BRABUS-front attachment for W463-G350d/ G500, MY 2019
Article-no. 464-250-00

BRABUS®



Installation guide

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.

Please read these instructions carefully and check the content of the parts supplied prior to assembly. Wear protective clothes.
For disassembly/ assembly of standard components please regard to Mercedes-Benz Workshop information system.
The assembly takes about 3 hours of labour.

Take care for sufficient cleanliness while assembly and regard to bonding hints on page 3.

Included in delivery of BRABUS-front attachment, article-no. 464-250-00:

1x	Front attachment	464-250-001
1x	Design underride protection	464-250-002
1x	Left trim grille	464-250-821
1x	Right trim grille	463-250-822
1x	Left DRL carrier	464-250-901
1x	Right DRL carrier	464-250-902
1x	Set of slim DRL lights	000-TFL-SLS
13x	CLIP SPEEDFIX	Q0007371V000000000
4x	Screw M6x10	WU009802610
1x	DRL control unit wiring harness	464-250-501
1x	Set of logo connection wires	464-250-503
1x	BRABUS Lgo illuminated	464-250-504
1x	Screw for DRL control unit	N000000001116
2x	DRL extension wires	1911
1x	Cable tie	A0079975690
6x	Cable tie	WE24502668
6x	Adhesive bracket for cable tie 27x27 BK	61718613
1x	Adhesive kit 80ml	B28/000-8
1x	BRABUS badge Metall-Tec	216-000-22-2

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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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Preparation:

- Disassemble the right side dashboard cover.
- Disassemble the right lower a-pillar trim.
- Disassemble the glovebox.
- Disassemble the front bumper.
- Disassemble the front right wheelarch lining.
- Disassemble the right side entrance trim.

Attention:

Perform the disassembly/ assembly of standard components according to Mercedes-Benz workshop instructions.

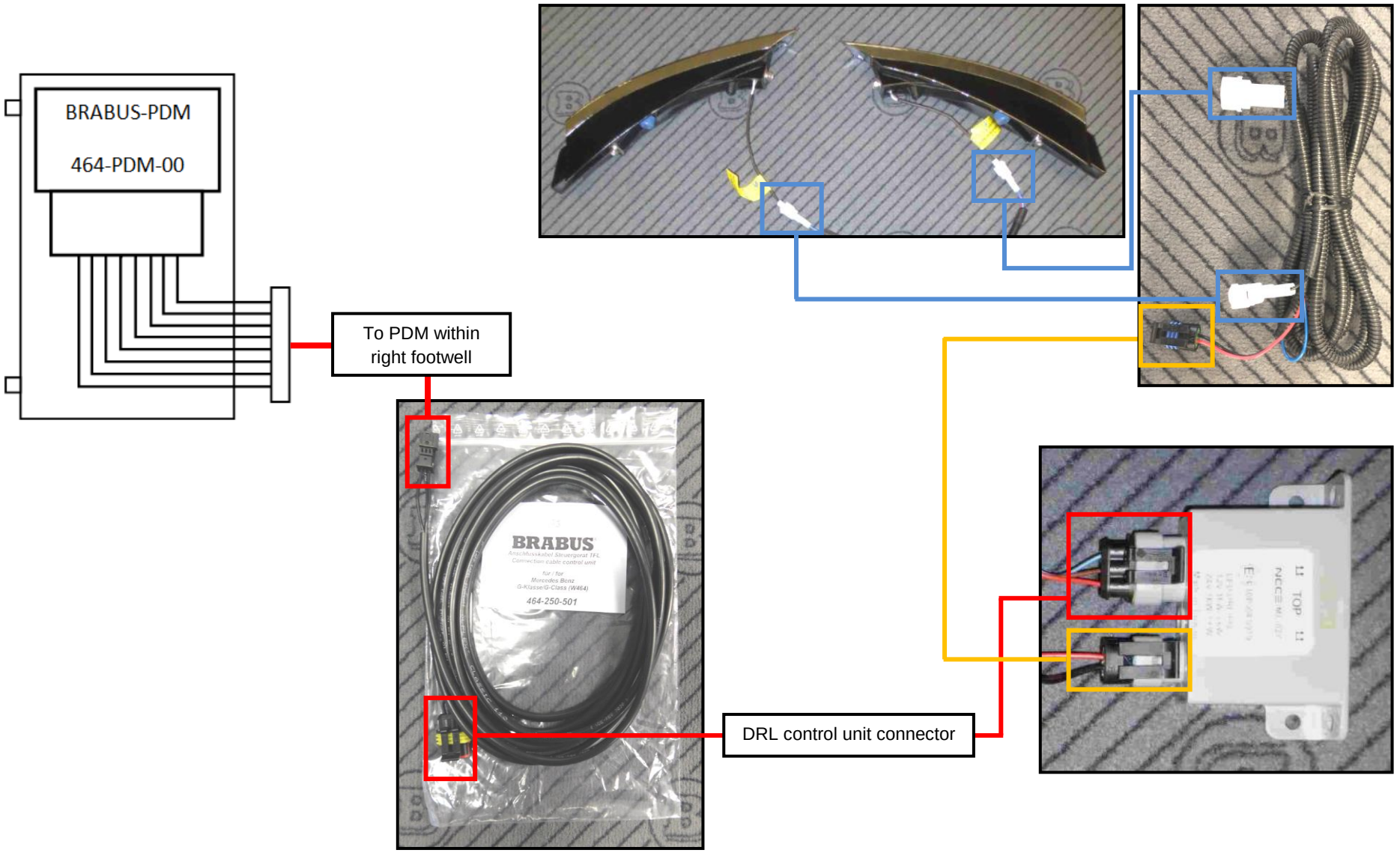
The operation power of the side illuminated BB-logos and the daytime running lights is supplied by the **BRABUS-PDM** (**464-PDM-00**), the wires of the components are just routed to PDM and connected to the respective port.

