Installation instructions

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 make the installation.
Therefore you have to read and completely understand these instructions.
Check the content of the parts supplied prior to installation.

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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Hint:

Ideally the carbon fibre bezels should be assembled while fitment of the Widestar-Bodykit.

If a vehicle already is equipped with a Brabus Widestar-Bodykit, the original Widestar fender braces must be removed and the front Widestar panels coloured new after the adhesive residues have been removed.

The carbon fibre bezels then can be bonded to the Widestar front fender attachments. Please be advised that these must be bonded together with their brackets and the illuminated typings because the wires of the typings at first are to be routed through the openings of the braces.



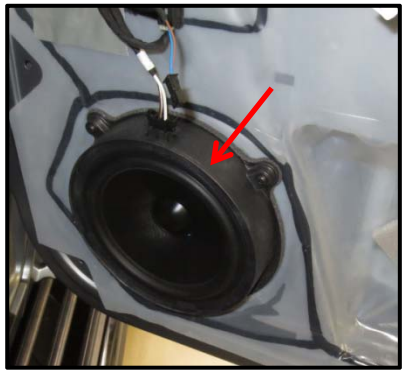
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Included in delivery:

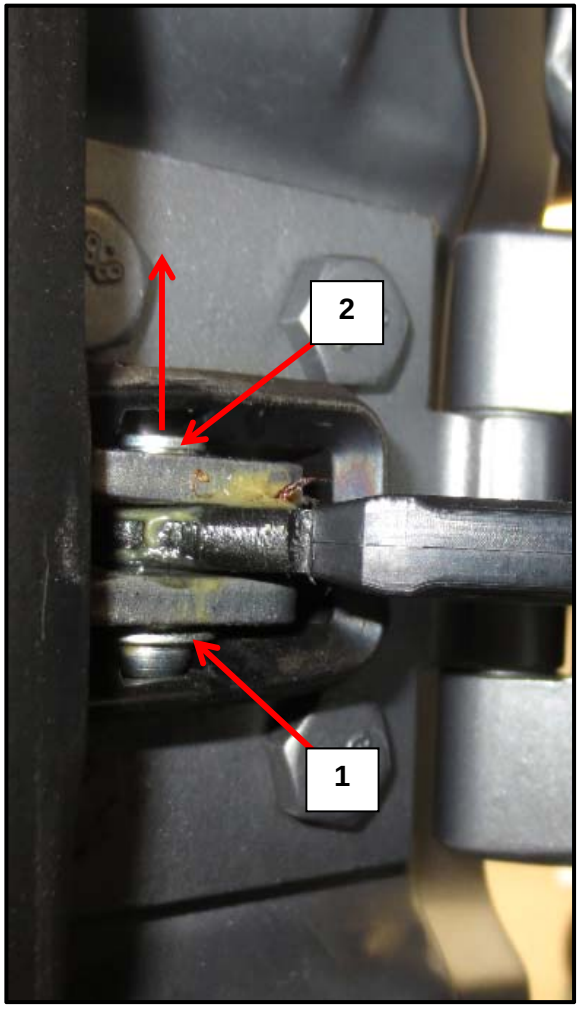
1x	463-236-CG-B	Carbon fibre bezels base kit, 12-pcs.
2x	222-351-51	Brabus typing, illuminated
1x	222-351-52	Wiring harness incl. converters
1x	463-555-01	Bracket for left fender brace
1x	463-555-02	Bracket for right fender brace
1x	B28/000-8	Adhesive kit „Elch“
1x	463-236-CB-DS	Sett of alloy spacers Necessary for reduction of front door opening angles To protect the carbon fibre parts against damages due to contact while opening.
1x	Installation instructions incl. template	

