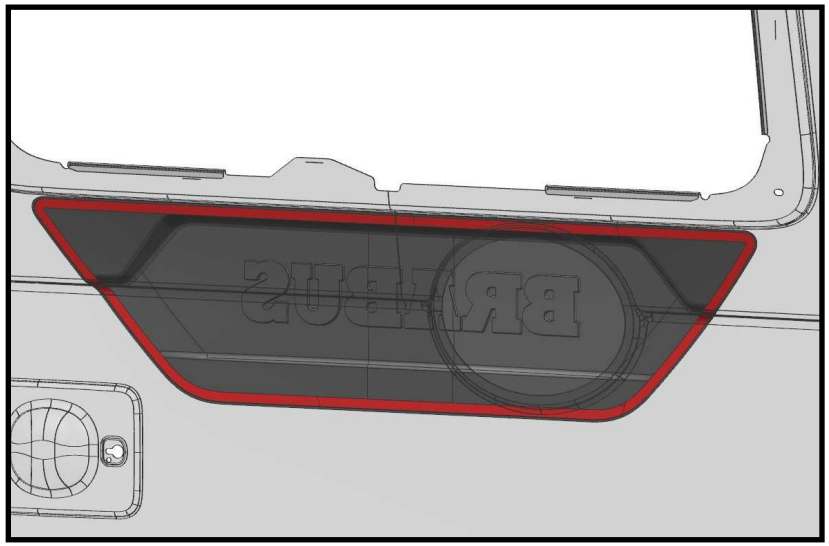
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Assembly

- Prepare the red marked areas according to the hints for adherence of body parts.
- Hold the BRABUS-part on the Surface of the rear door and mark the correct position (left and right same space).
- Remove the part and apply even lines of adhesive to the bonding areas.

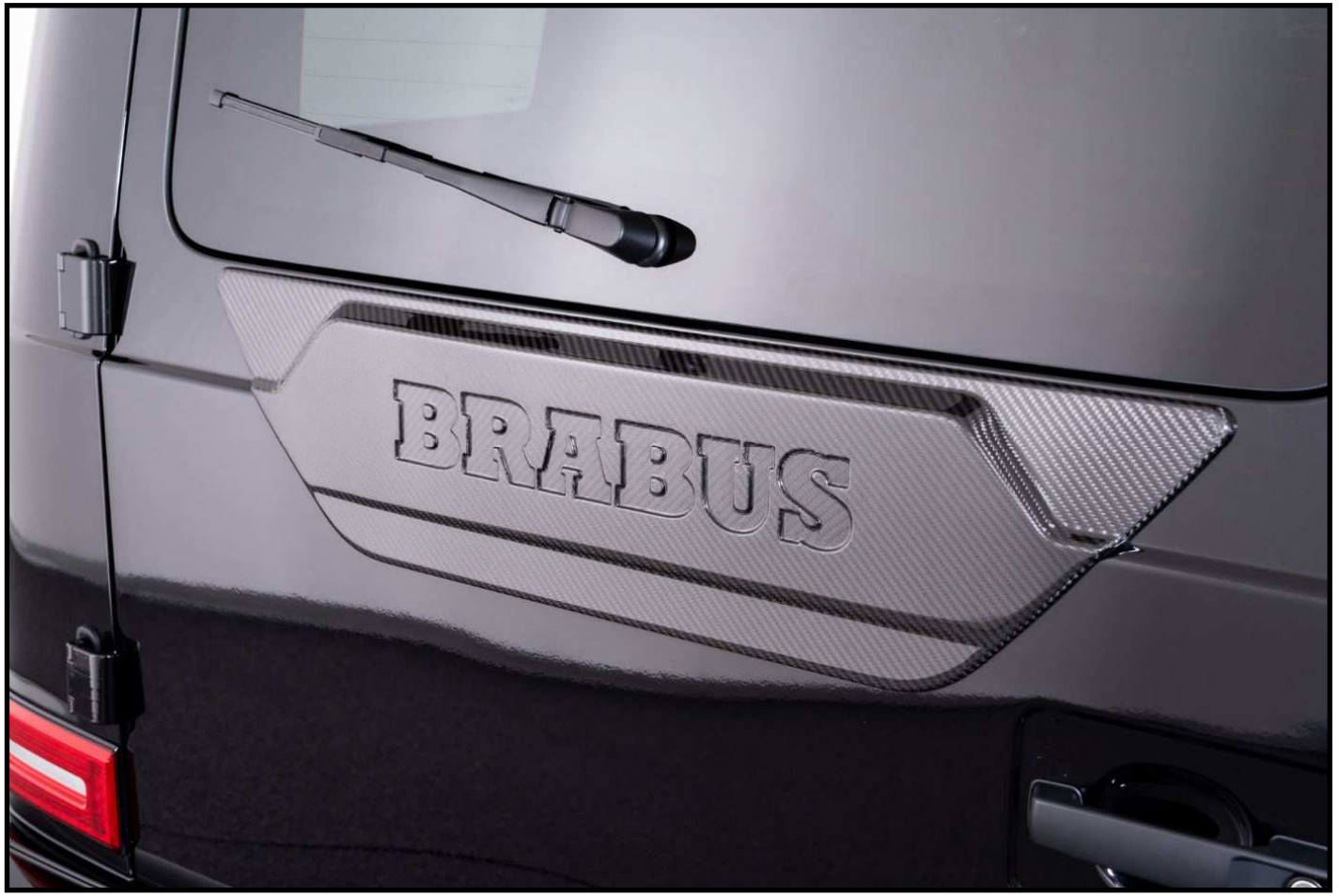






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- Fixate the carbon fiber attachment using appropriate adhesive tape (e.g. duct tape) until the adhesive has finally hardened.
- Align the part according to the markings on the rear door, remove excessive adhesive immediately.
- Avoid to wash the vehicle in an automatic washing bay within 24 hours after assembly!



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