BRABUS-Widestar for W465-G63-AMG Model year 2025
Partnumber 465-234-00

BRABUS



Assembly Instructions

Illustration shows special equipment

The product described in these instructions was developed, produced and subjected to extensive quality controls in compliance with the necessary safety requirements. To ensure proper and safe functioning and rule out danger for persons and objects, this product must be installed appropriately and according to the explanations on the following pages. The components should only be installed by trained, qualified staff having the necessary expertise and technical experience in the field of motor vehicles as well as the required tools. Furthermore, the specialist workshop carrying out the installation work should have access to the Mercedes-Benz Workshop Information System (WIS).

Read the assembly instructions carefully and install the components in the specified order.
Before starting the installation, check the components included in the scope of delivery for completeness according to the BRABUS parts catalogue. Disassemble/assemble standard components according to the Mercedes-Benz Workshop Information System.
The assembly time for the BRABUS Widestar body kit is about 20 hours (without adhesive curing times). Pay attention to cleanliness during the assembly and observe the bonding instructions on pages 4 & 5.

Painting instructions

The following components must be painted before installation and should be ready painted at the start of installation

- Front and rear shells of the fender attachments (car colour)
- Front and, running board caps and lamp frame (car colour)
- Design elements of the fender attachments and Cover, front and rear (contrasting colour)
- Top parts of the aprons fore & aft, left & right (contrasting colour)
- Externally visible PDC holders or their inserts that are visible from the outside (car colour)
- Front bumper, Insert with struts, license plate holder (car colour) and upper inner radiator housing (suggested paint for radiator housing black, matt finish)
- Rear bumper (car colour) and inlays around reflectors, left and right (contrasting colour)
- Front lip (contrasting colour)
- Underride guard (contrasting colour) ATTENTION: When using a trailer coupling, the underride guard must be cut free in the middle before Painting!

Use the outer packaging of the Widestar aerodynamic components for the safe transport of the components to the paint shop and return transport of the painted parts.

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Important

- Pretreatment -

The adhesive surfaces must be clean, dry and free of grease.
To achieve optimum adhesion, it is necessary to mechanically roughen the surface using 240-grit sandpaper or to use a primer/adhesion promoter. Do not sand the bonding areas of the rear radar sensor brackets!

After roughening, the adhesive surfaces must be cleaned with silicone remover in two stages to remove any grease and release agent residues. The cleaning cloth should be changed after each process.
To fix the bonded components in place until the adhesive has cured, we recommend using suction clamps (e.g. Würth, item number 069155210).

Technical data concerning the delivered adhesive Teroson MS 937 :

Component A, density, white, grey, black, approx. 1.5 g/cm³:
Skin formation time, min*: approx. 5 to 15
Curing speed, mm/24 hrs: approx. 4
Shore hardness A (ISO 868, durometer A): approx. 50
Tensile strength (acc. to ISO 37), MPa: 3.0
Elongation at break (acc. to. ISO 37, speed 200 mm/min), %: approx. 220
Stress at 100% strain (acc. to ISO 37), MPa: approx. 2.0
Change in volume (acc. to DIN 52451), %: ←2
Processing temperature, °C: 5 to 40
Service temperature, °C: -40 to +100
Short-term (up to 1 hr), °C: 120
* ISO 291 standard atmosphere: 23 °C, 50% relative humidity



Important

- Cleaning of the surface -

Before starting bonding with VHB adhesive tape, it must be ensured that the surfaces to be bonded are free of dust and grease and completely dry.
The best result can be achieved using a commercially available silicone remover with which the surfaces to be bonded are thoroughly cleaned in two stages ensuring that any grease and release agent residues are removed. The cleaning cloth should be changed after each process.

- Any finger contact with the adhesive surfaces of the VHB adhesive tape should always be avoided after the liner has been removed!

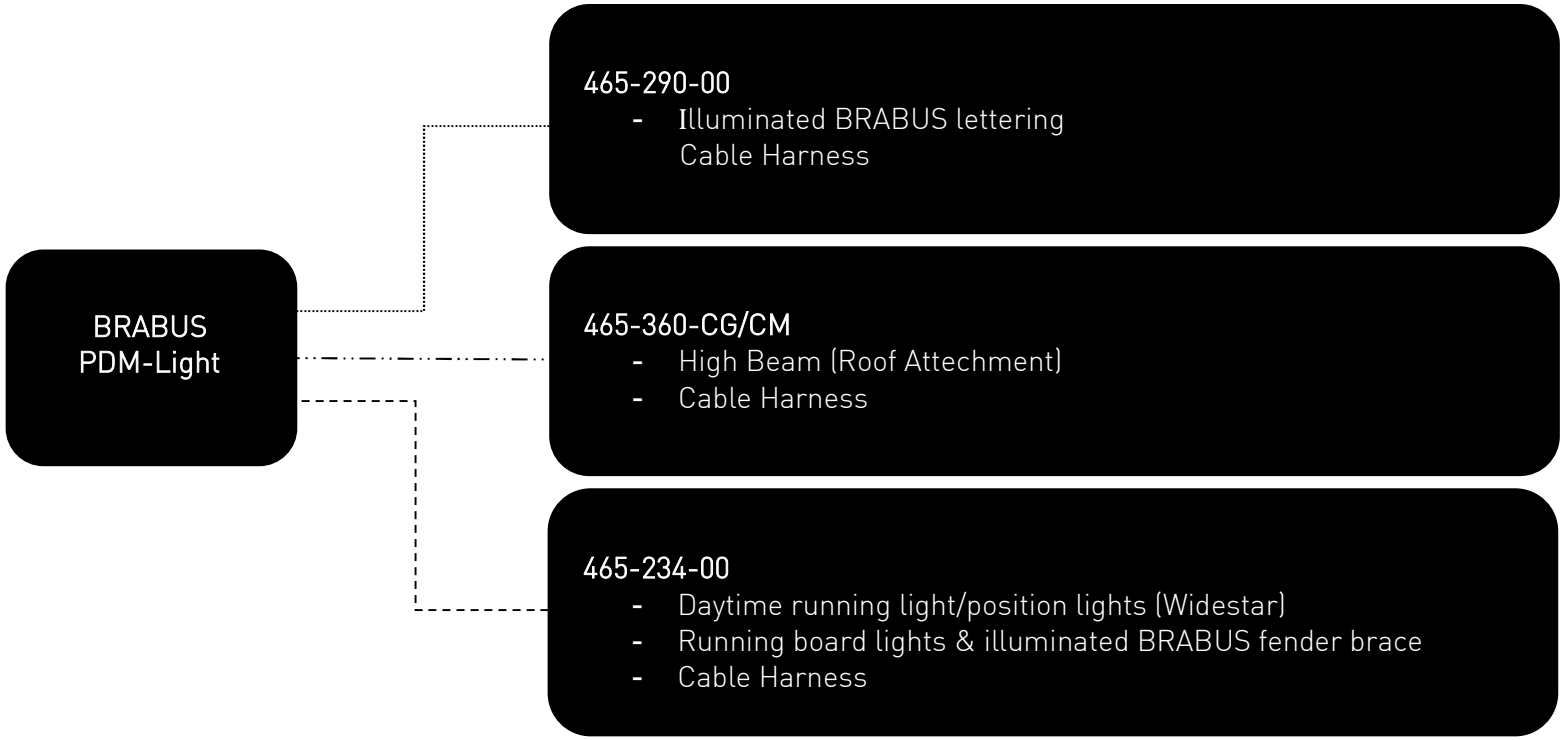
- Workpieces to be bonded should be firmly pressed on over the entire surface after they have been bonded.

- The final bonding stregnth of the VHB adhesive tape is only achieved after 72 hours (at a room temperature of approx. 20 °C).

Heat has an accelerating effect on reaching the final bonding strength.

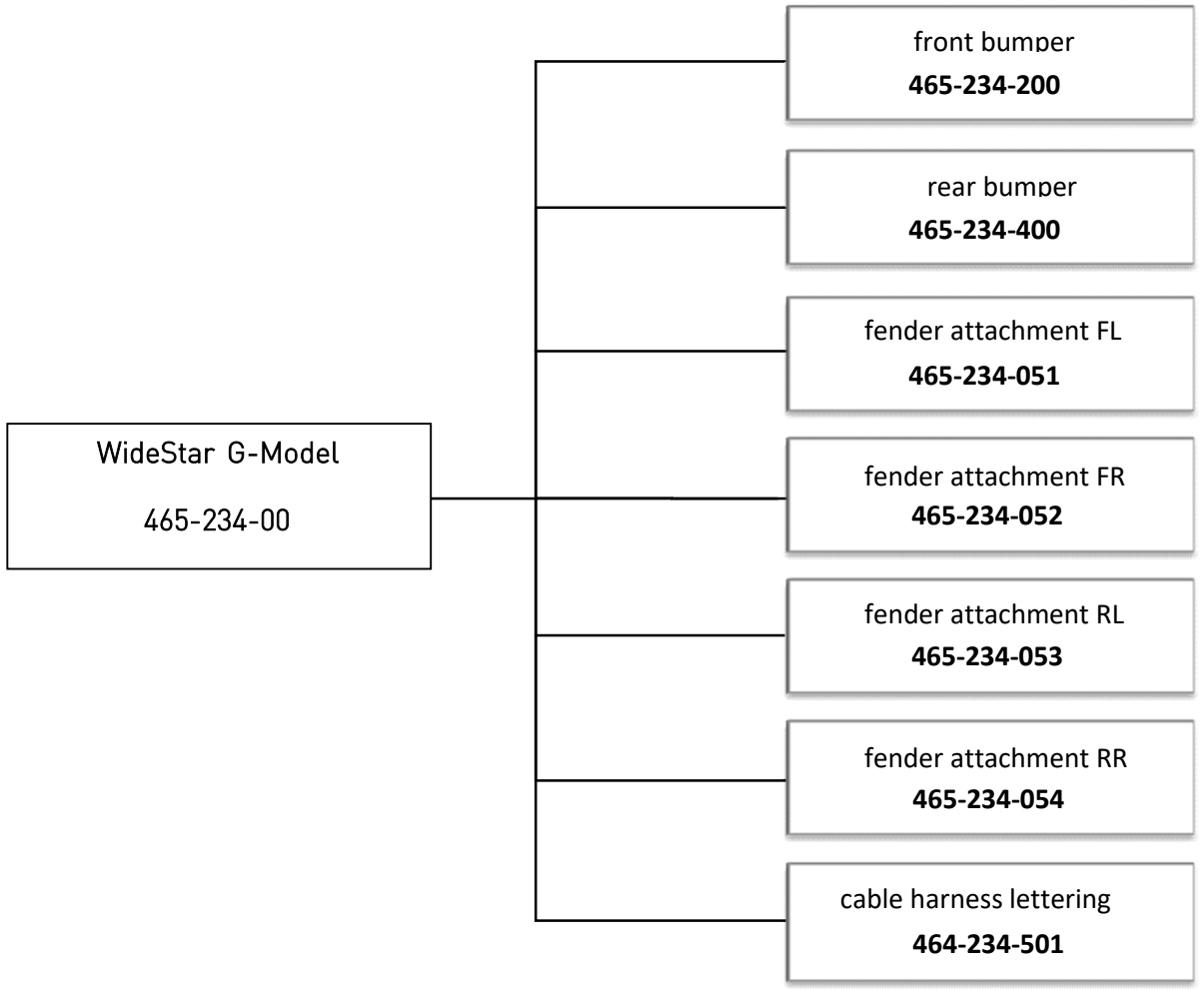
First, the Brabus PDM is to be installed and the further electrical connections to be carried out, then the Widestar body kit is assembled.

The lateral BB logos and the daytime running/position lights are supplied with voltage via the BRABUS PDM (465-PDM-00).
The connection cables of the electrical components for the front bumper attachment are simply connected to the corresponding output of the PDM. When installing the BRABUS PDM, observe the corresponding installation instructions.
Attention: The BRABUS PDM is required 1x per vehicle.



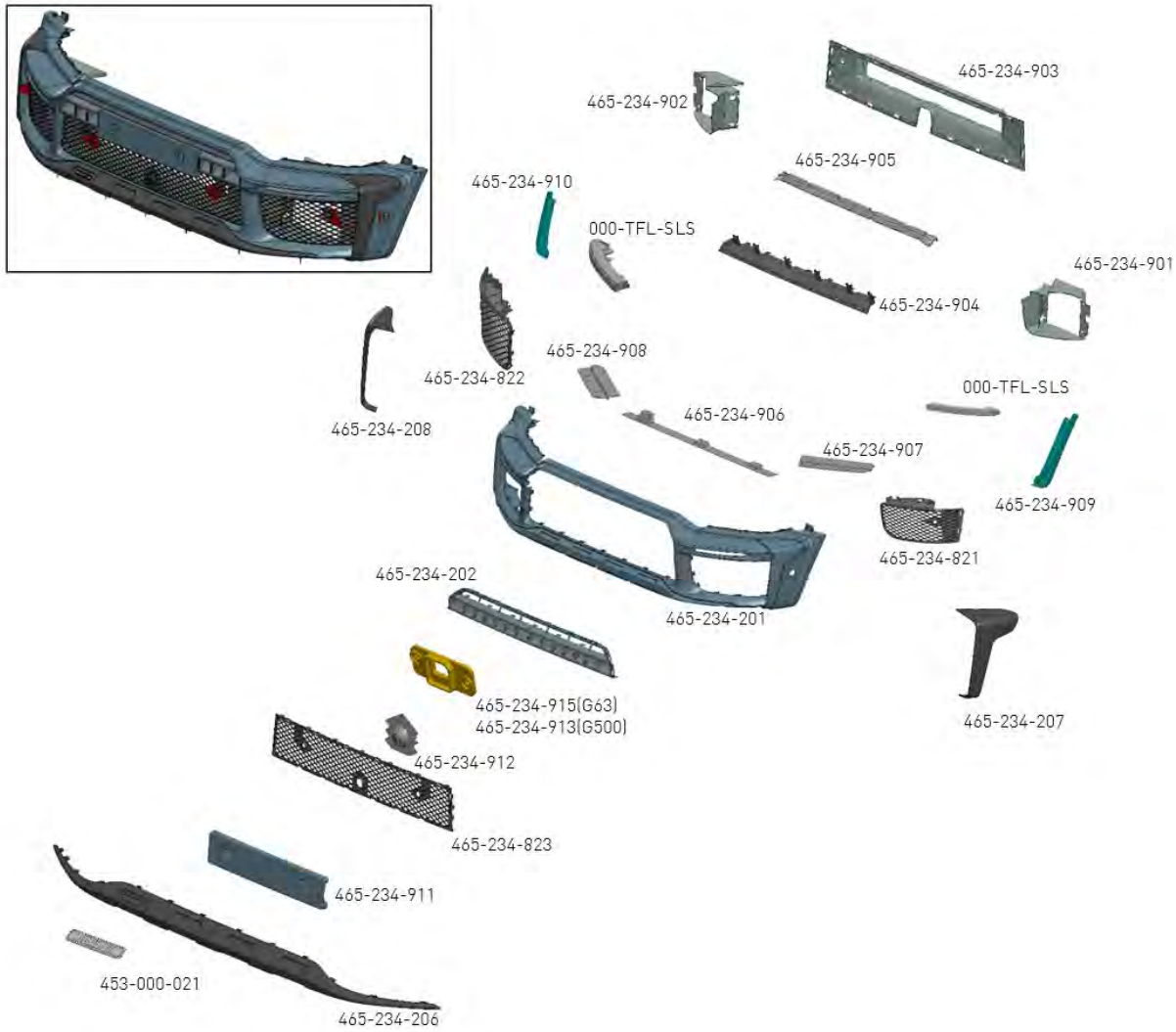
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Presentation of the BRABUS Widestar scopes of delivery



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465-234-200 Front Bumper Widestar and external components



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465-234-400 Rear Bumper Widestar and external components

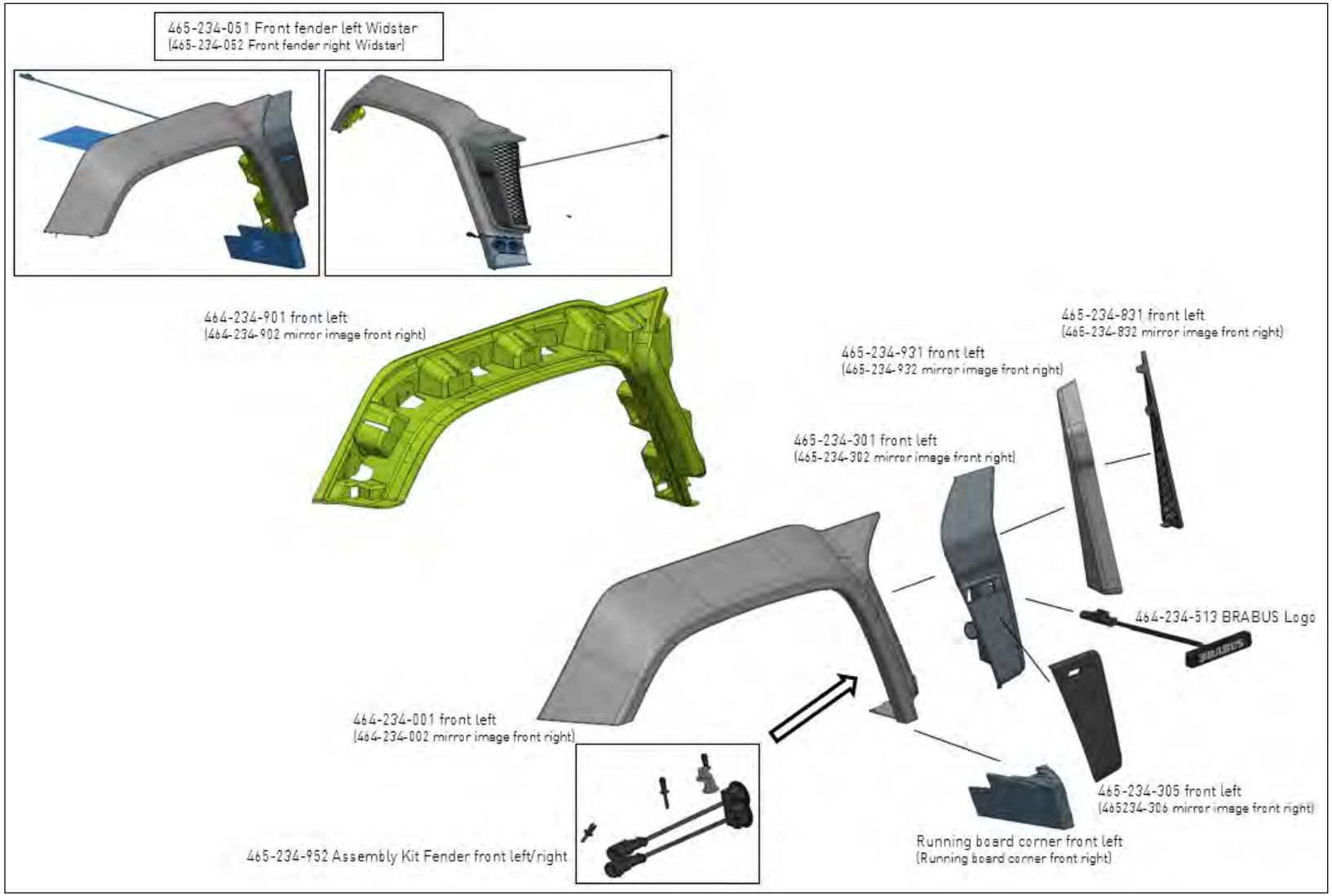




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465-234-051 Front left fender attachment and components

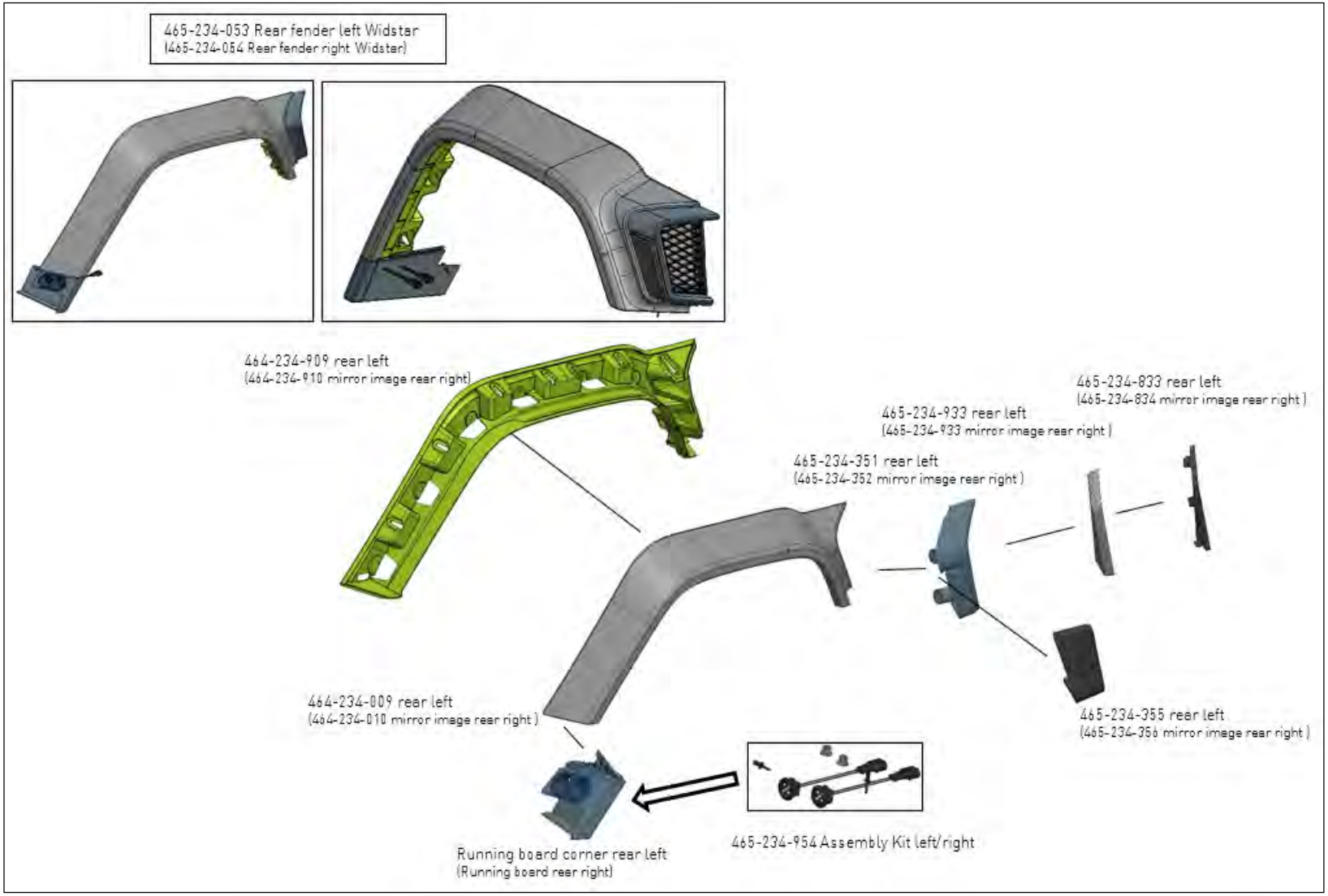
465-234-052 Front right fender attachment and components



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465-234-053 Rear left fender attachment and components

465-234-054 Rear right fender attachment and components



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Scope of delivery Assembly Kits / PTS-Sets:

465-234-992

Kleinteilesatz Frontschürze Widestar
Assembly kit front bumper Widestar

17 x	Q0007371V000000000
2 x	4234412
1 x	453-000-021
4 x	WU42236520
7 x	W4914048100
10 x	000-000-600
10 x	000-000-601
11 x	WE245 026 68
1 x	464-234-919
2x	465-400-501

PTS-465-020

PTS Halter-Set Frontschürze Widestar
PTS bracket kit front bumper Widestar

1 x	PTS-464-021
1 x	PTS-464-022
1 x	PTS-465-023
1 x	PTS-465-024
1 x	PTS-465-025
1 x	PTS-465-026
2 x	PTS-464-027

PTS-465-200

PTS Klebepad-Set Frontschürze Widestar
PTS adhesive pad kit front bumper Widestar

1 x	465-234-914
3 x	PTS-464-051
2 x	PTS-465-027
2 x	PTS-465-028
1 x	000-VHB-AB

465-234-220

Kleinteilesatz Kamerahalter Frontschürze Widestar
Assembly kit camera holder front bumper Widestar

1 x	465-234-912
1 x	465-234-915

465-234-952

Kleinteilesatz Verbreiterung Widestar vorne L/R
Assembly kit fender attachment Widestar front L/R

10 x	22023640
4 x	23006250
2 x	166-351-05
1 x	464-234-513
1 x	2300154A

465-234-994

Kleinteilesatz Heckschürze Widestar
Assembly kit rear bumper Widestar

16 x	Q0007371V000000000
2 x	WU914048100
1 x	453-000-021
10 x	000-000-600
10 x	000-000-601
10 x	WE245 026 68
2 x	465-234-407
2x	465-234-406
2x	A0039949445
1x	465-400-501

PTS-465-040

PTS Halter-Set Heckschürze Widestar
PTS bracket kit rear bumper Widestar

1 x	PTS-465-041
1 x	PTS-465-042
1 x	PTS-464-043
1 x	PTS-464-044
1 x	PTS-465-045
1 x	PTS-465-046
2 x	PTS-464-048
2 x	PTS-465-049

PTS-465-400

PTS Klebepad-Set Heckschürze Widestar
PTS adhesive pad kit rear bumper Widestar

2 x	PTS-465-054
1 x	000-VHB_AB

465-234-954

Kleinteilesatz Verbreiterung Widestar hinten L/R
Assembly kit fender attachment Widestar rear L/R

11 x	22023640
3 x	23006250
2 x	166-351-05
1 x	A1249900492

= Front **= Fender Attachments** **= Rear**

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- Disconnect the earth connection of the vehicle battery in the boot of the vehicle.
- Disassemble the standard assemblies marked below according to the Mercedes-Benz Workshop Information System.
- Dismantle the standard assemblies. The standard components marked on pages 36 & 62 will still be used.
- Disassemble the front left and right entry panel.
- Disassemble the front and rear wheel arch liners.
- Install the BRABUS PDM (465-PDM-00) in the vehicle according to the product-specific assembly instructions.
- Disassemble the the center insert of the rear bumper.
- Taking over the screws for fastening the front license plate holder.
- Taking over the screws for mounting the reversing camera.

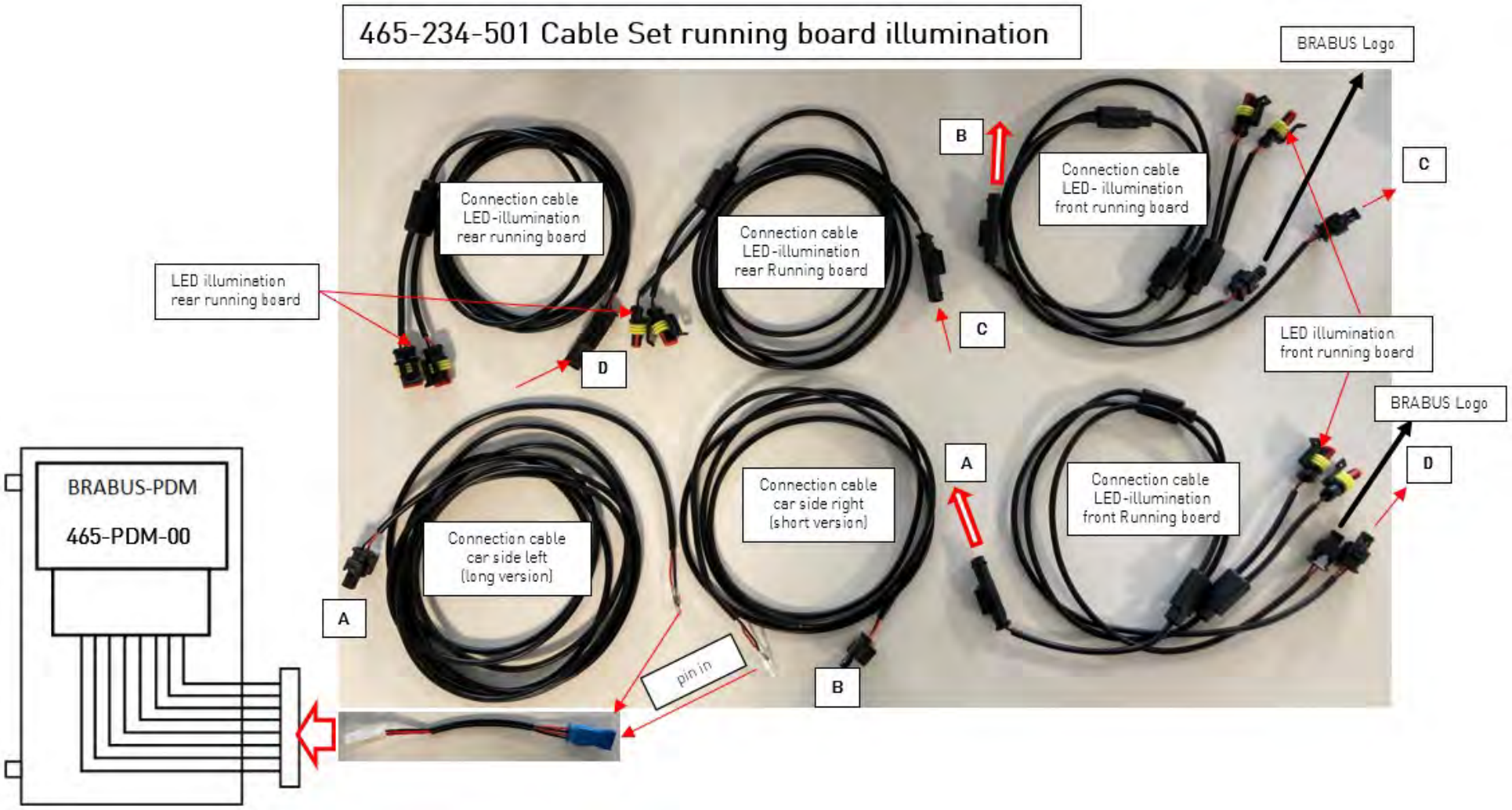
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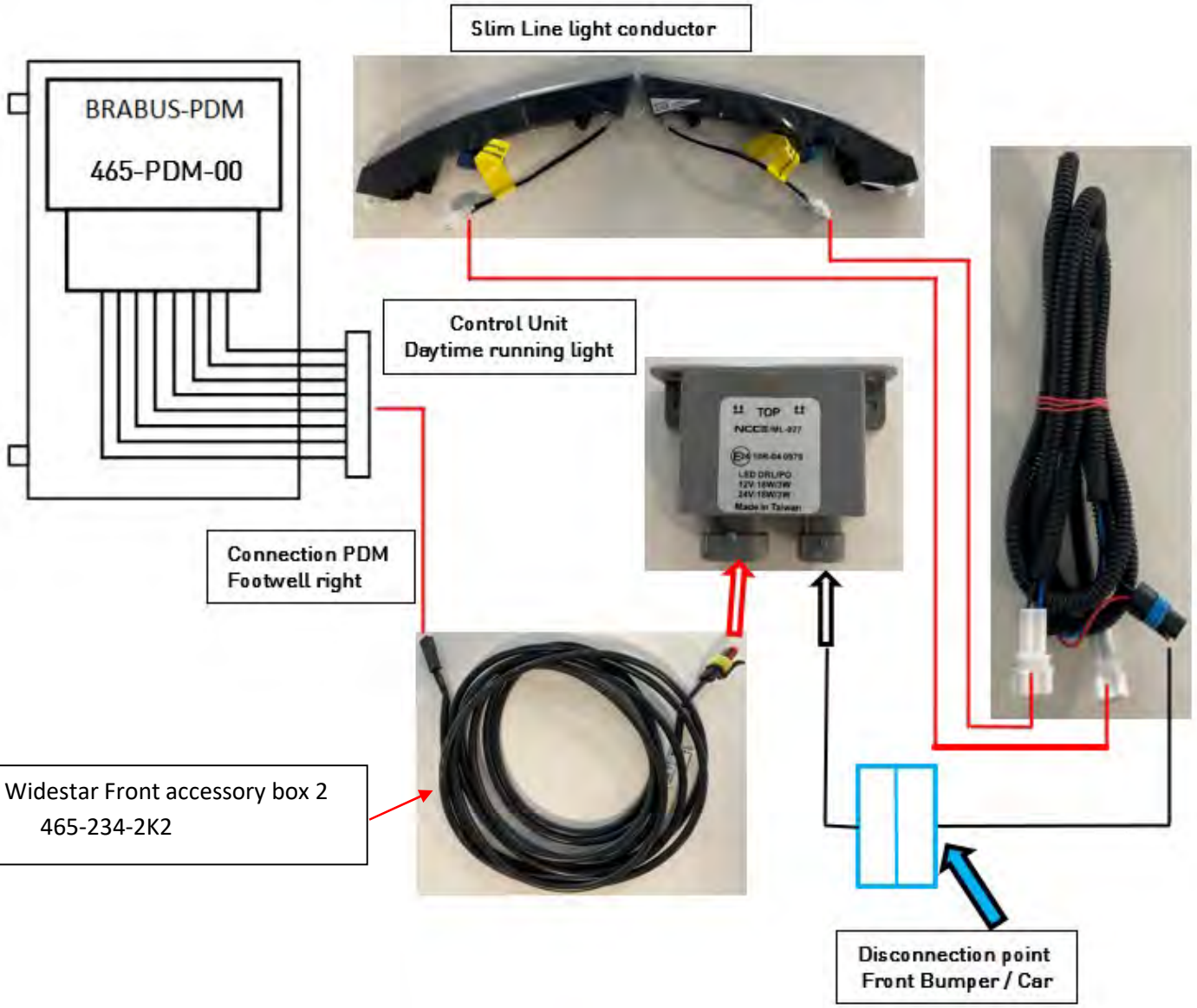




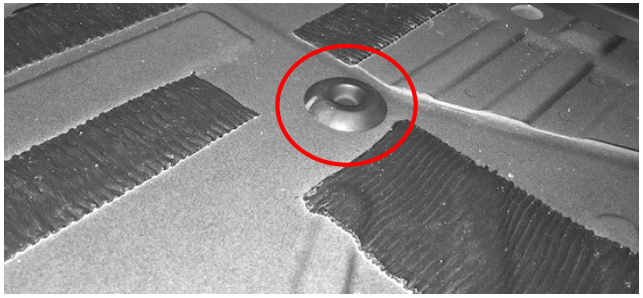
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Installation of the electrical components




Slim Line light conductor
BRABUS-PDM
465-PDM-00
Control Unit
Daytime running light
Connection PDM
Footwell right
Included in Widestar Front accessory box 2
465-234-2K2
Disconnection point
Front Bumper / Car

Lift the floor covering on the rig ht vehicle side and remove the rubber plug shown.

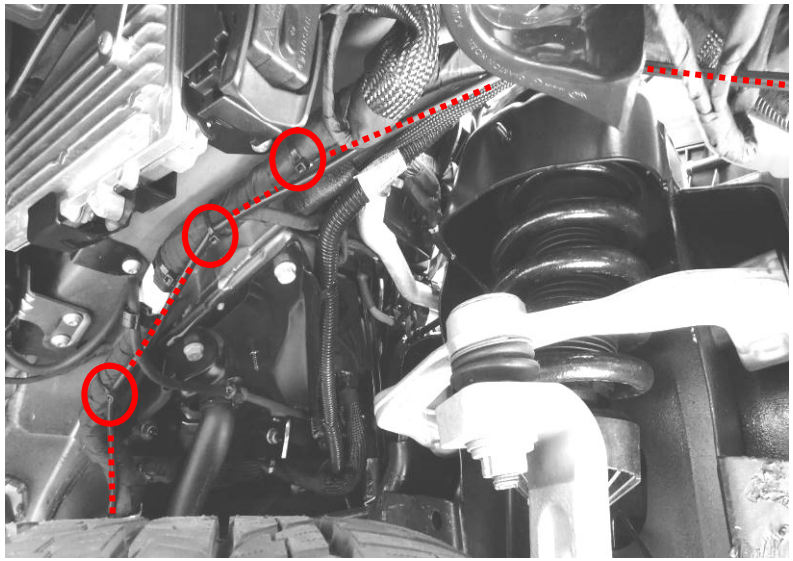


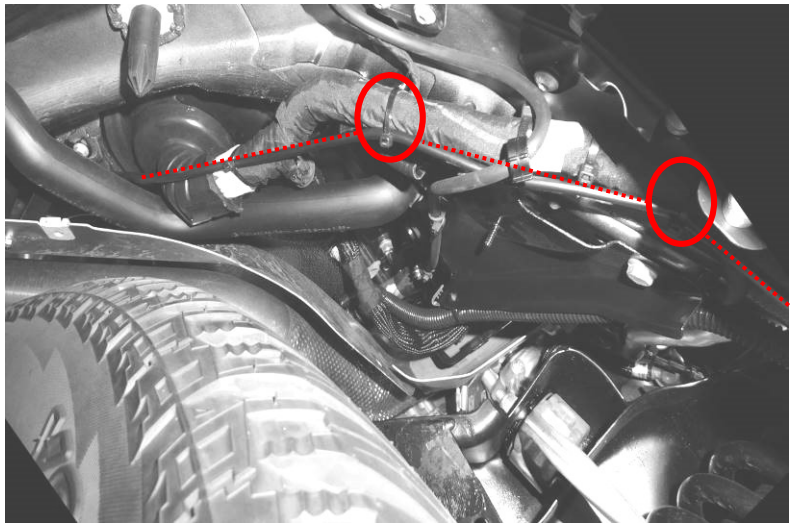
Connect the Widesta r cable harness for the right vehicle side and the daytime running light cable harness to the outputs of the BRABUS PDM (ensuring that the colours match), lay them in the footwell and then through the rubber plug to the outside and in the front right wheel arch using the draw cord .





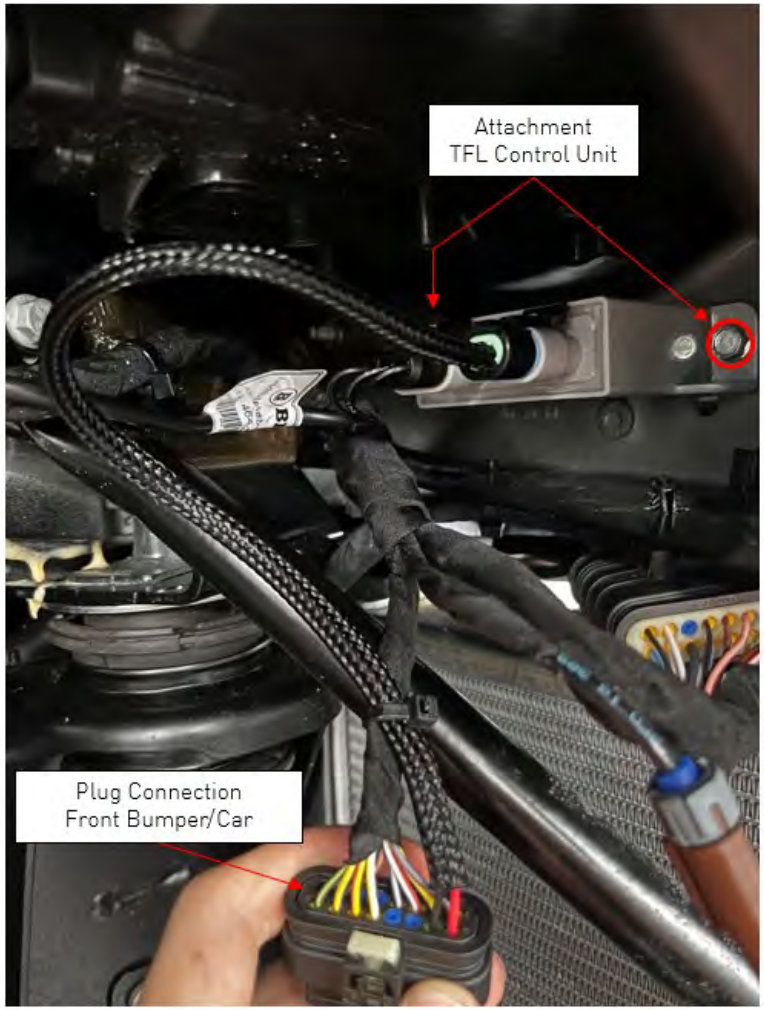
Lay the daytime running light cable harness to the vehicle front as shown and fix it in place along the cable route using cable ties

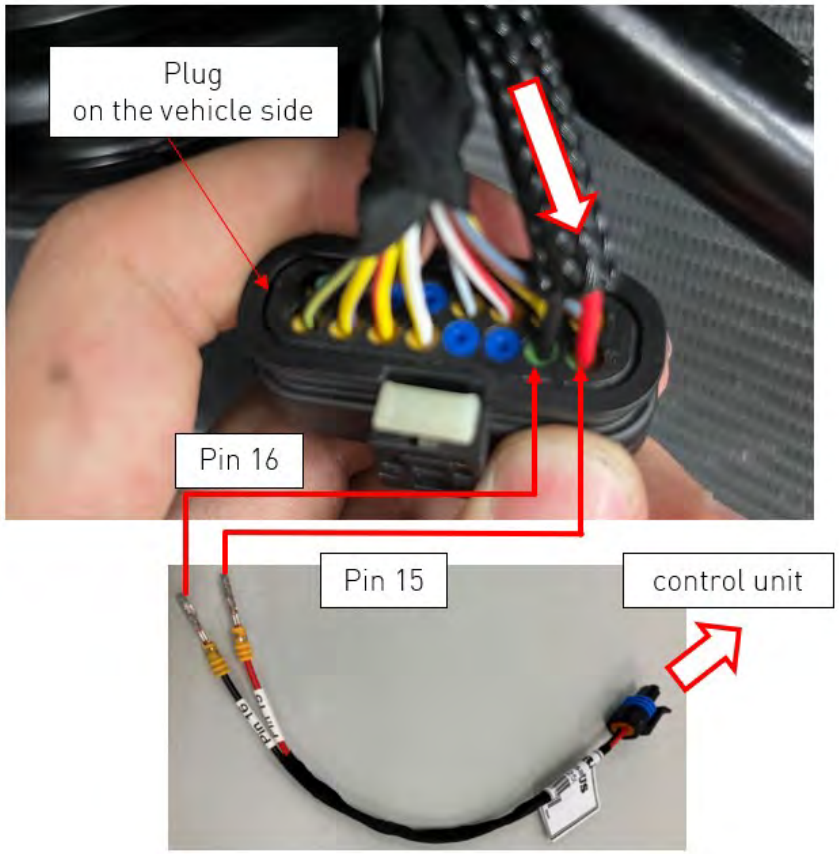




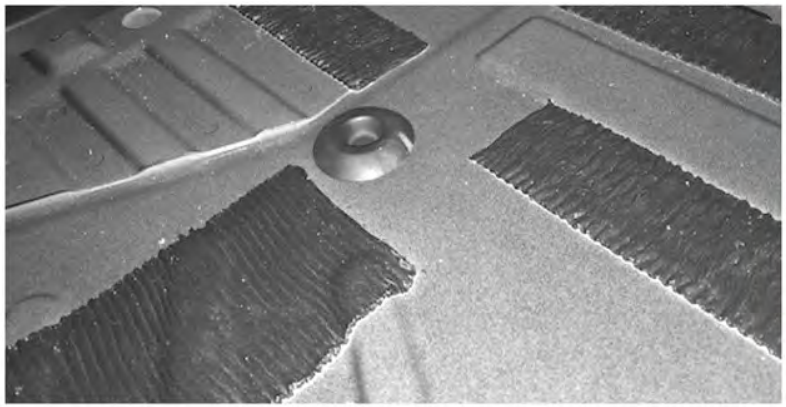
Attach the cable holder of the cable harness to the edge at the frame. Use the delivered Torx screw to screw the day time running light controller to the front longitudinal member on the outer right-hand side in the position shown (above the intercooler, widen the screw-in opening at the controller to Ø6 mm). Connect the electric cable of the daytime running lights to the controller.