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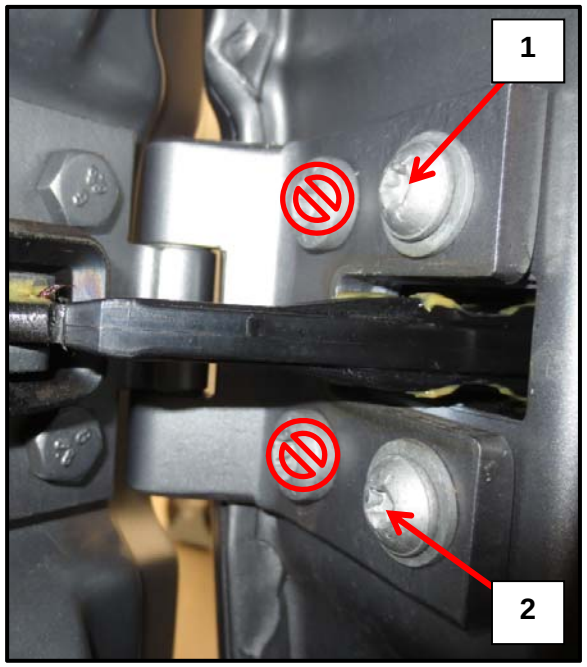
- Remove the front door panels according to Mercedes-Benz workshop instructions.
- Disconnect the plugs of the front door speakers, disassemble the speakers.



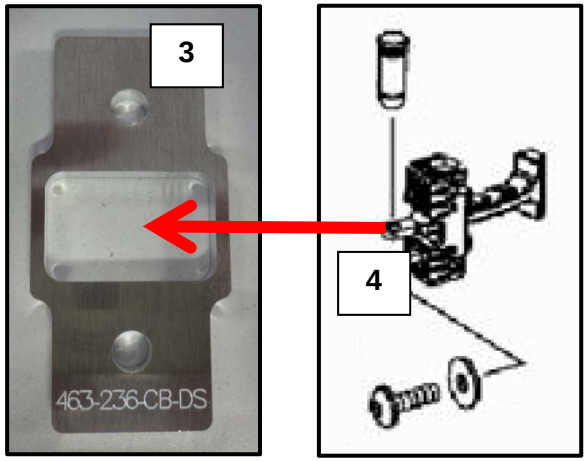
- Remove the retaining rings (**1**) of the front door catches and take the bolts (**2**) out.



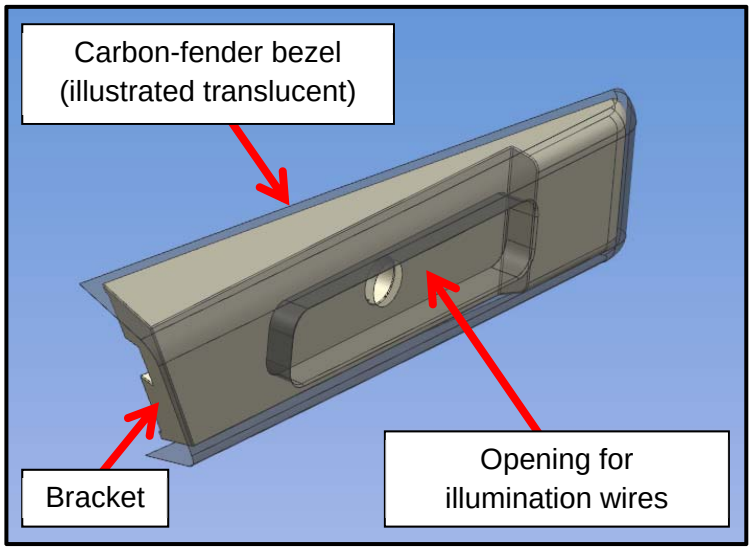
- Loosen and remove the screws (**1**, **2**) of the front door catches.
  Do not loosen the rearmost screws!

