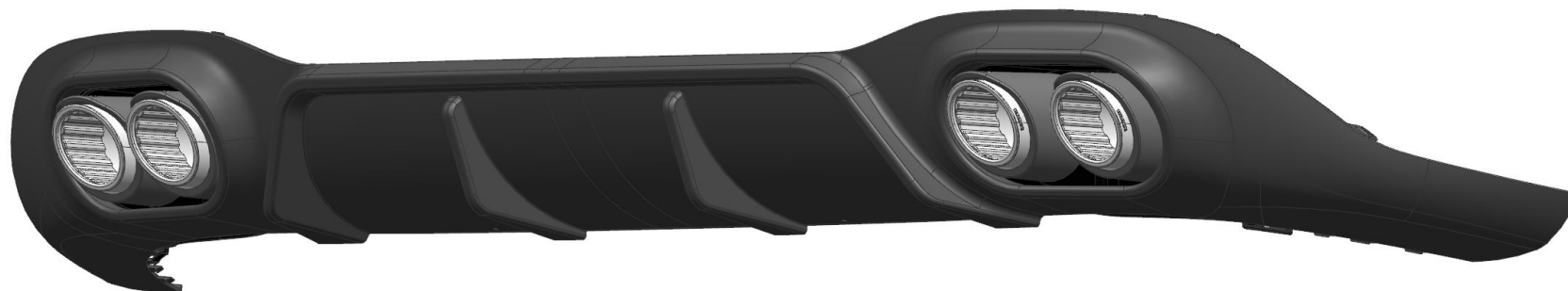




BRABUS®

**BRABUS rear bumper insert, for A-Class W177 – up from 2018,
order number 177-420-00**



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 )

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Remove paint fog prior to painting!

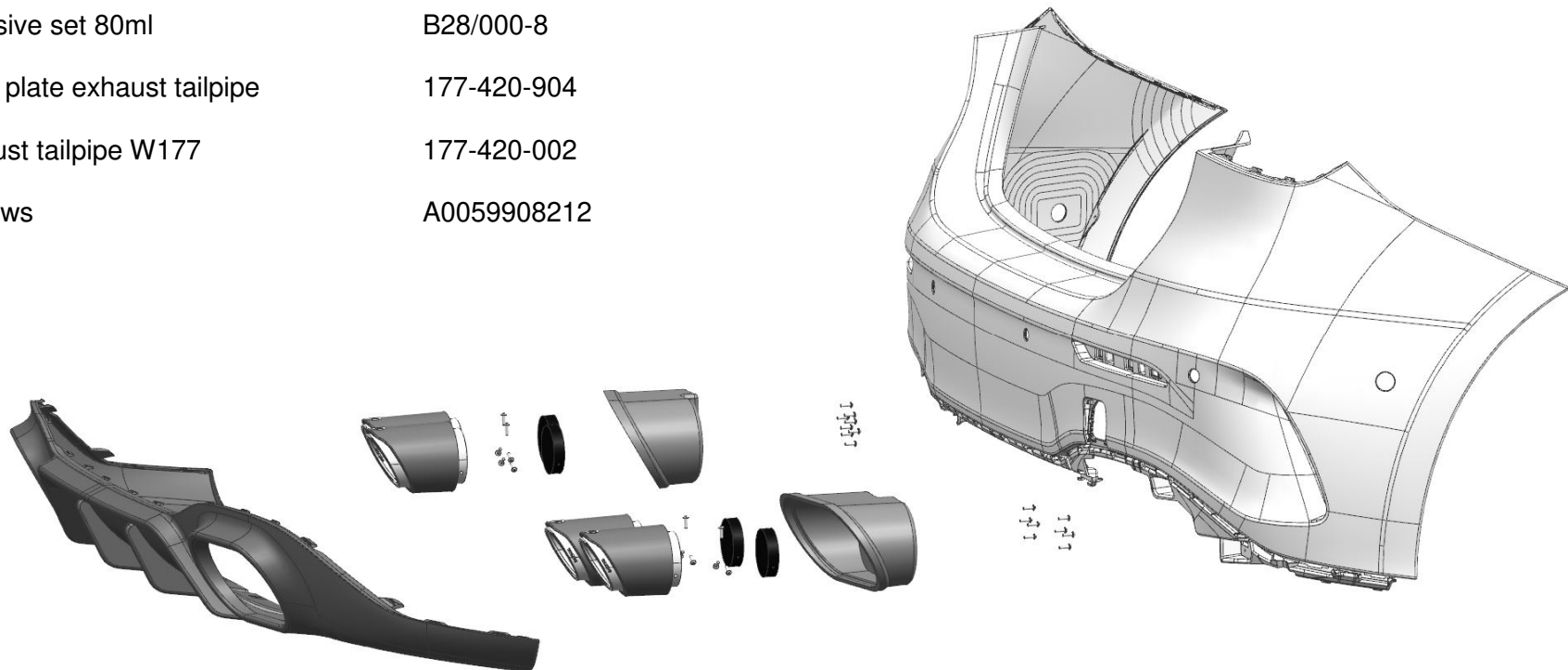
Take care not to apply the primer to areas which are still visible after bonding, apply up to 5mm away from the markings!