Electrical cable for the daytime running lights: Pin the two cable ends of the wiring harness into slot 15 (red) and slot 16





Connect the Widestar cable harness for the left vehicle side to the BRABUS-PDM ensuring that the colours match. Lay the cable harness below the dashboard to the left vehicle side. Lift the floor covering on the left vehicle side and remove the rubber plug shown.





Lay the Widestar cable harness for the left vehicle side through the rubber plug to the outside and in the front left wheel arch using the draw cord.

Connect the front cable harnesses to the Widestar ca ble harnesses.

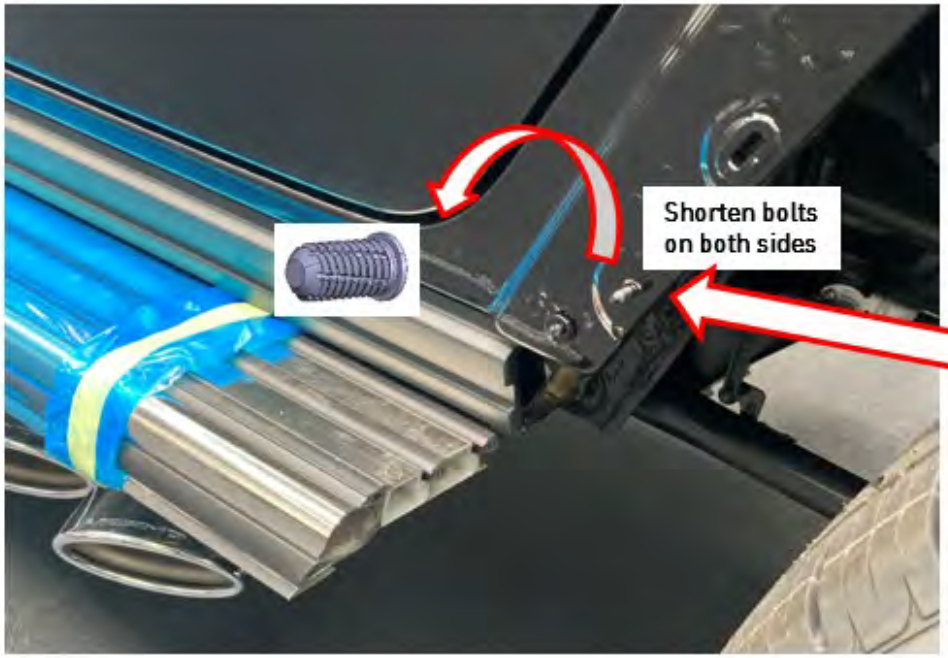
Connect the cable harnesses for the rear running board caps to the front left/right cable harnesses and lay them to the rear through the left/right running

Lay excess cable harness es in the two front wheel arches in loops and fix them in place using cable ties.



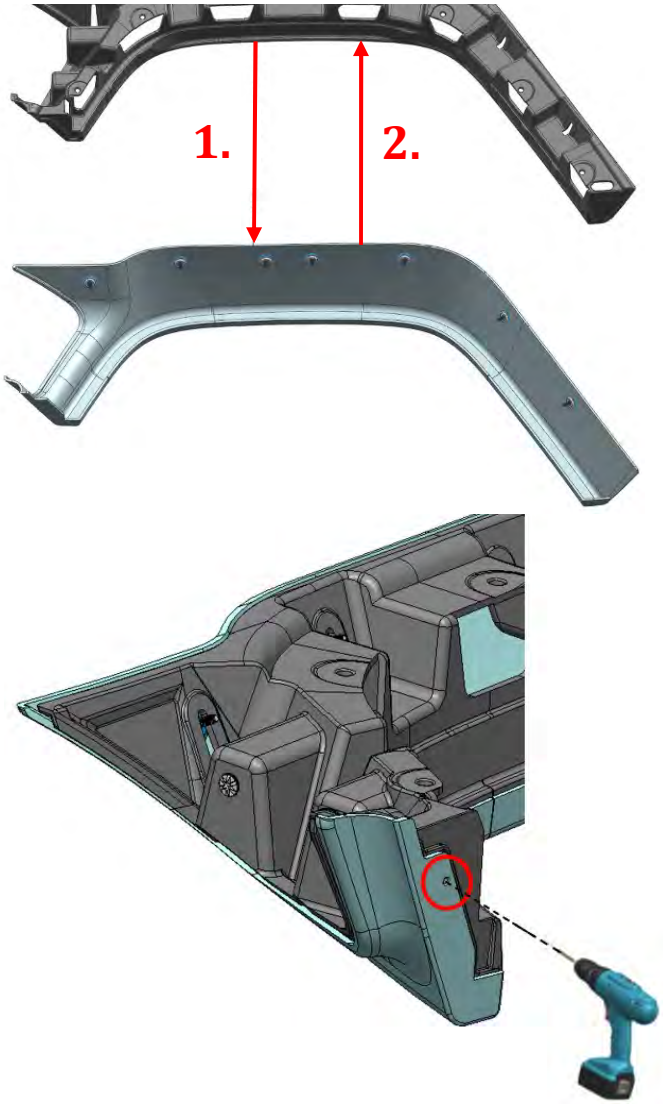
Assembly of rear fender attachments

Use a suitable tool to cut the lower standard self -cutting threaded bolt (marked red) to the required length before assembling the carrier and protect the cut surface against corrosion.

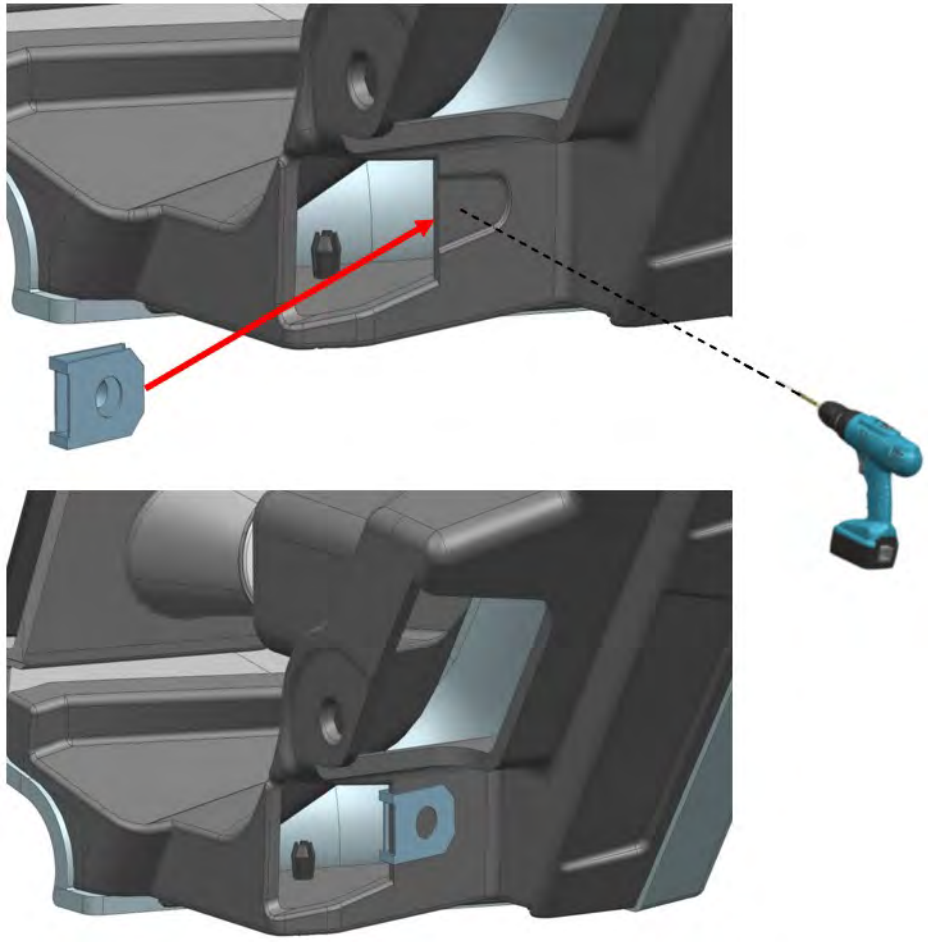




Insert the carrier into the shell from above and use a suitable Ø 5.5 mm drill bit to drill hole in the position shown. Remove the carrier from the shell.

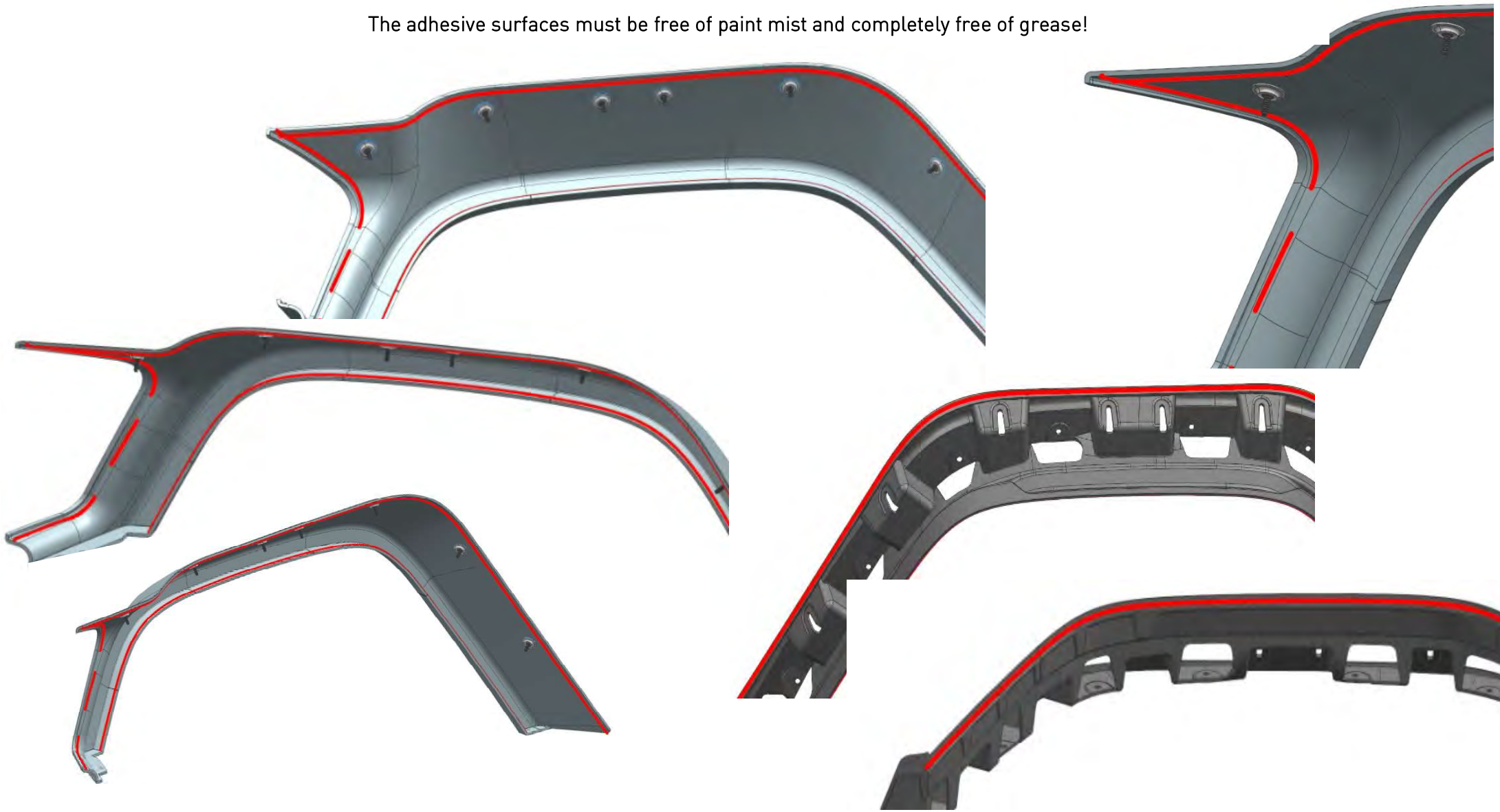


Remove the sheet metal nuts of the screw connections to the rear bumper from the original standard attachments and attach them to the fastening points of the carriers of the Widestar fender

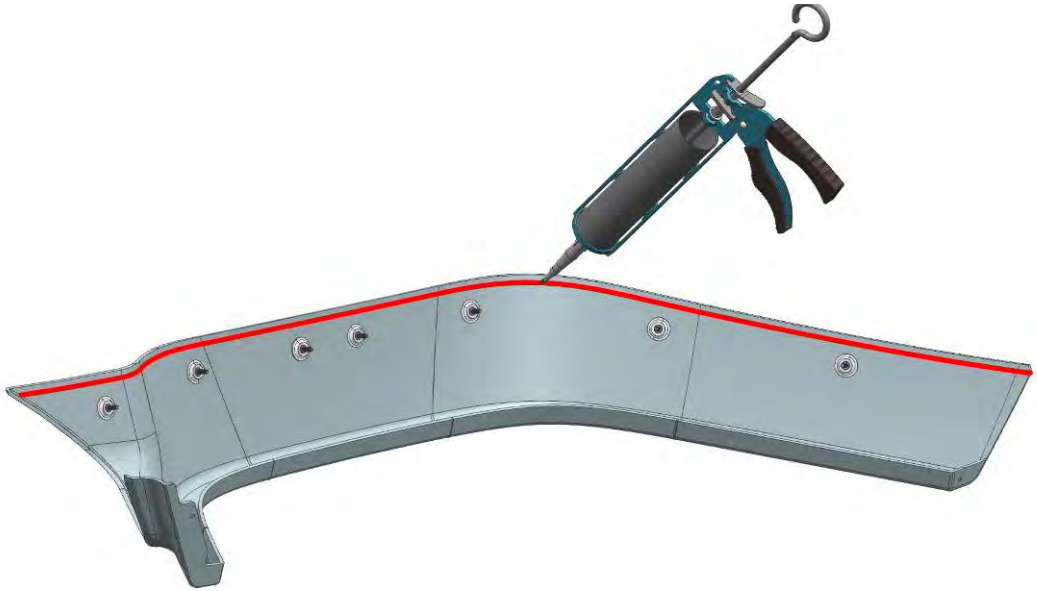


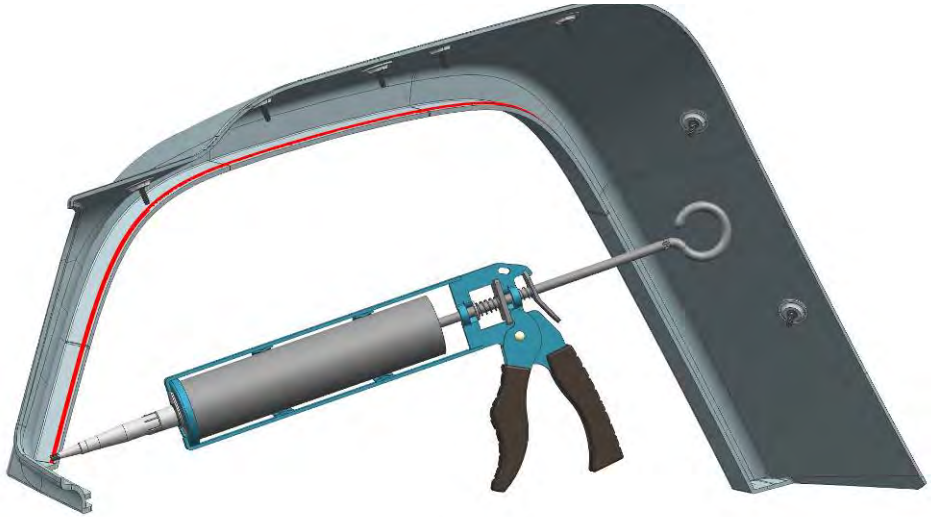
Use sandpaper (240-grit!) to roughen the adhesive surfaces of the shell and carrier which are marked red in the pictures on the following pages and clean them thoroughly afterwards using silicone remover in two stages.

The adhesive surfaces must be free of paint mist and completely free of grease!



Apply even adhesive beads to t he adhesive surfaces as shown. Apply the adhesive beads at a distance of appr ox. 3 - 4 mm to the outer edges. The opening of the adhesive tip should have a diameter of 4 - 5 mm.



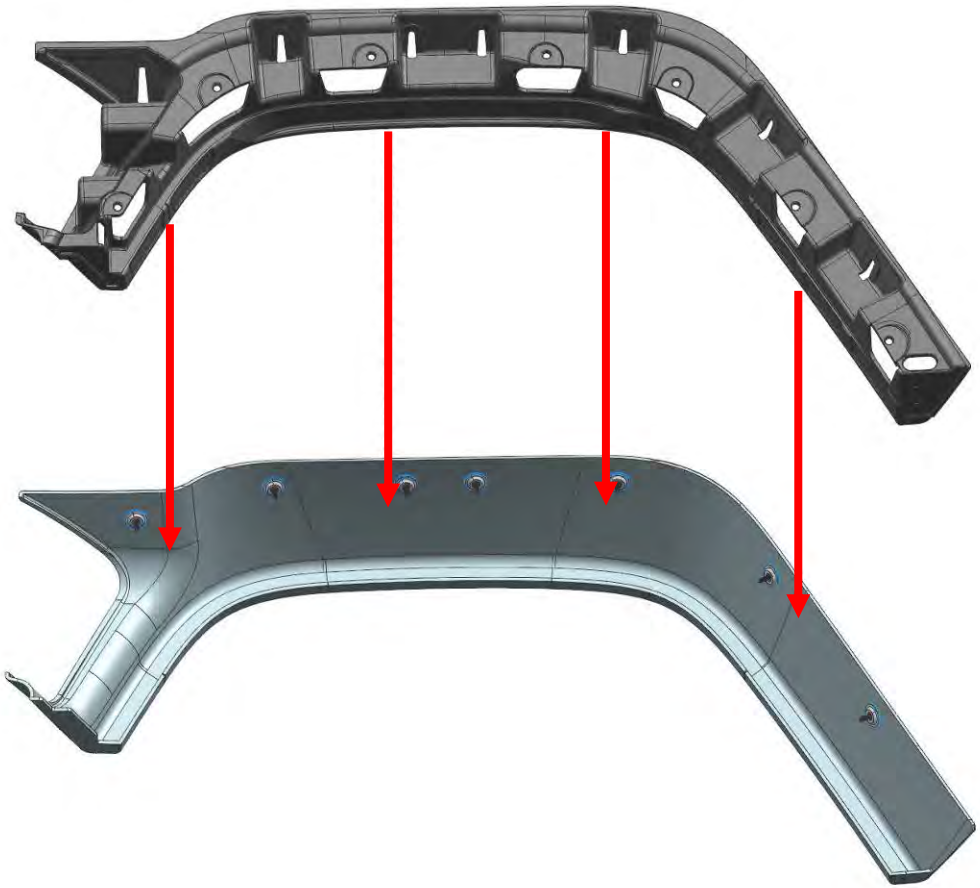






Attach carrier to fender attachment from above.

Attention: Remove excessive adhesive immediately!

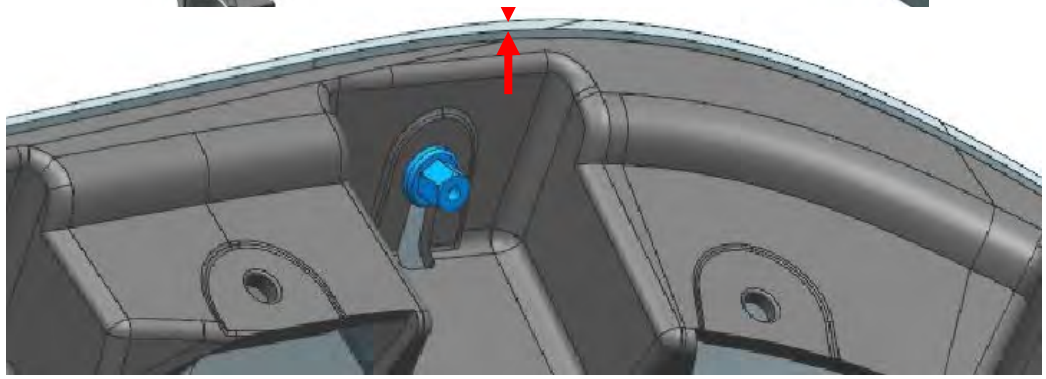


Screw the plastic nuts onto the threads and tighten them hand-tight.

The fender attachment must protrude the carrier edge for 2 -3 mm!



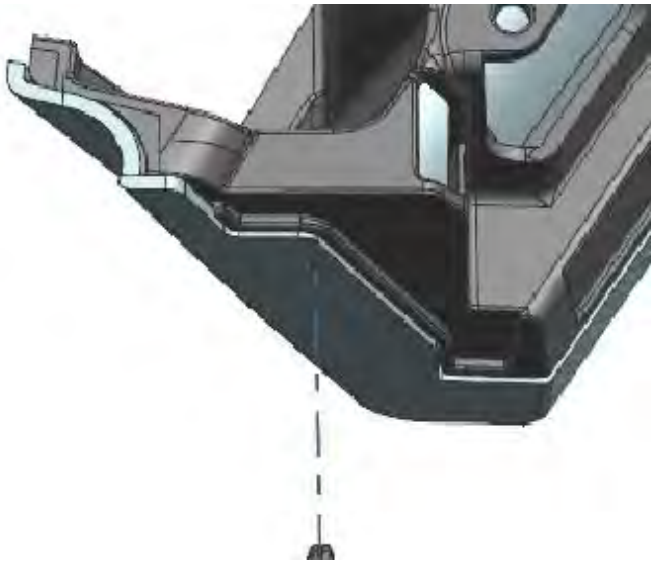




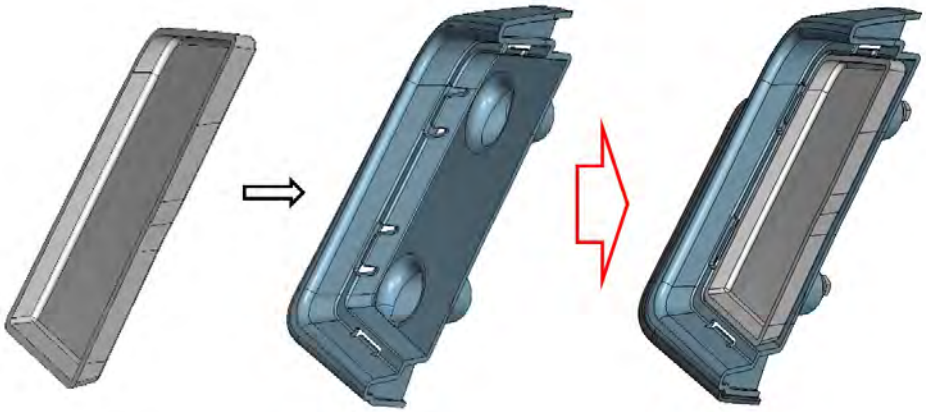
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Insert the plastic expanding rivets into the fender attachments as shown.

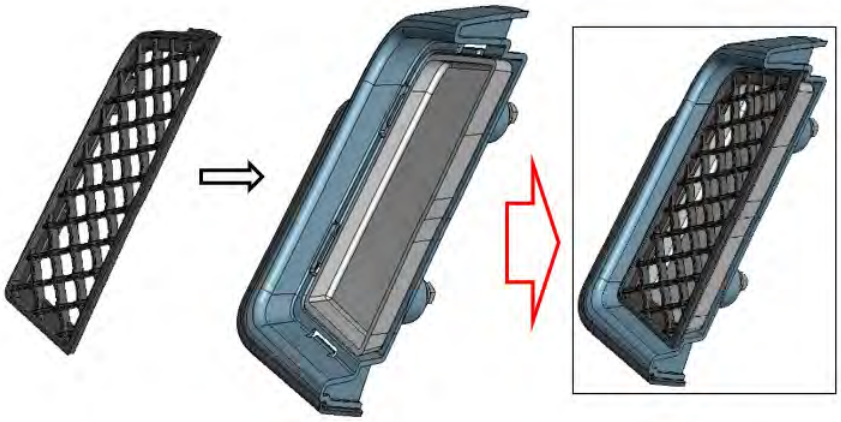




Glue bowl to the frame



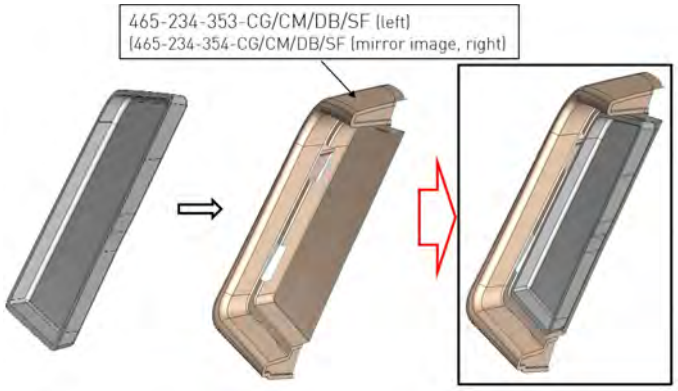
Clip the grille to the frame



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Carbon-Package 3

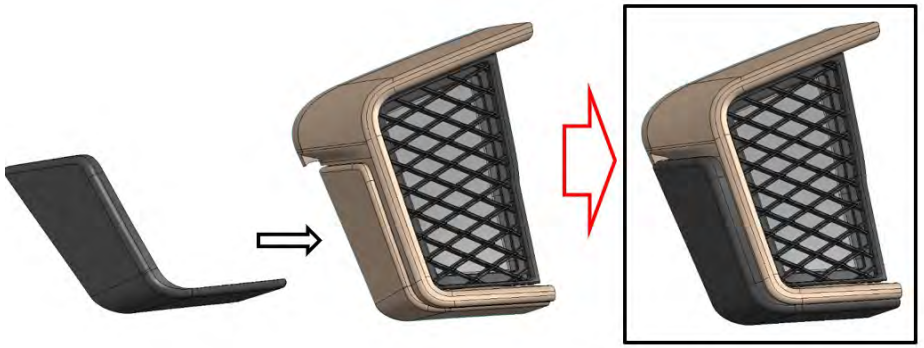
Gluing the shell to the carbon trim



Gluing the decorative grille to the carbo n decorative frame

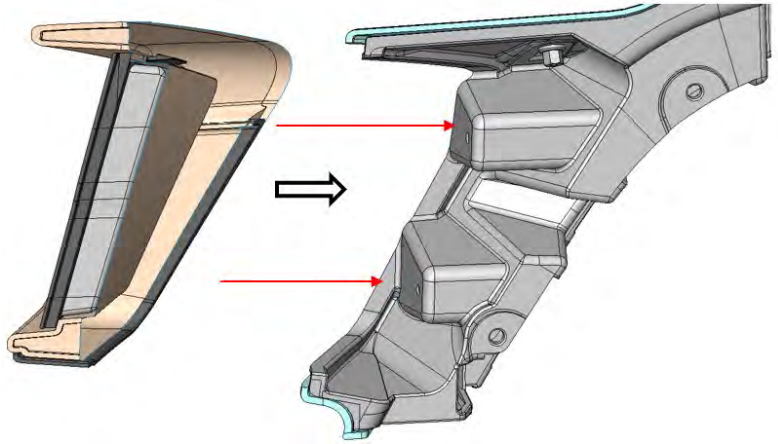


Gluing the cover to the carbon trim frame



Glueing the decorative frame with mudguard attachments .

(continue on page 27)

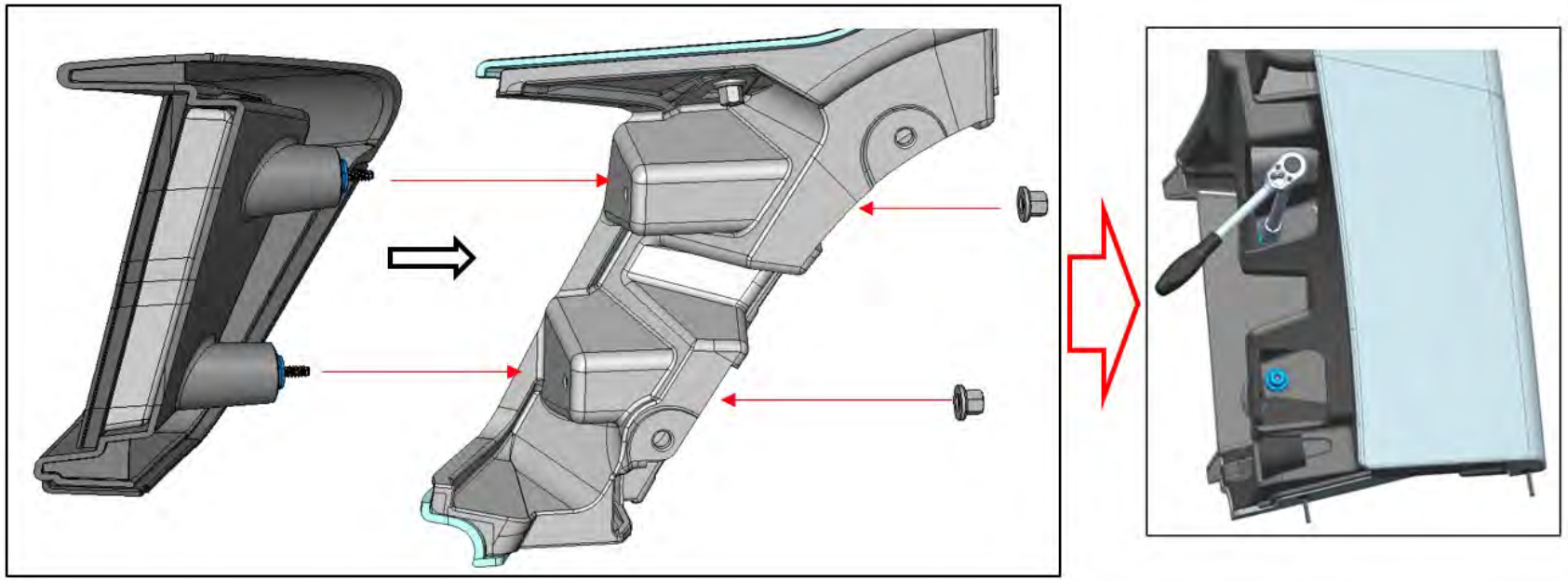


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Glue the cover to the frame.



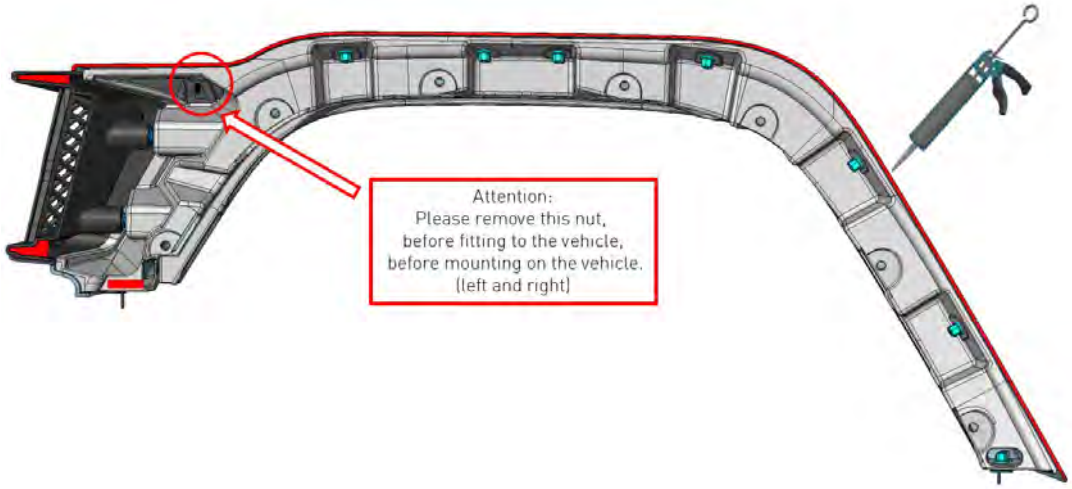
Loosely attach the design air outlets of the rear mudguard attachments us ing the plastic nuts supplied (22023640). Do not tighten the nuts at this stage!



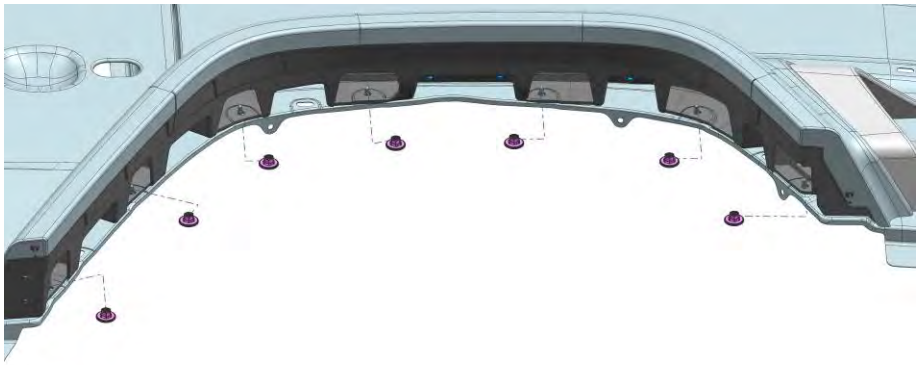
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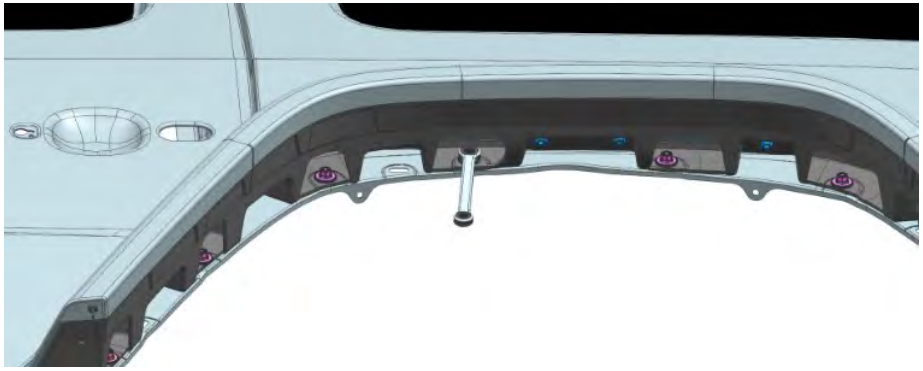
Use sandpaper (240 -grit!) to roughen the adhesive surfaces of the rear air outlets and clean them thoroughly afterwards using silicone remover in two stages.

Apply even lines of adhesive to the red marked bonding surfaces. The opening of the adhesive tip should have a diameter of 4 - 5 mm.

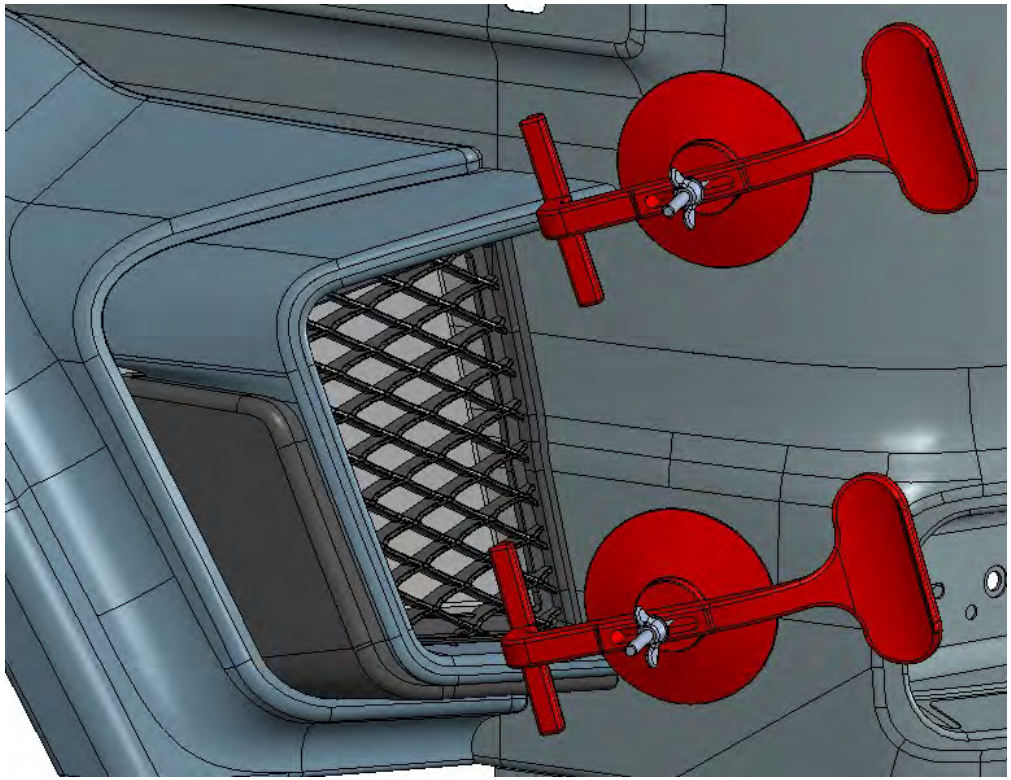


Attach the completed fender at tachments to the standard fixation rods of the vehicle and bolt them on with plastic nuts supplied (22023640).





Align the design frame of the rear fender atta chments and fix the design frame in place using appropriate measures as shown until the adhesive has finally cured. We recommend using suction clamps.



Tighten the plas tic nuts of the rea air outlets.