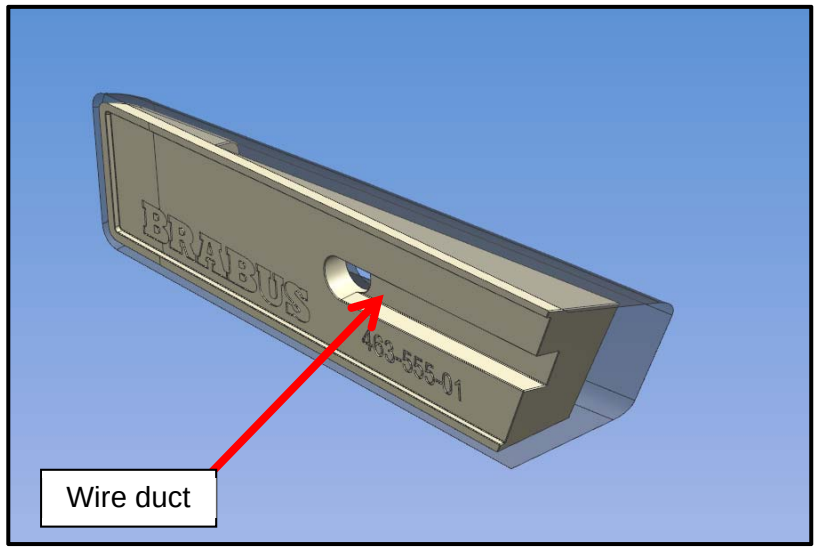


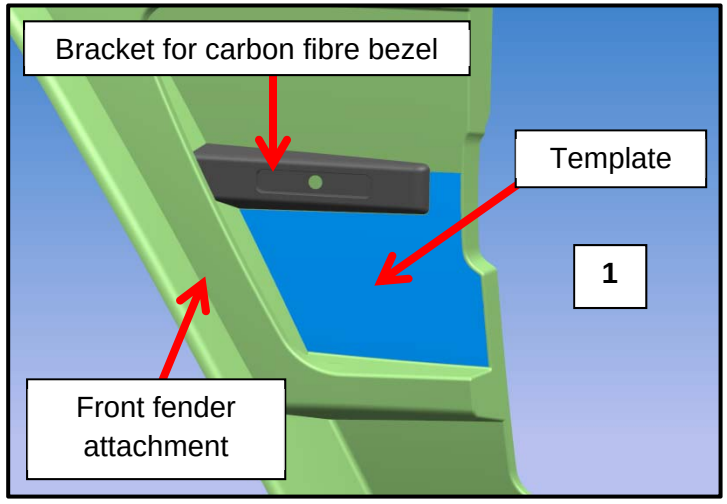
- Remove the front door catches through the speaker openings.
  Attach each one spacer (**3**) to the door catches (**4**) and re-attach the door catches. Take care for correct alignment of the spacers while assembly.
  The standard screws are used furthermore.



- Print the template last page two times (original size, please check control dimension!).
  Cut the templates out along the outer edges and hold them to the Widestar front fender attachments according to illustration (**1**). Mark the position of the fender braces to the front fender attachments using a washable marker.







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- Bond the carbon fibre fender braces to the brackets according to bonding hints. Remove excessive immediately until the adhesive is finally hardened.

- Route the wires of the illuminated typings through the openings and bond these to the completed fender braces.

- Prepare the bonding edges of the fender braces and those of the front fender attachments for bonding according to bonding hints and bond them to the fender attachments. Align them, remove excessive adhesive immediately and fixate the braces until the adhesive is finally hardened.