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

Shipment **BRABUS**:

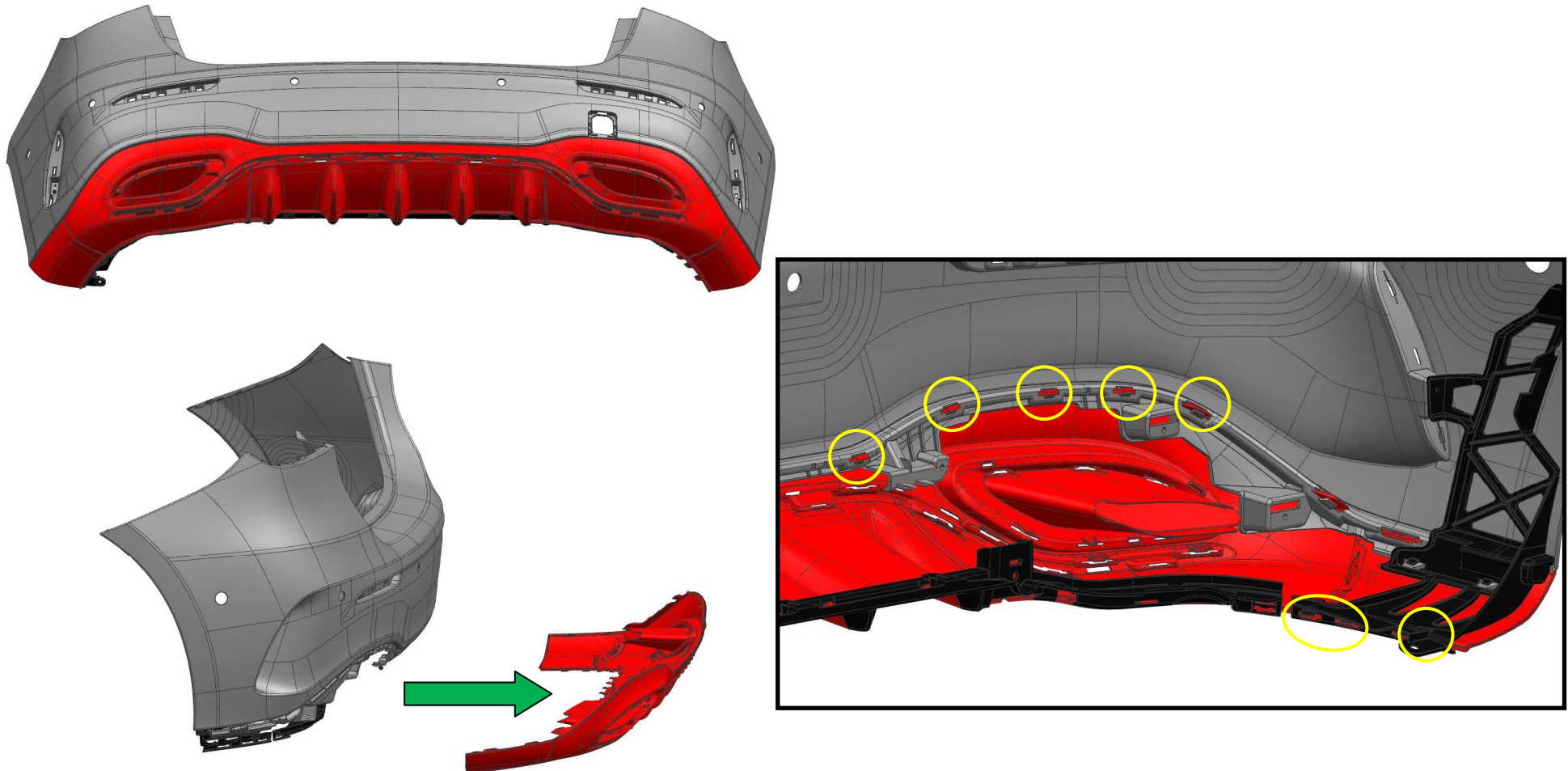
177-420-00

1x rear bumper insert	177-420-001
1x bracket exhaust left	177-420-901
1x bracket exhaust right	177-420-902
1x adhesive set 80ml	B28/000-8
4x fixing plate exhaust tailpipe	177-420-904
4x exhaust tailpipe W177	177-420-002