Perform the assembly of the **BRABUS-PDM** system according to the respective installation manual.

At first perform the assembly of the PDM system, after having finished establish the further electrical connections.
Assemble the front attachment after all electrical connections have been established.

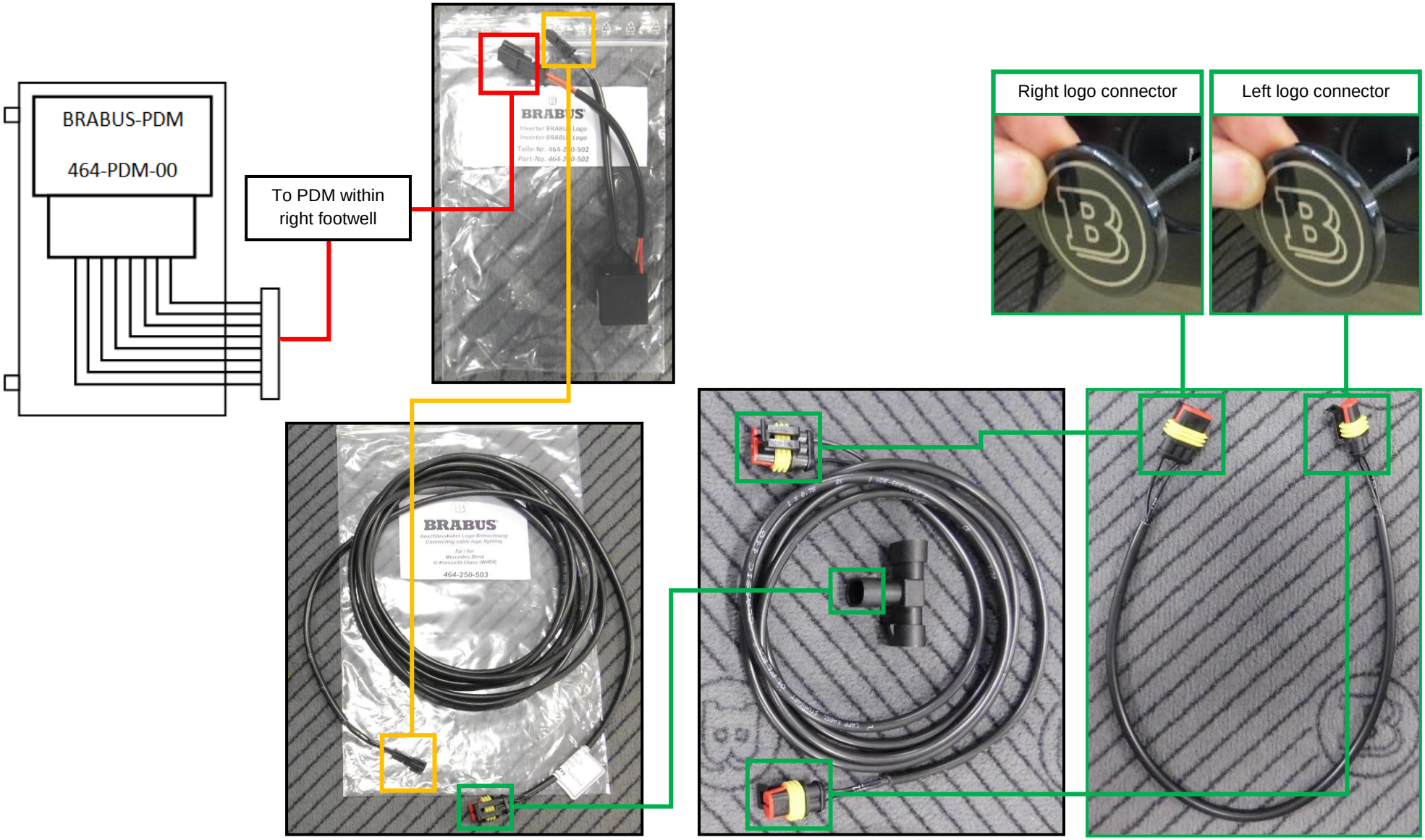
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Overview of DRL lamp connections:



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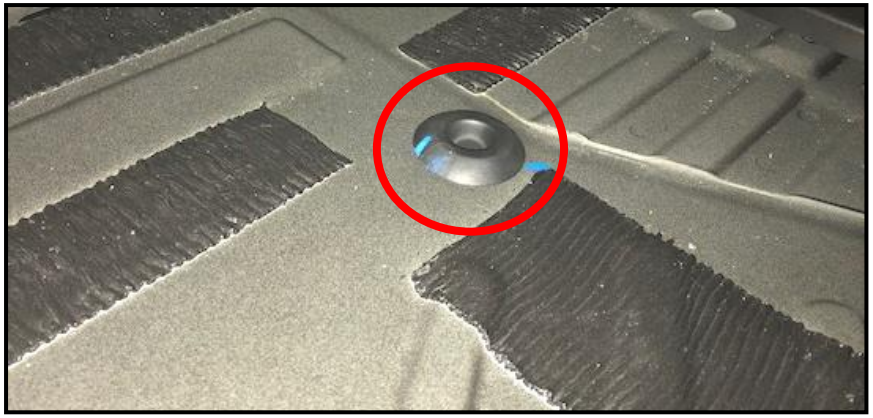
Overview of illuminated BB-logo connections:



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Assembly:

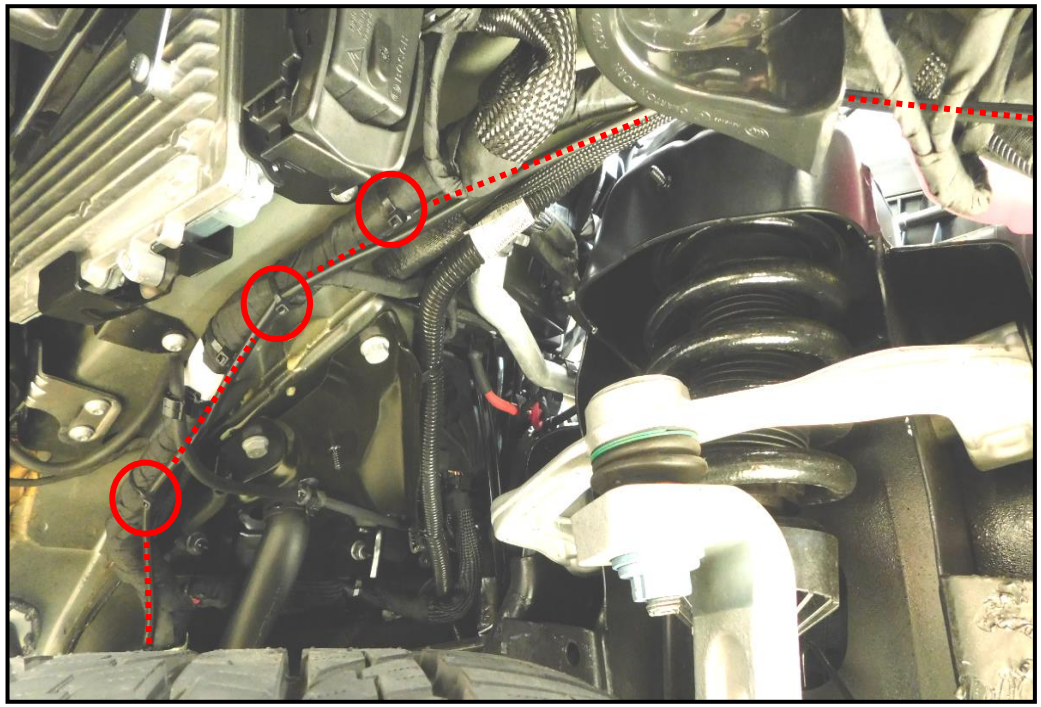
- Connect the logo inverter supplied to the illuminated logo port of BRABUS PDM.
- Lift the flooring within the right footwell to gain access to the rubber plug show below. Remove the rubber plug.