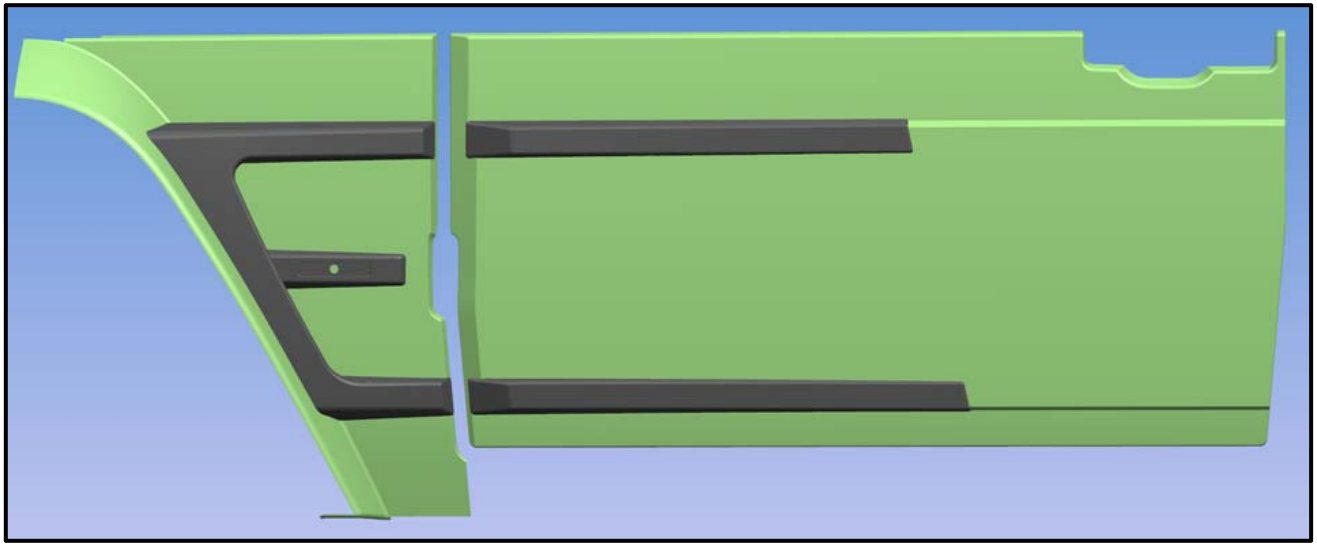
- The carbon fibre fender attachments now can be bonded to the front fenders. The wires of the illuminated typings are to be connected to the Widestar wiring harness. Fixate the inverters within the front wheelhouses.

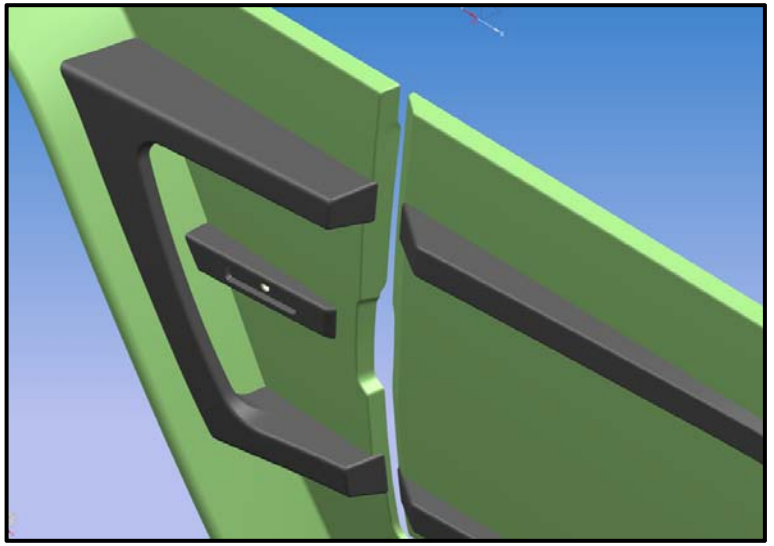
- Bond the carbon fibre Widestar bezels to the Widestar components according to images and illustrations on the next pages and with due regard to the bonding hints.

- Remove excessive adhesive immediately.