30x screws	A0059908212



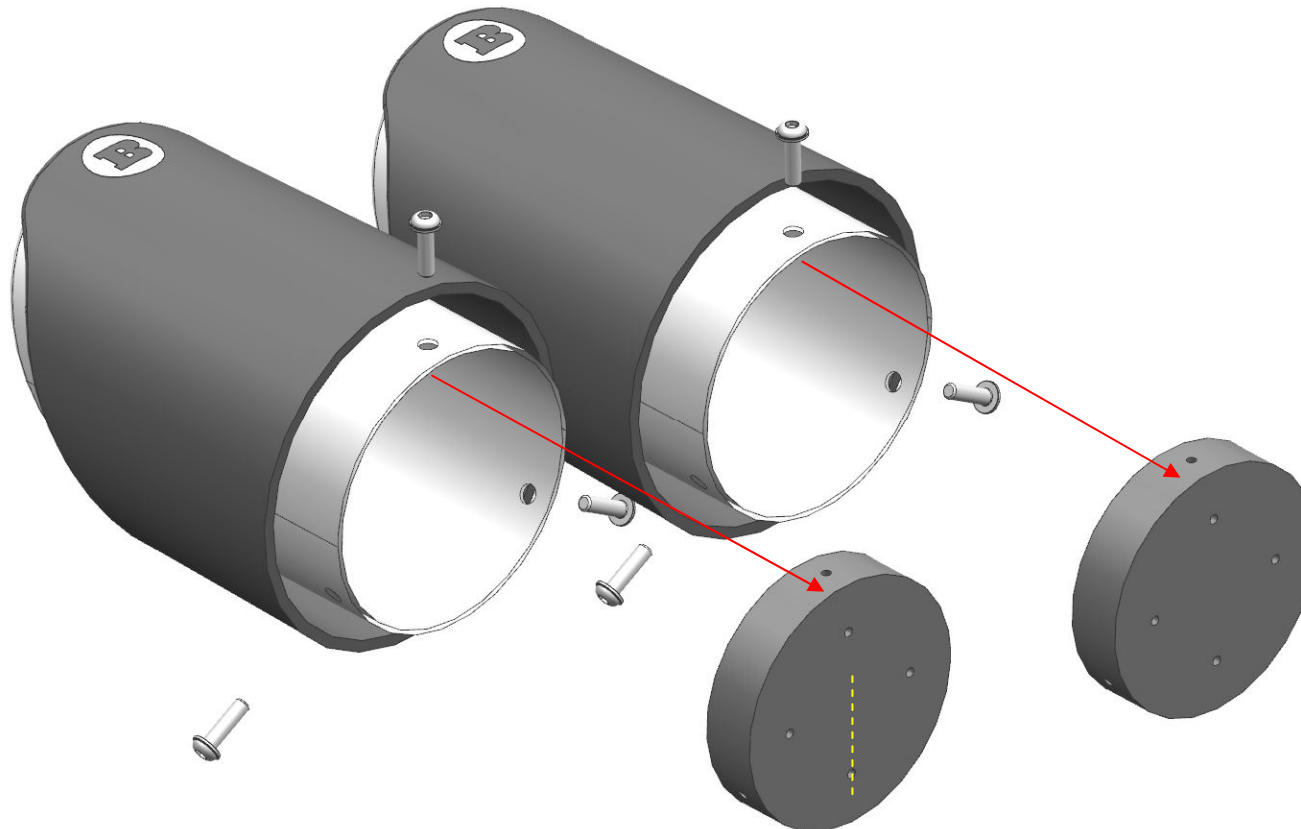
preparative action:

- The rear bumper has to be dismantled and the original insert has to be taken out of the bumper. Take care on the snap-fits (yellow marker) and pull the insert out of the bumper carefully. The snap-fits are needed for the BRABUS-insert later.