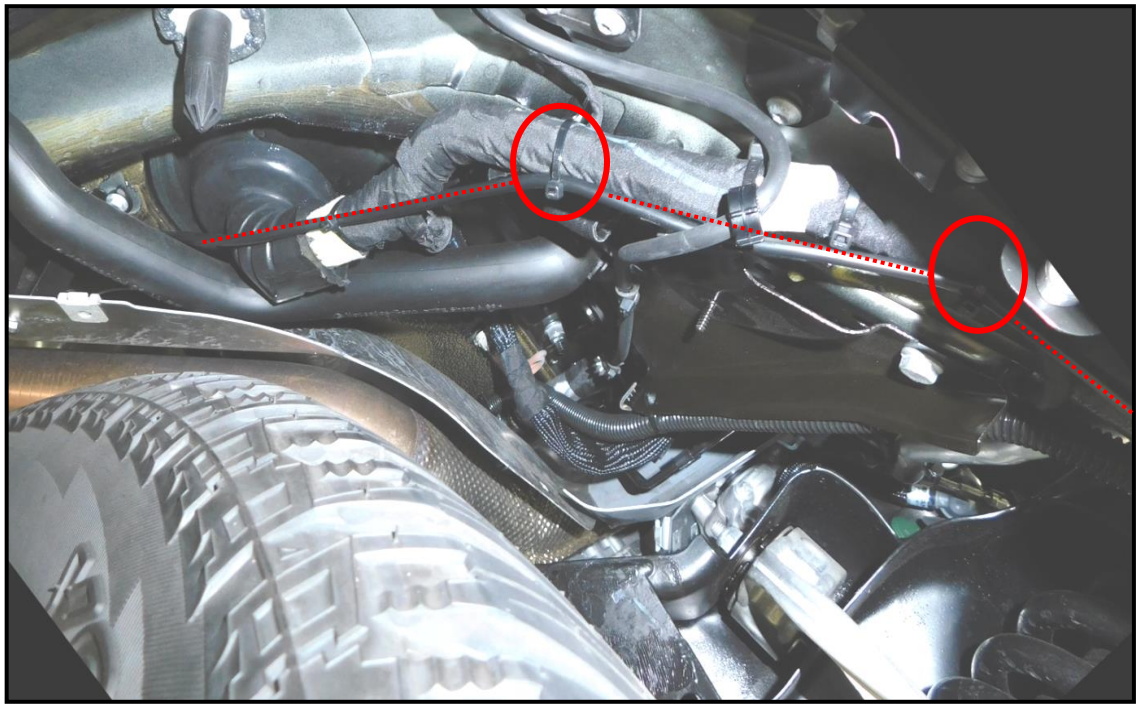


- Route the litz wire supplied through the hole and out in front right direction until the litz wire appears above the right side exhaust heat shield.

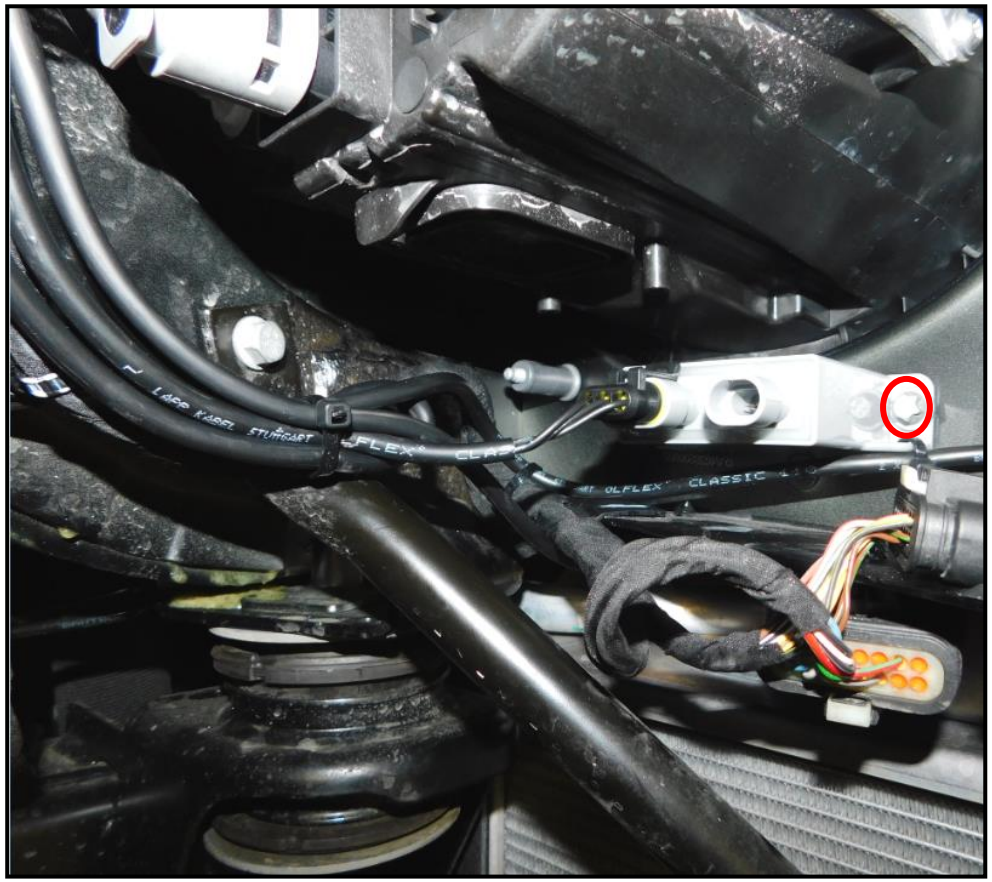
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- Attach the wire for the illuminated logos and the wire for the DRL system to the litz wire by using adhesive tape. Pull the wires through the hole into the vehicle. Make sure not to damage the wires while routing them. Cut the rubber plug and route the wire connectors through, attach the rubber plug back into the vehicle body.
- Route the connectors to BRABUS PDM, do not yet realize the plug connections.
- Route the wires frontward within the right wheel house according to images below, fixate the wires to the standard wiring harness using cable ties.