Carbon fibre bezels for Widestar door and front fender attachments

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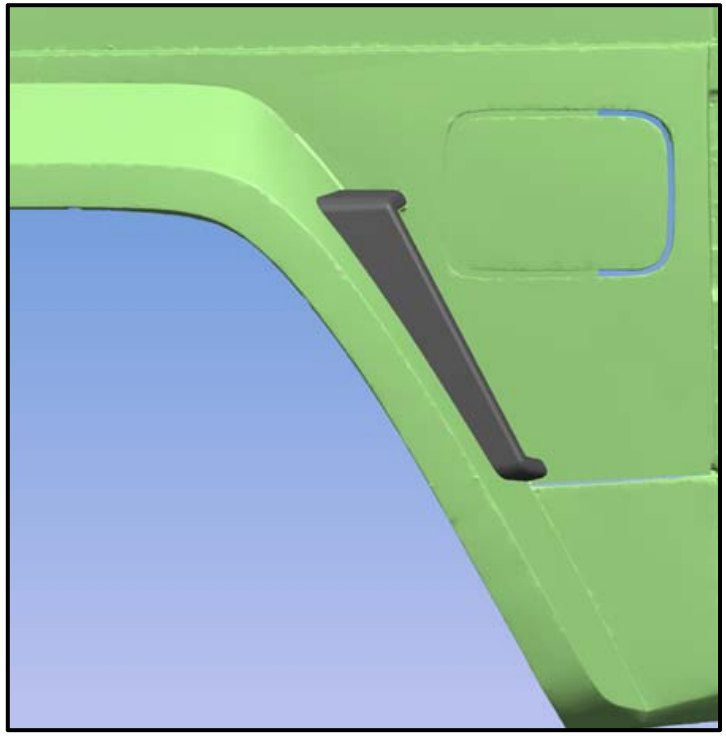


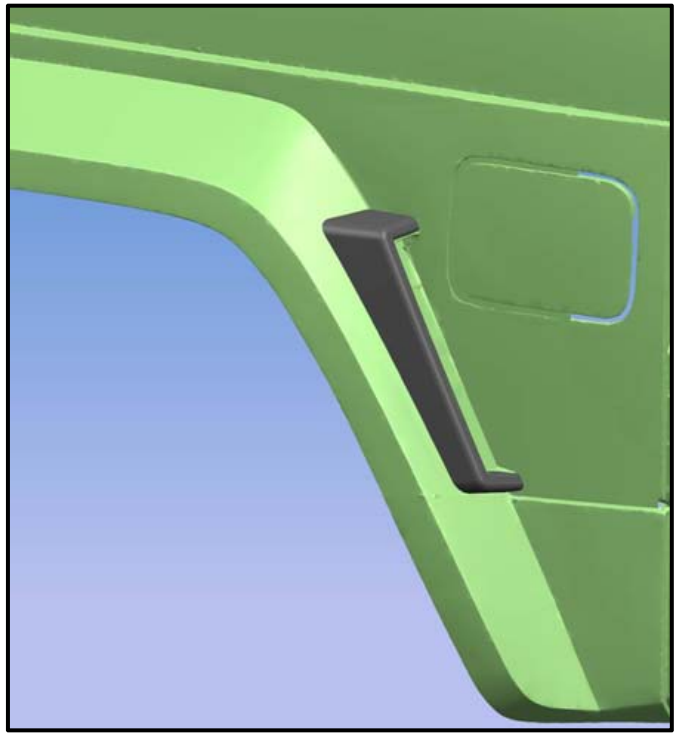




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Carbon fibre bezels for rear Widestar sidewall attachments