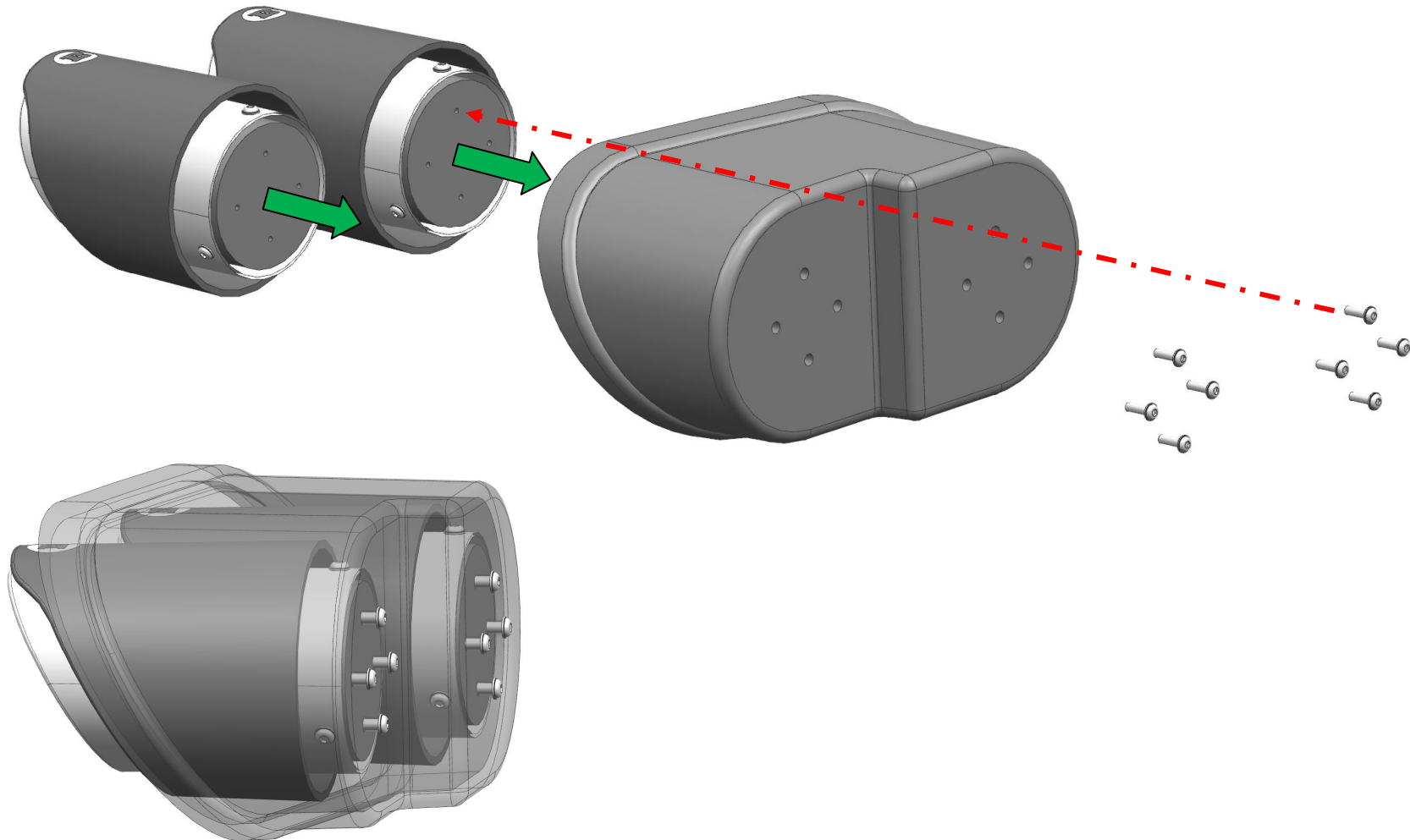


Montage der BRABUS Komponenten

- The BRABUS-insert consists of a lot of parts, which will be mounted to assembly groups before they get placed on the car.
- Start with the assembly of the fixing plates of the exhaust tailpipes. Put the plates in the correct direction to the drilled holes in the exhaust tailpipe.
- Bolt the fixing plates and the exhaust tailpipes together while using the delivered screws. Take care of the correct direction of the pattern of drilling in the fixing plates. The drilled hole on the outside ring has to be in top position and one of the holes in the pattern of drilling as well. The yellow line is for your orientation and has to be vertical.