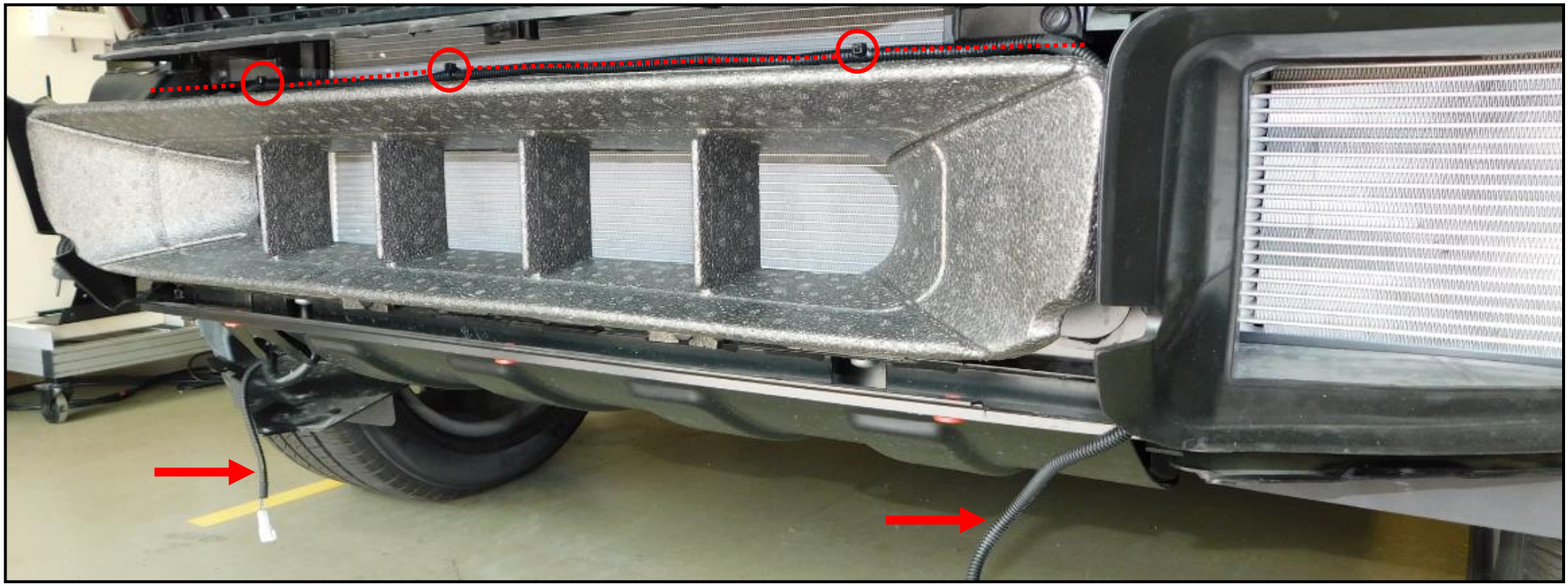
- Route the wires downward at the vehicle front. Attach the cable bracket to the body edge according to image. Bolt the DRL control unit to the standard thread on the right longitudinal member using torx screw supplied (extend the assembly hole of the control unit to 6mm). Connect the DRL wiring harness to the DRL control unit.





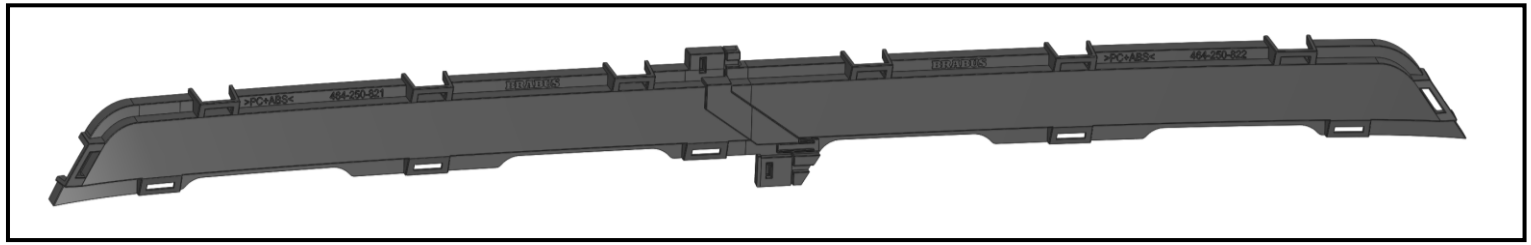
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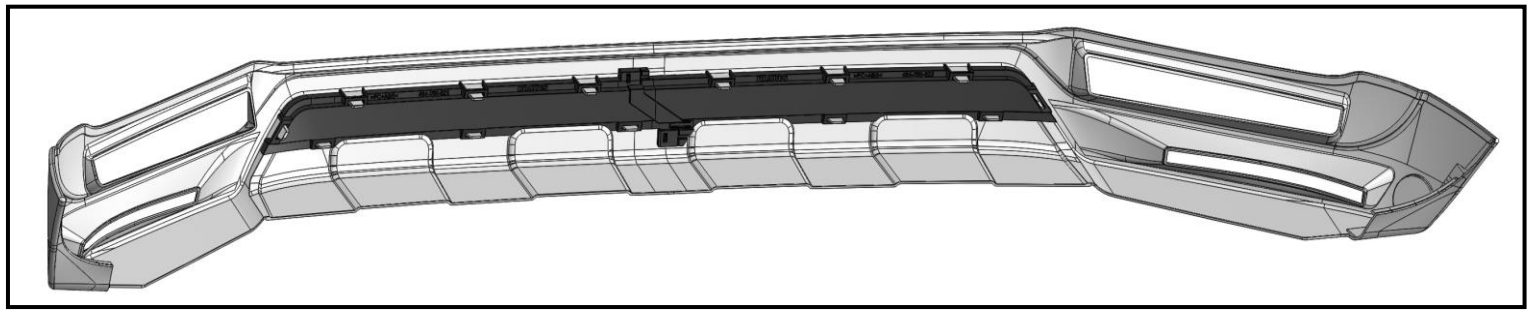
- Connect the DRL lamp wiring harness to the control unit and the wire of the illuminated logos to the t-distributor. Attach the left and right logo wire to the t-distributor.
  The short wires are used on the right vehicle side, the long wires are routed to the left vehicle side, on top of the front cross member. Fixate the wires by suing cable ties at appropriate positions, also fixate the t-distributor to an appropriate position using a cable tie.