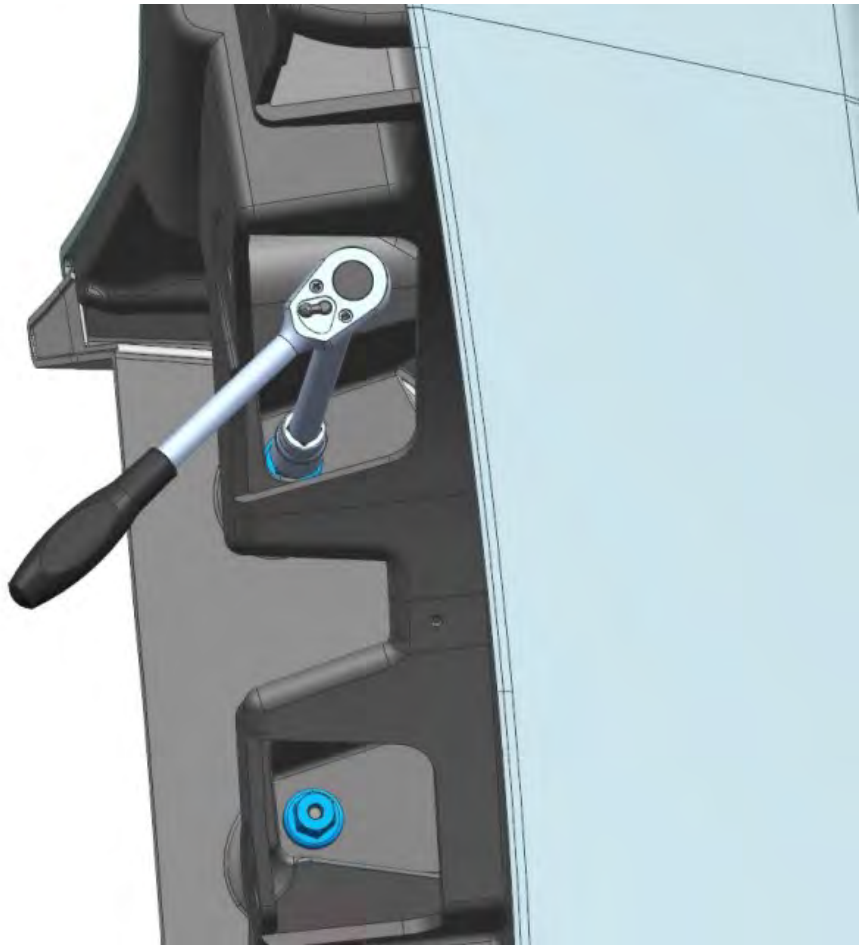
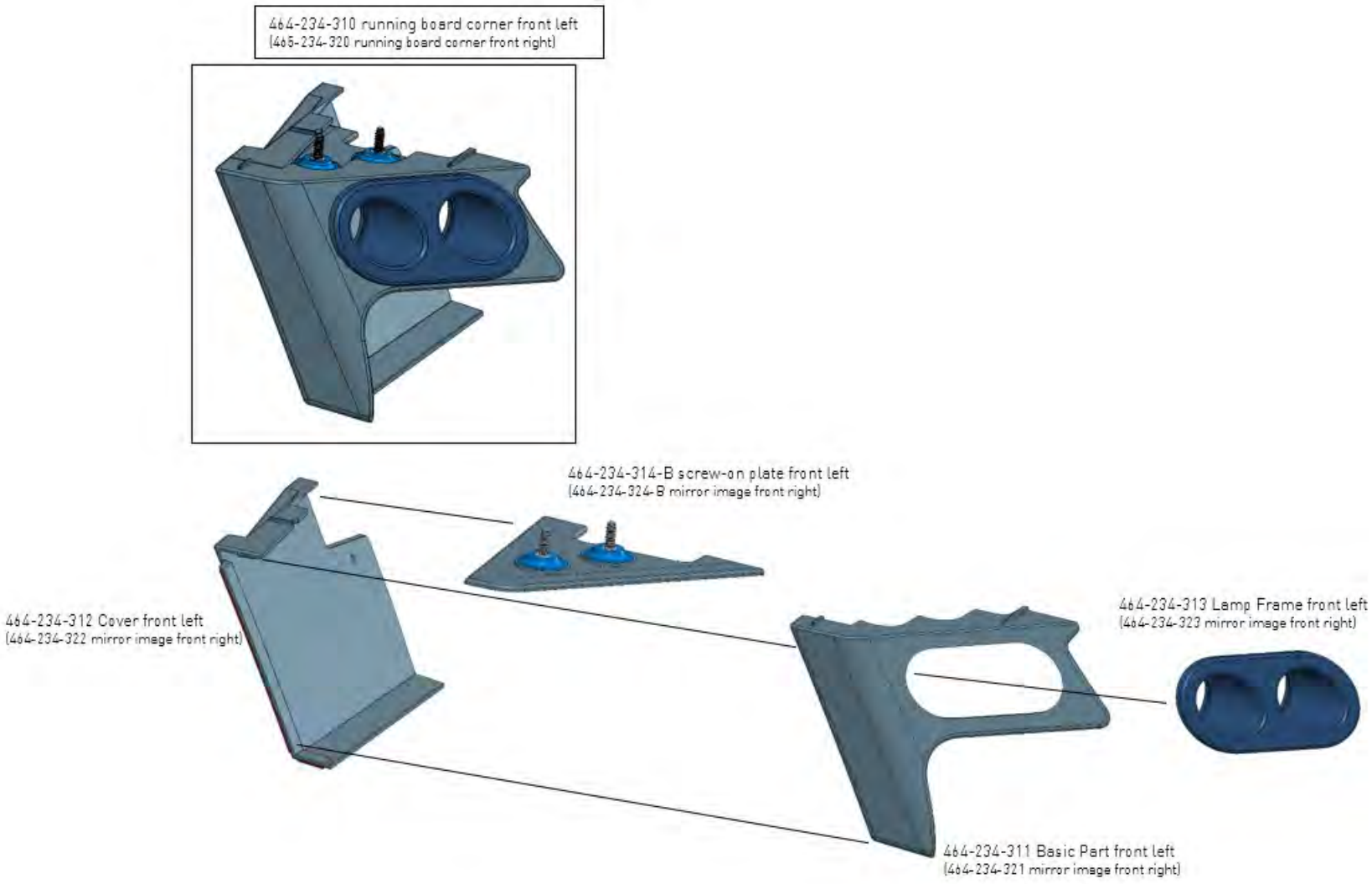
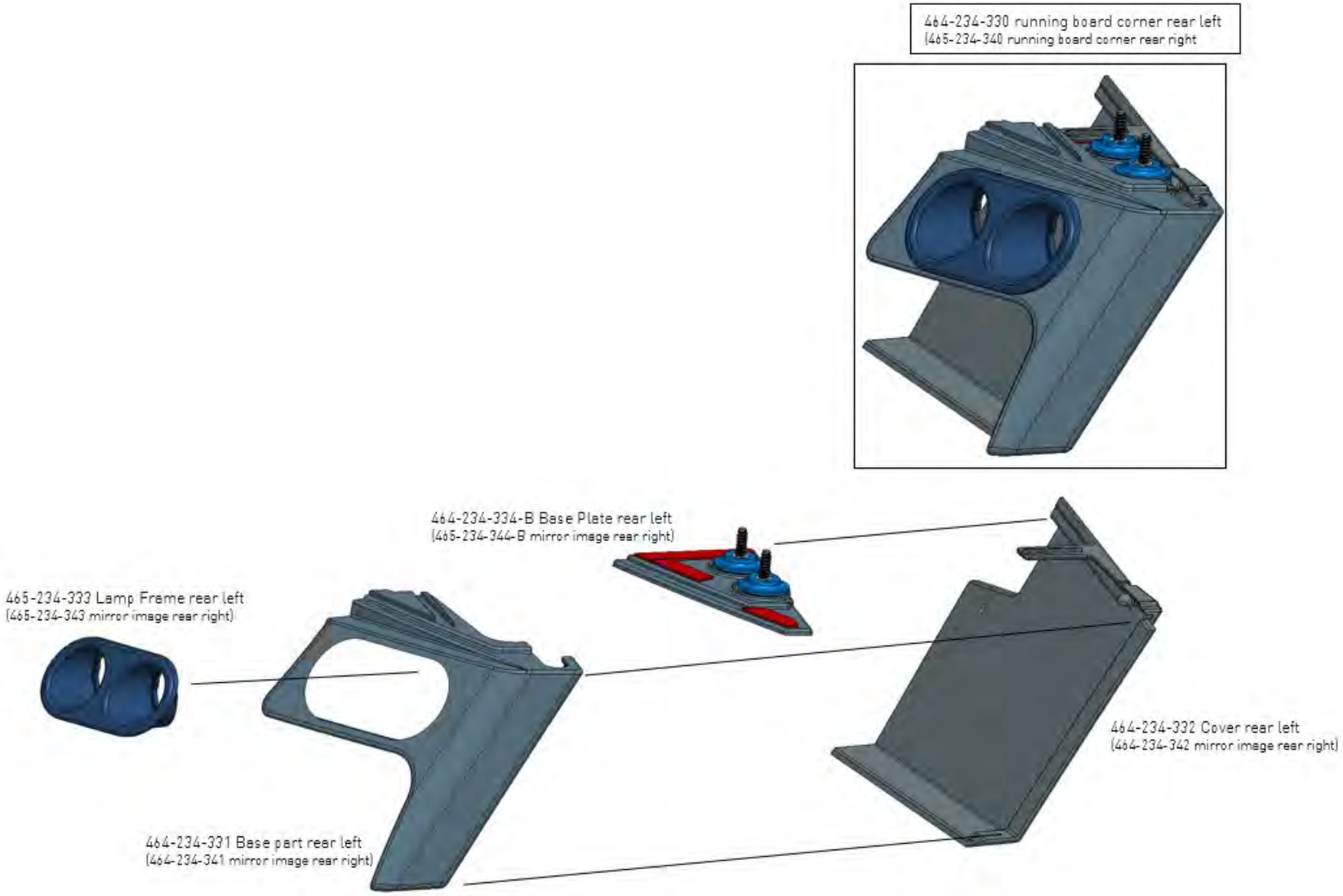


Illustration running board corners front left



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Illustration running board corners rear left



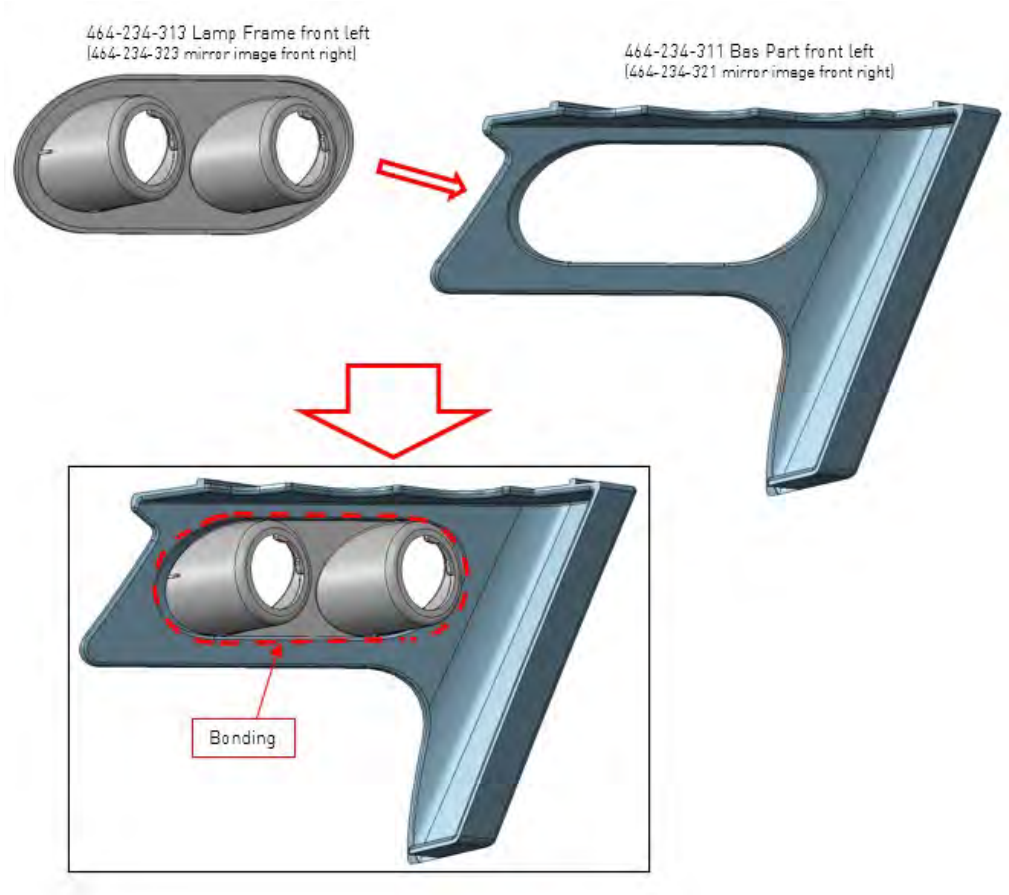
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Bonding of front running board corners

The following instructions provide a better understanding when assembling the running board corners. The bonding of a running board corner at the front is visualized as an example.

! Remember to paint the base plate as well as the LED- light support in car colour before gluing!

Clean the components carefully with a suitable cleaning agent. The components must be free of dust and grease!

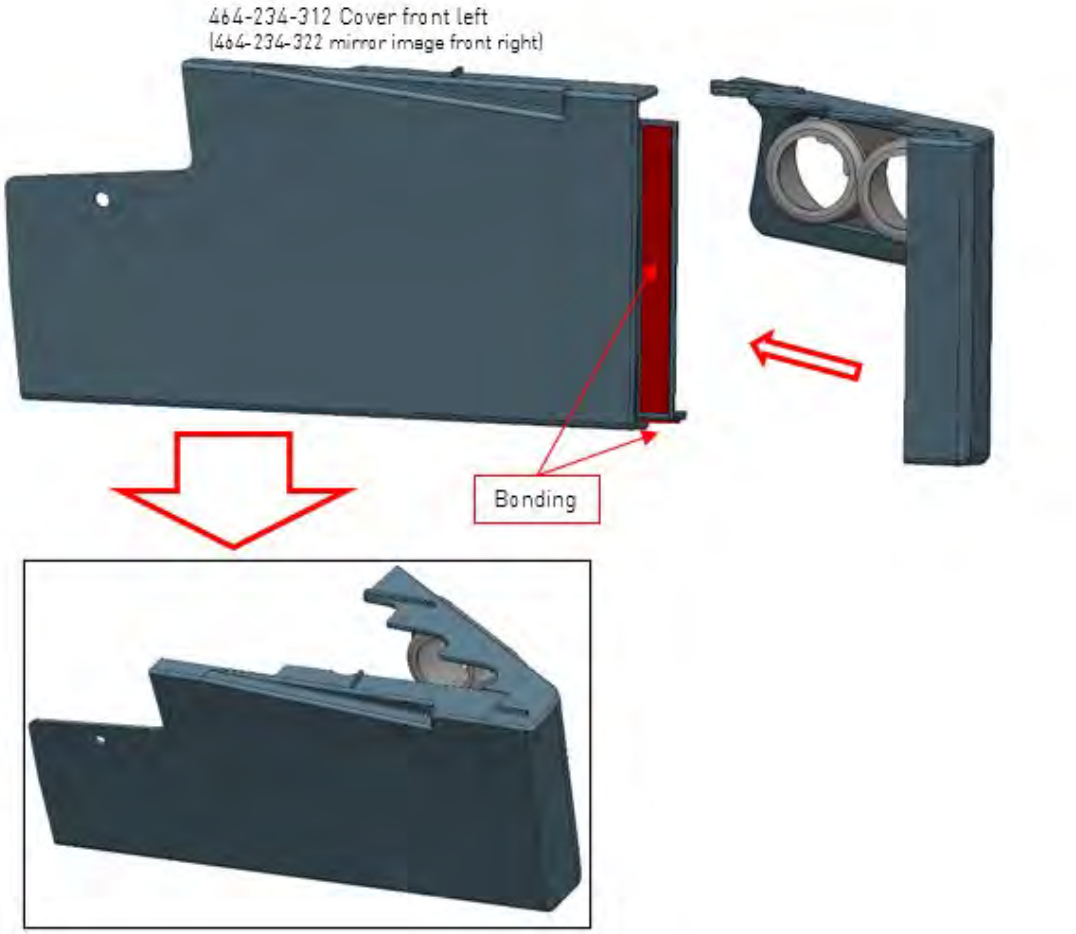


- Apply a suitable primer to the marked areas (inside of the components)

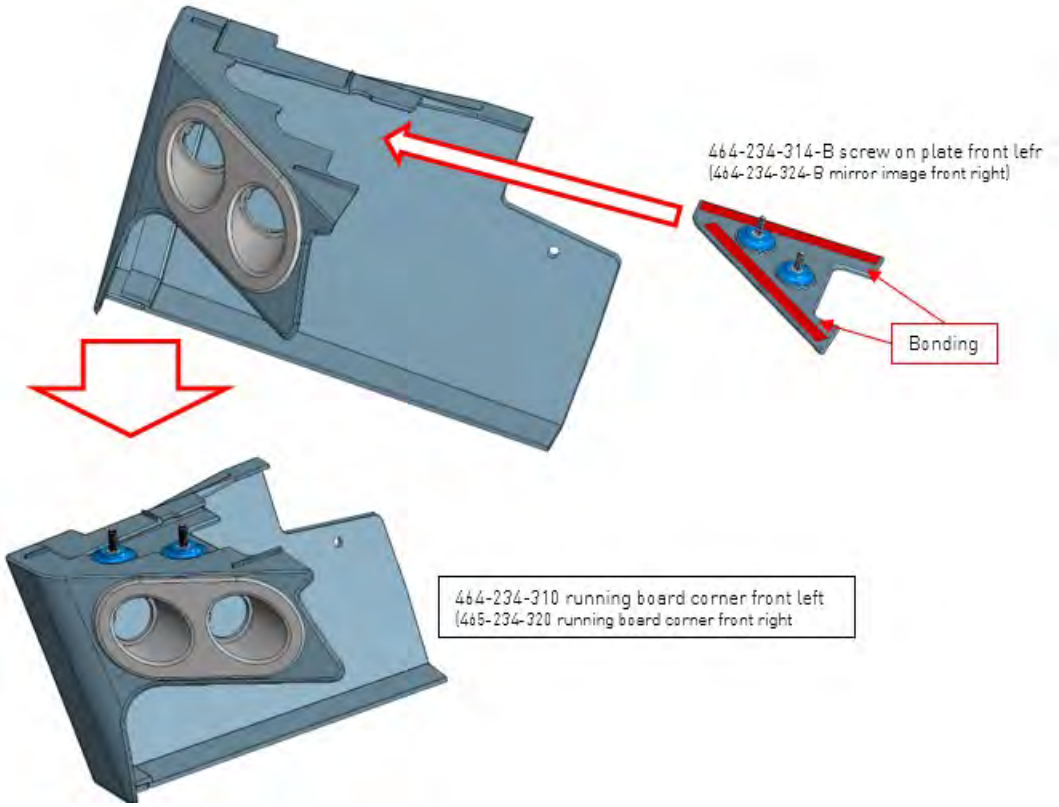
- Allow the surfaces to flash off.

- Insert the lamp frame into the base part, align it, fix it in place with adhesive tape and glue the two components together on the back with PU adhesive.

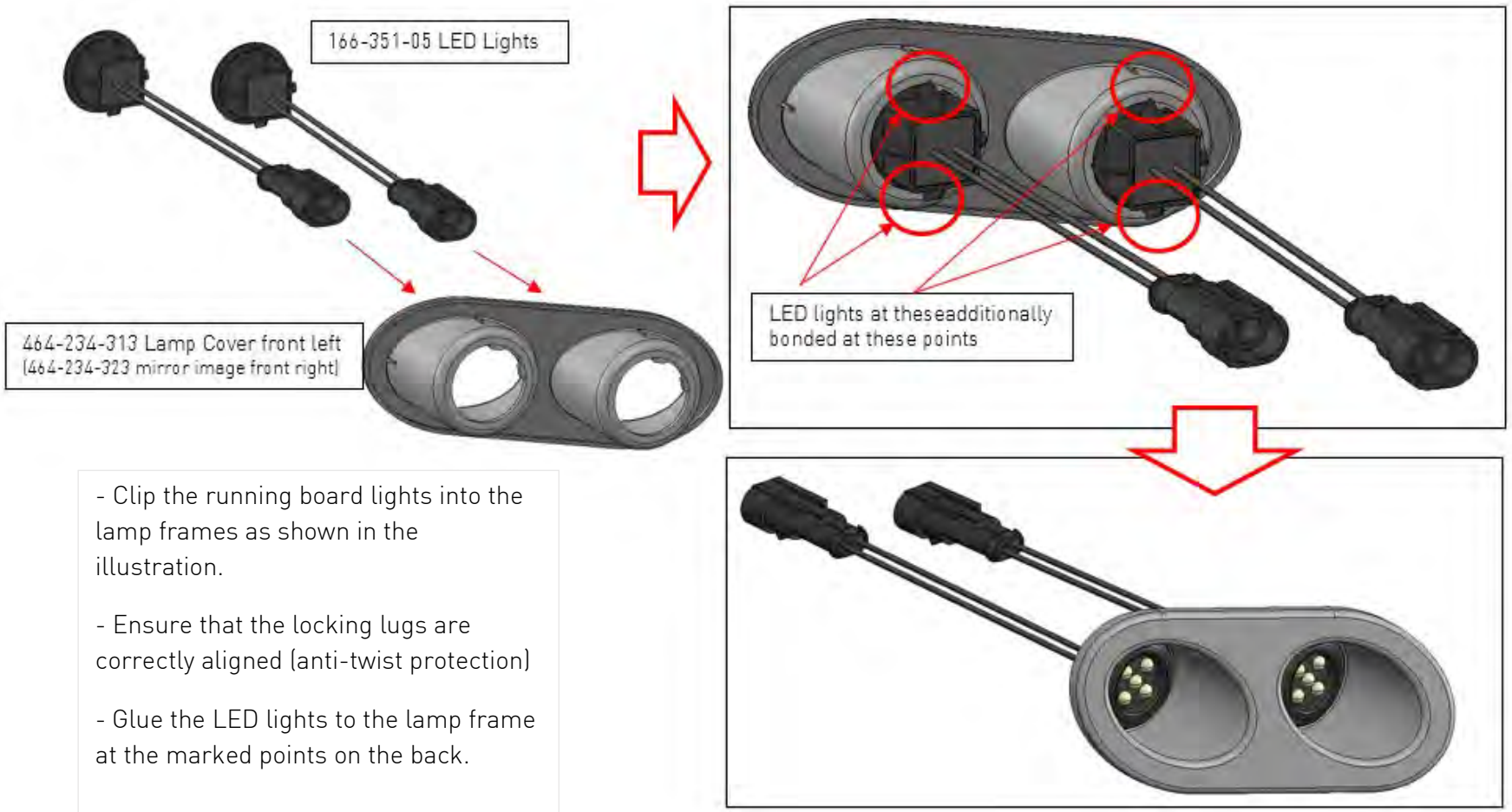
- Fix the components with suitable means until the adhesive has finally hardened.



- Remove liner 1 of the VHB- adhesive tape (marked red).
- Press the mounting plate and the cover together.
- Apply pressure to the components to achieve optimum adhesive strength.



- Remove liner 1 of the VHB- adhesive tape (marked red).
- Press the mounting plate and the cover together.
- Apply pressure to the components to achieve optimum adhesive strength.

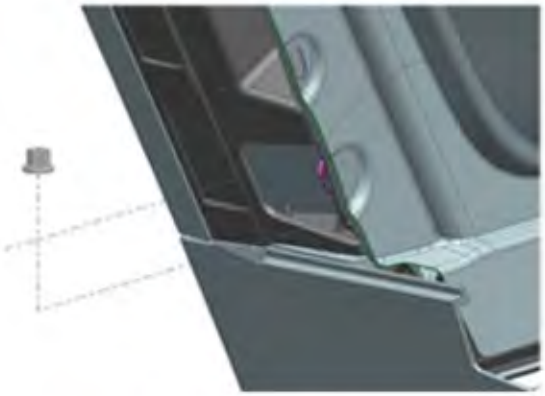


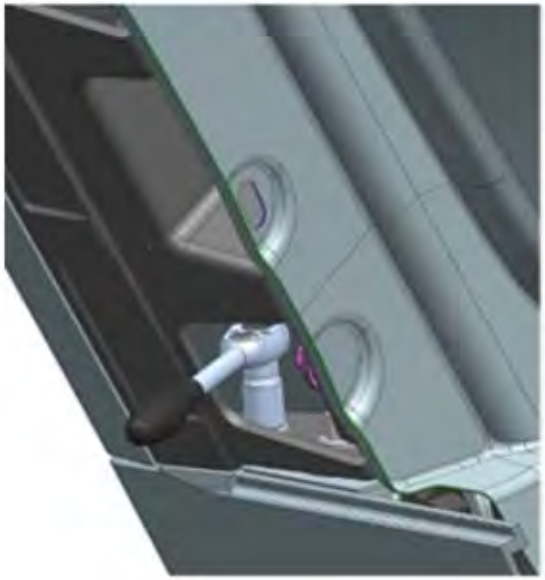
- Clip the running board lights into the lamp frames as shown in the illustration.

- Ensure that the locking lugs are correctly aligned (anti-twist protection)

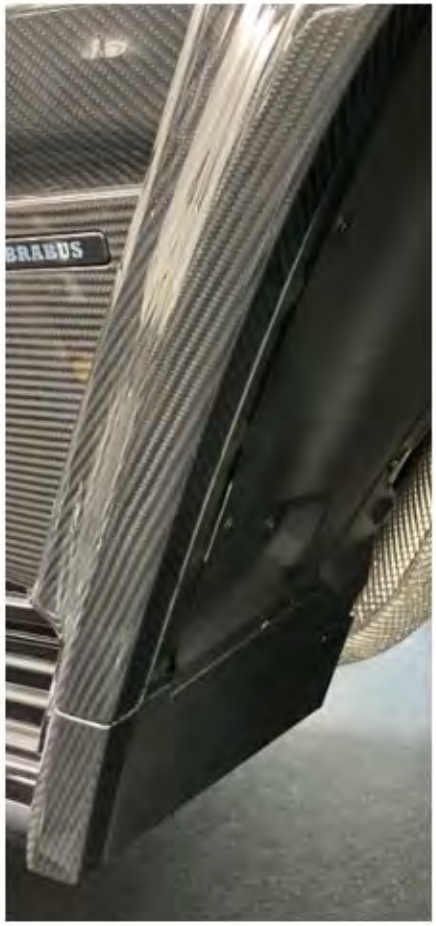
- Glue the LED lights to the lamp frame at the marked points on the back.

Connect running board lighting to vehicle wiring harness, position running board corners between running boards and rear extensions, align and screw together.



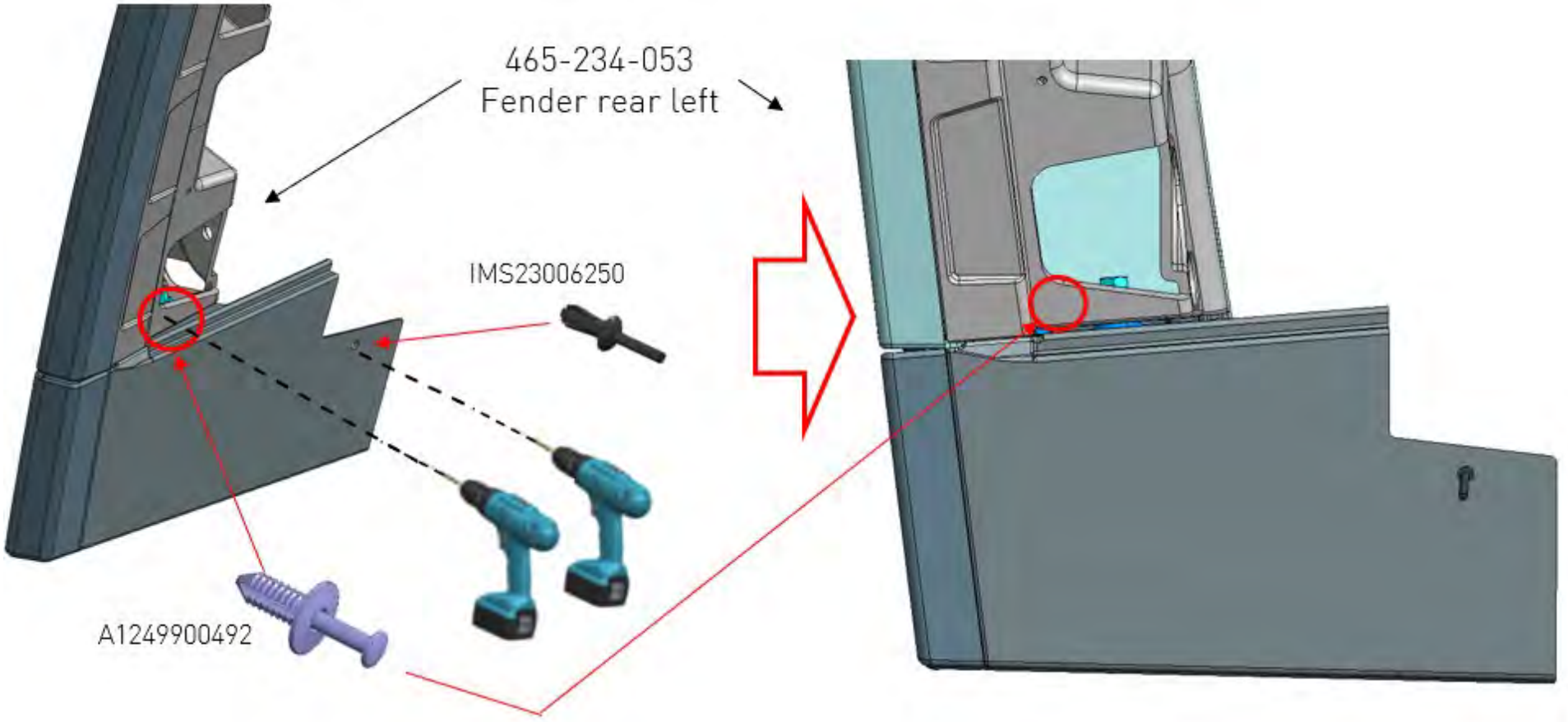




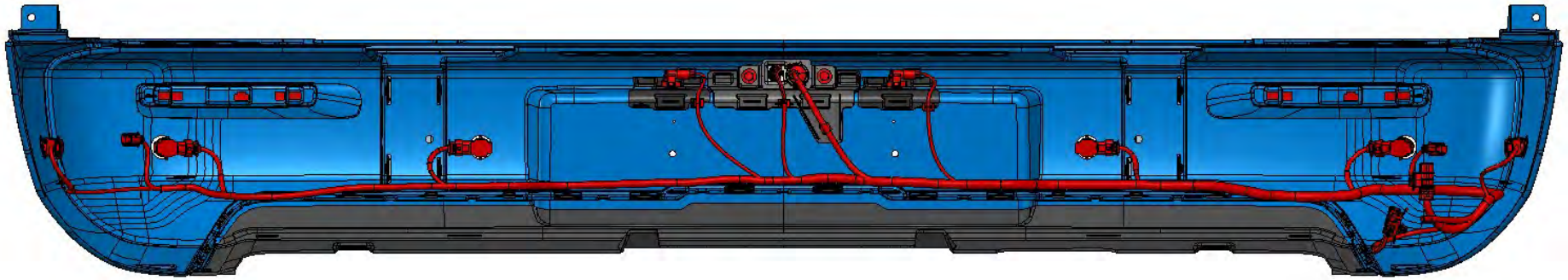


Drill hole (Ø5 mm) for expanding rivet IMS23006250 through the wheel arch liner (not shown) .

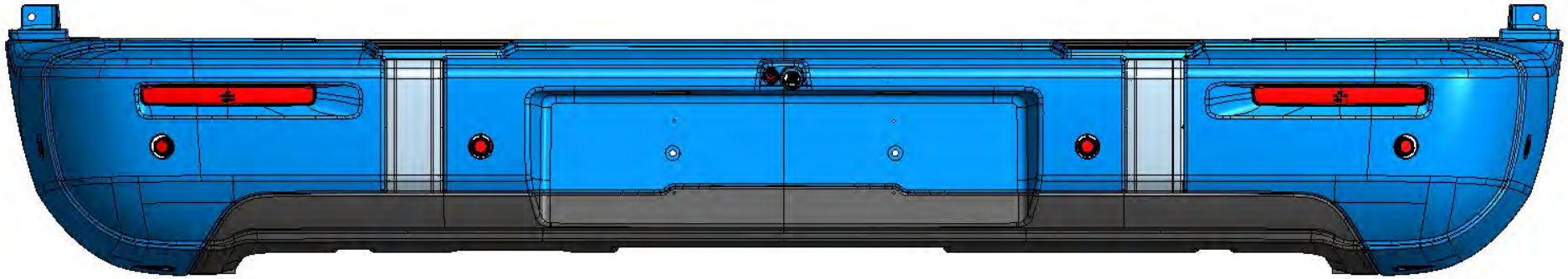
Drill hole (Ø7 mm) for clips A1249900492 through wheel arch liner (not shown) and carrier mudguard attachment.



Presentation of the standard rear bumper components which will still be used.



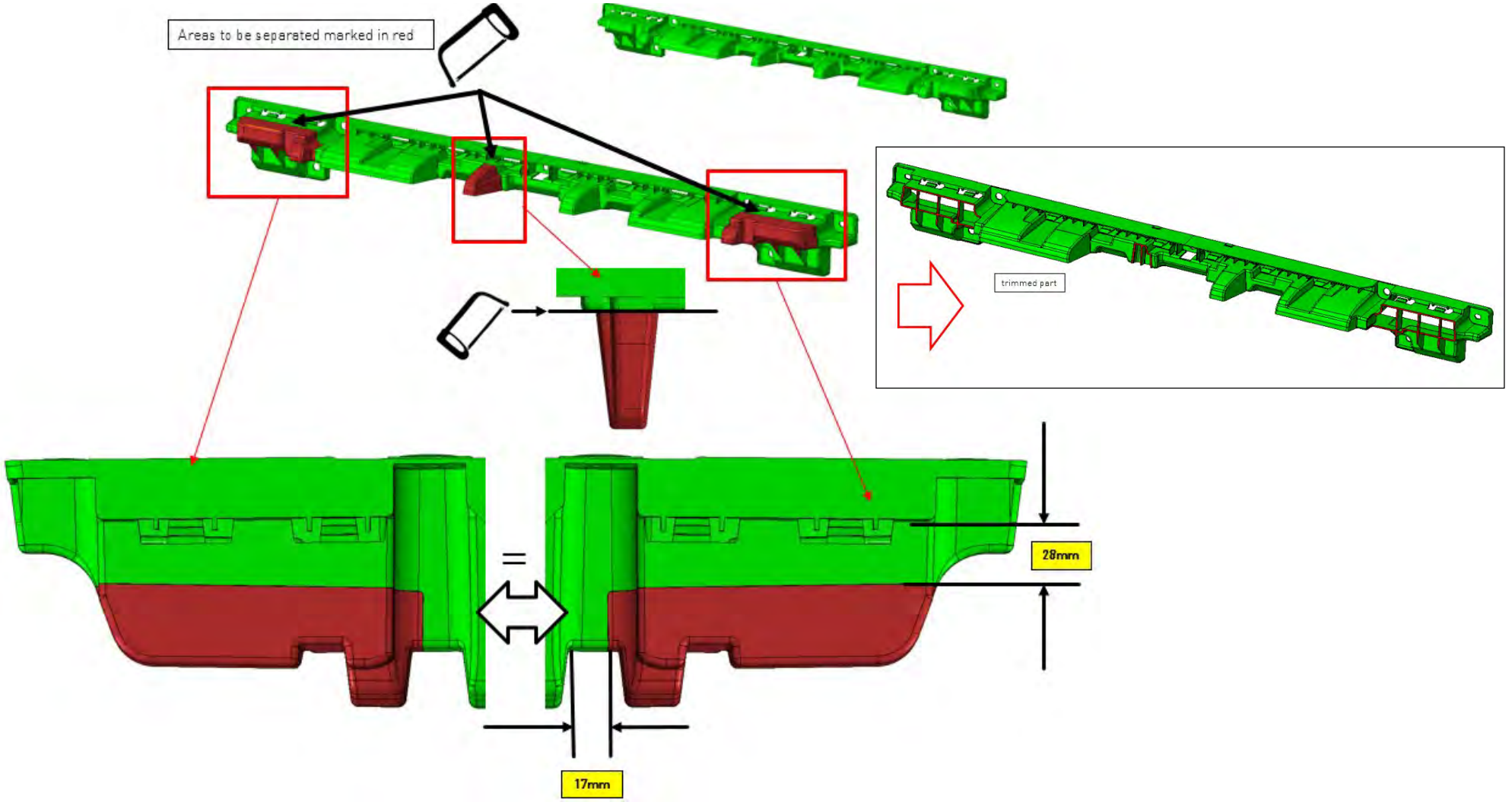
The components marked red must be removed from the standard rear bumper. They will still be used when setting up the BRABUS rear bumper.



Remove the original rear apron according to the Mercedes w orkshop information system.

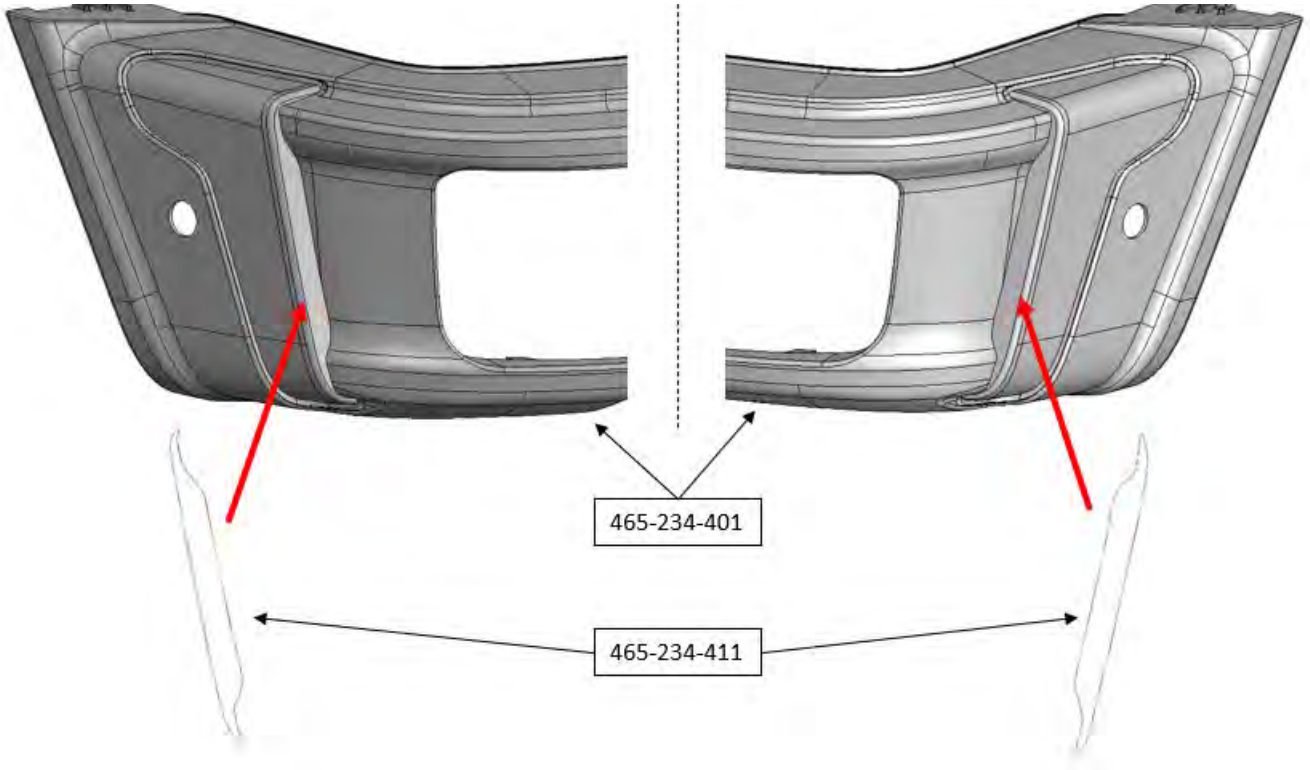
Trim the vehicle-side bumper bracket behind the rear apron using a suitable tool as shown in the illustrations.

Areas shown in red must be separated f rom the insert.



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- Clean the adhesive surfaces for the BRABUS design foils on t he left and right of the rear apron in two stages using a suitable cleaner.
- Remove the protective cover from the pieces of foil.
- Apply and position film parts. The films can be repositioned during the bonding process and only achieve the desired adhesive strength after heating with a hot air gun.
- Gently and carefully heat the glued foils with a hot air dryer, squeegee out any remaining bubbles if necessary.

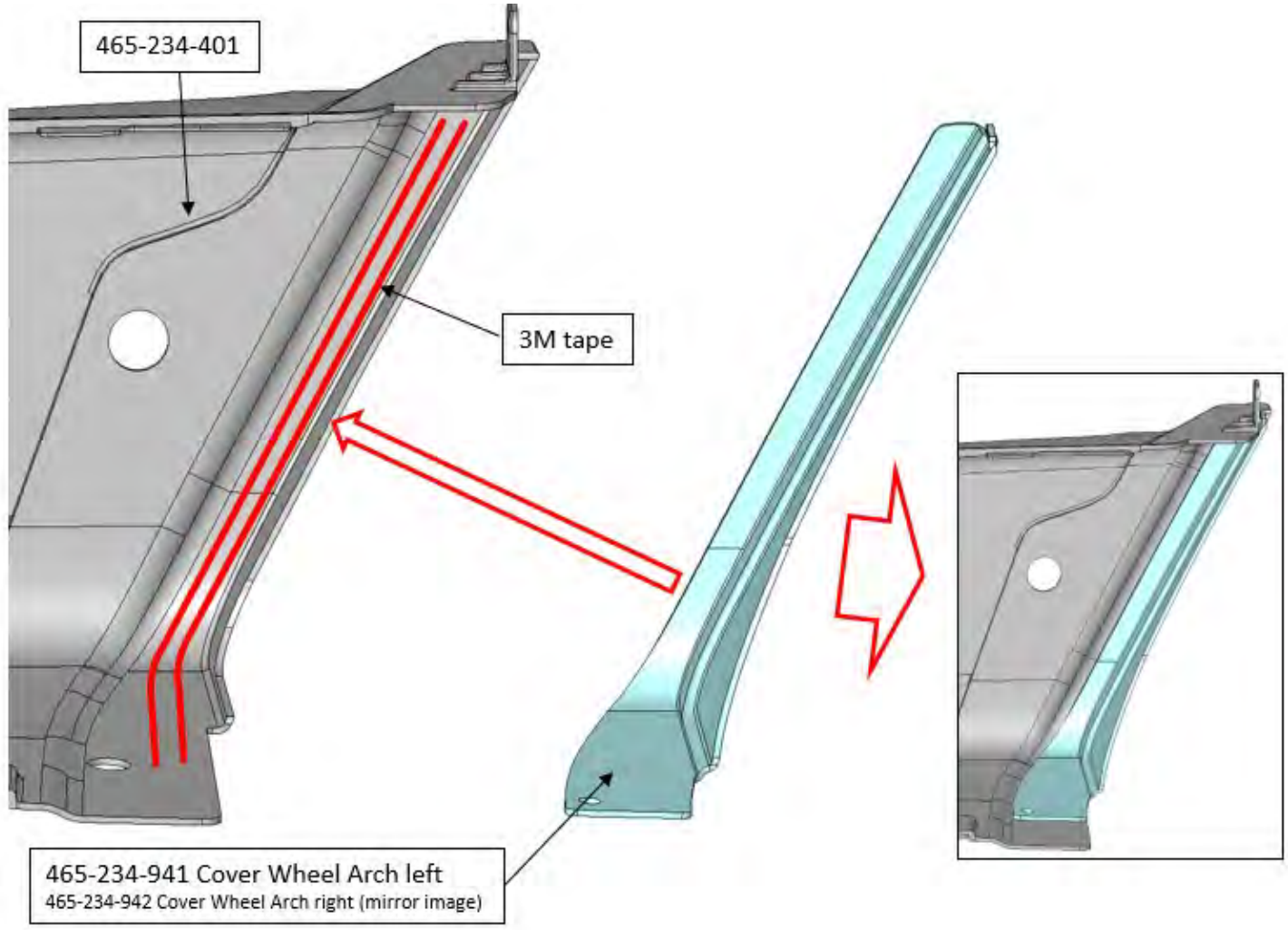


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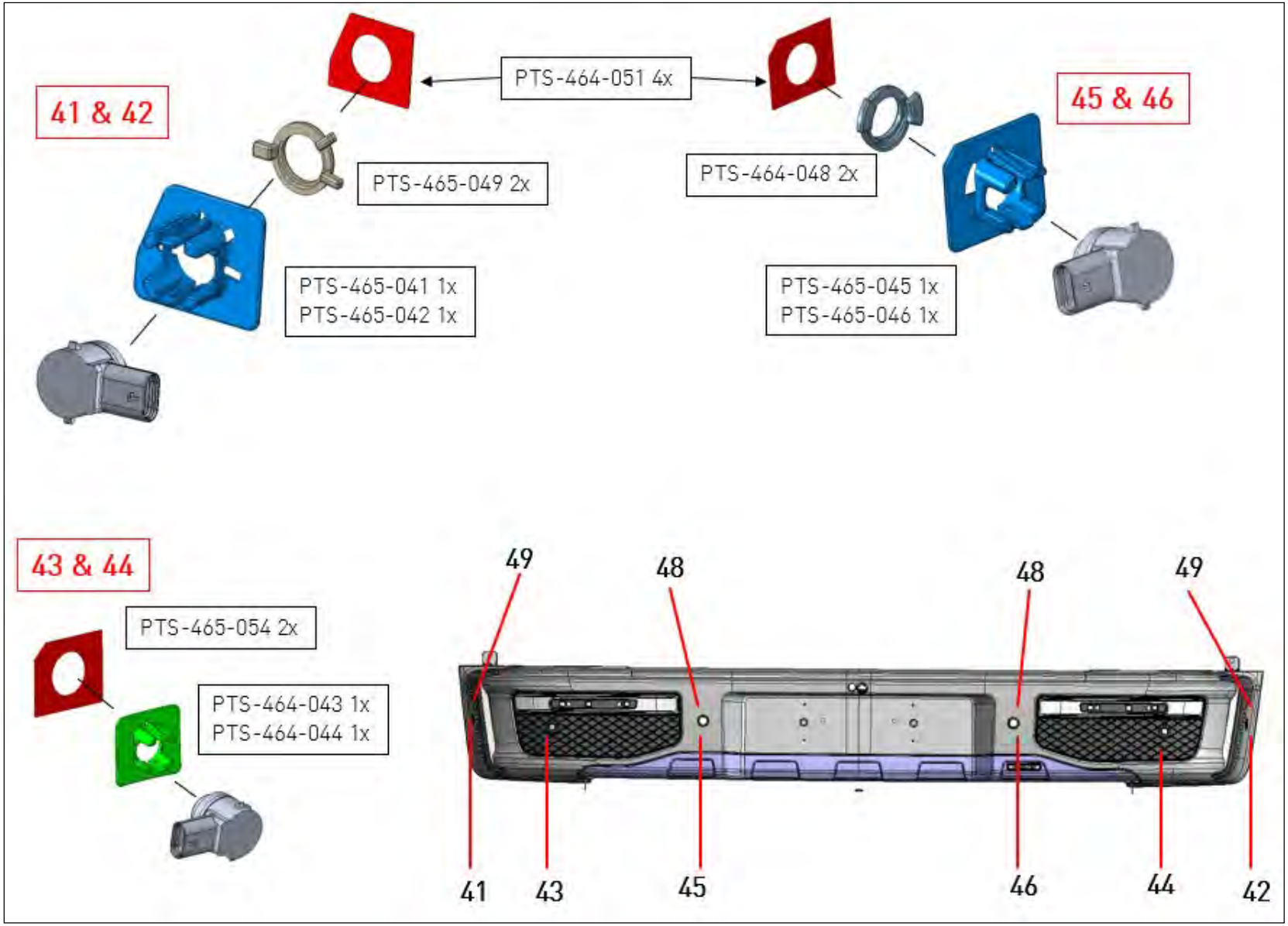
Clean the adhesive su rfaces of the two wheel arch covers left & right, using silicone remover .