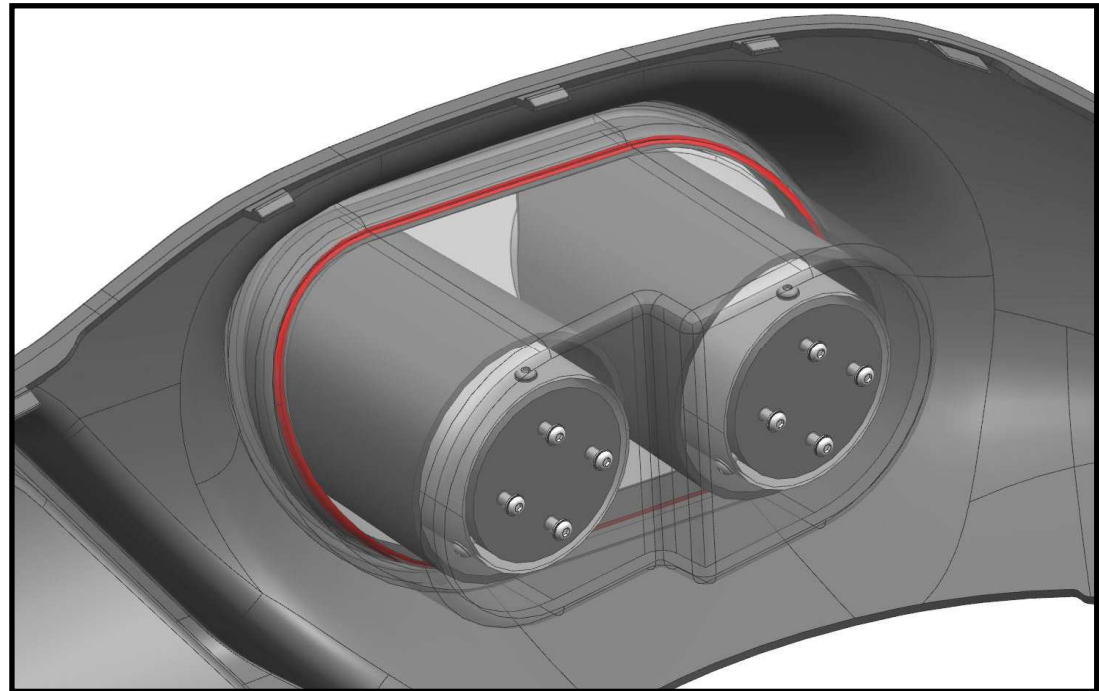
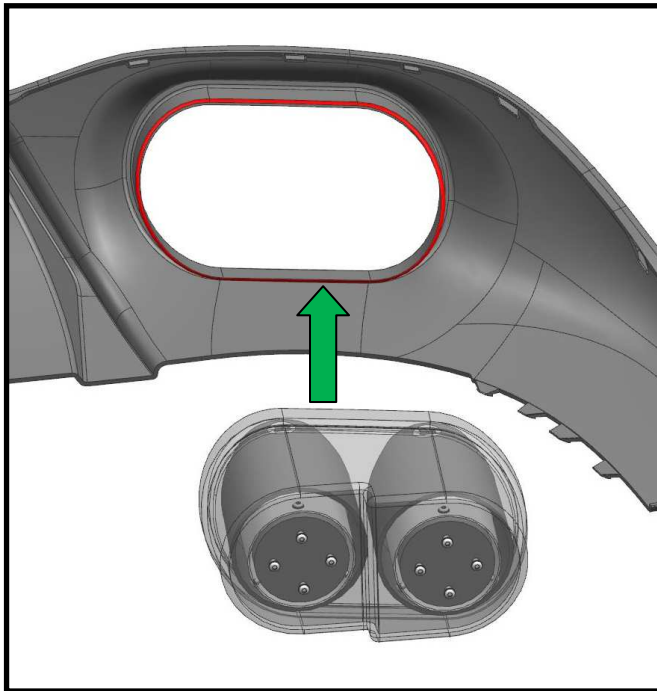


- The exhaust tailpipes have to be mounted in the bracket. Therefore you need the correct direction of the pattern of drilling from the step before.