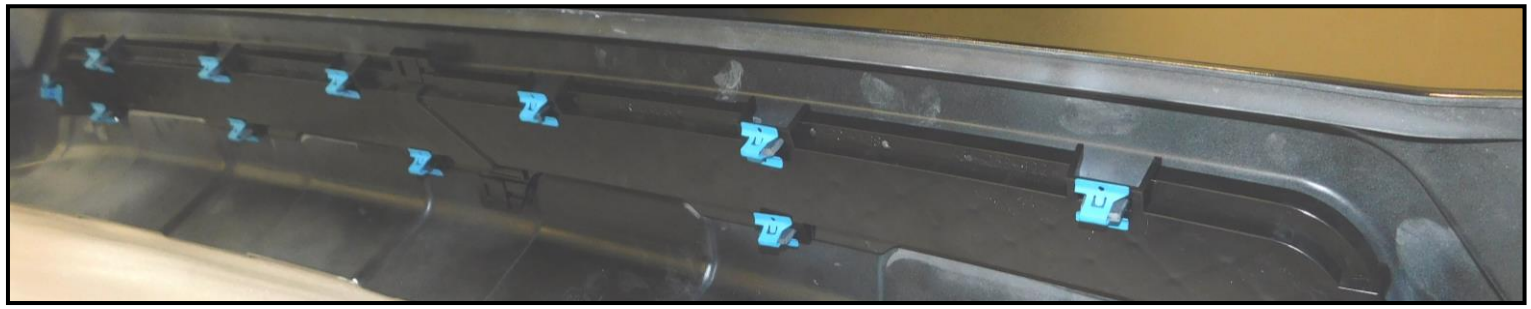


- Re-assemble the front bumper.

- Connect both trim parts and attach the completed part to the front attachment. Fixate the trim grille by using metal brackets supplied.