Insert the wheel arch covers into the rear apron and remove the liner of the VHB adhesive tape (marked red) in the rear apron.

Apply pressure to the adhesive surface to achieve optimum adhesive strength.



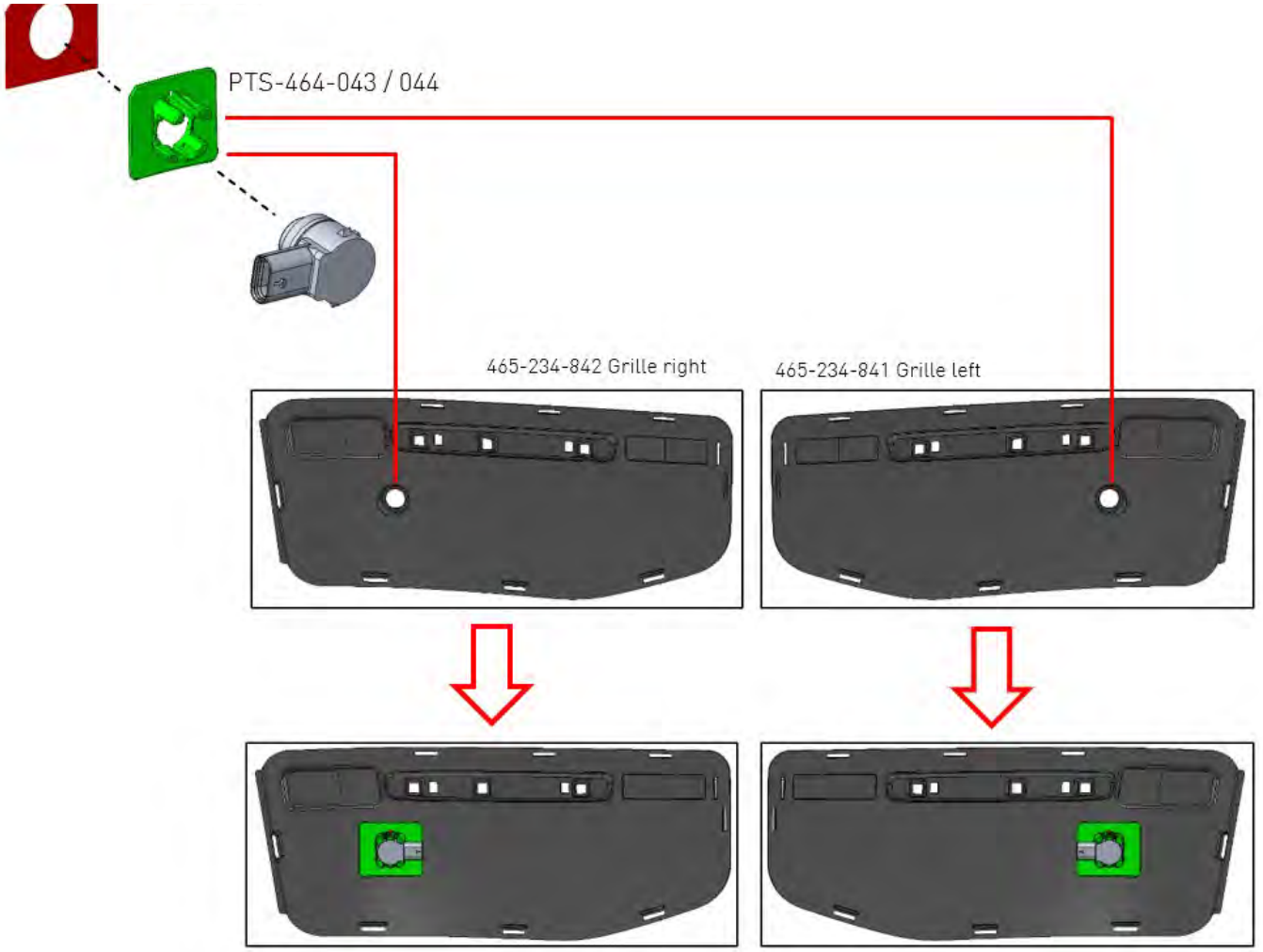
Assignment of PTS sensor ho lder to inserts and ad hesive pads rear apron



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Clean the adhesive surfaces of the PDC sensors in the rear apron and the adhesive surfaces of the PDC holders -043, -044 in two stages using silicone remover.

Adhere VHB adhesive pads with part numbers -54 to the PDC holders with part numbers -43 & -44. Clip the PDC sensors into the PDC holder. Remove the protective film from the VHB adhesive pads, Glue the PDC units to the intended positions in the rear apron. Press the PDC units firmly into place.



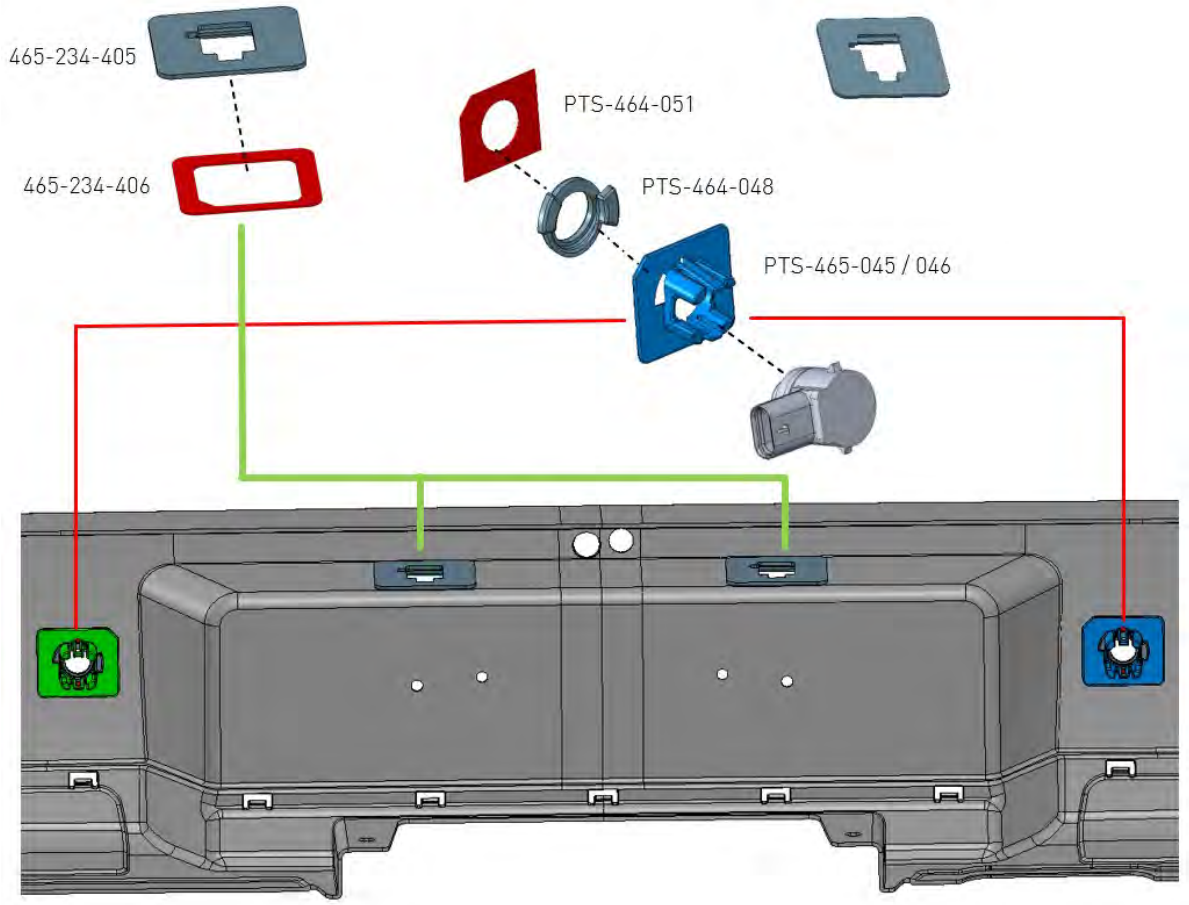
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Clean the adhesive surfa ces of the PDC sensors and the license plate light holder in the rear bumper and the adhesive surfaces of the PDC holders -045 & -046 and the license plate light holder using silicone remover in two stages.

Stick the VHB adhesive pads with part numbers -51 onto the PDC frames -48 and the PDC holders with part numbers -45 & -46.

Clip the PDC sensors into the PDC holder. Remove the protective film from the VHB adhesive pads and stick the PDC units to the intended positions in the rear apron. Press PDC units firmly into place.

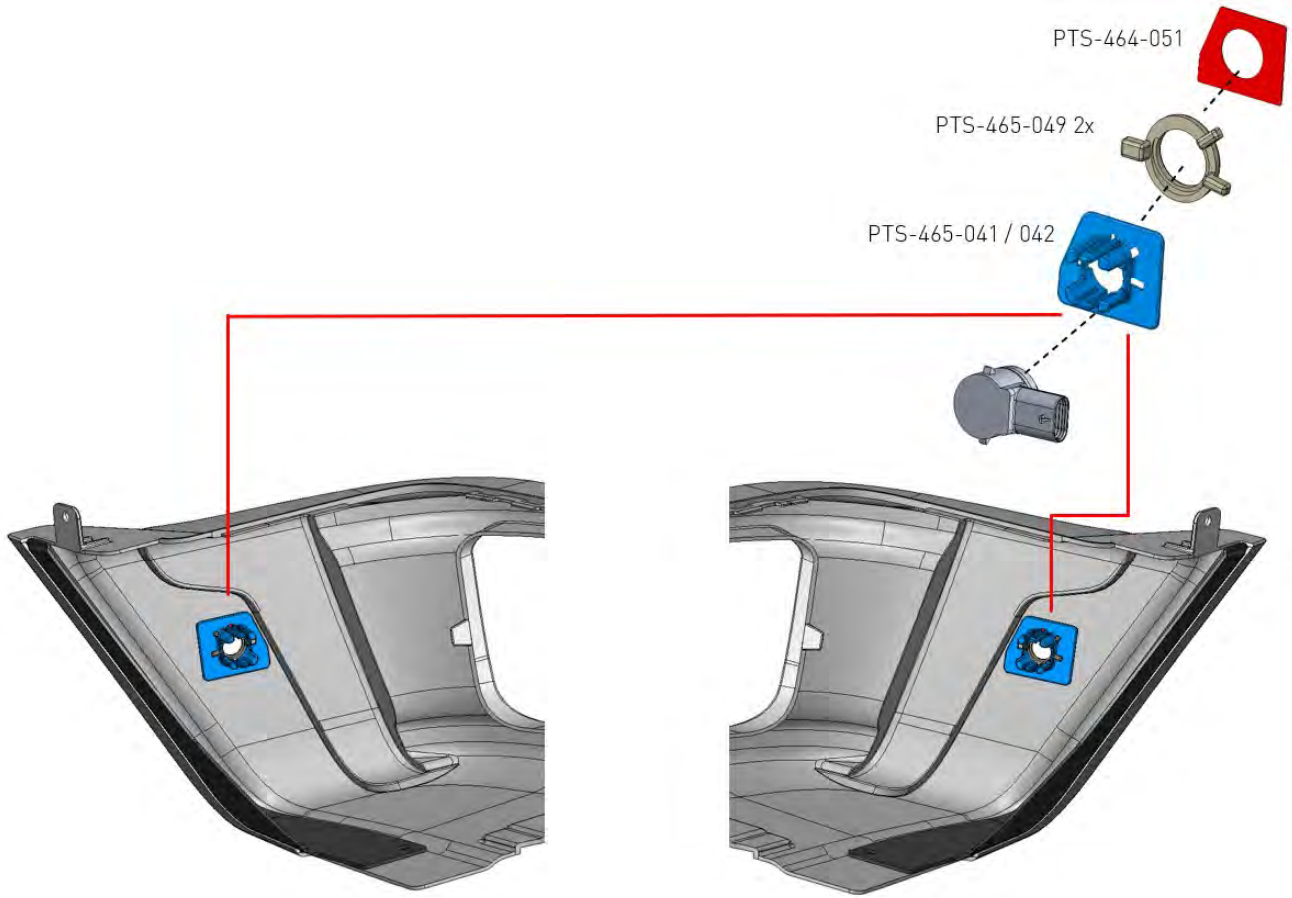
Glue the VHB adhesive pads -406 to the camera holder -405. Remove the protective film from the VHB adhesive pads and glue the camera holder to the intended positions in the rear apron. Press the holder units firmly into place.



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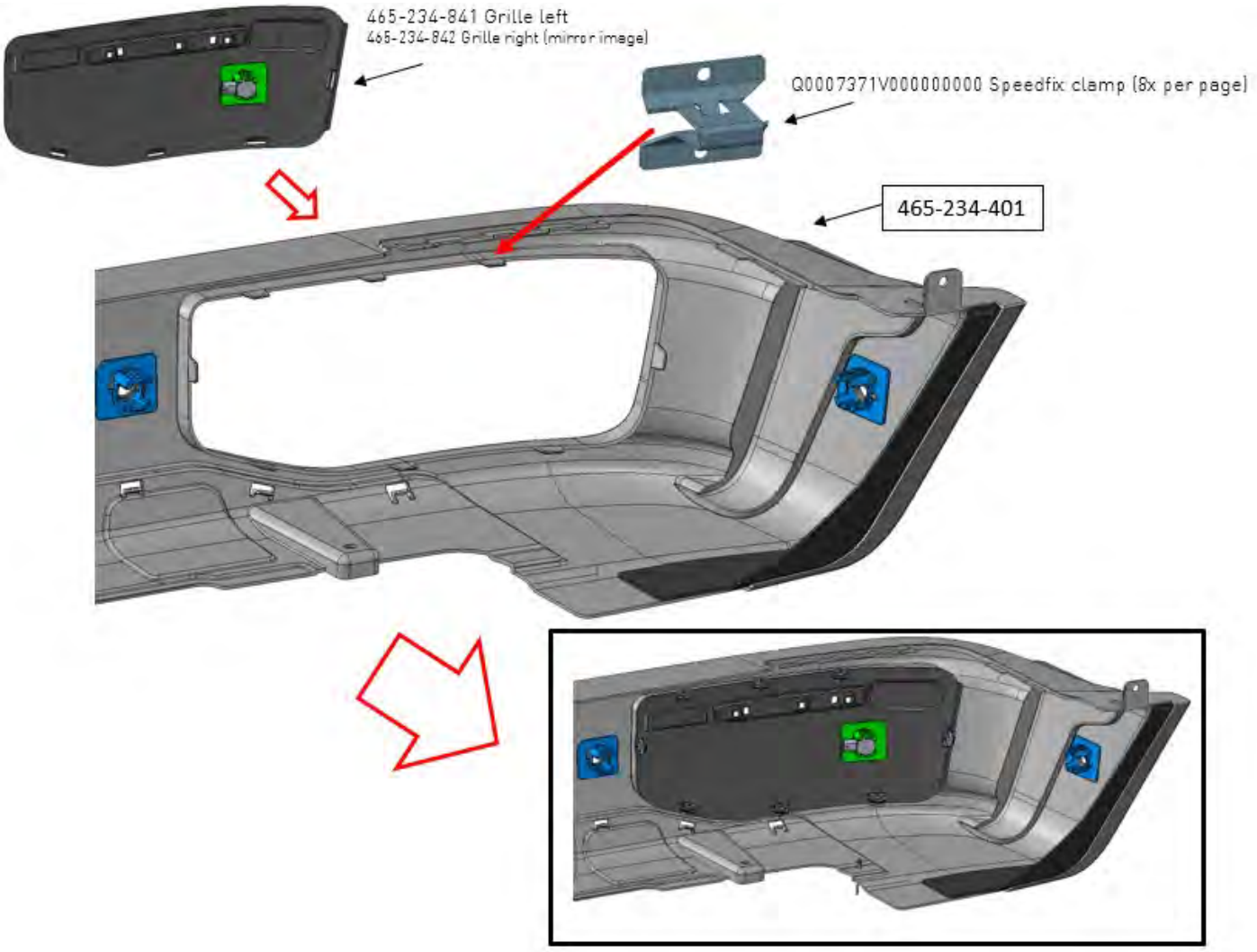
Clean the adhesive surfaces of the PDC sensors in the rear apron and the adhesive surfaces of the PDC holders -041, -042 in two stages using silicone remover.

Adhere VHB adhesive pads with part numbers -51 to the PDC frames -49 and the PDC holders with part numbers -41 & -42. Clip the PDC sensors into the PDC holder. Remove the protective film from the VHB adhesive pads and stick the PDC units to the intended positions in the rear apron. Press PDC units firmly into place.



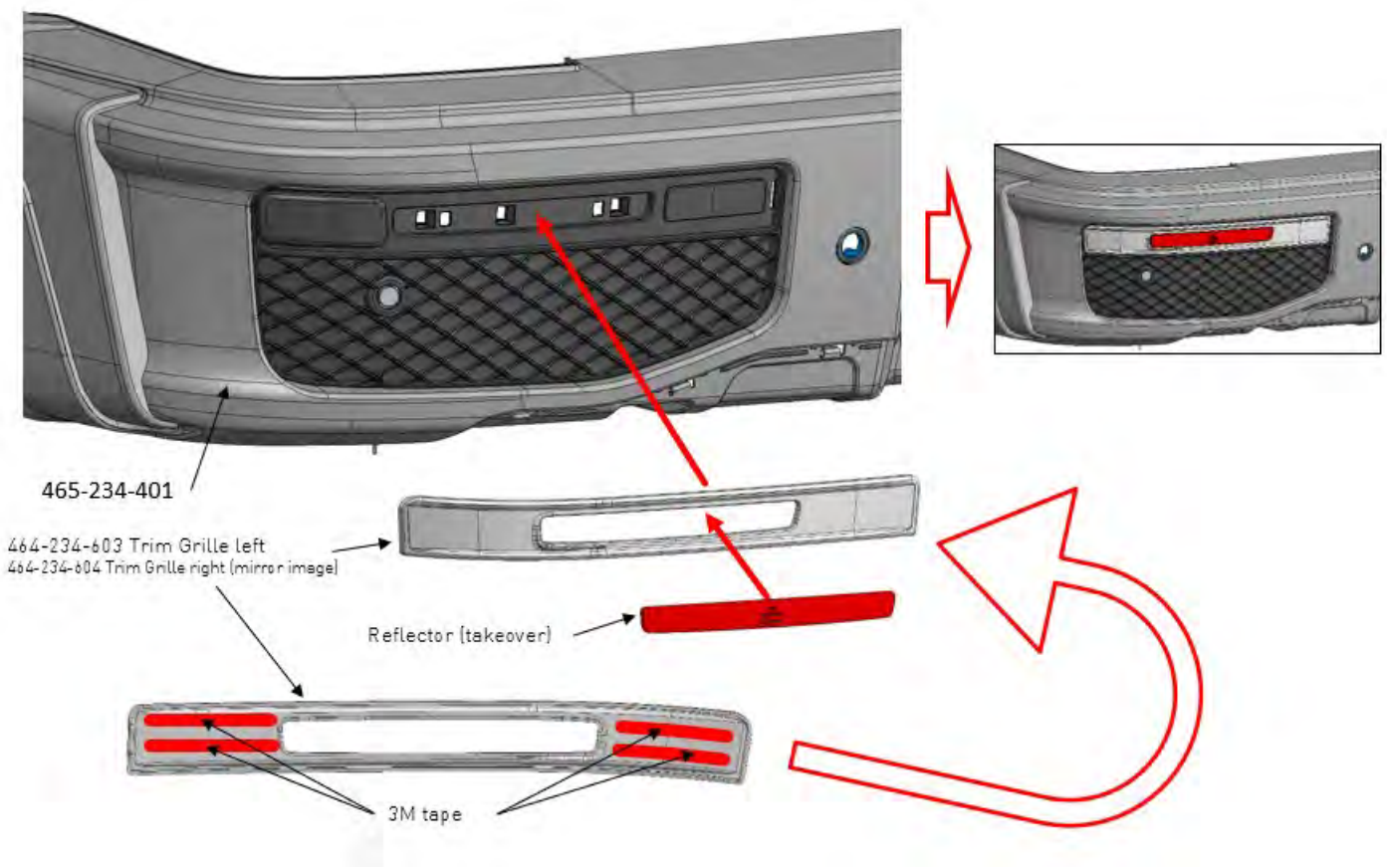
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Attach the two decorative g rilles to the rear apron using the Speedfix clips supplied .



Clean the adhesive surfaces of the two grilles left & ri ght, using silicone remover .

Remove the liner of the VHB adhesive tape (marked red) on the left & right trim strips grille and place the trim strip grilles on the trim grille of the rear apron.
Apply pressure to the adhesive surface to achieve optimum adhesive strength.

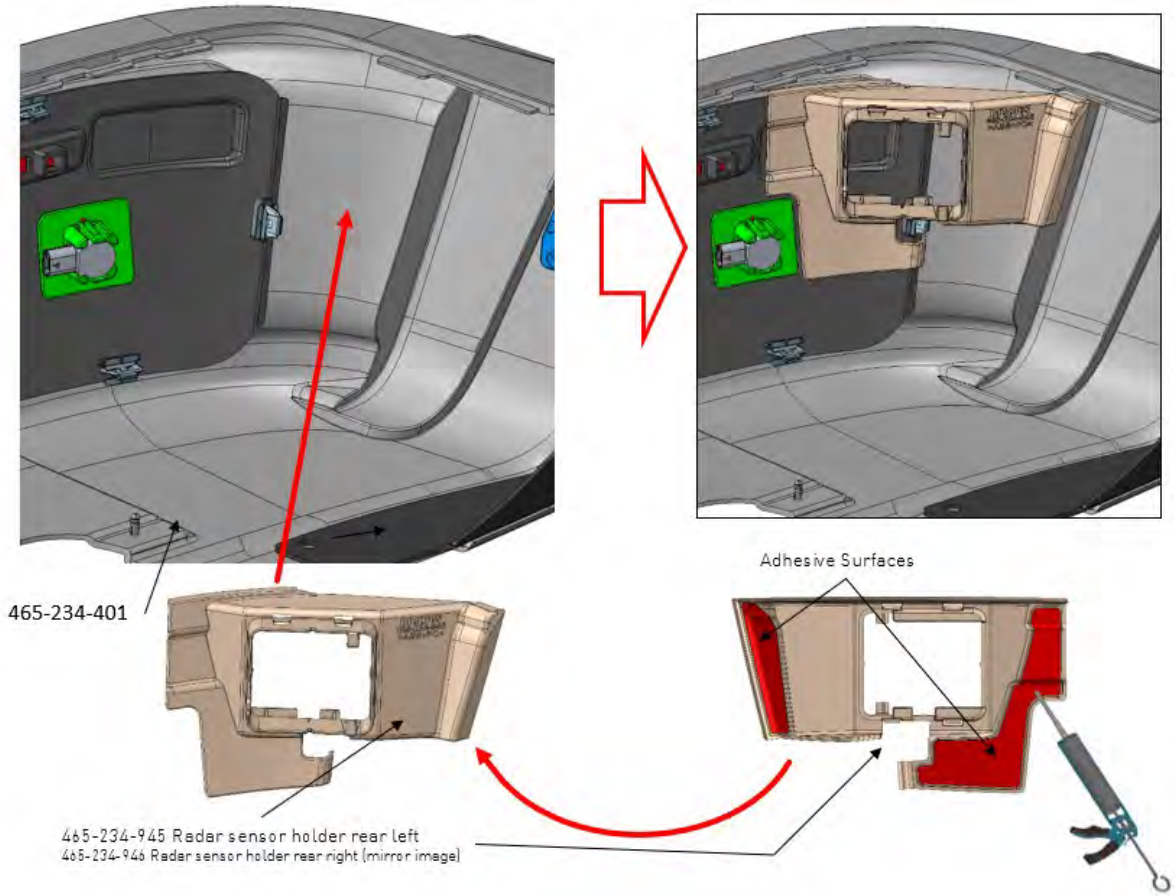


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Prepare the brackets of the left & righ t radar sensors and the adhesive surfaces of the grilles for bonding in accord ance with the bonding instructions on page 4. Apply even beads of adhesive to the adhesive surfaces (marked red) of the radar sensor bracket and glue them to the grilles.

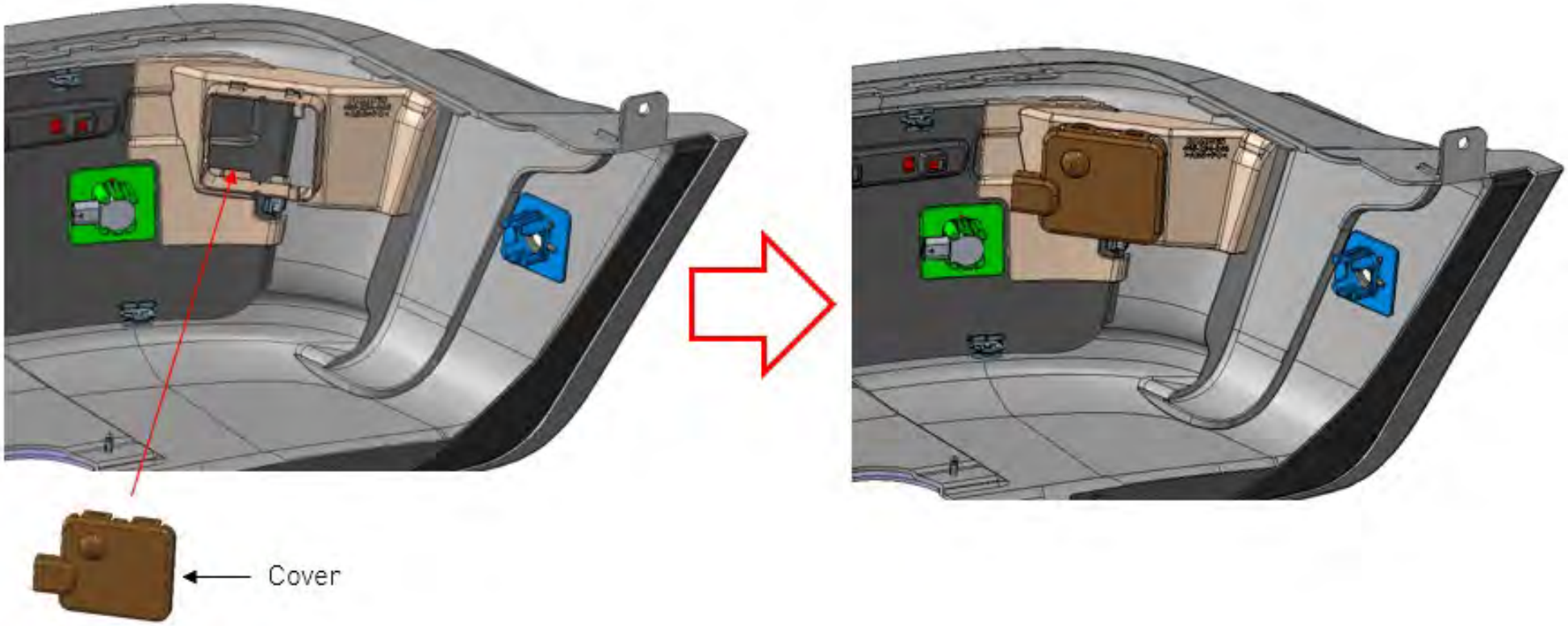
Fix the bonding with suitable means until the adhesive has finally hardened.

Never sand the adhesive surfaces of the grilles! And the rear apron!

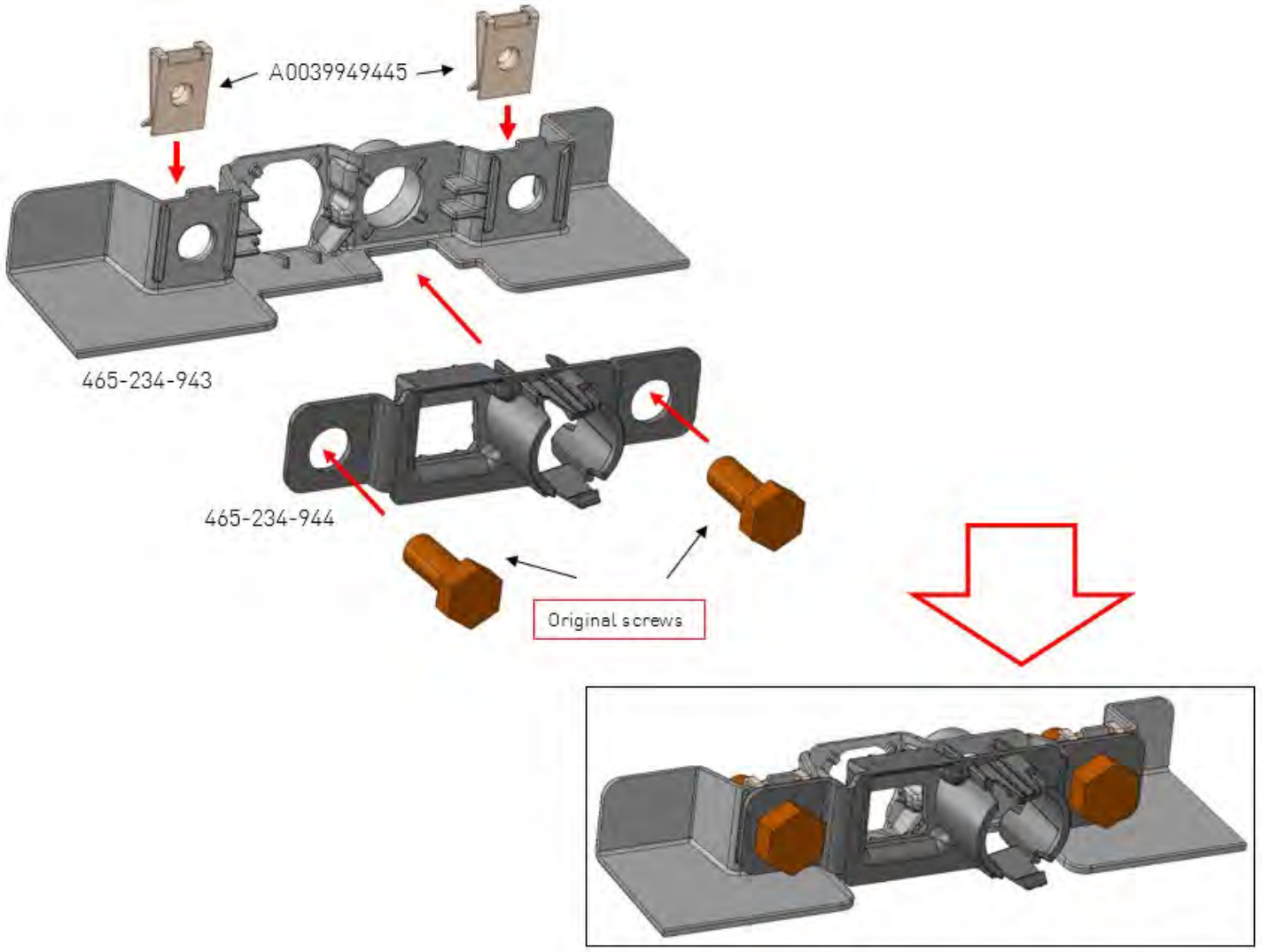


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Insert the radar sensors into the holders an d place the standard cover on the holder.



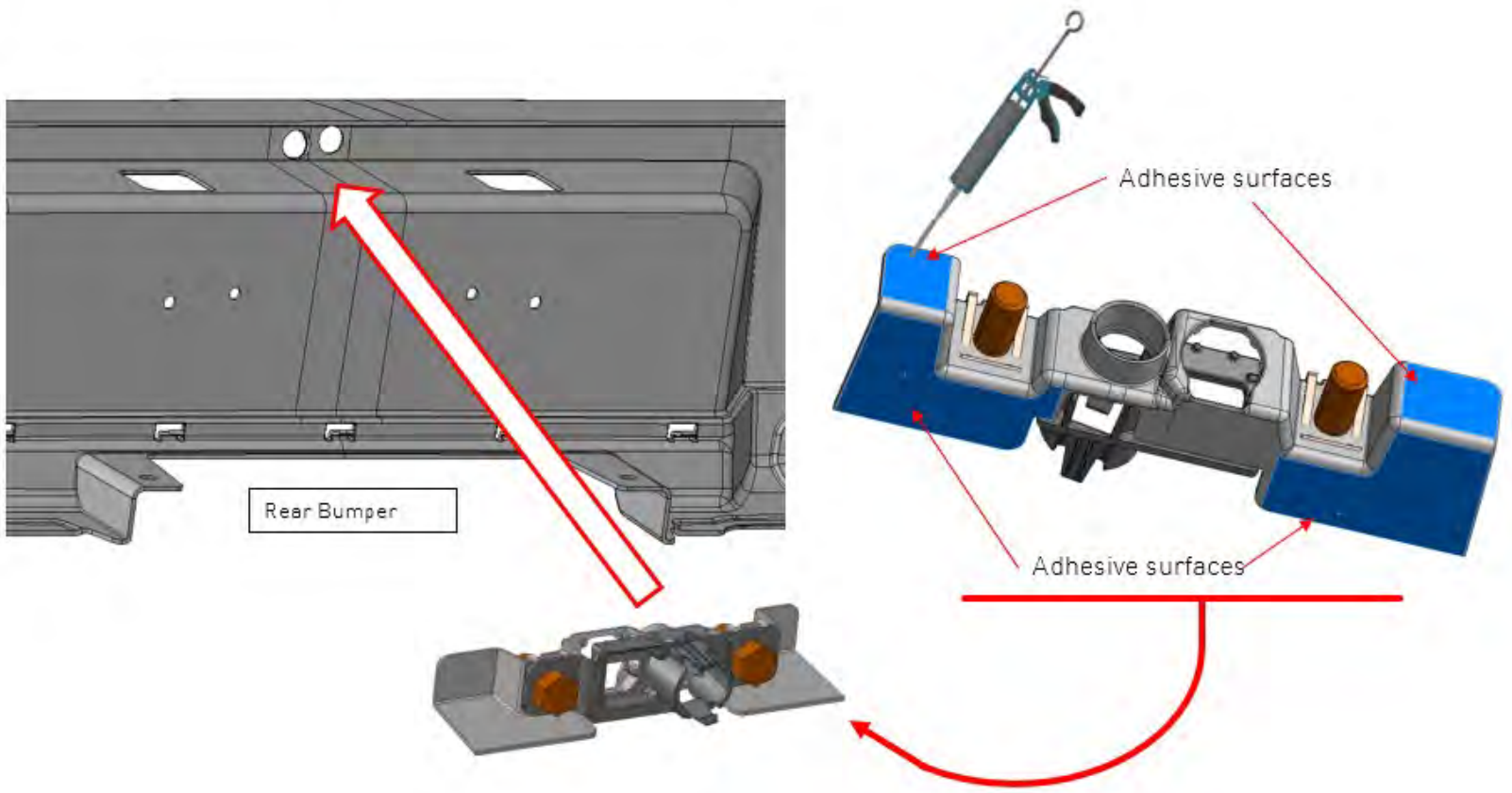
Fit the two sheet metal nuts (A0039949445) onto the came ra system holder (465 -234-943). Fit the original camera and the washer nozzle and screw the fastener (465-234-944) to the holder using the original screws.



Prepare the camera holder and the adhesive surfaces on the rear apron for bonding in accordance with the bonding instructions on page 4. Apply even beads of adhesive to the adhesive surfaces (marked in blue) of the camera bracket and glue them to the rear apron.

Fix the bonding with suitable means until the adhesive has finally hardened.

Pay attention to the alignment of the camera and the washer nozzle in the rear apron!

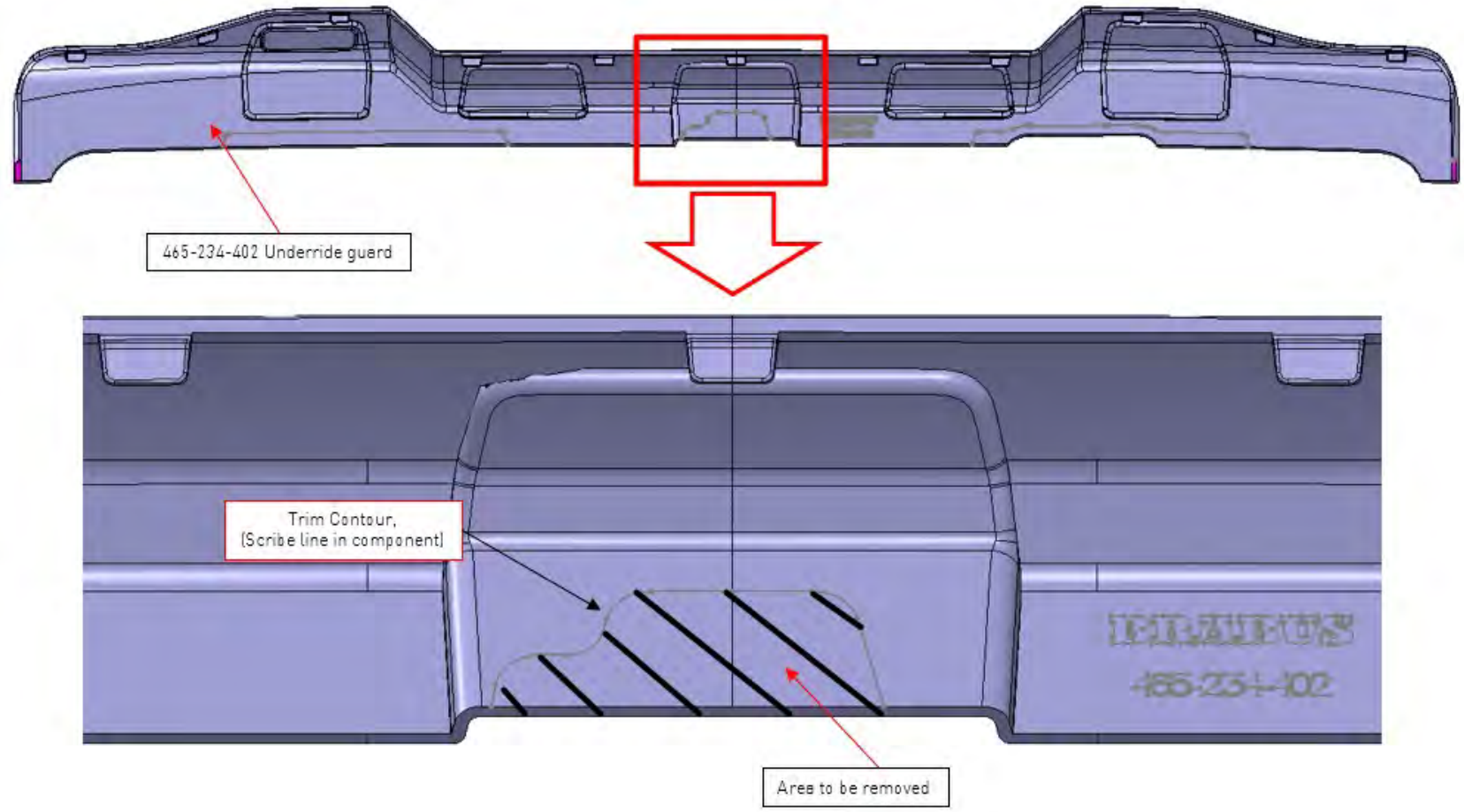


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Attention: Only to be processed when using a trailer hitch.

This step must be carried out before painting.