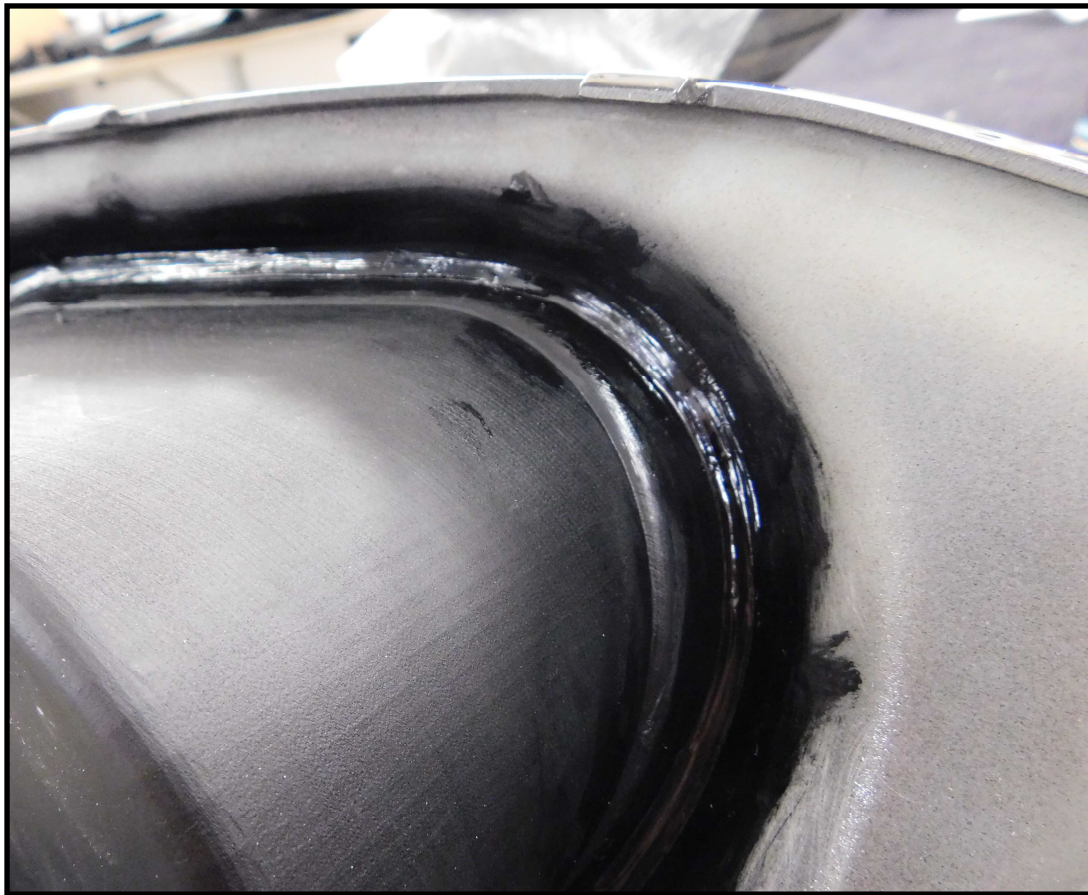


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- The brackets have to be mounted in the insert and fixed with adhesive.
- Apply even lines of adhesive to the red marked bonding areas according to the hints for adherence of body parts and put the bracket on the insert.
- Pay attention to the inside of the bracket and remove excessive adhesive immediately in case that the adhesive extrude to the visible face.



- Distribute adhesive over the junction of the two components and seal the joining.
- Repeat this work steps for the other side.
- The two brackets have to be fixed with adhesive tape until the adhesive is full hardened.
- The following steps should be done after the adhesive is full hardened.



- The insert has to be mounted to the rear bumper while using the snap-fits.
- The rear bumper has to be mounted on the car.
- Now the angle support has to be fixed (red markers).



- The position of the angle support has to be transferred to the original cross brace and one hole for each support has to be drilled.
- Rivet the angle support with the original cross brace.
- The assembly of the rear bumper insert is done.