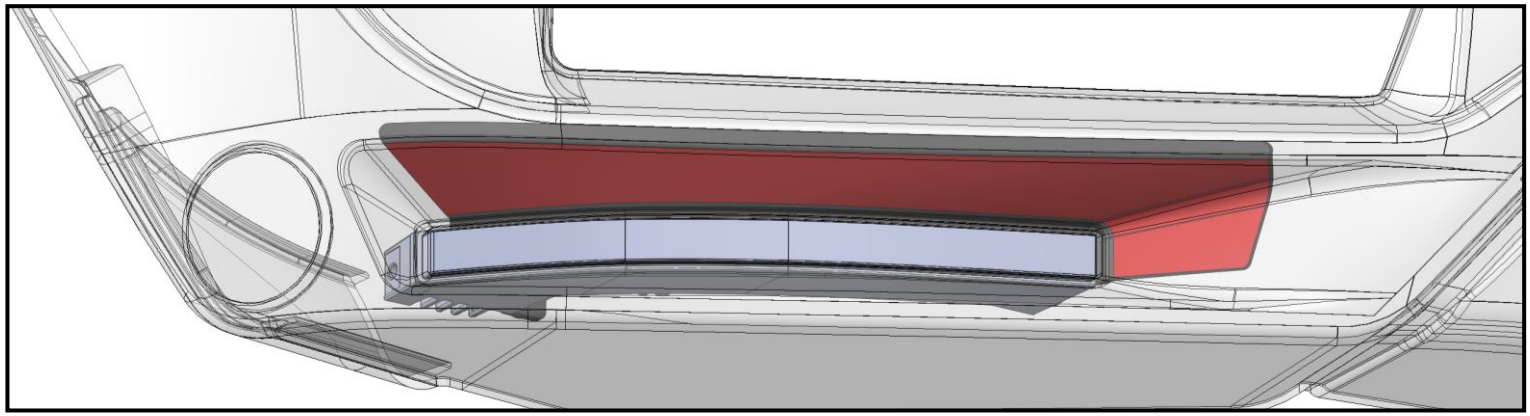




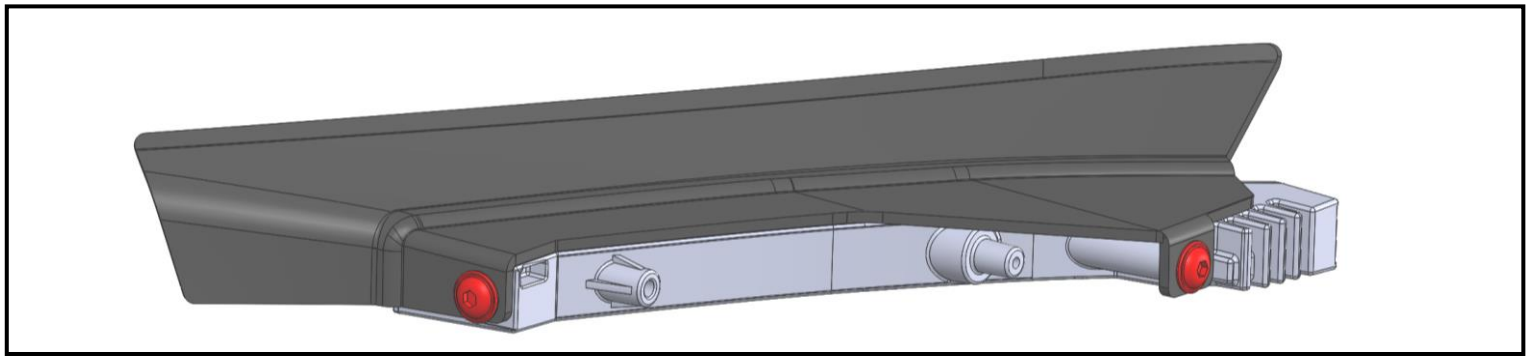


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- Carefully clean and degrease the DRL carrier bonding areas of the front attachment (colored areas marked red below) using acetone.

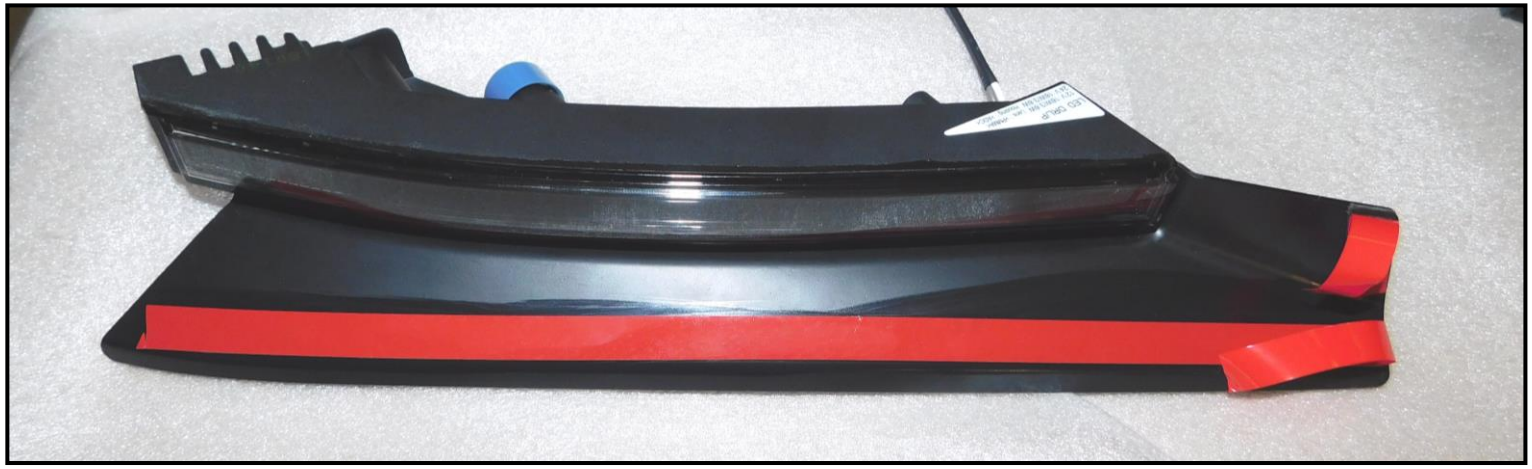


- Attach the DRL lamps to the DRL brackets using screws supplied (colored red within within illustration below).