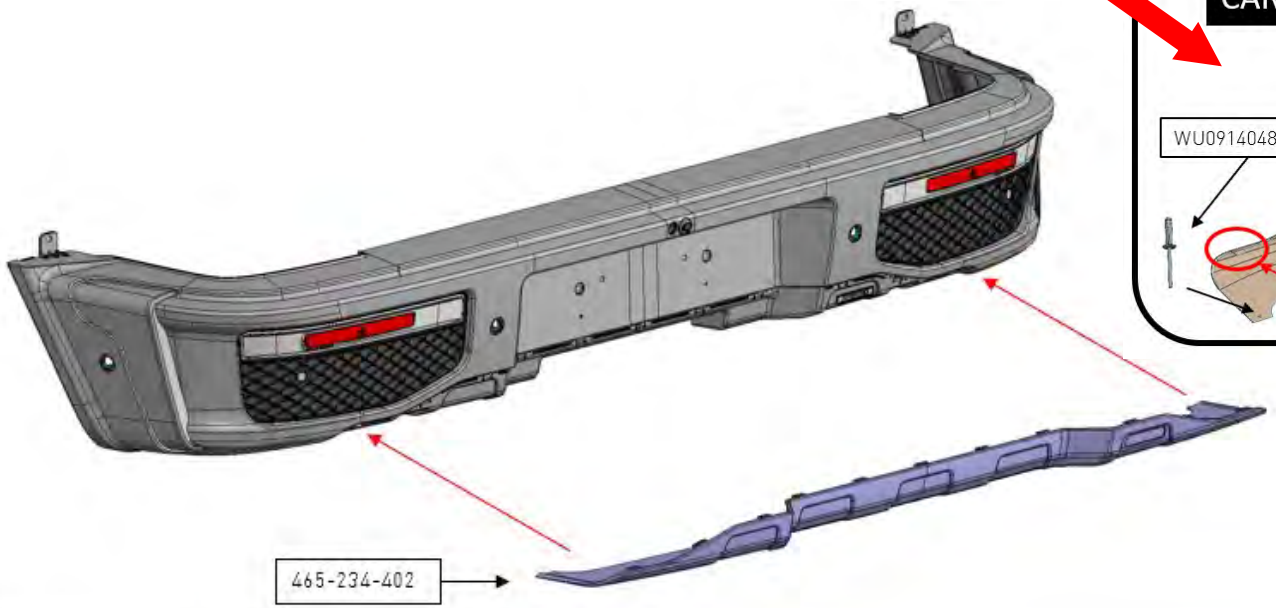
Use a suitable tool to cut the outlined area at the scribe line from the underride guard and carefully deburr the cut edges.

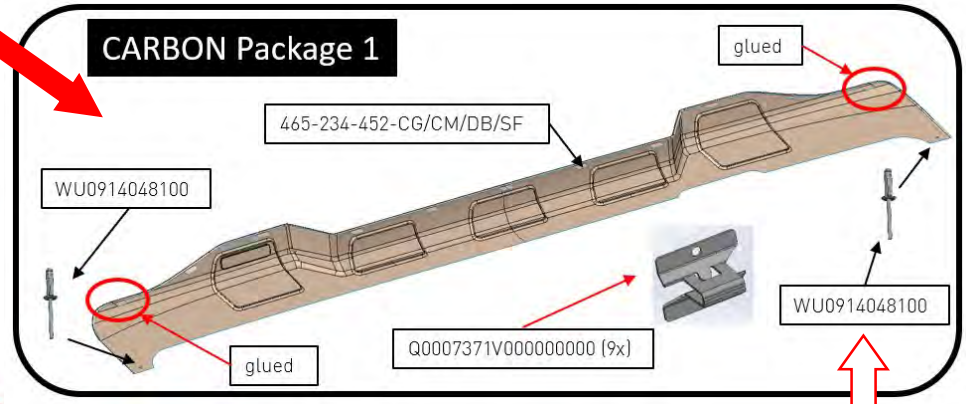


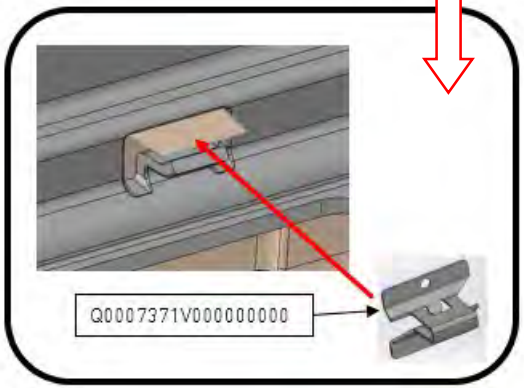
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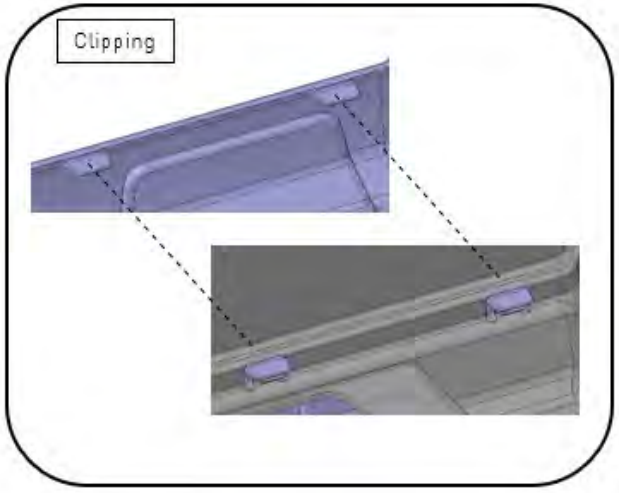
Clip the BRABUS underride guard into the BRABUS rear apron .

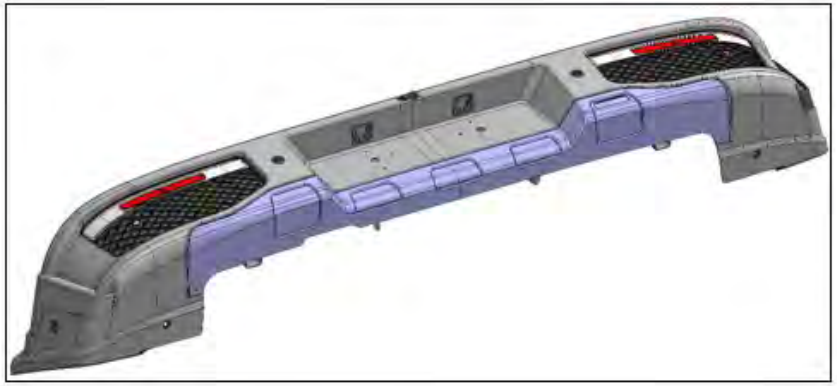
When using the BRABUS underride guard Carbon 465-234-452-CG/CM/DB/SF, the 9 Speedfix clamps must be used for installation and the two outer tabs are glued together .





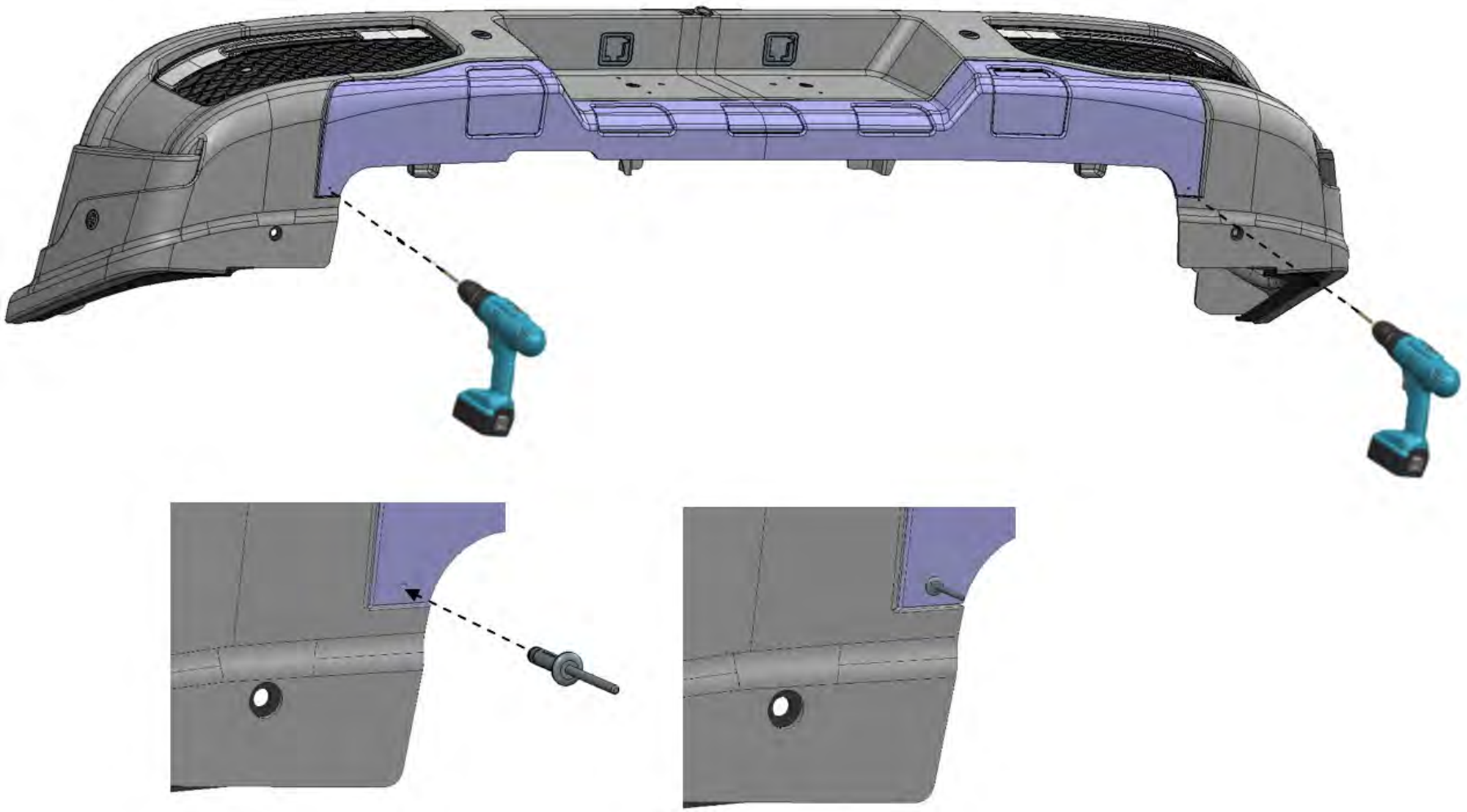






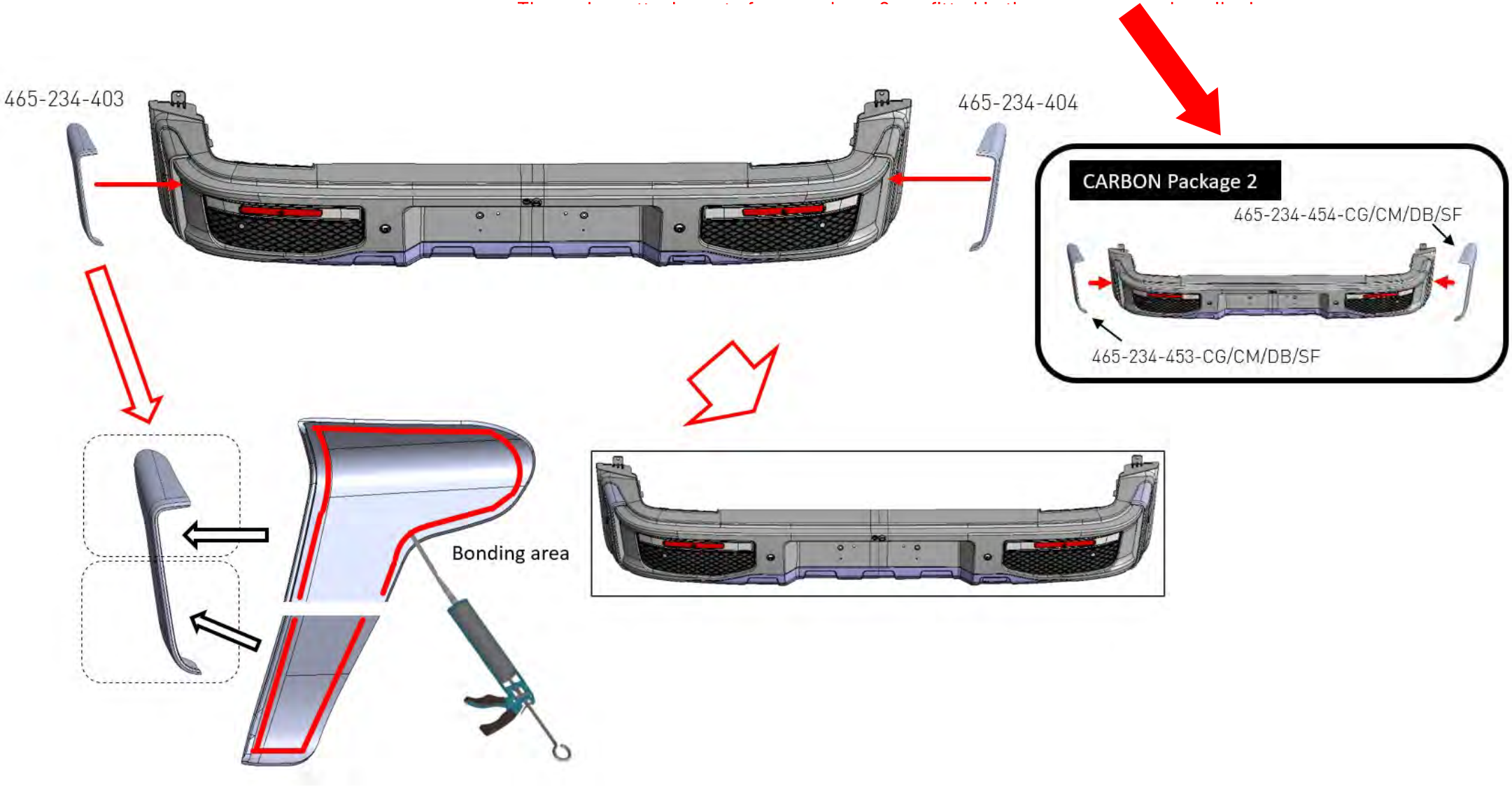
Drill Ø 5.0 mm holes at the positions shown (embossed) using a suitable 5.0 mm drill bit and a suitable drill in the BRABUS underride guard and rear apron.

Attach the BRABUS underride guard to the BRABUS rear apron using the supplied aluminum blind rivets.



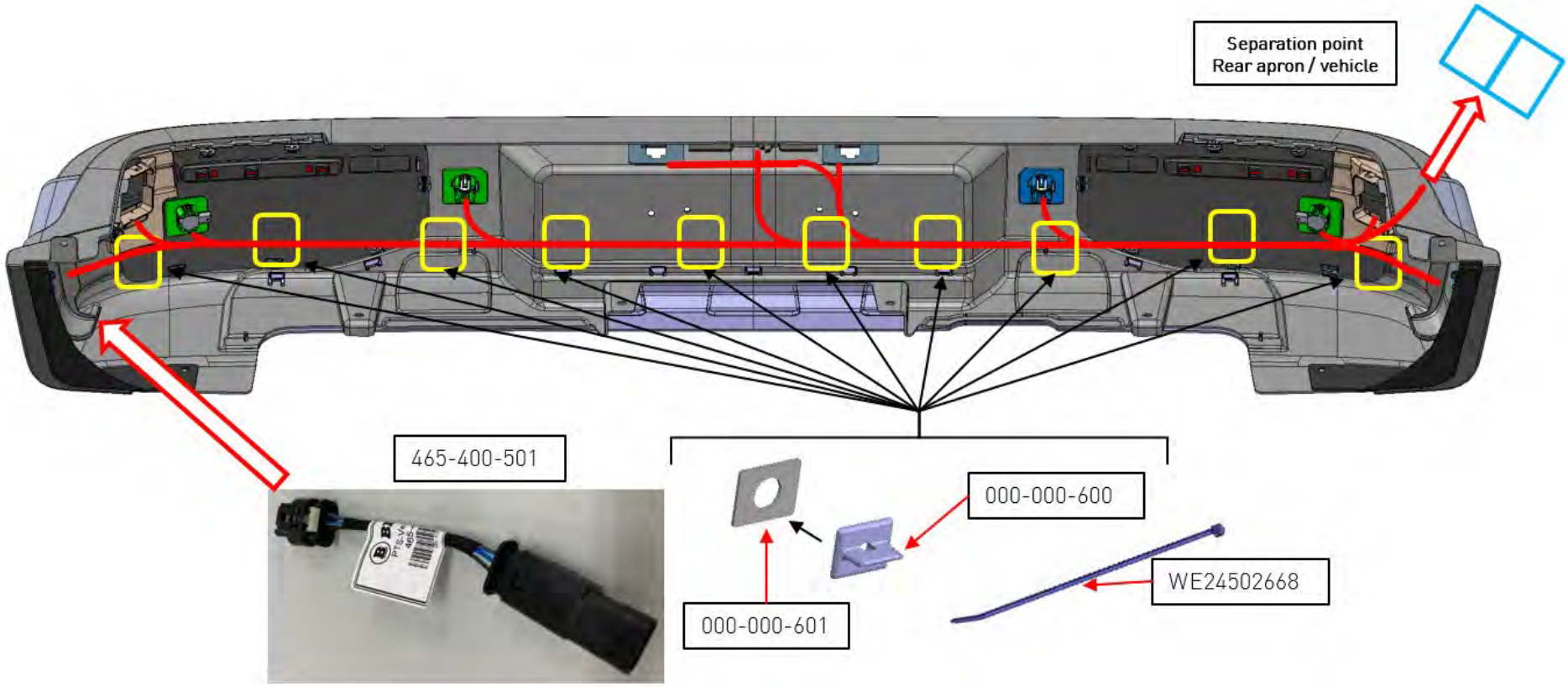
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Prepare the left & right attachments and the adhesive surfaces on the rear skirt for bonding in a ccordance with the bonding instructions on page 4. Apply even beads of adhesive to the bonding surfaces in accordance with the illustrations. Apply the adhesive beads at a distance of approx. 3 - 4 mm from the outer edges. The opening of the adhesive tip should have a diameter of 4 - 5 mm.



Clean the adhesiv e surfaces of the bases for attaching the wiring harn ess in the rear skirt in two stages using silicone remover .

Glue VHB adhesive pads base / cable set in the positions shown and press down firmly .



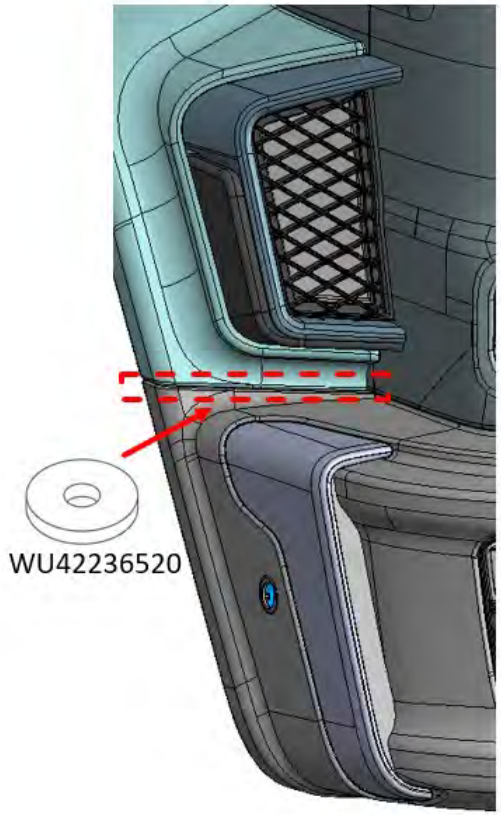
Clip the license plate lights into the BRABUS rea r apron in the s ame way as the standard mounting procedure.

Connect the rear skirt cable set to the adapter cable of both radar sensors, the license plate illumination and the PDC sensors and attach the cable set to the bases with the cable ties. Cable routing (red) shown. Adapter cable 465-400-501 is required as an extension to connect the outer right-hand PDC sensor.

Connect the rear skirt wiring harness to the vehicle wiring harness, push the completed rear skirt into the holder at the rear of the vehicle as standard and lock in place. The BRABUS rear apron is bolted in the same way as the standard Mercedes-Benz rear apron



Use the supplied spacers to align the widening and rear apron!



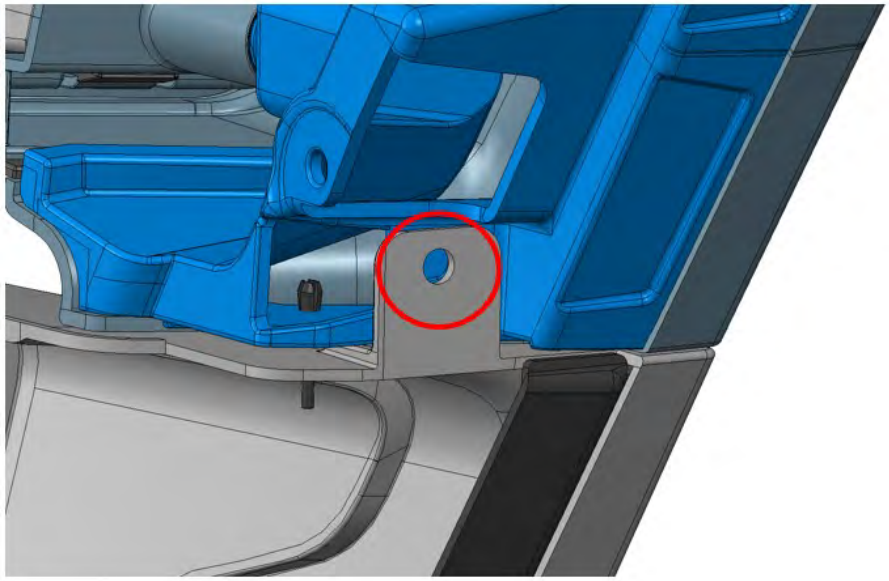
Making electrical plug connections for the LED running board lights .

Fasten wheel arch liners on the inside, drill outer fastening holes for mounting the Ø7 mm plastic expanding rivets in the supports of the rear wideners.

Fasten wheel arch liners on the outside with standard expanding rivets.

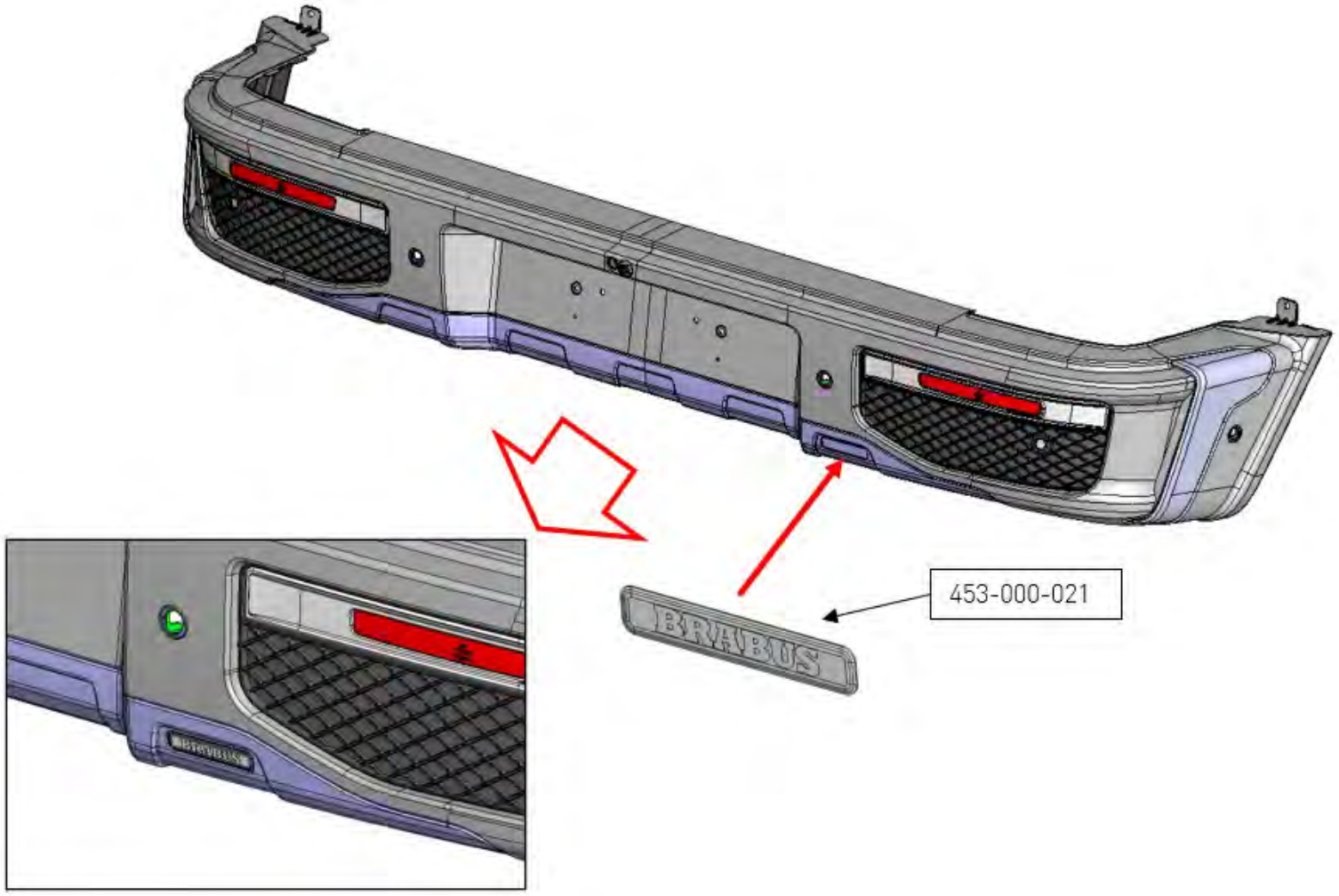


Align the rear skirt with the rear extensions and screw it to the extensions in the transition using the standard screws.
Attach the central brackets to the vehicle.



Clean the adhesive surface in the rec ess of the BRABUS underride guard in two stages using silicone remove r.

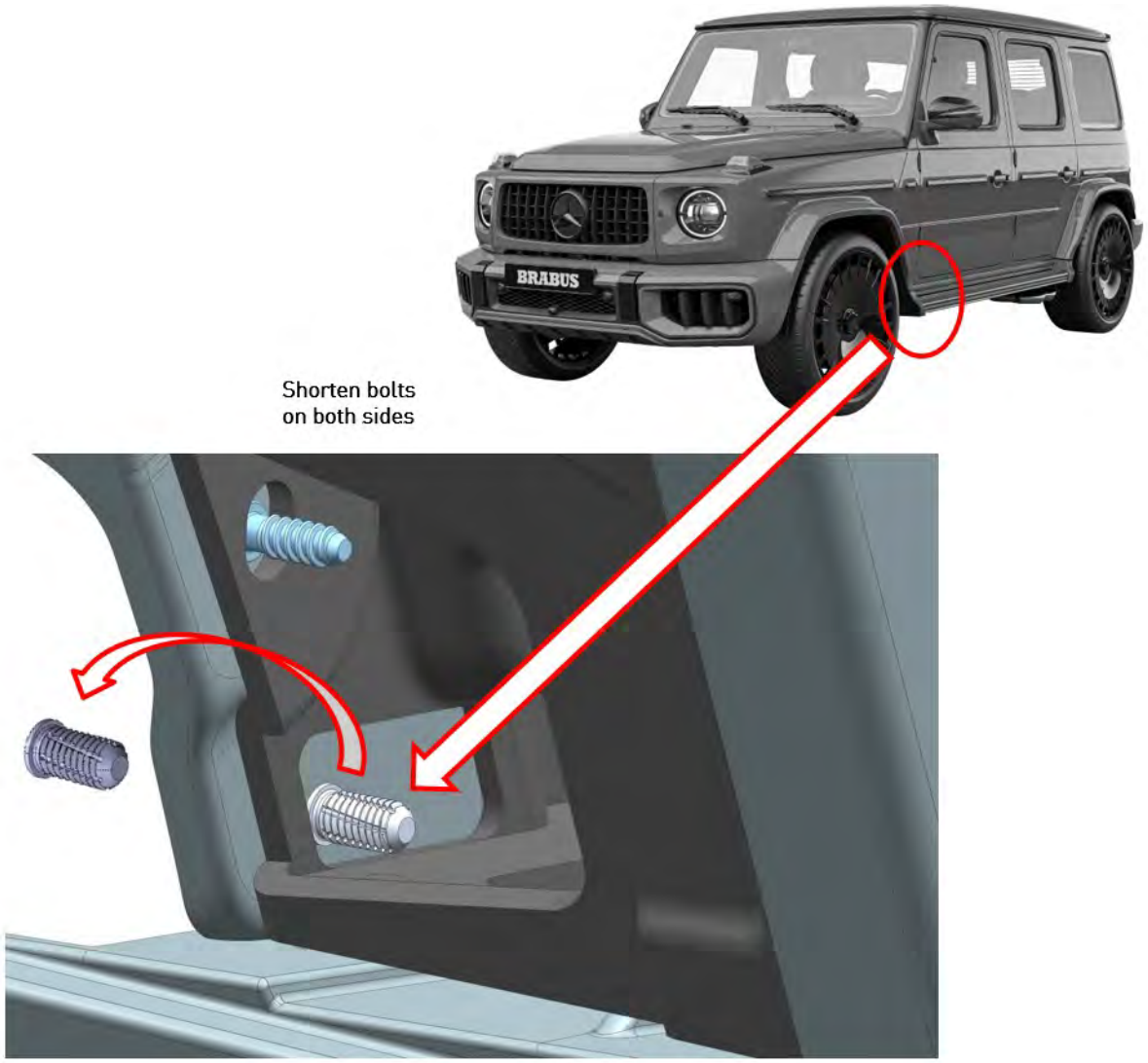
Remove the protective film from the adhesive strip on the BRABUS lettering, stick the lettering in the recess and press down firmly.



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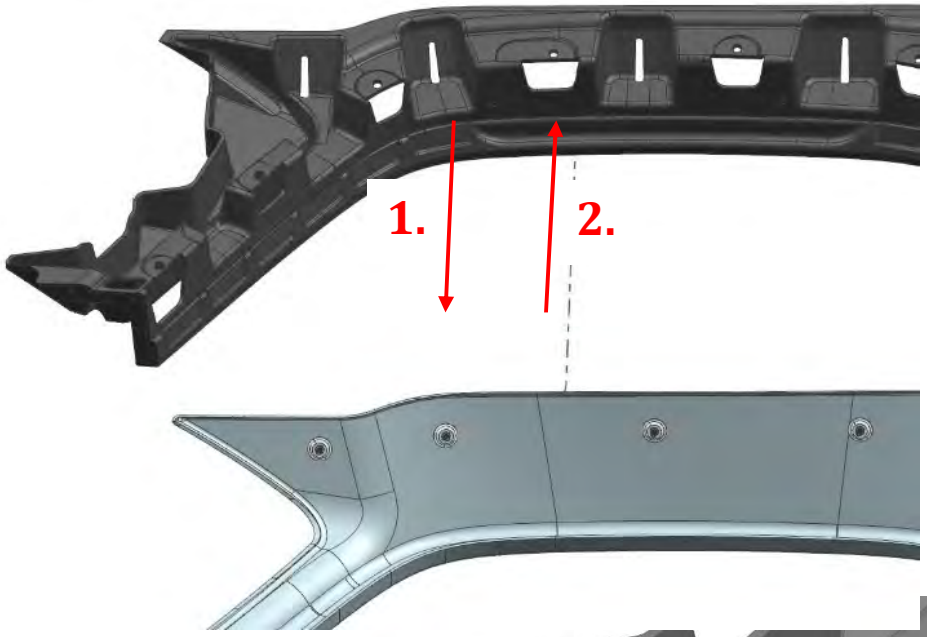
Assembly of front fender attachments

Shorten the lower, standard cutting thread bolt (marked red) with a suitable tool before fitting the carrier and protect the cut surface against corrosion.

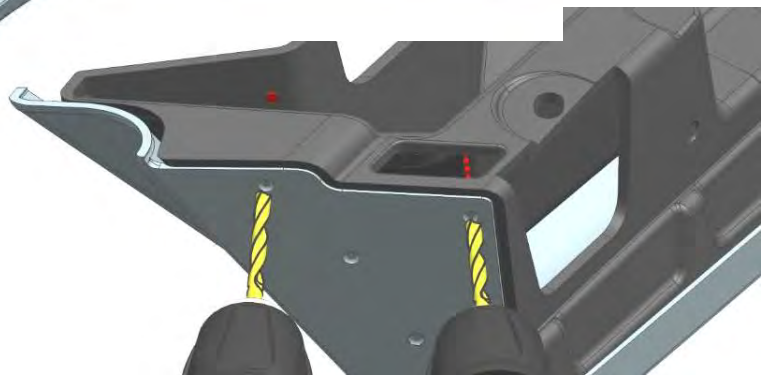


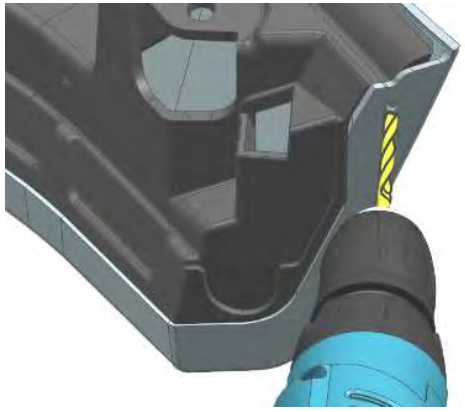
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Insert the carrier into the outer skin from above, drill holes at the positions shown using a suita ble Ø 5.5 mm drill bit. Remove the carrier from the outer skin.

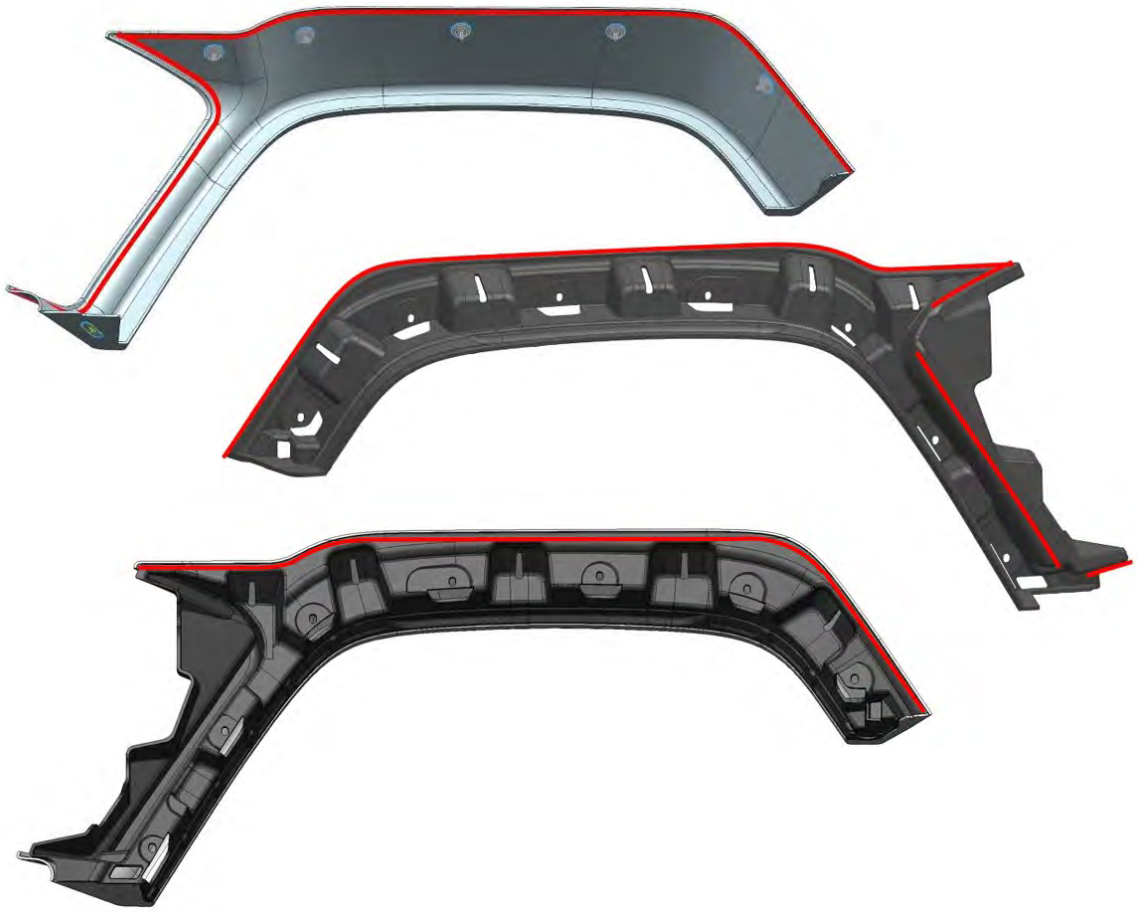




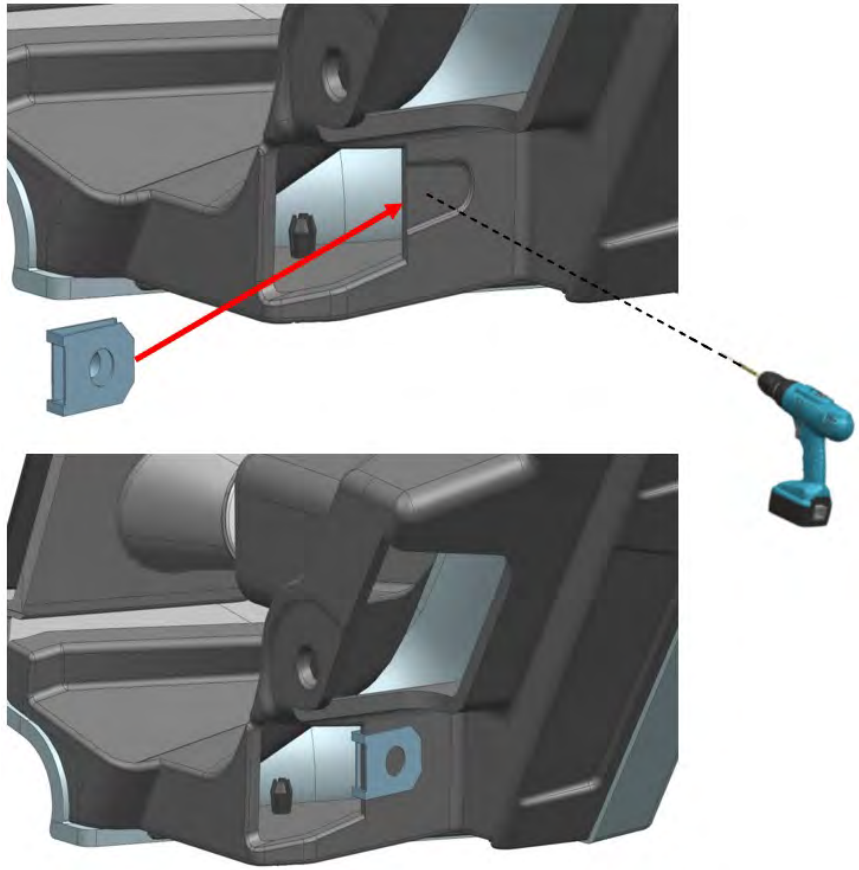




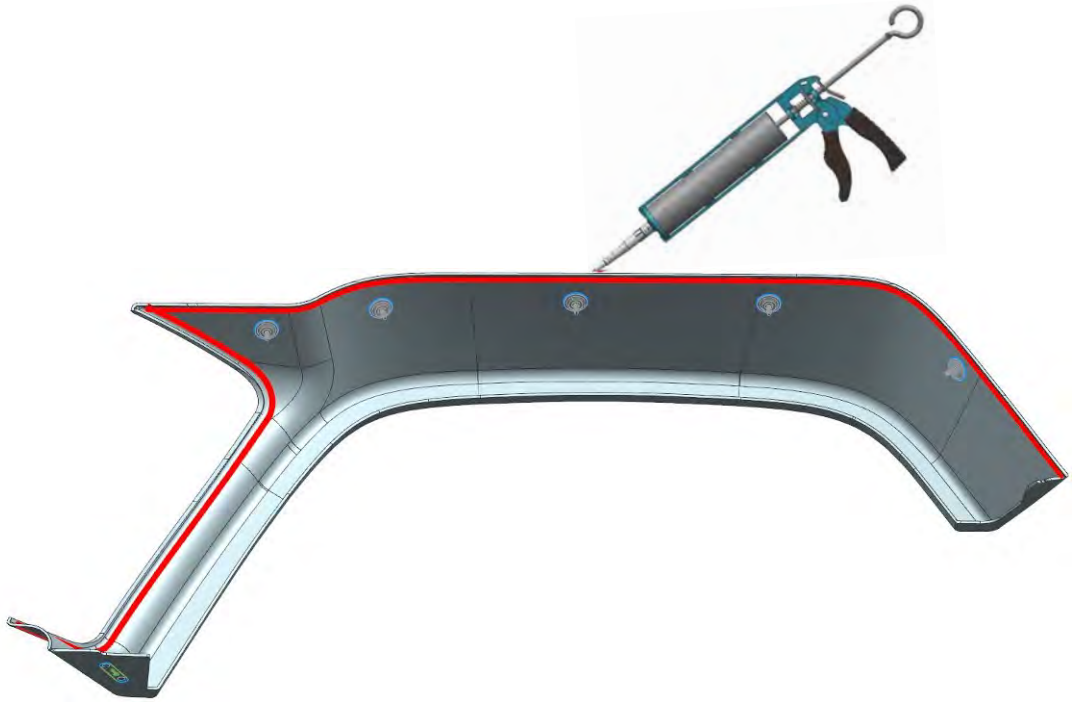
In the illustrations on the following pages, ro ughen the red ma rked adhesive surfaces of the outer skin and the carrier with sandpaper (grit size 240!) and then clean thoroughly in two stages with silicone remover. The bonding surfaces must be free of paint mist and absolutely grease-free!



Remove the sheet metal nuts of the screw connections to the rear apron from the original extensions. Drill a Ø 5.5 mm hole at the position shown using a suitable drill. Fit the sheet metal nut.