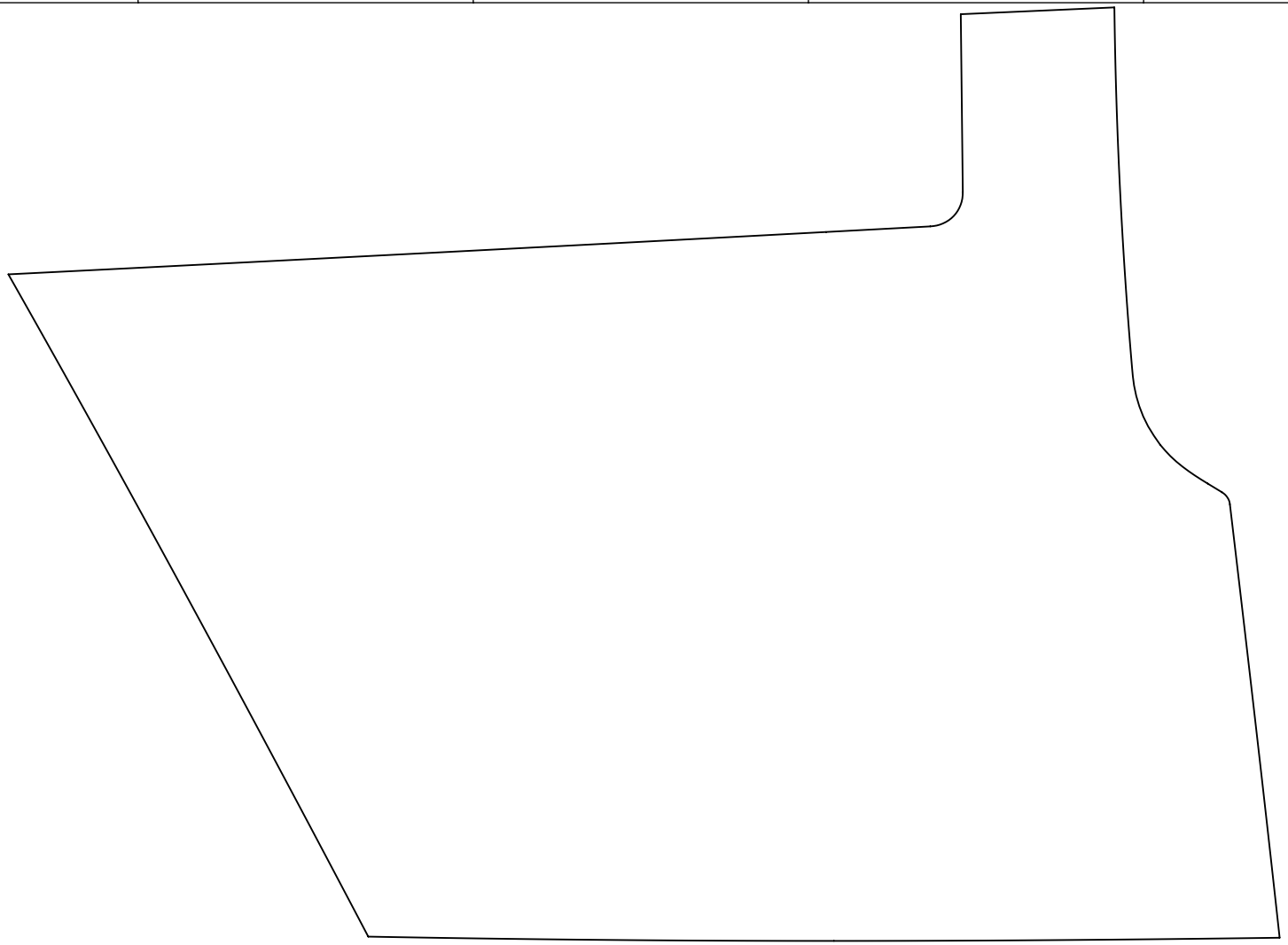


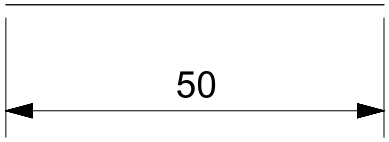




- Avoid to wash the vehicle in an automatic washing bay within 24 hours after the parts have been bonded.

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Entgraten und scharfe Kanten brechen.

Änderung/Bemerkung: V01

	Datum	Name	Signatur
Gezeichnet:	15.09.2016	Brekoff	K.B.
Geprüft:			
Genehmigt:			
Qualitätssicherung:			

Titel: Schablone Emblemträger

Toleranz: ISO 2768-m

Bauteil | Anzahl

Werkstoff:

Oberfläche:

Anwendung:

Zeichnungsnummer: 463 G-Klasse WIDESTAR 2016 2016_09_15

REV: A

A4

Maßstab: 1:1

Gewicht:

Blatt 1 von 1