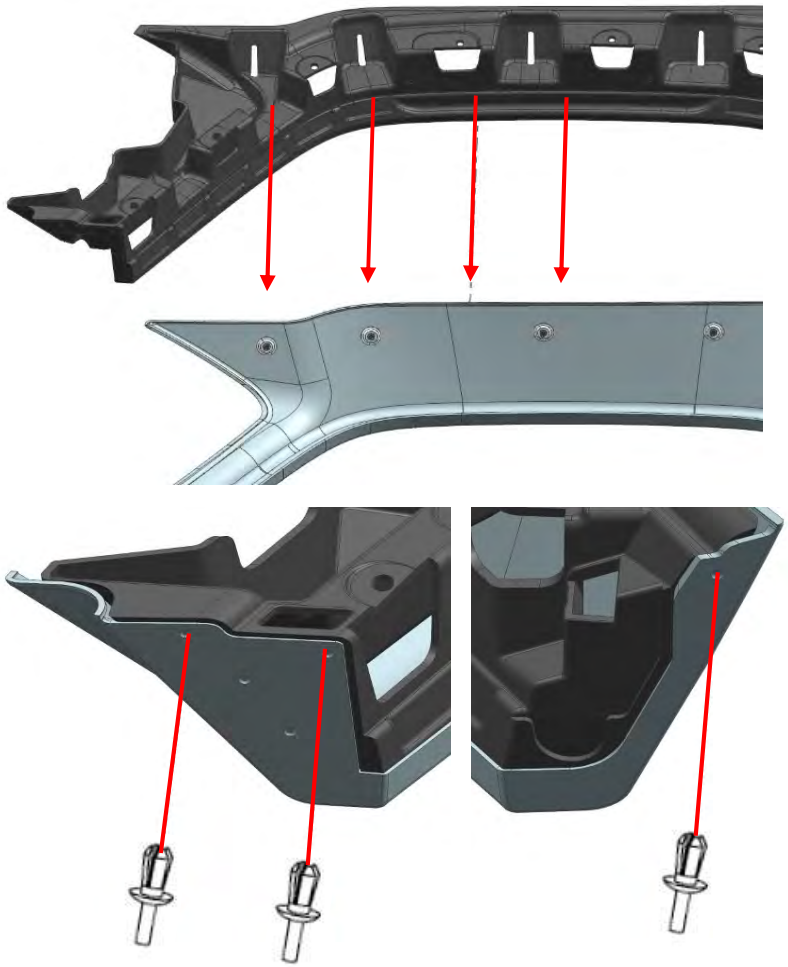
Apply even beads of adhesive to bonding surfaces as shown in the diagrams. Apply the adhesive beads at a distance of approx. 3 - 4 mm from the outer edges. The opening of the adhesive tip should have a diameter of 4-5 mm.



Insert the carrier into the outer skin f rom above.

Attention: Remove excess adhesive immediately!

Insert plastic expanding rivets into the extensions as shown.

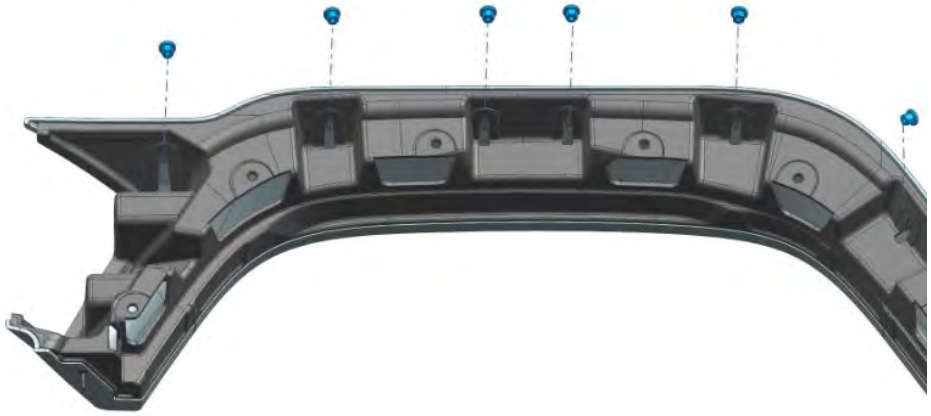


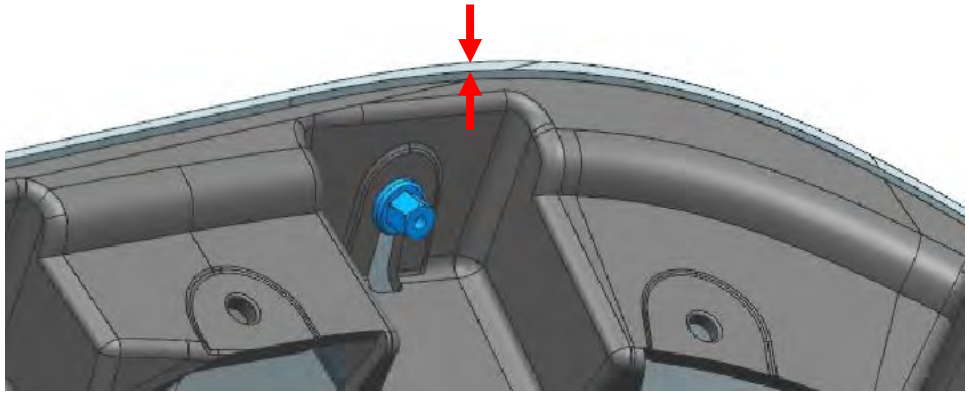
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Carbon-Paket 3

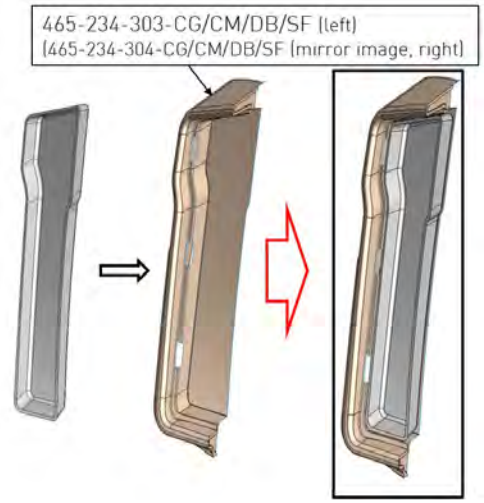
Screw the plastic nuts onto the thread and tight en hand-tight.

The projection of the outer skin to the support must be approx. 2.5 - 3 mm!

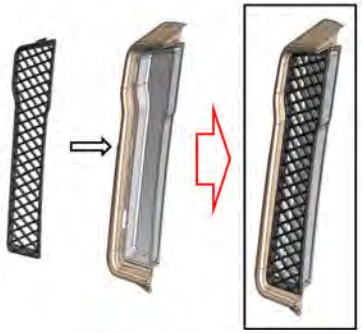


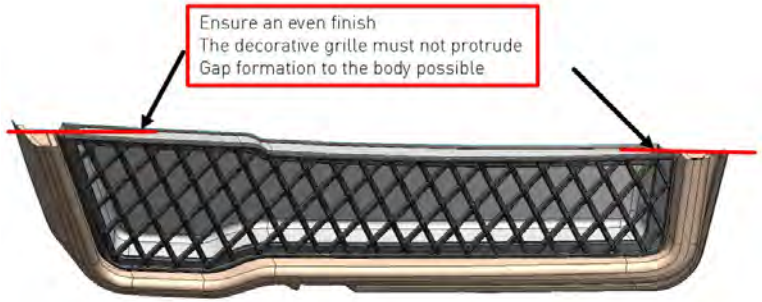


Gluing the shell to the carbon trim



Gluing the decorative grille to the carbon decorative

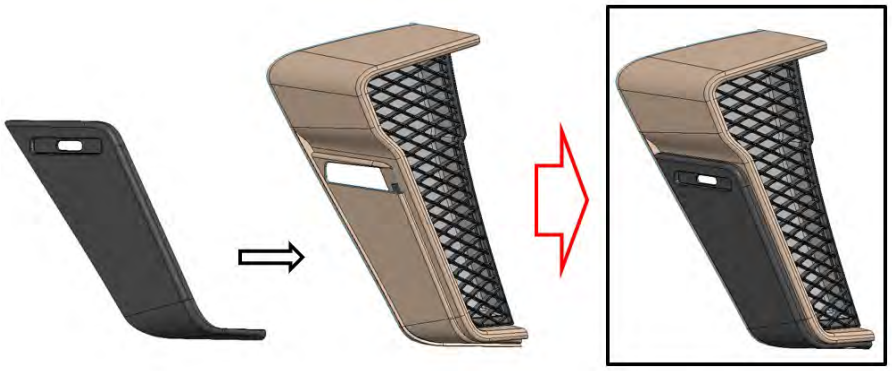




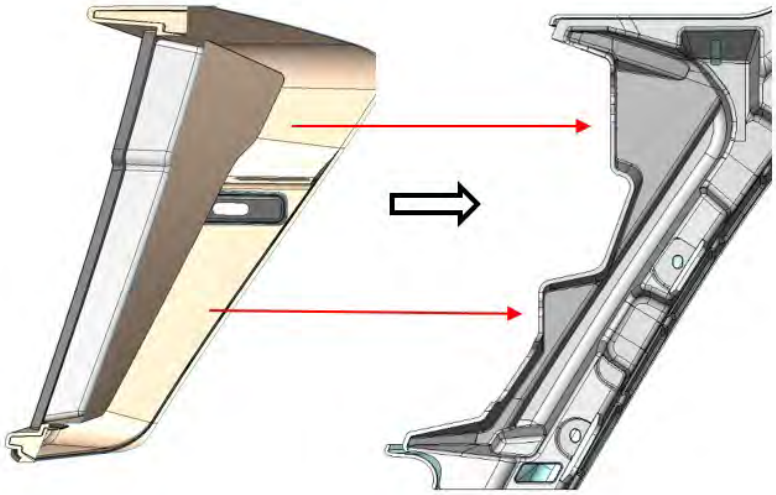
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Carbon-Paket 3

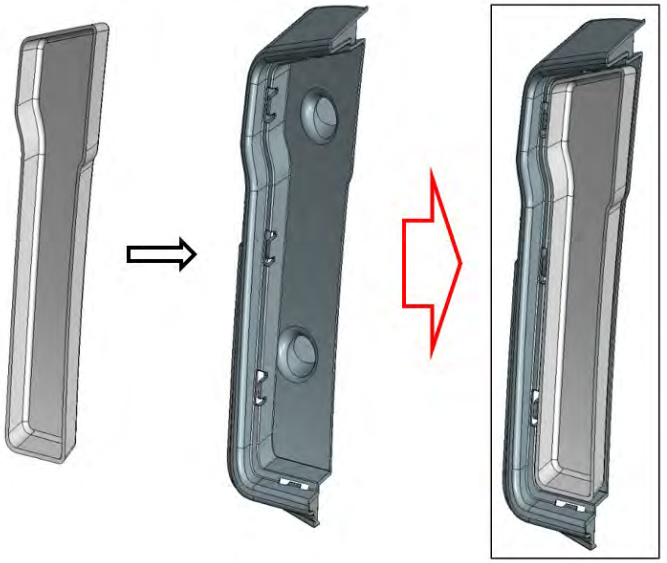
Gluing the cover to the carbon trim frame



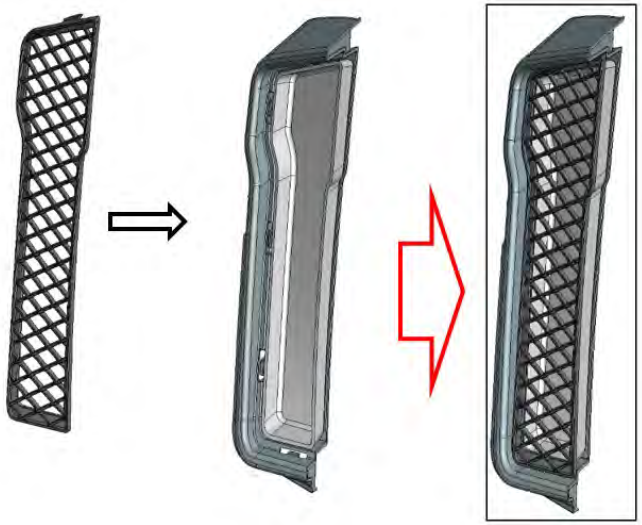
Glueing the decorative frame with mudguard atta chments.
(continue on page 66)



Glue cover to decorative fra me.

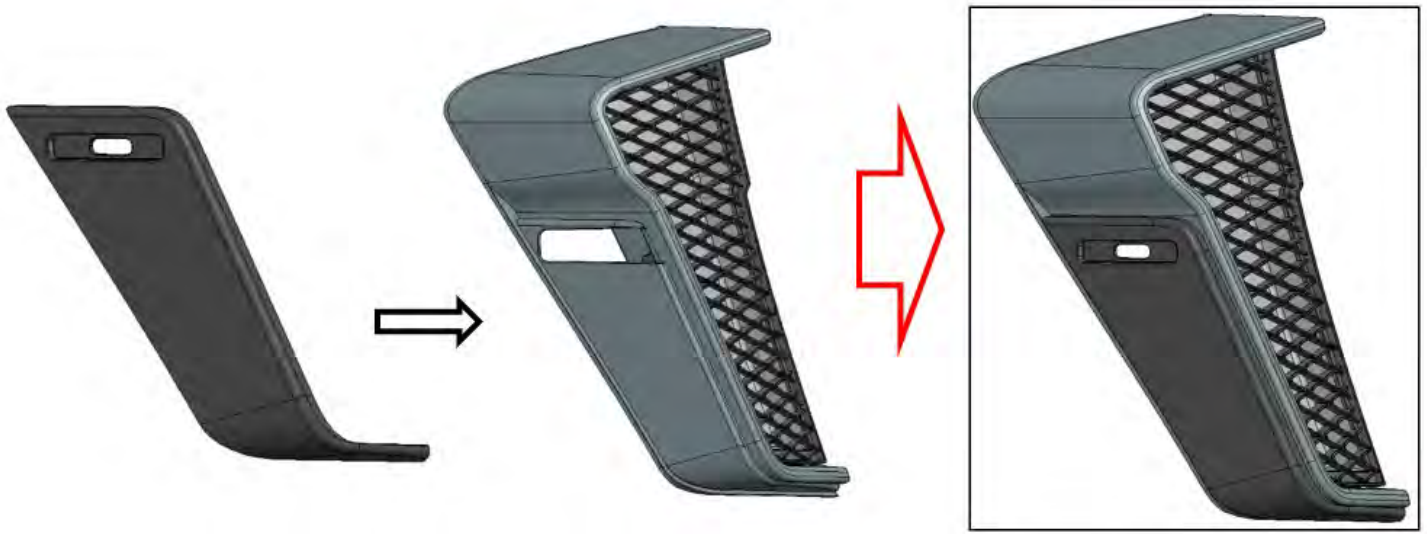


Clip the decorative grille to the decorative frame.

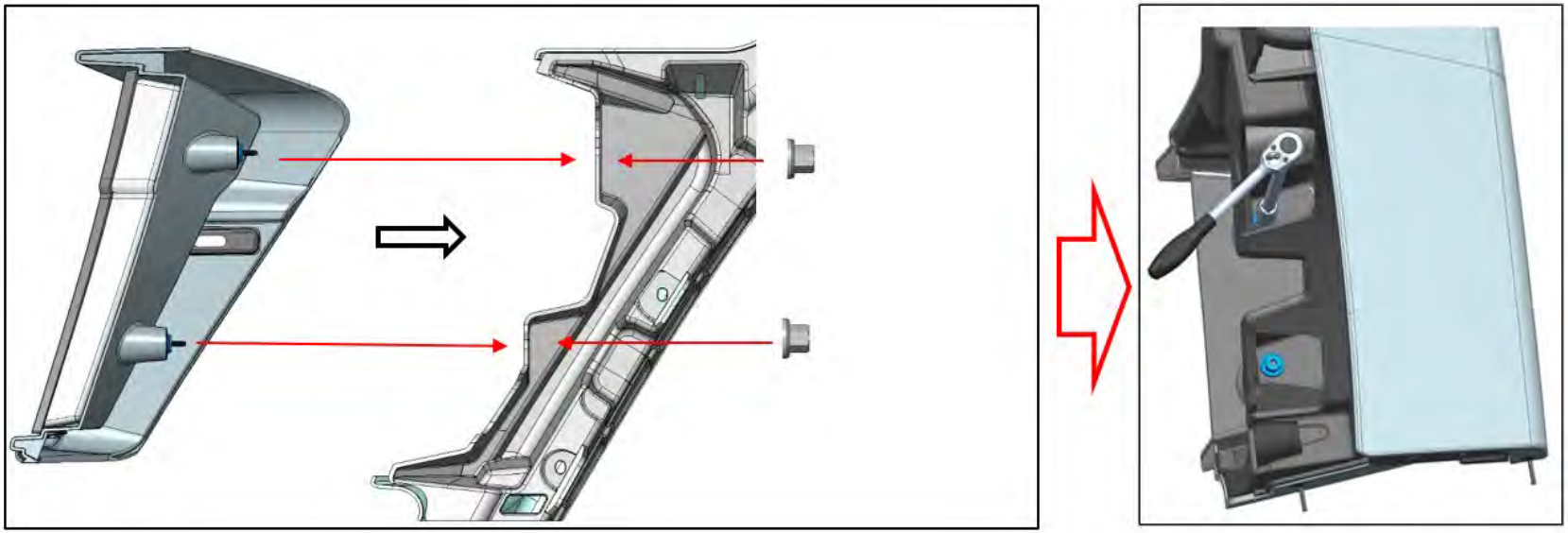


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Glue the cover to the decorative frame .



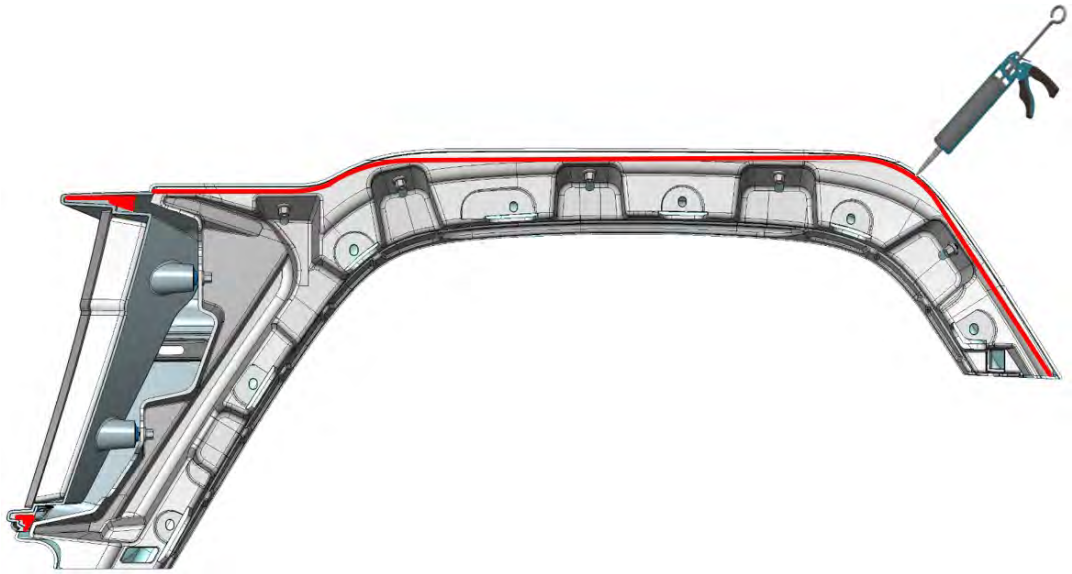
Loosely attach the design air outlets of the front mudguard attach ments using the plastic nuts supplied (22023640). Do not tighten the nuts at this stage!



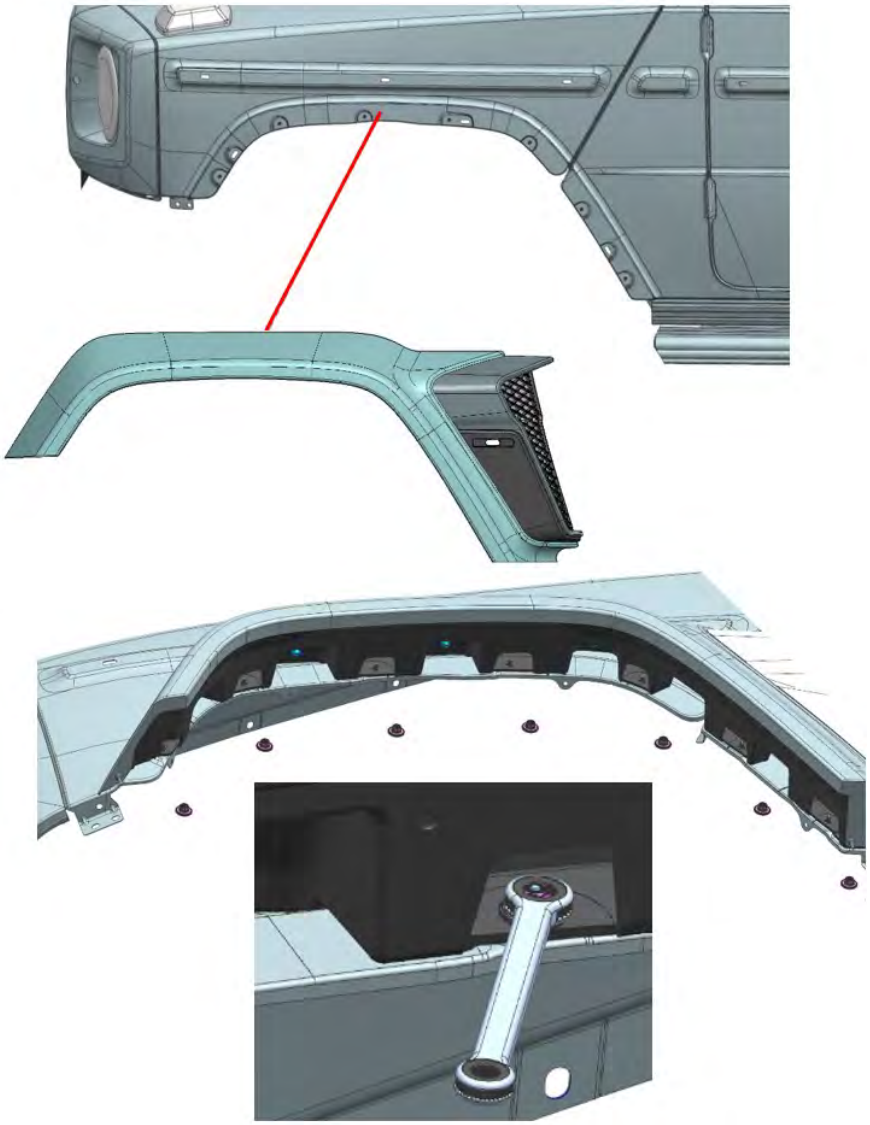
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Roughen the red -marked adhesive surfaces of the front decorative frames and clean thoroughly in two stages using silicone remover.

Apply even beads of the supplied adhesive to the areas marked in red. The opening of the adhesive tip should have a diameter of 4-5 mm.



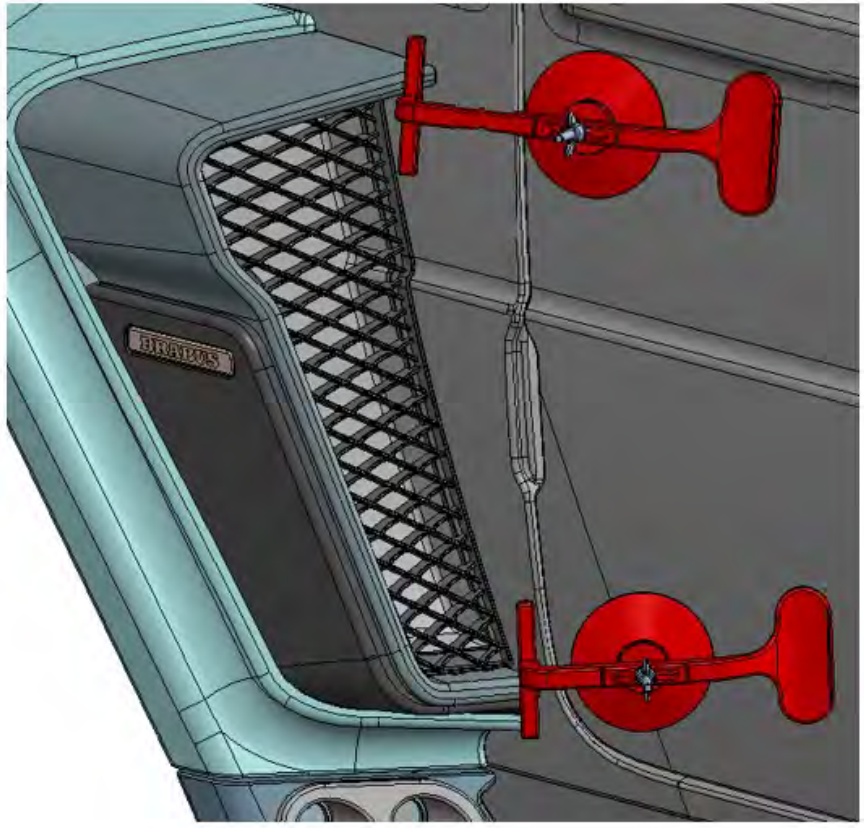
Attach the carrier with outer skin to the standard attachment points on the body and screw on with plastic nuts (22023640).



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Align and firmly screw down the decorative frame of the front extensions, fix the decorative frame with suitable means as shown until the adhesive has finally hardened.

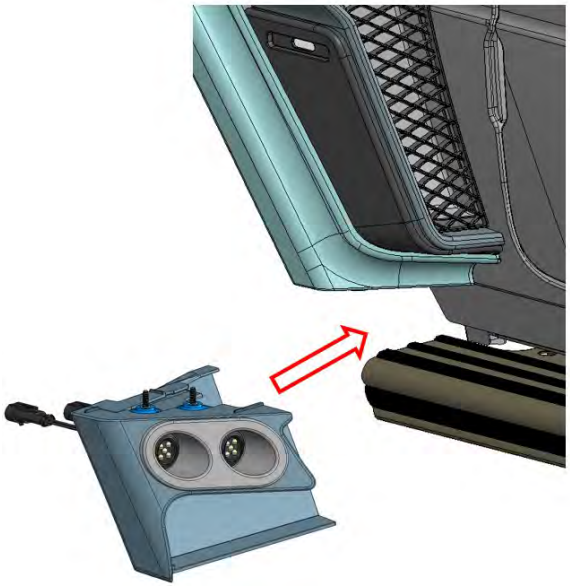
We recommend the use of adhesive suction cups. Fix the widenings in the areas of the transitions to the front running board corners with fabric tape until the adhesive has finally hardened .

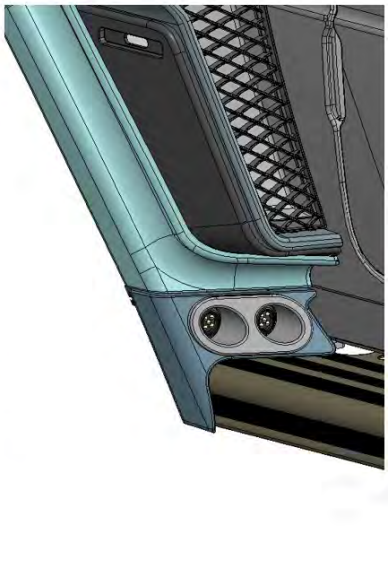


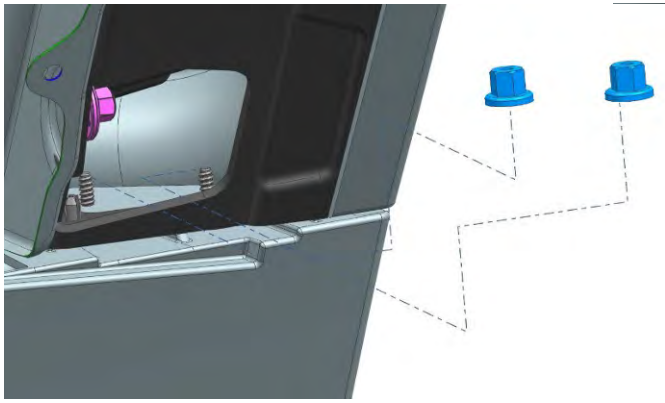
Fasten the plastic nuts on t he front decorative frame .

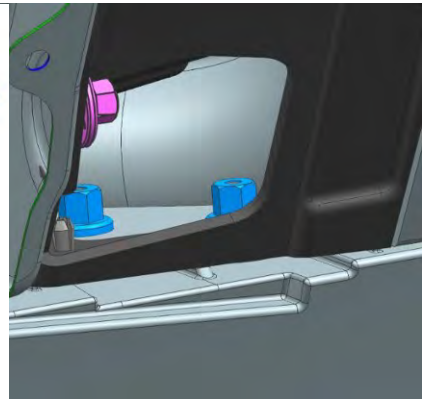


Connect running board lighting to vehicle wiring harness, position running board corners between running boards and rear extensions, align and screw together.

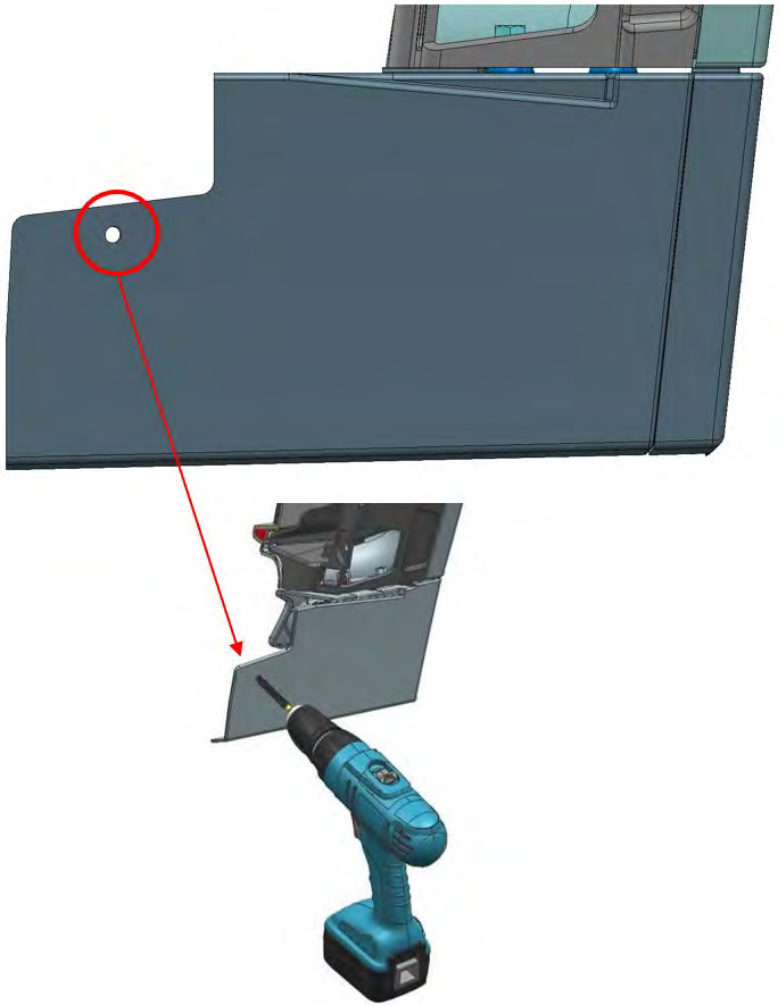




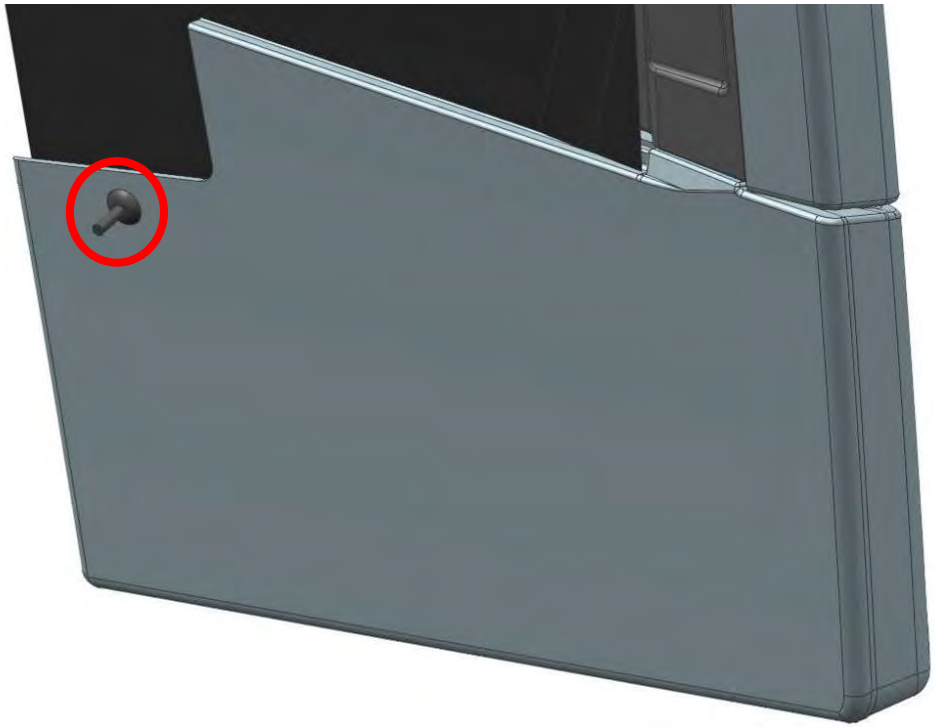




Mark the position shown below on the corner of the running board. Then drill a hole with a diameter of 5.5 mm through the corner of the running board and the standard inner mudguard at this position.

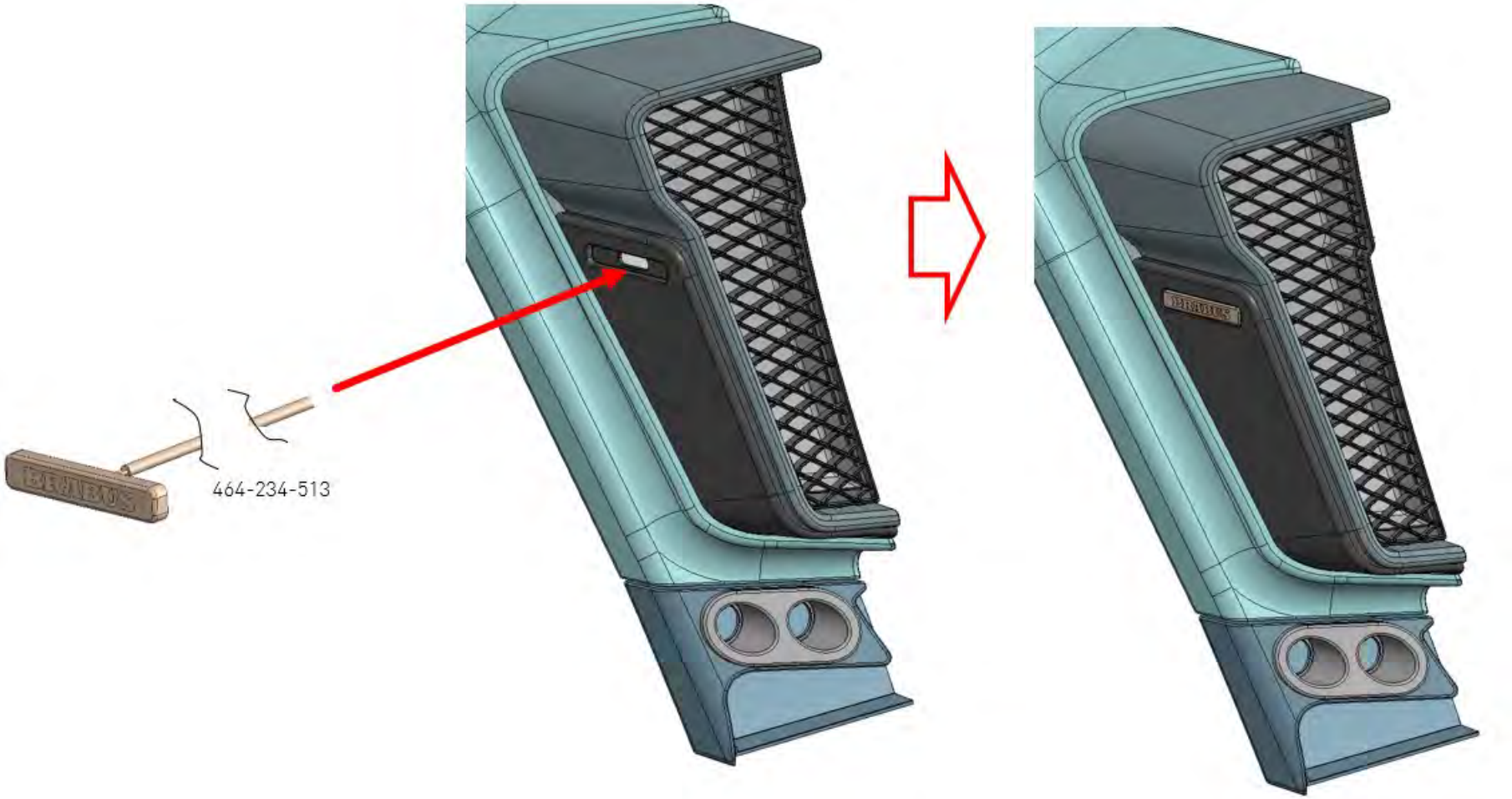


Connect the r unning board corner and the wheel arch liner using the expanding rivet.



Thoroughly clean the adhesive surfaces of the front trim frame clasps in t wo stages using silicone remover.
Remove the protective film from the VHB adhesive strips of the illuminated logos.

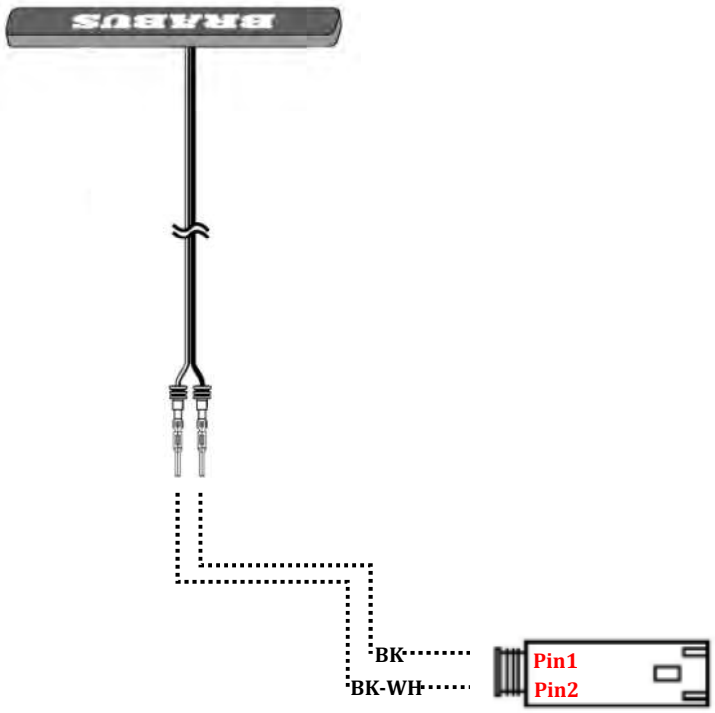
Guide the LED lighting cables for the decorative frames inwards through the openings in the decorative frames, glue the logos into the recesses in the decorative frame clasps and press firmly into place.



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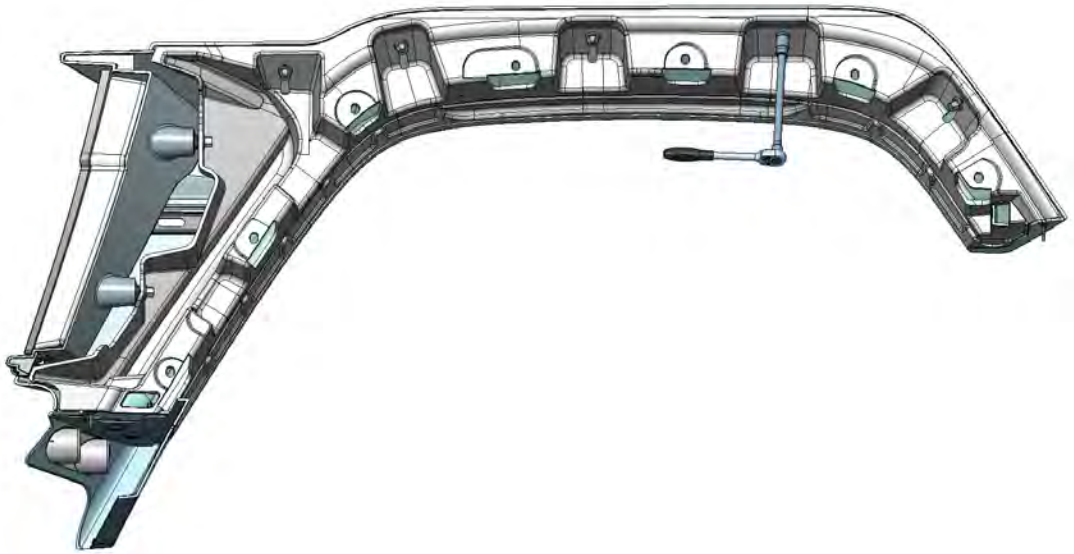
Insert the contacts into the supplied plug according to the assignment below and lock in place.

Connect illuminated logos with vehicle cable set.



Important:

Please remove all plastic nuts for fastening the front outer skins after the adhesive has hardened!

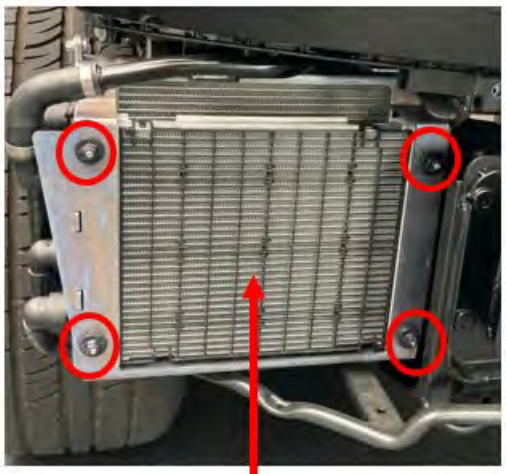


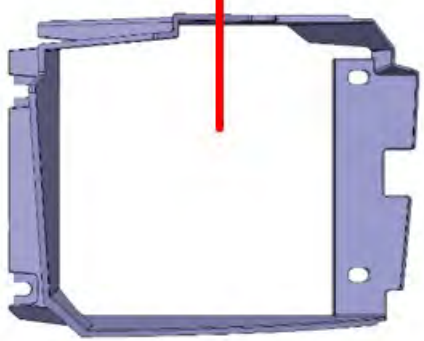
Attention: The original wiring harness from the front apron must be transferred with all sensors (PDC & temperature) and the front camera for the BRABUS front apron. These components are still used in the construction of the BRABUS front apron.



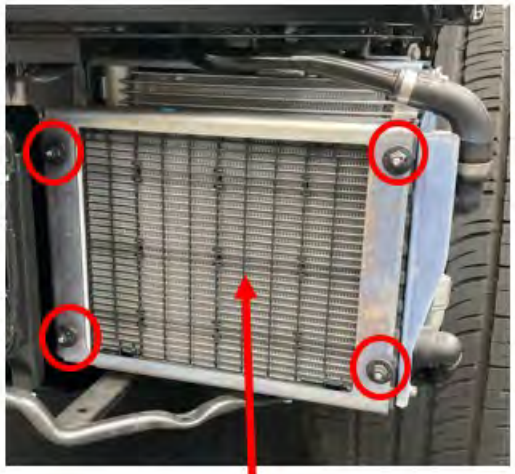
Remove the original front apron according to the Mercedes workshop in formation system.

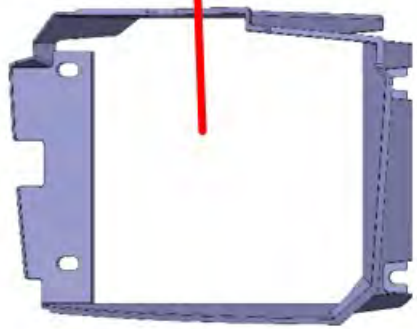
Remove the left and right air ducts behind the front apron and replace them with the two BRABUS air ducts. The original nuts are used for fastening.





465-234-901





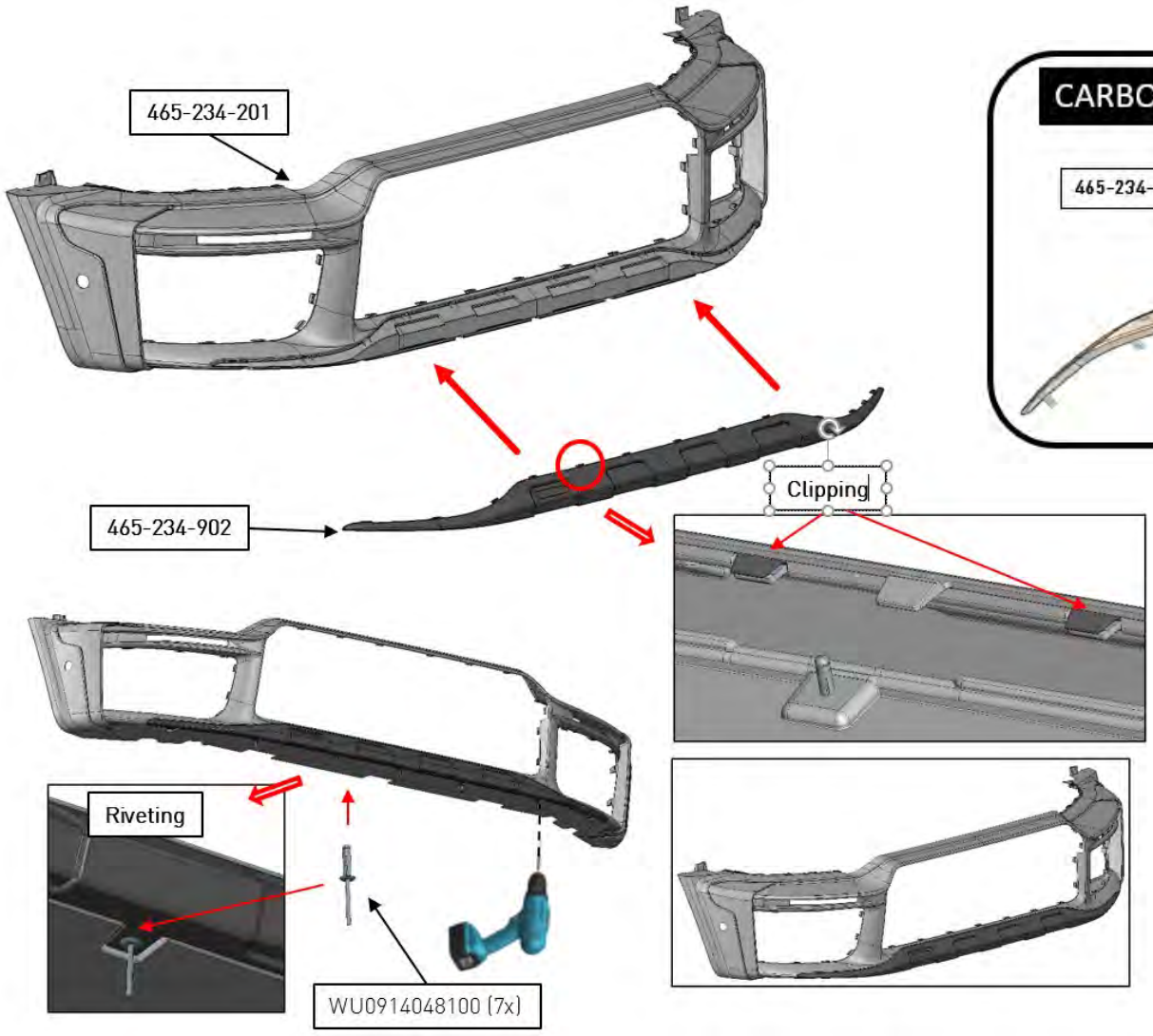
465-234-902

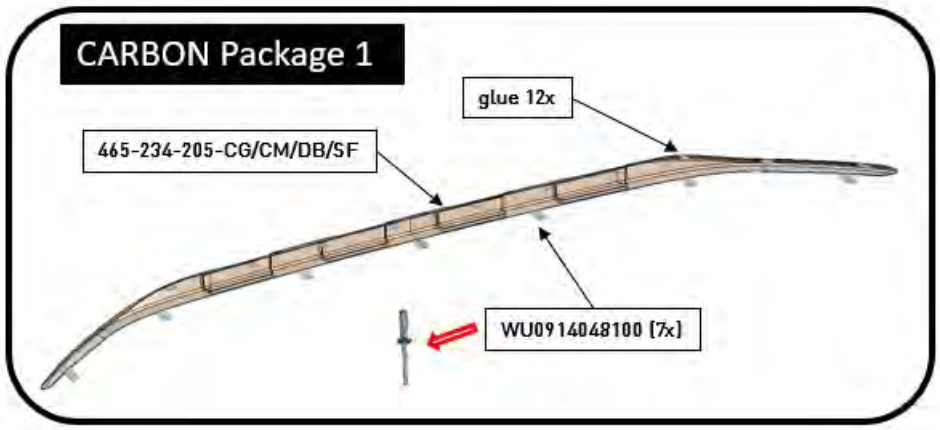
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Clip the BRABUS front lip into the BRABUS front apro n. Drill Ø 5.0 mm holes in the BRABUS front apron at the fastening positions using a suitable 5.0 mm drill bit and a suitable drill.

Fasten BRABUS front lip using the supplied aluminum blind rivets (7x).

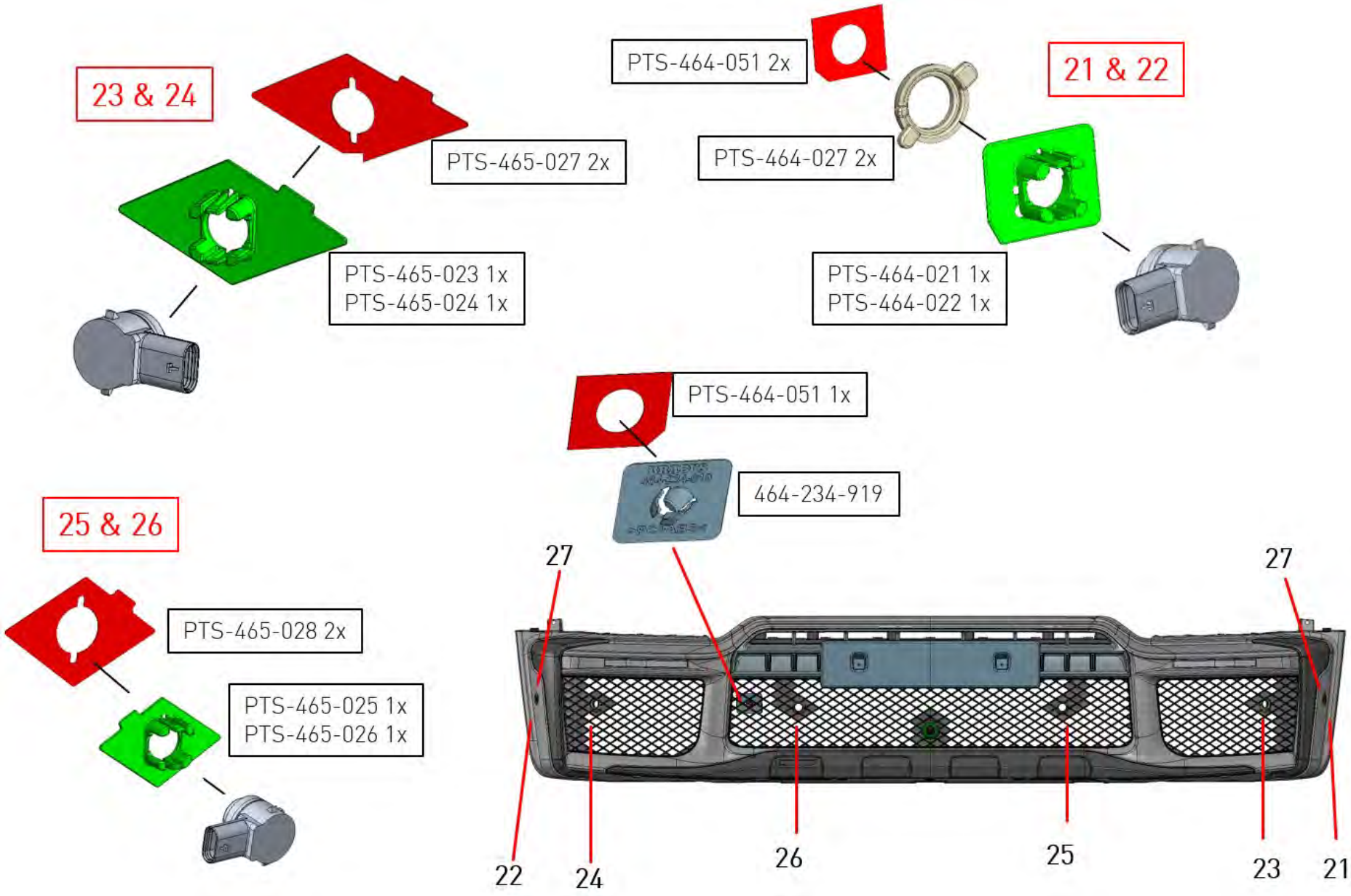
When using the BRABUS front lip carbon 465 -234-205-CG/CM/DB/SF, all lower fixing points must first be riveted and then all upper tabs glued.





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Assignment of PTS sensor holder to inserts and adhesive pads front apron

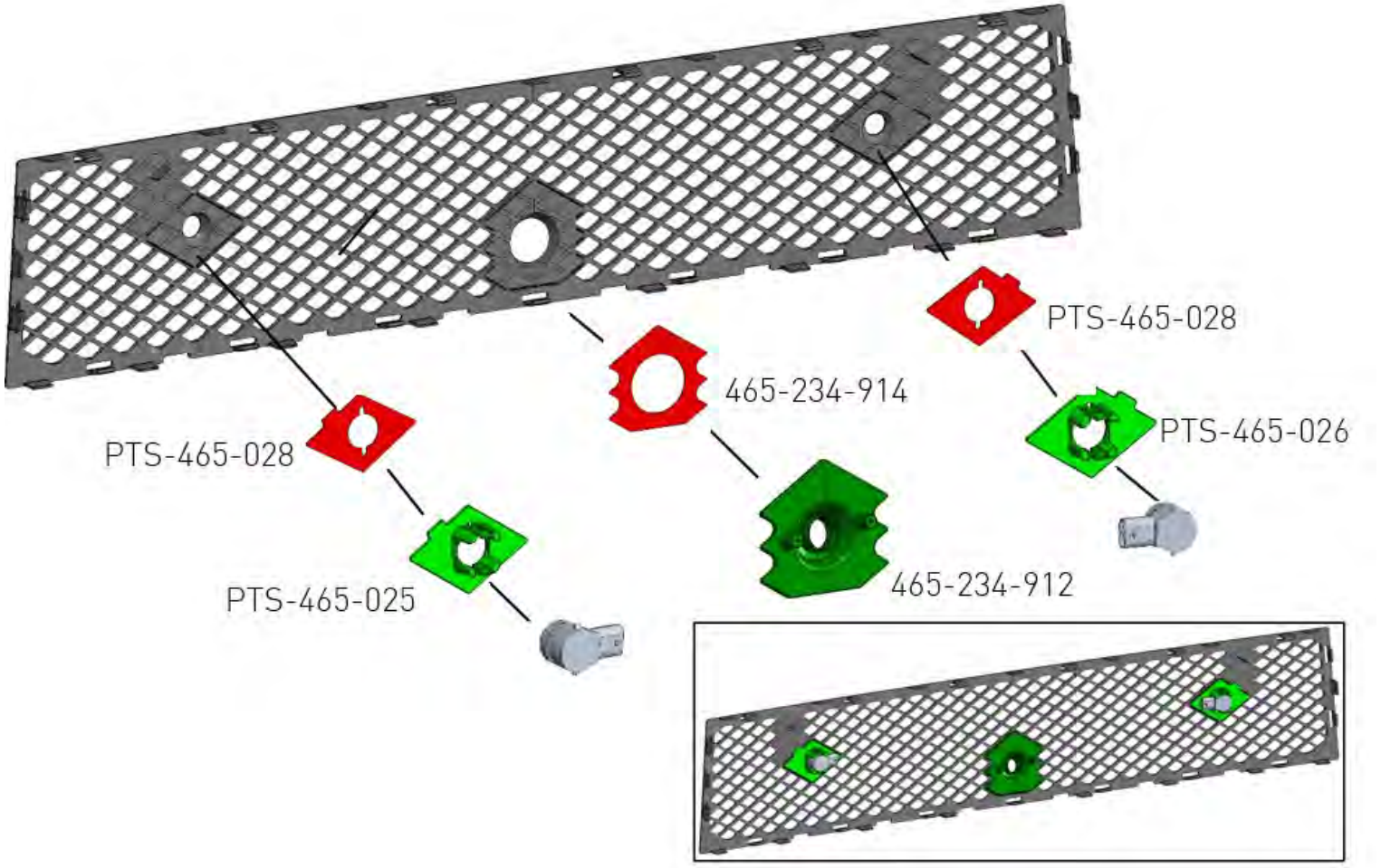


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Clean the adhesive surfaces of the PDC sensors and the camera h older on the central grille and the adhesive surfaces of the PDC holders -025 & -026 &-912 in two stages using silicone remover.

Adhere VHB adhesive pads with part numbers -028 & 914 to the PDC holders and camera holders with part numbers -025, -026 & -912.

Clip the PDC sensors into the PDC holder. Remove the protective film from the VHB adhesive pads, stick the PDC units and camera holder in the intended positions in the rear apron. Press all units firmly into place.



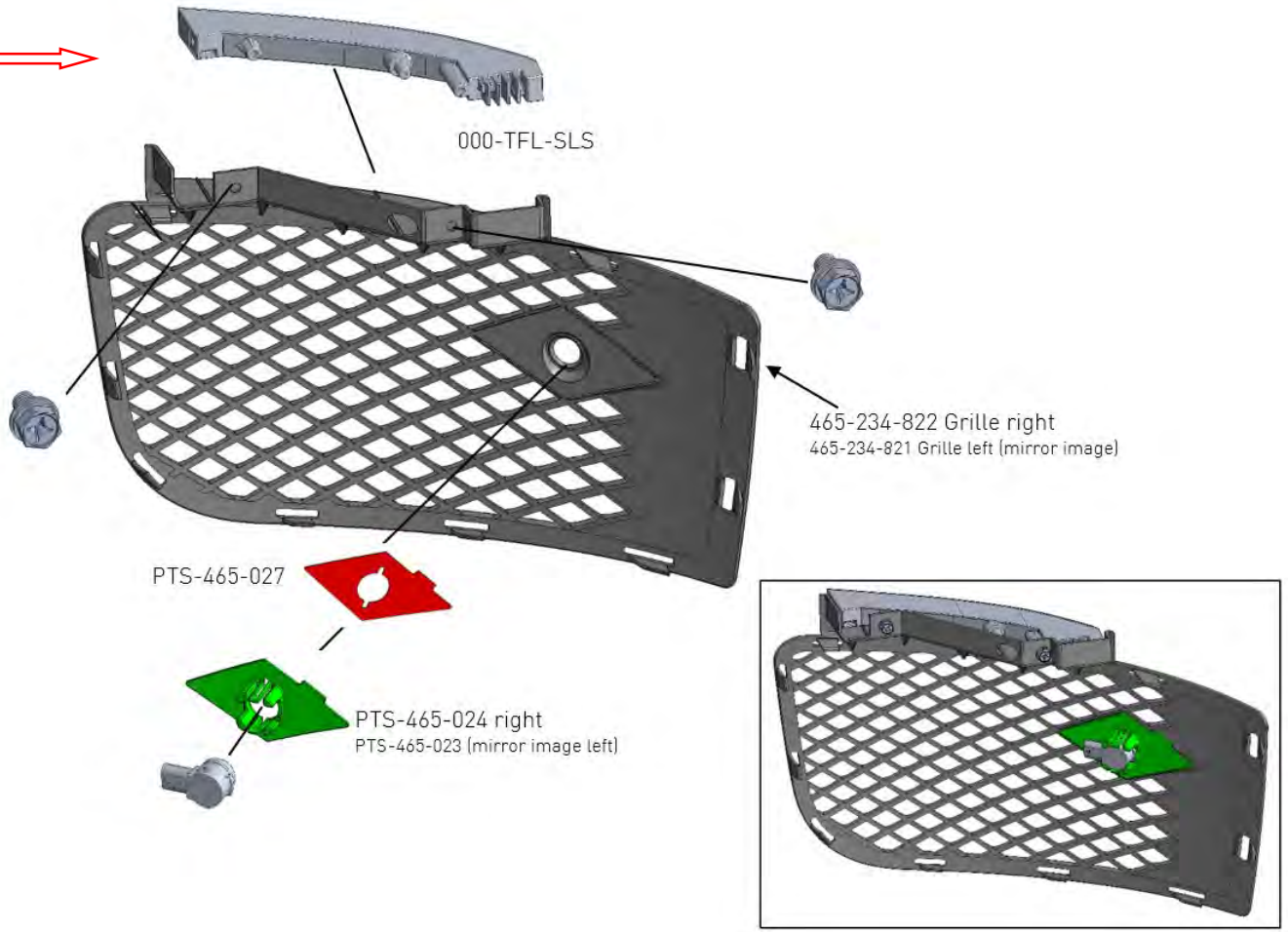
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Clean the adh esive surfaces of the PDC sensors o f the left and right grille and the adhesive surfaces o f the PDC holders -023 & -024 in two stages using silicone remover.

Clip the PDC sensors into the holders as shown and attach the adhesive pads -027.
To do this, remove the liner with the sides facing the holders and glue the pads to the holders.
Firmly press on the VHB adhesive pads and remove the liners from the other sides. Glue the completed PDC units to the predetermined positions in the left and right grille and press down firmly.

Screw the LED daytime running lights to the two grilles using the screws supplied.

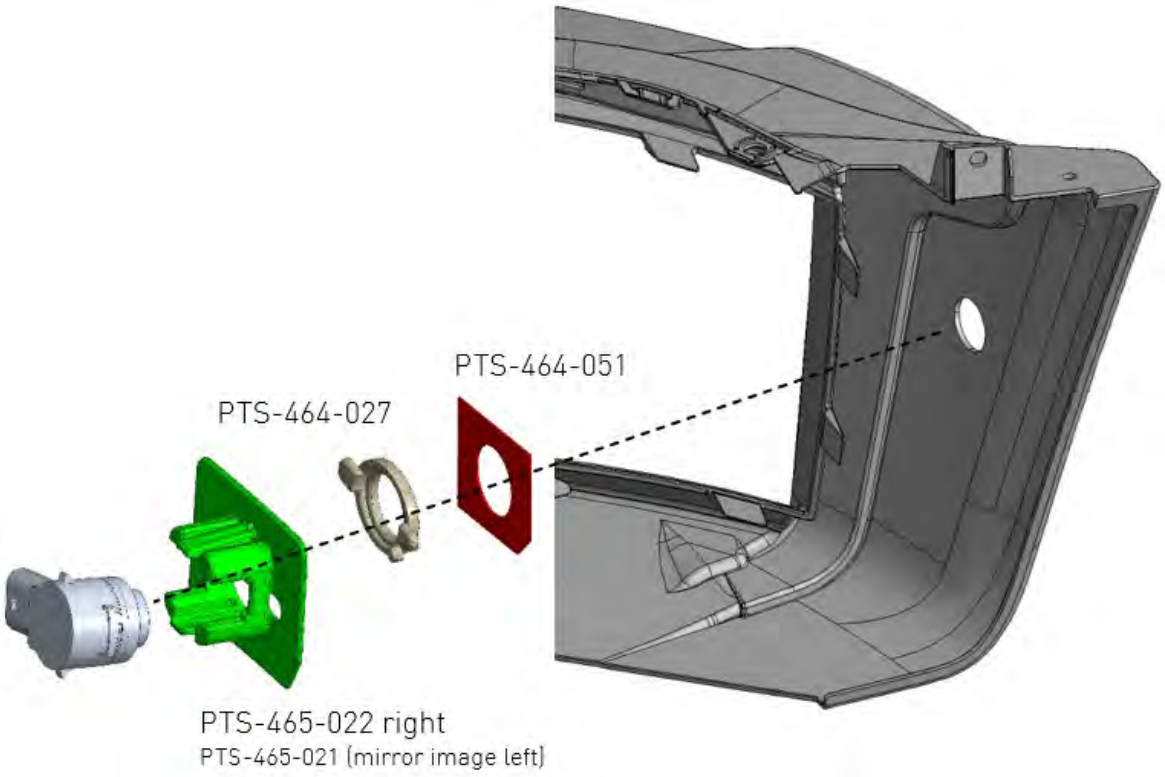
Do not tighten the screw connection completely to allow alignment after installing the grilles.



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Clean the adhesive surfaces of the PDC sensors of the left and right grille and the adhesive surfaces of the PDC holders -021 & -022 in two stages using silicone remover.

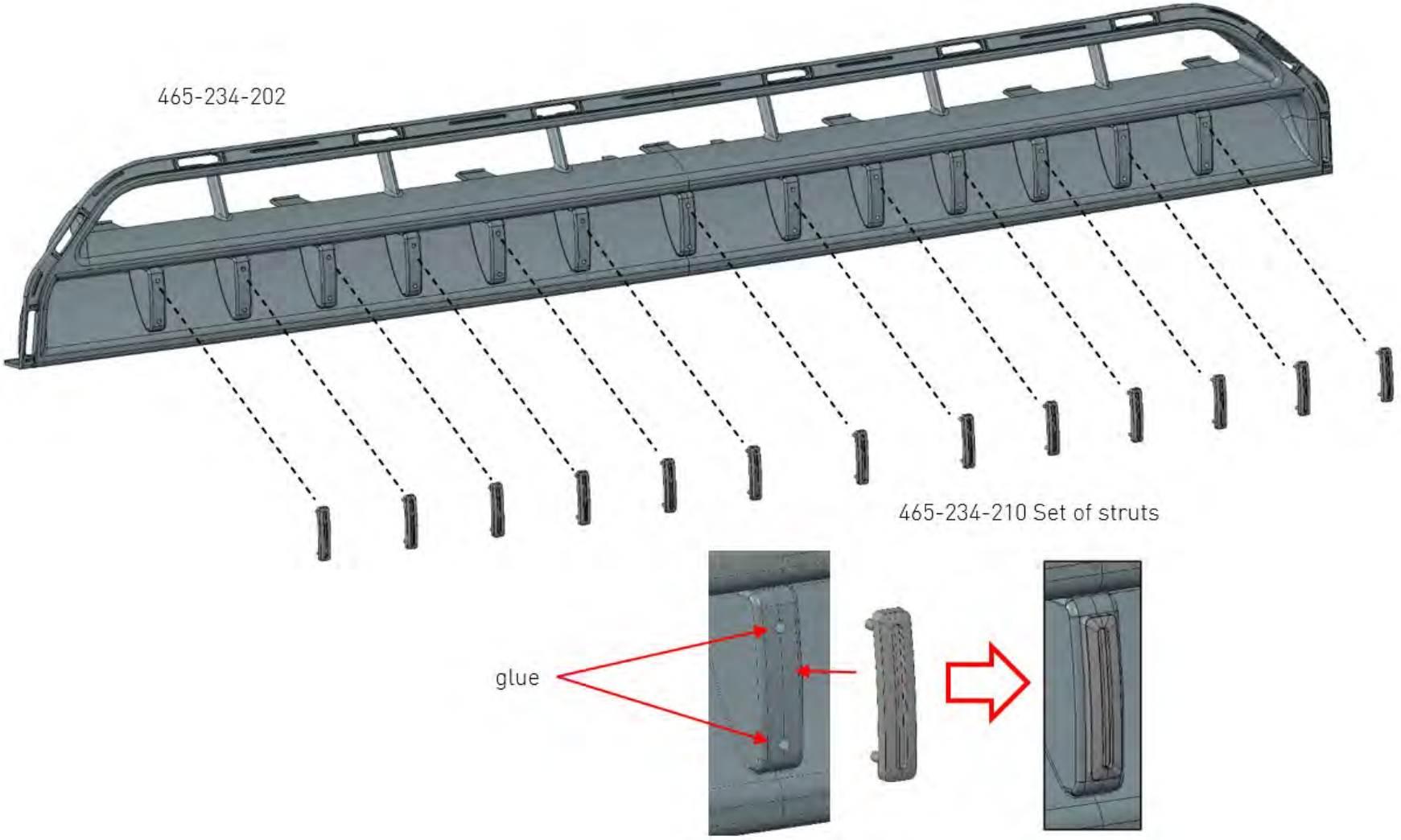
Clip the PDC sensors into the holders as shown and fit the inserts -27 and the adhesive pads -051.
To do this, remove the liner with the sides facing the holders and glue the pads to the holders.
Firmly press on the VHB adhesive pads and remove the liners from the other sides. Glue the completed PDC units in the intended positions and press firmly into place.





Insert the struts through the holes in the insert and glue the protruding tips on the ba ck with wet adhesive .

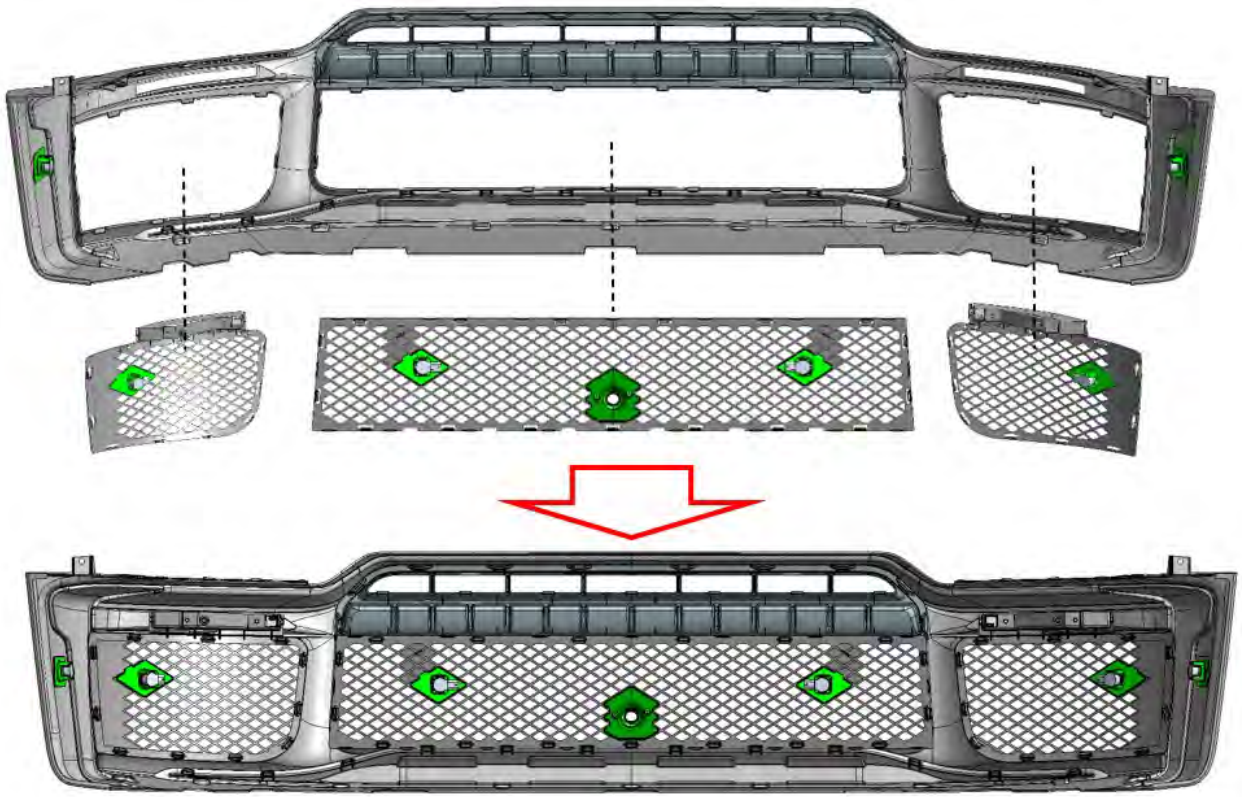
Fix the bonding with suitable means until the adhesive has finally hardened.



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Clip the decorative grille left, center & right int o the front apron.

Align the LED daytime running lights and tighten all 4 screws.

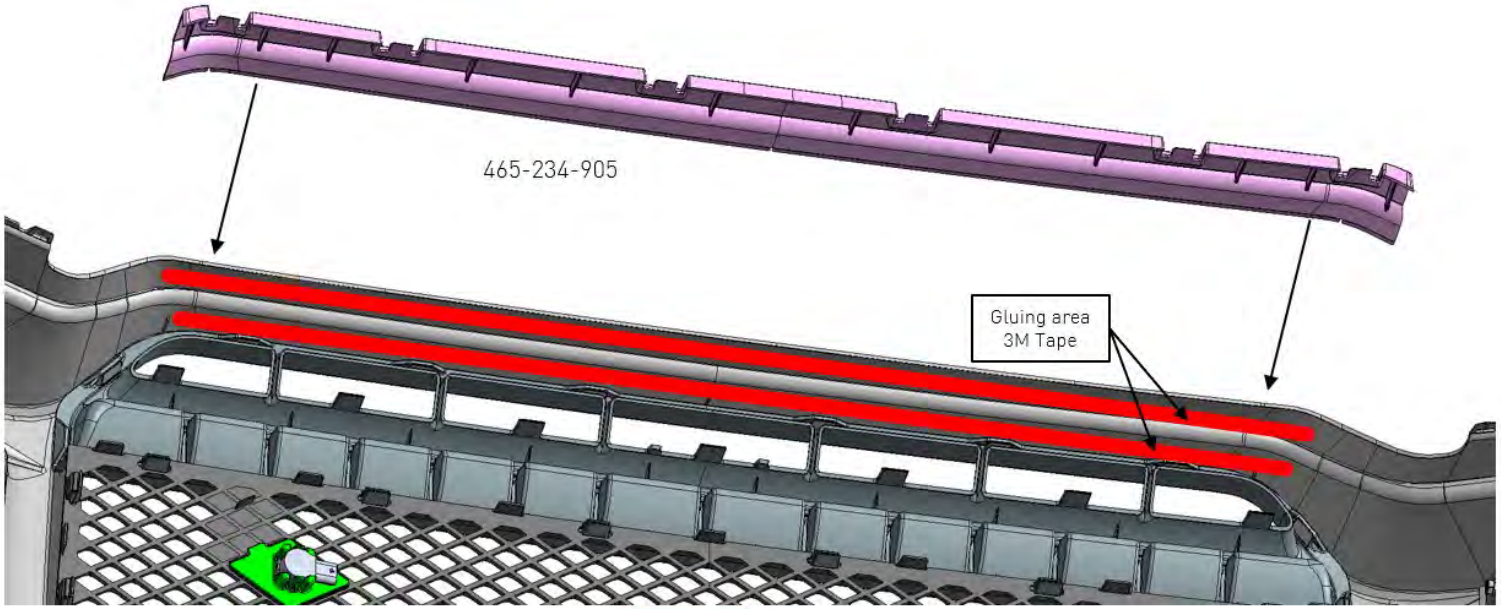


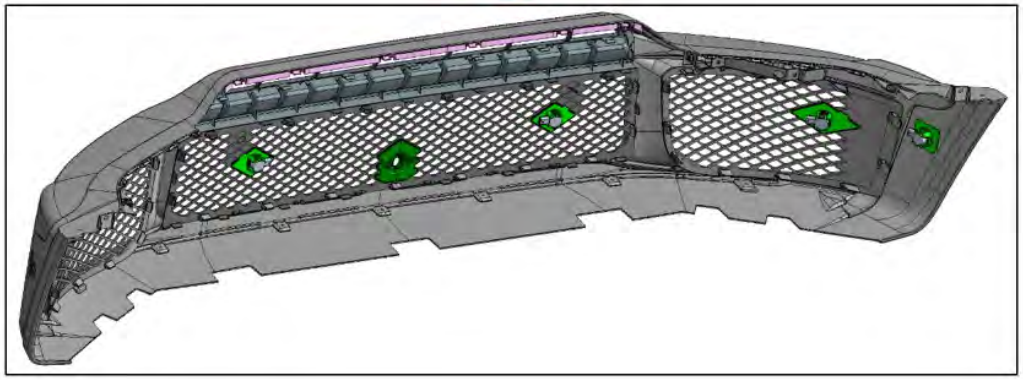
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Clean the adhesive surfaces on the air guide at the t op of the upper section using silicone remover .

Remove the liner of the VHB adhesive tape (marked red) on the front apron and insert the air duct into the front apron.

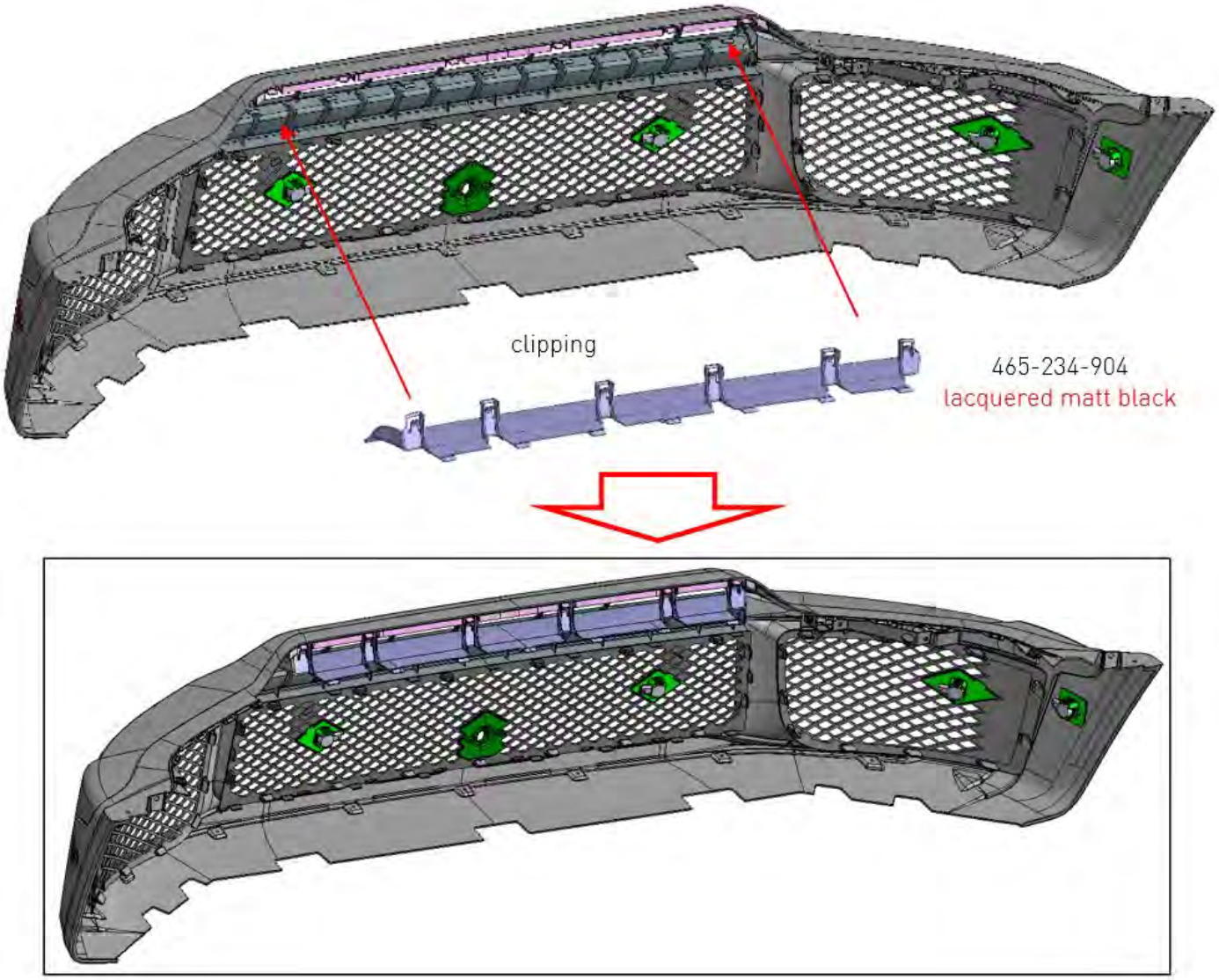
Apply pressure to the adhesive surface to achieve optimum adhesive strength.





Clip the upper air duct lower section into the front apron .

Attention: The component must be painted matt black.



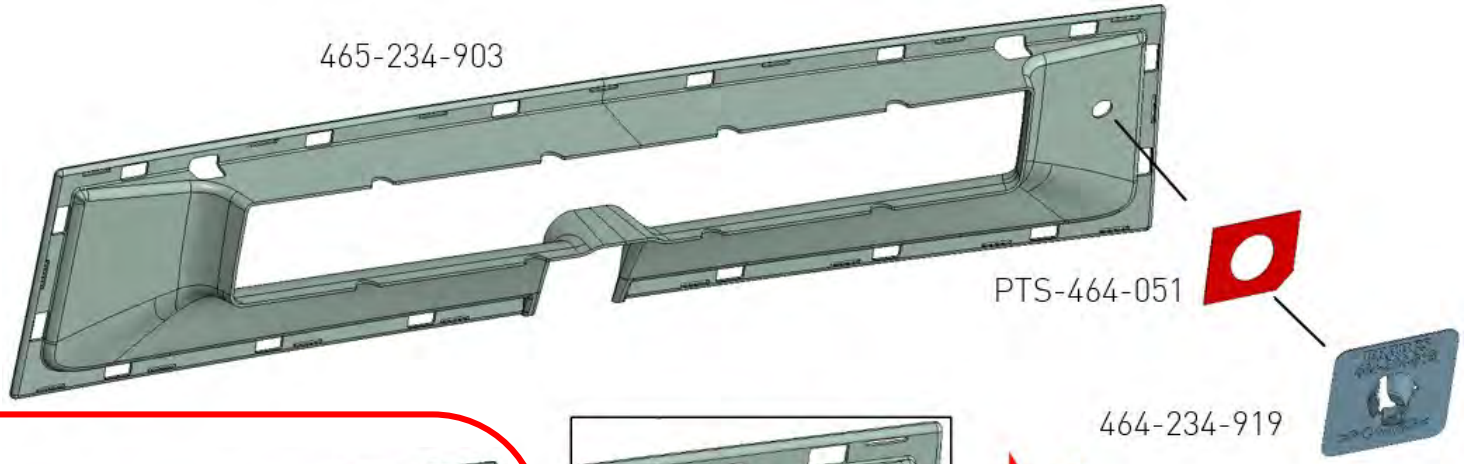
Official technology-partners Continental MOTUL YOKOHAMA ADVAN HANKOOK Member of VDA

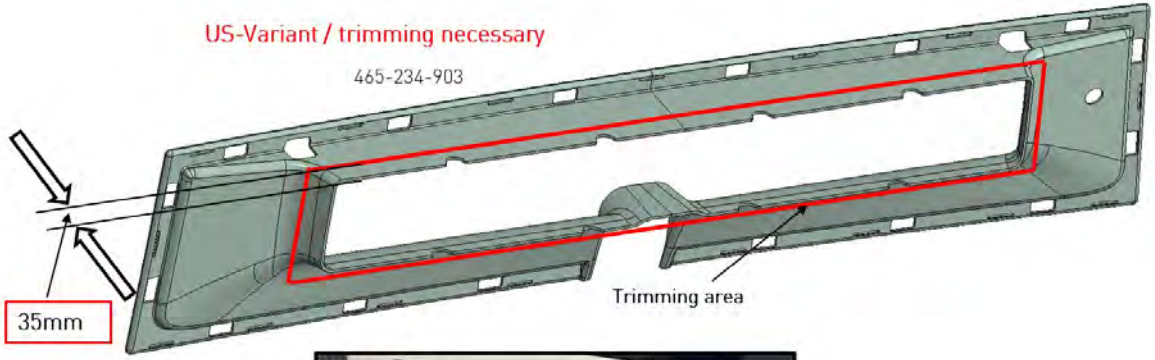
Clean the adhesive surface of the temperature sensor holder and the central air duct in two sta ges using silico ne rem over.

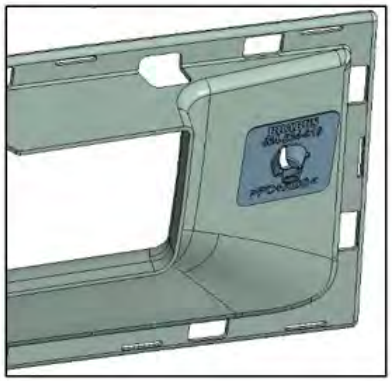
Stick the VHB adhesive pad with part number -51 onto the temperature sensor holder -919.
Clip the temperature sensor into the holder. Remove the protective film from the VHB adhesive pads, Glue the unit to the intended position in the air duct and press down firmly.

Attention!

On the US-G465, the air duct 465-234-903 must be shortened by 35mm.



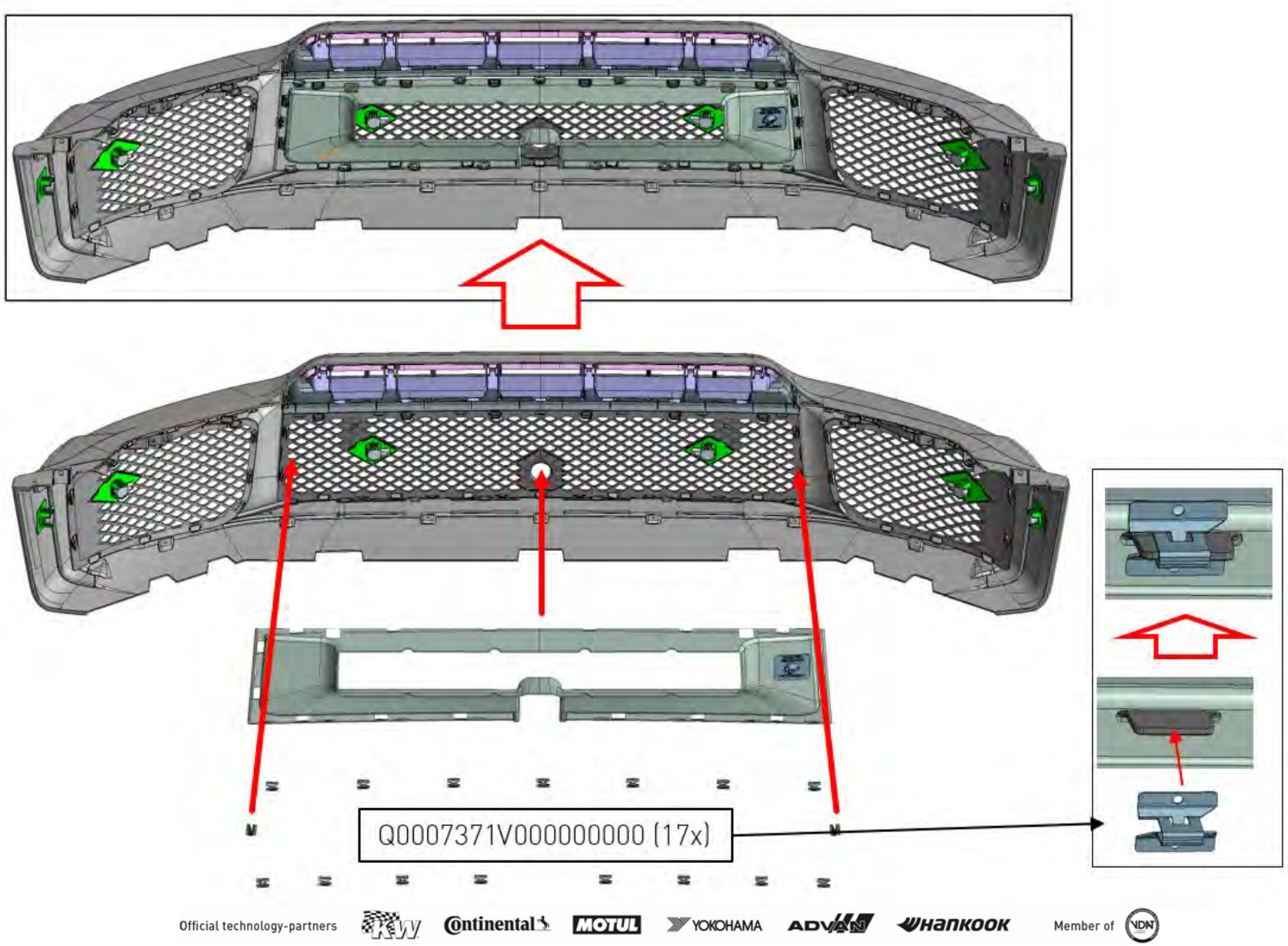






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Place the center a ir duct on the front apron and attach to the front apron using the 17 Speedfix clamps (Q0007371V000000000).

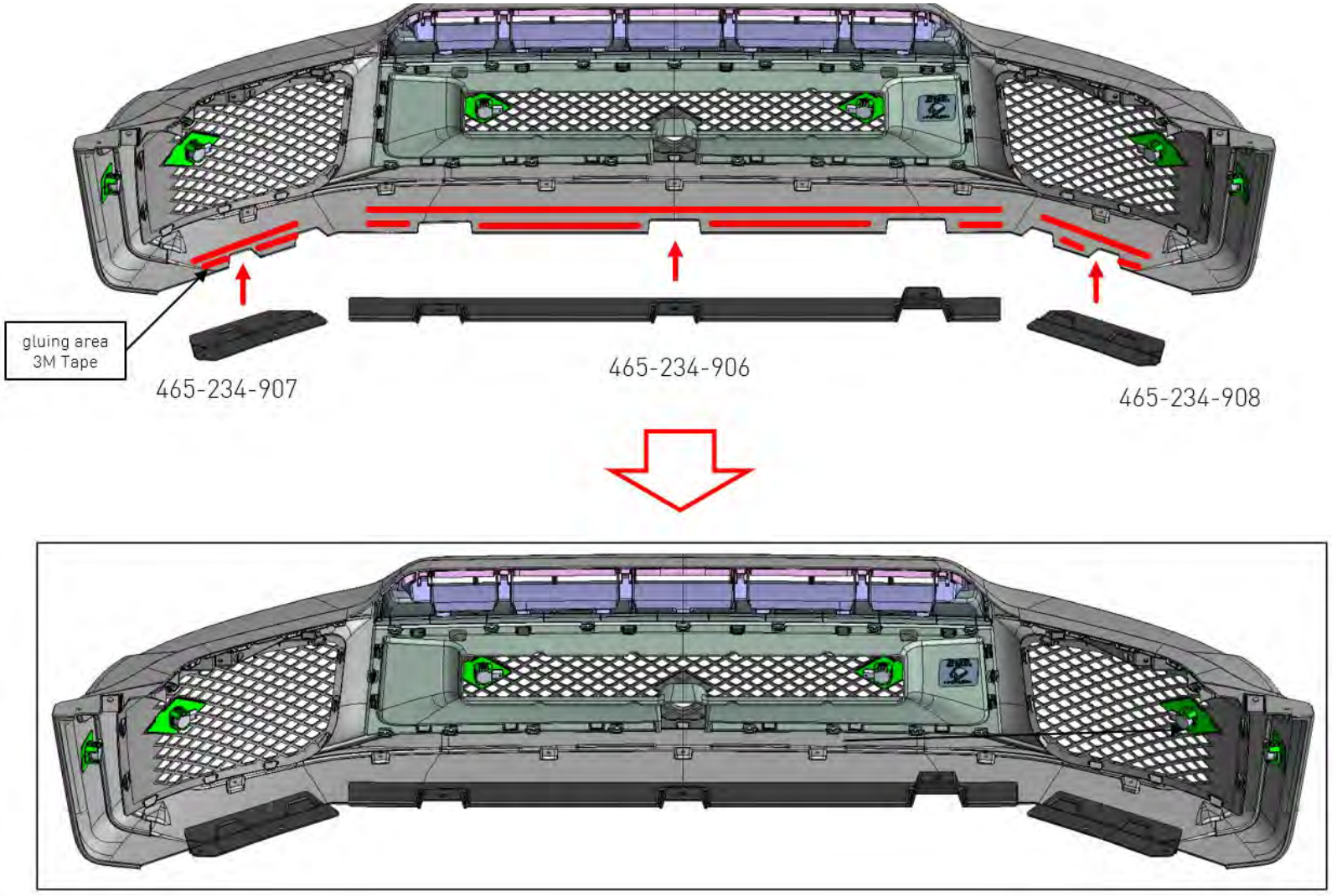


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Clean the adhesive surfaces on the front apron holders using silicone remover .

Remove the liner of the VHB adhesive tape (marked red) on the front apron and insert the left, right & center holders at the bottom of the front apron.

Apply pressure to the adhesive surface to achieve optimum adhesive strength.

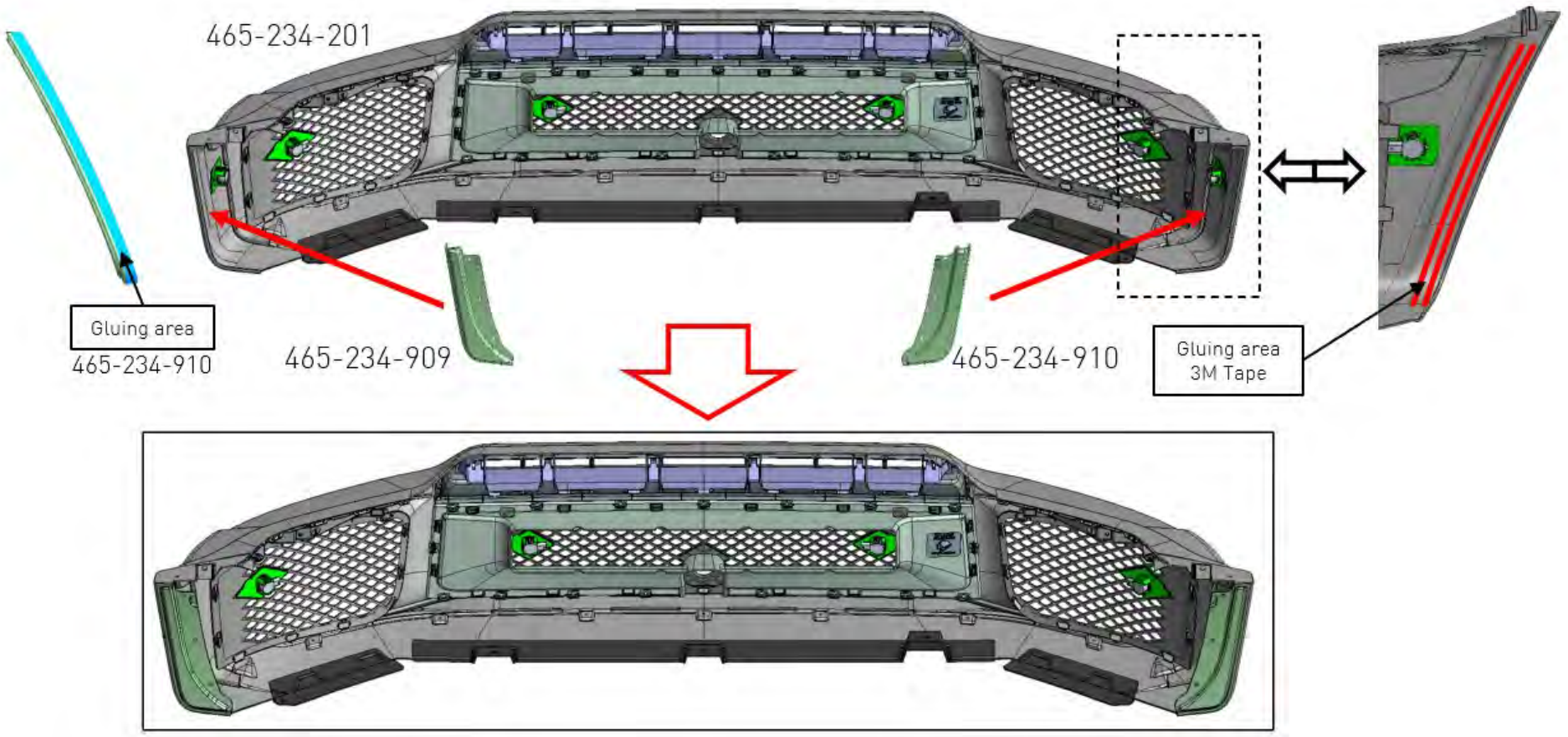


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Clean the adhesive surfaces (marked in blue) on the left & right wheel arch liner brackets using silicone remover .

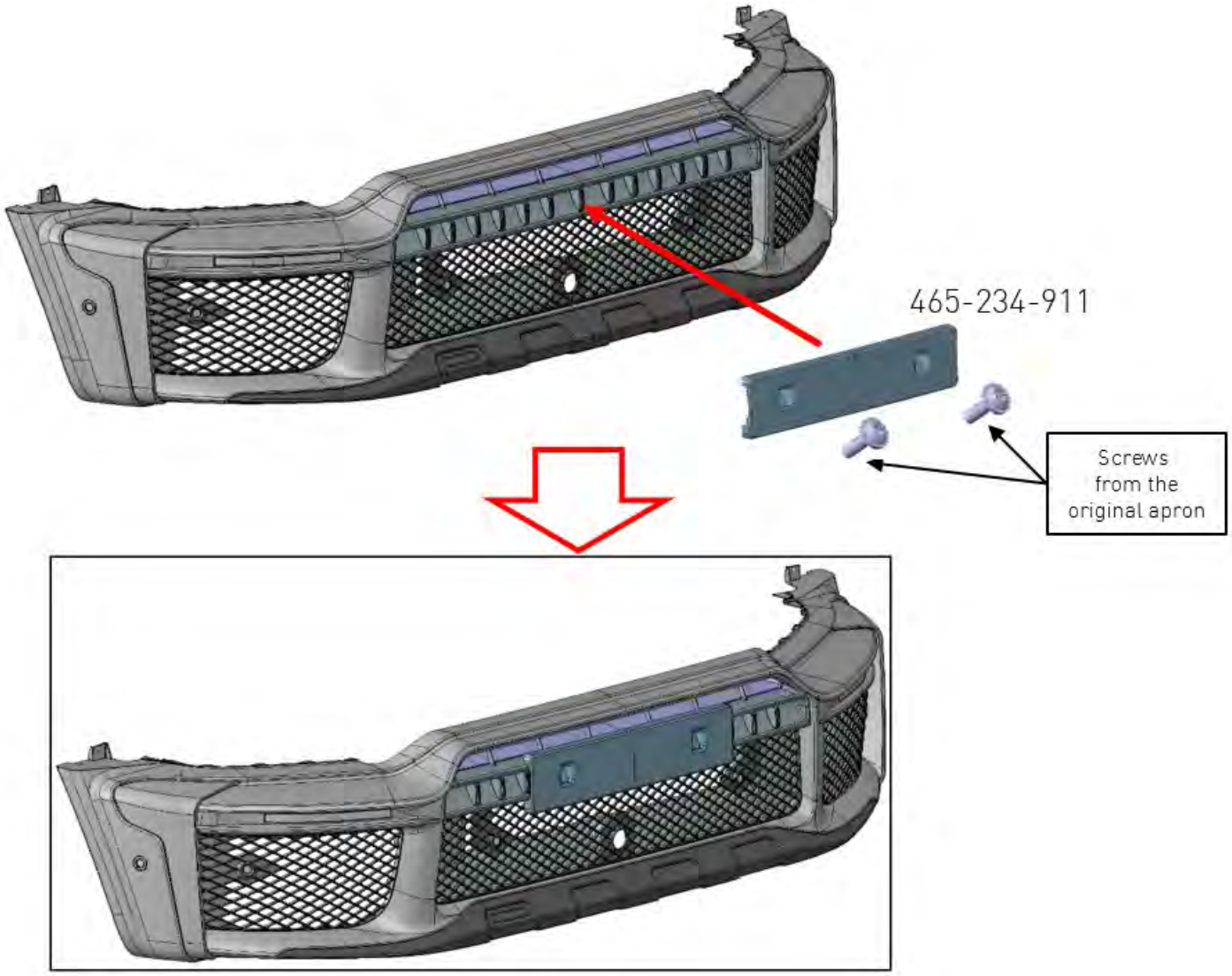
Remove the liner of the VHB adhesive tape (marked red) on the front apron and place the left & right wheel arch liner holders on the outside of the front apron.

Apply pressure to the adhesive surface to achieve optimum adhesive strength.



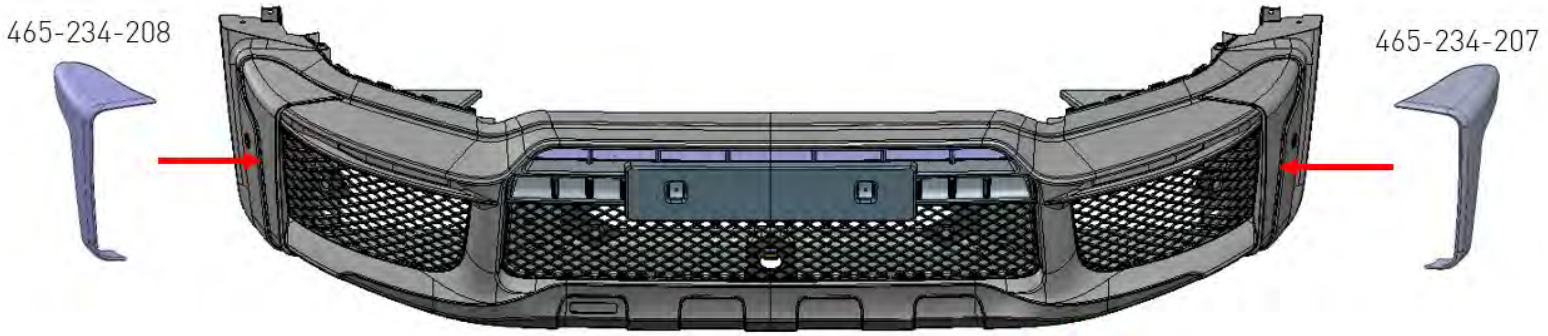
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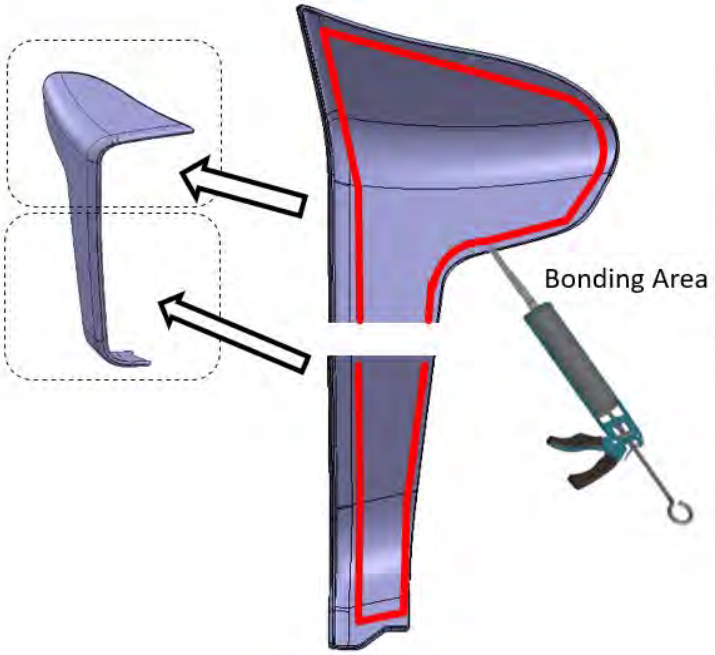
Screw the license pl ate holder to the front apron u sing the 2 original screws .

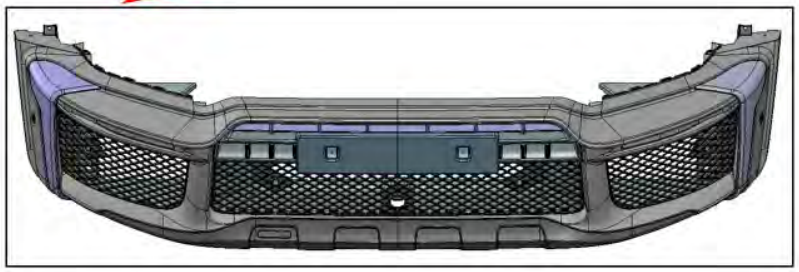


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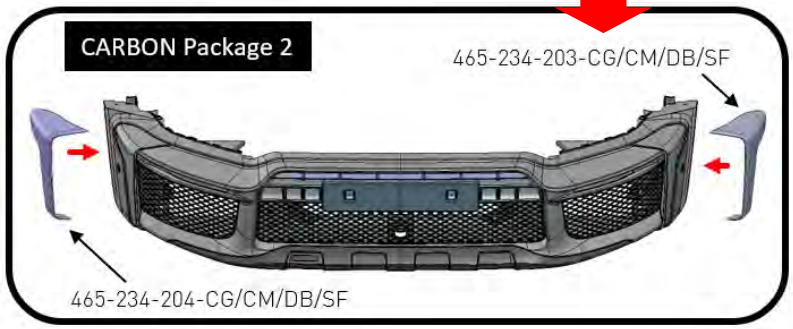
Prepare the left & right attachments and the adhesive surfaces on the f ront apron for bonding in accordan ce with the bonding instructions on page 4. Apply even beads of adhesive to bonding surfaces as shown in the diagrams. Apply adhesive beads at a distance of approx. 3 - 4 mm from the outer edges. The opening of the adhesive tip should have a diameter of 4 - 5mm.







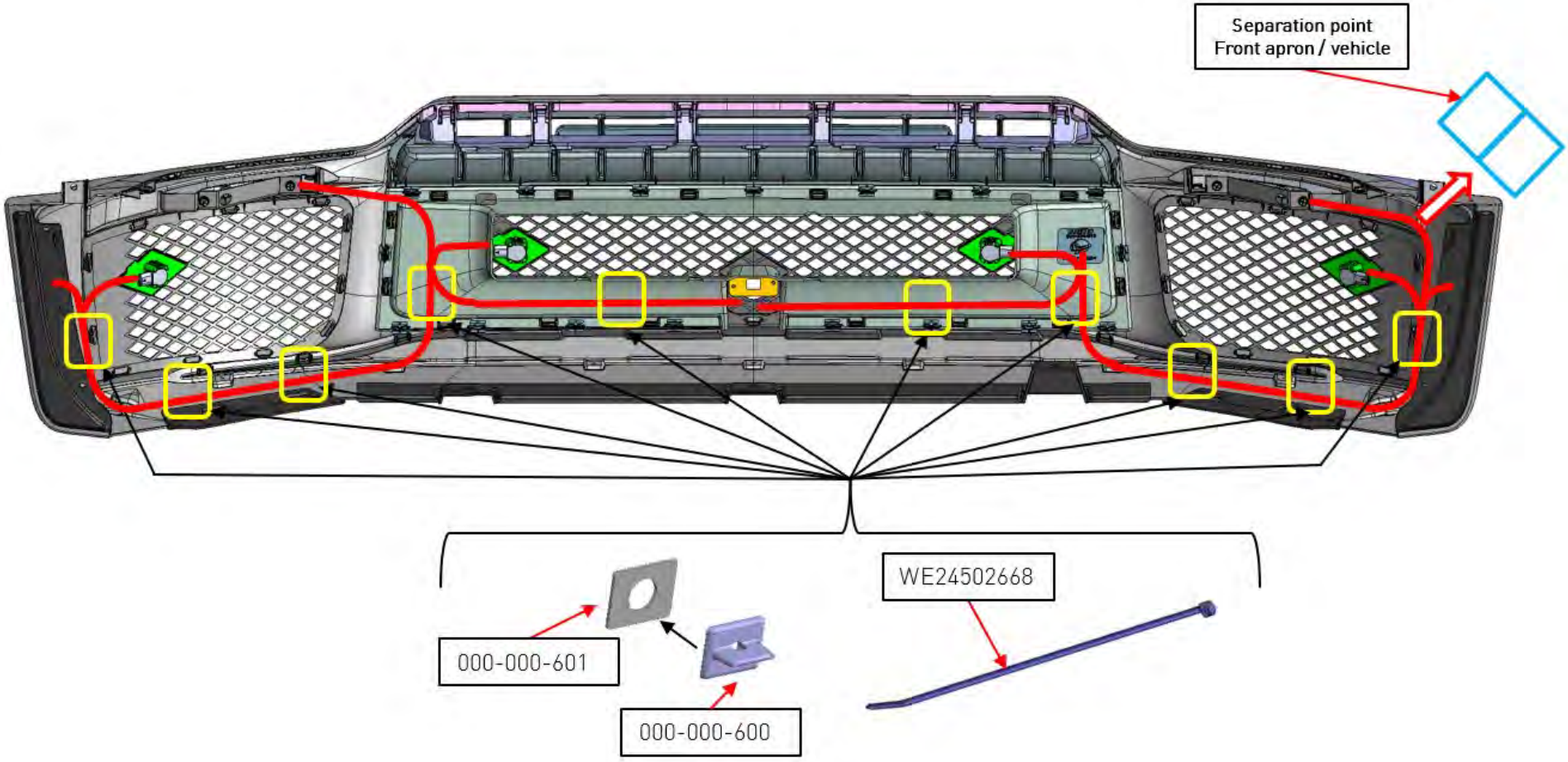
The carbon attachments from package 2 are fitted in the same way as described above.



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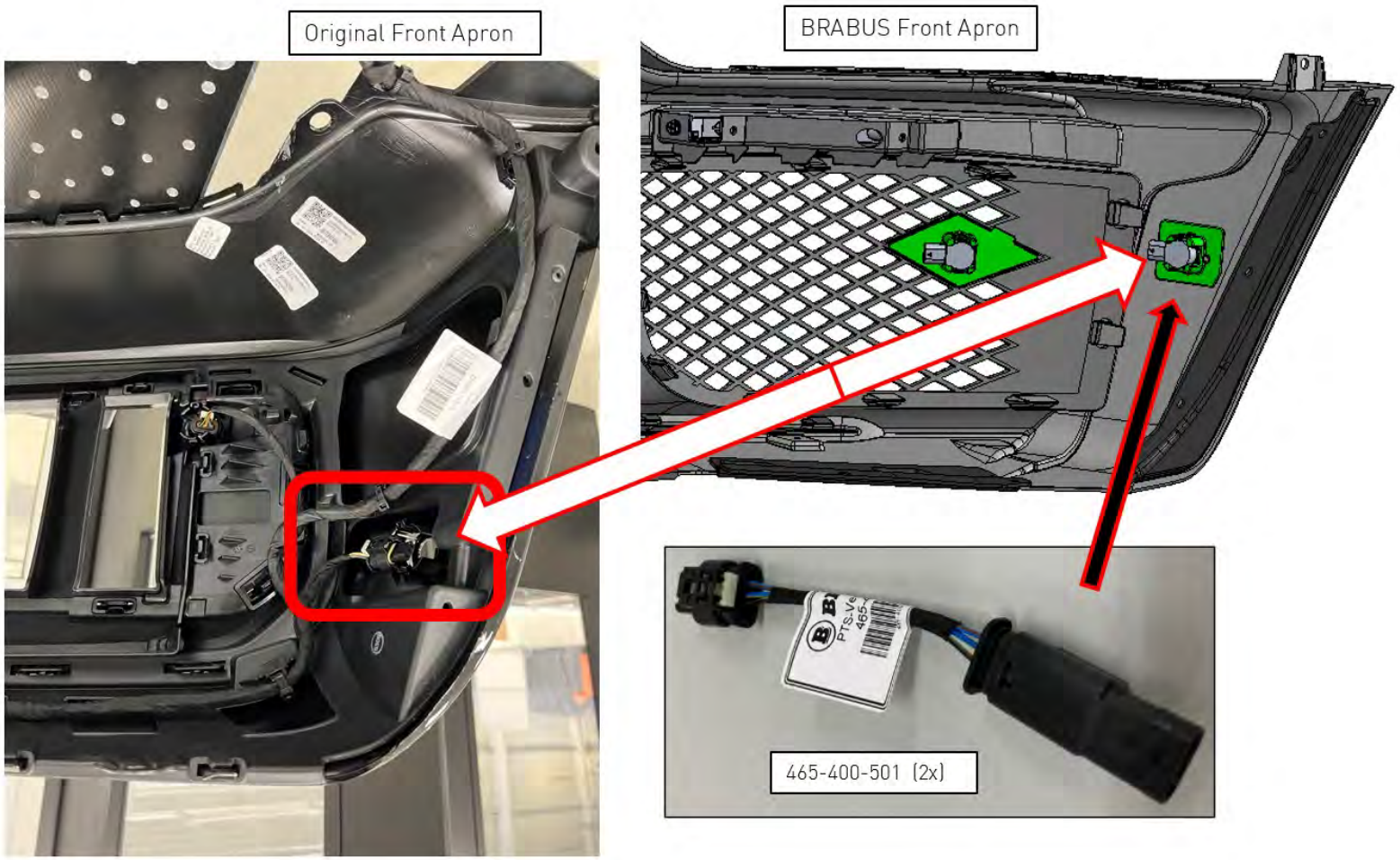
Clean the adhesive surfac es of the bases for attaching the wiring harness in the front apron in two stages using silicone remover.

Glue VHB adhesive pads base / ca ble set in the positions shown and press dow n firmly



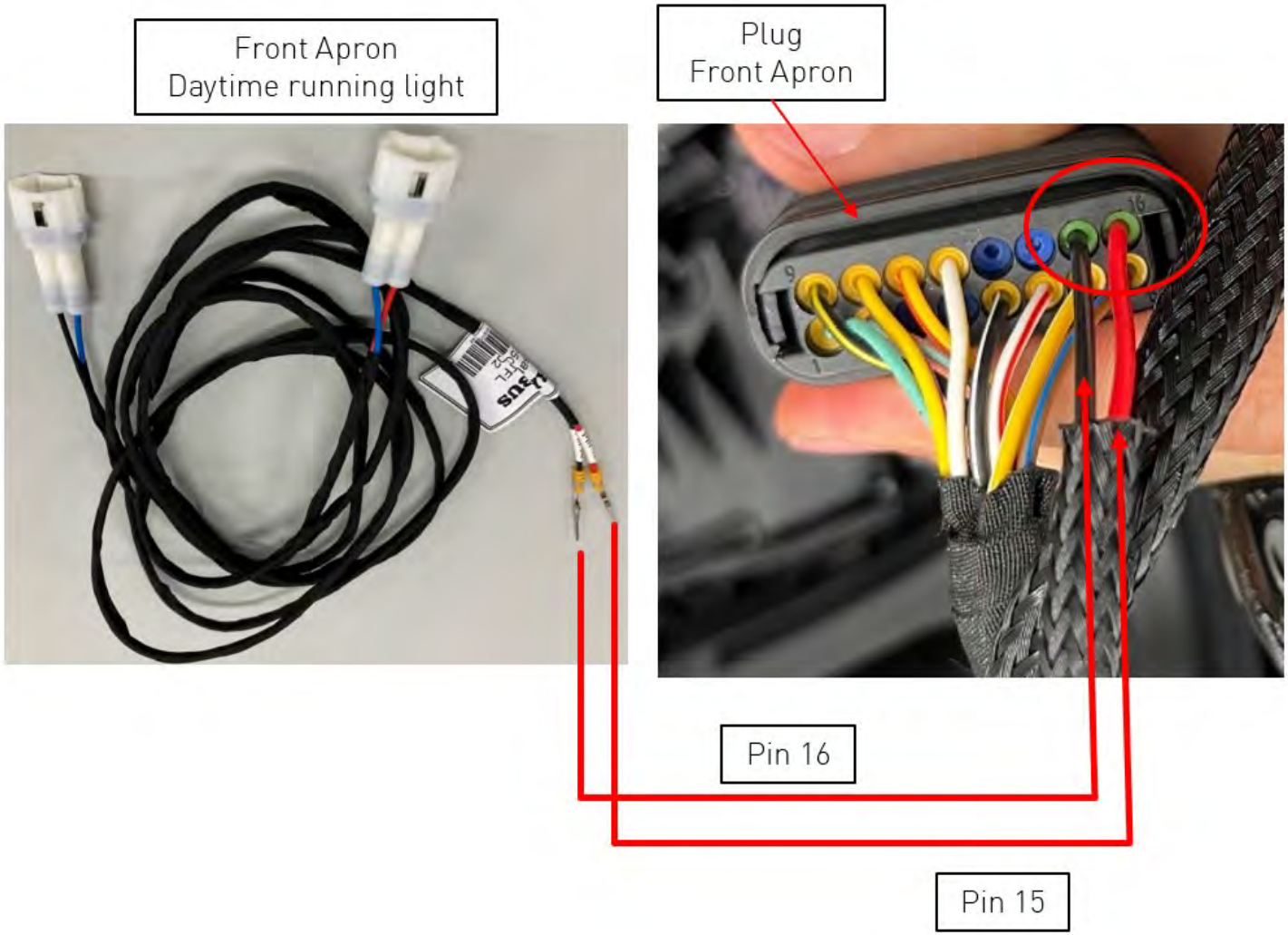
Connect the front apron ca ble set to the front camera, the te mperature sensor and the PDC sensors and attach the cable set to the bases using the cable ties. Cable routing shown on page 86 (red).

Attention: To connect the two outer PDC sensors left & right (marked), the two adapter cables 465-400-501 are required as an extension.



Plug the daytime running light wiring harness into the connector / front apron, slot 15 (red), slot 16 (black), pin in .

Establish plug connection between front skirt wiring harness and vehicle wiring harness, insert completed front skirt into the holder on the front of the vehicle in the same way as the standard component.



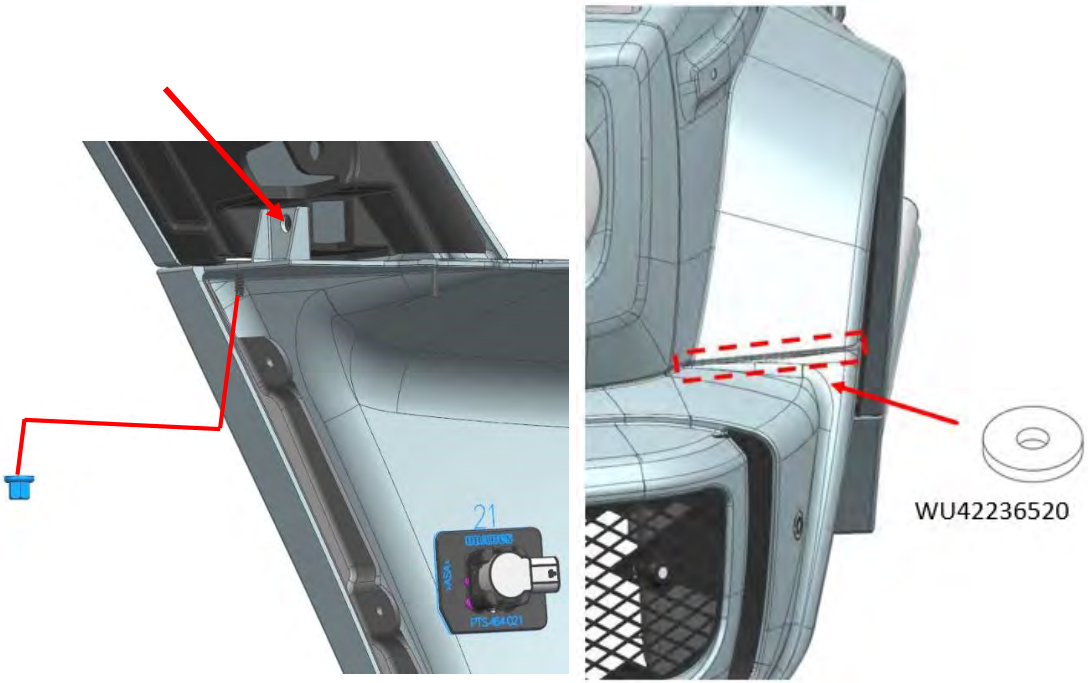
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Establish plug connection between front skirt wiring harness and vehicle wiring harness, insert completed front skirt into the holder on the front of the vehicle in the same way as the standard component. The BRABUS front apron is bolted in the same way as the standard Mercedes-Benz front apron.



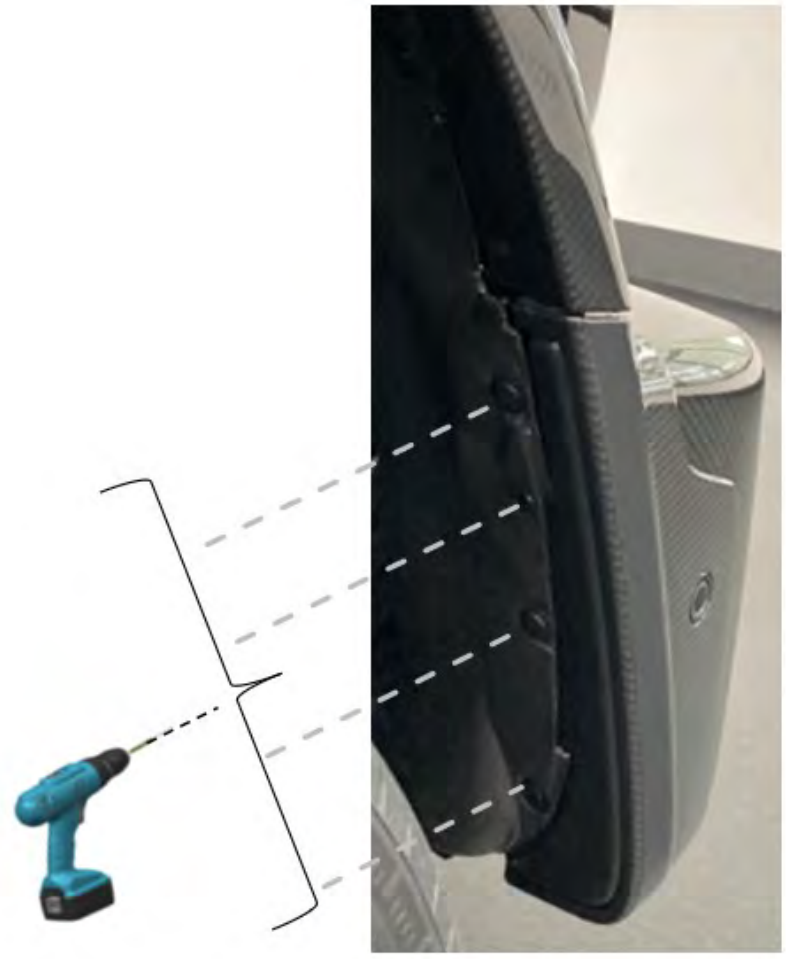
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Align front a pron to front extensions and connect to extensions in the transition using the standard screws. Use the supplied spacers for alignment!



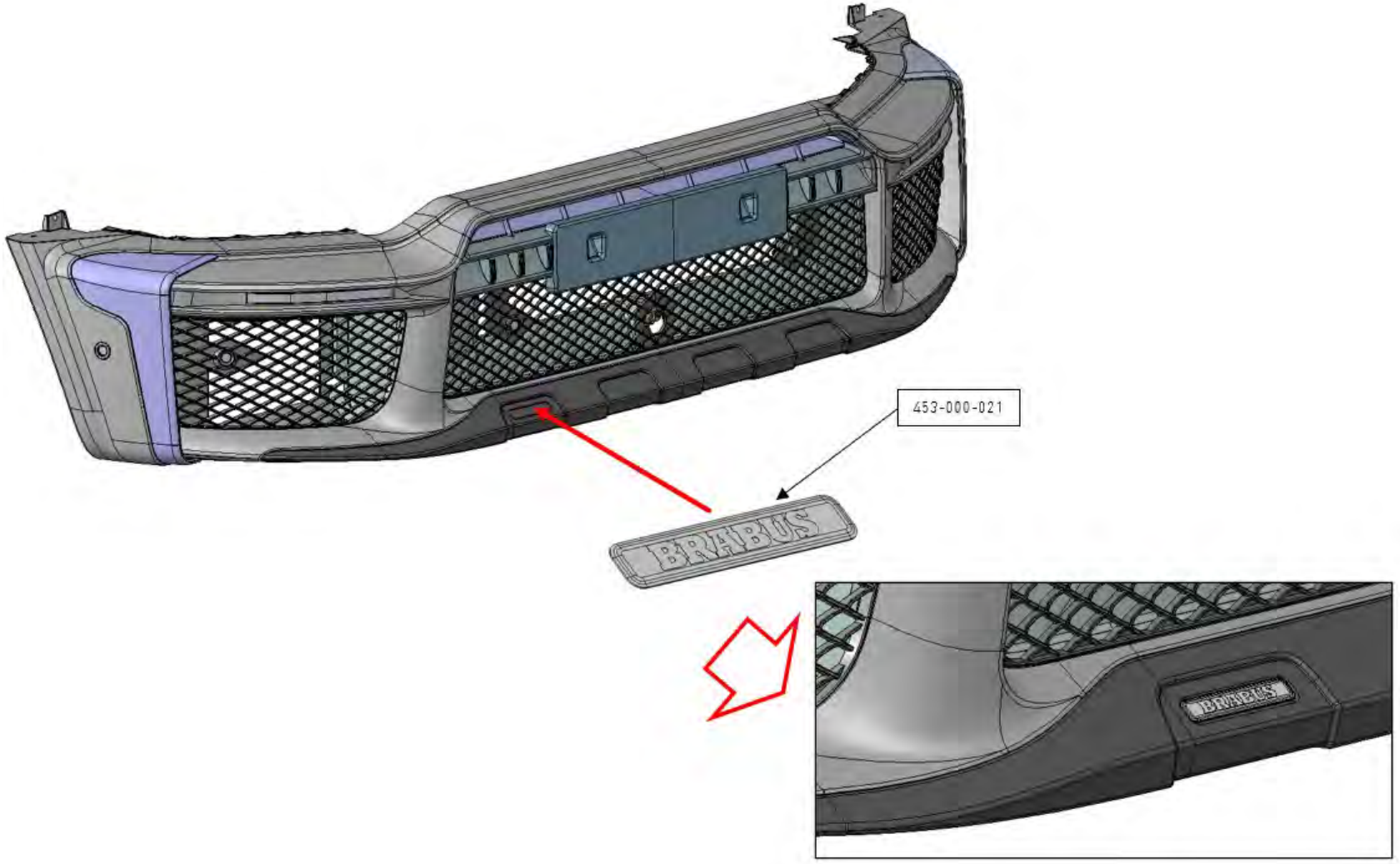
Fasten wheel arch liners on th e inside, drill outer fastening holes for mounting the Ø7 mm plastic expanding rivets in the supports of the front wideners.

Fasten wheel arch liners on the outside with standard expanding rivets.



Clean the adhesive surface in the r ecess of the BRABUS front lip in two stages using silicone remover .

Remove the protective film from the adhesive strip on the BRABUS lettering, stick the lettering in the recess and press down firmly.



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If you have any questions about the product itself or about the installation of the BRABUS Widestar body kit, please do not hesitate to contact

TECHNIK@BRABUS.COM



Illustration shows special equipment