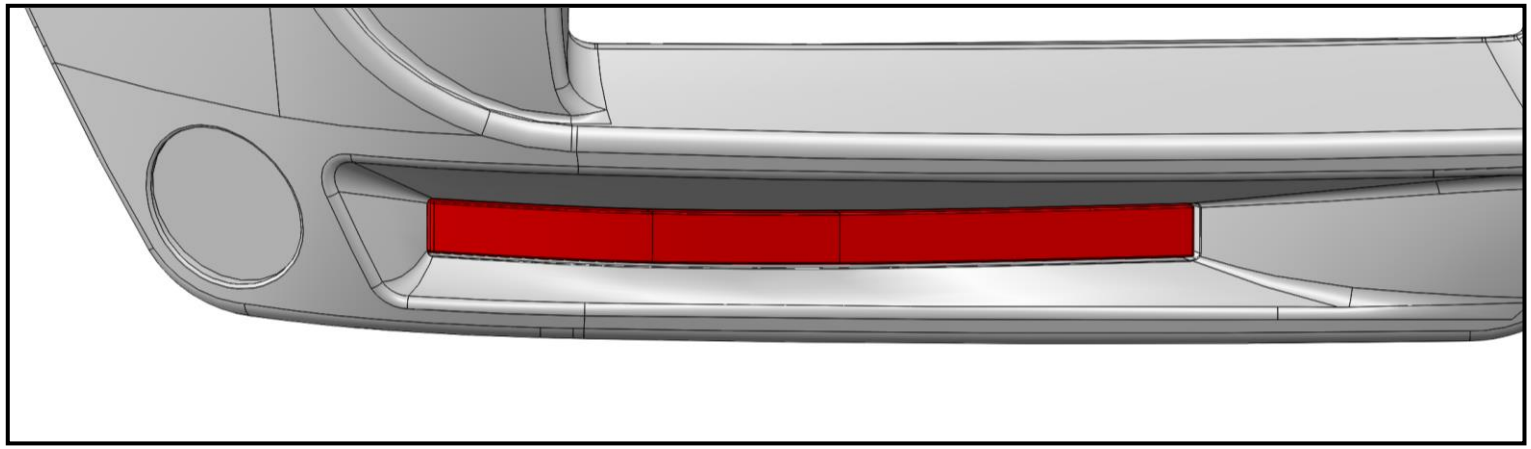


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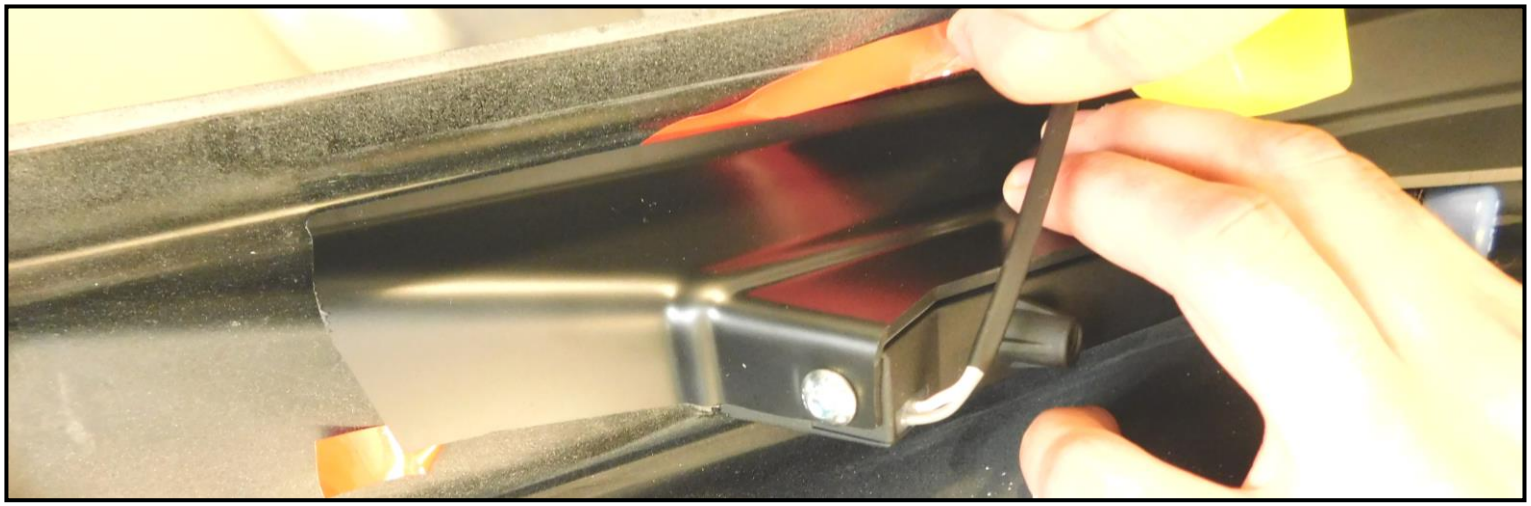
- The DRL carrier is equipped with adhesive stripes for fixation of the DRL unit within the front attachment.



- Position the DRL unit within the front attachment.



- Keep the DRL unit in position and remove the protection foil of the adhesive stripes. Firmly press the unit to the front attachment.

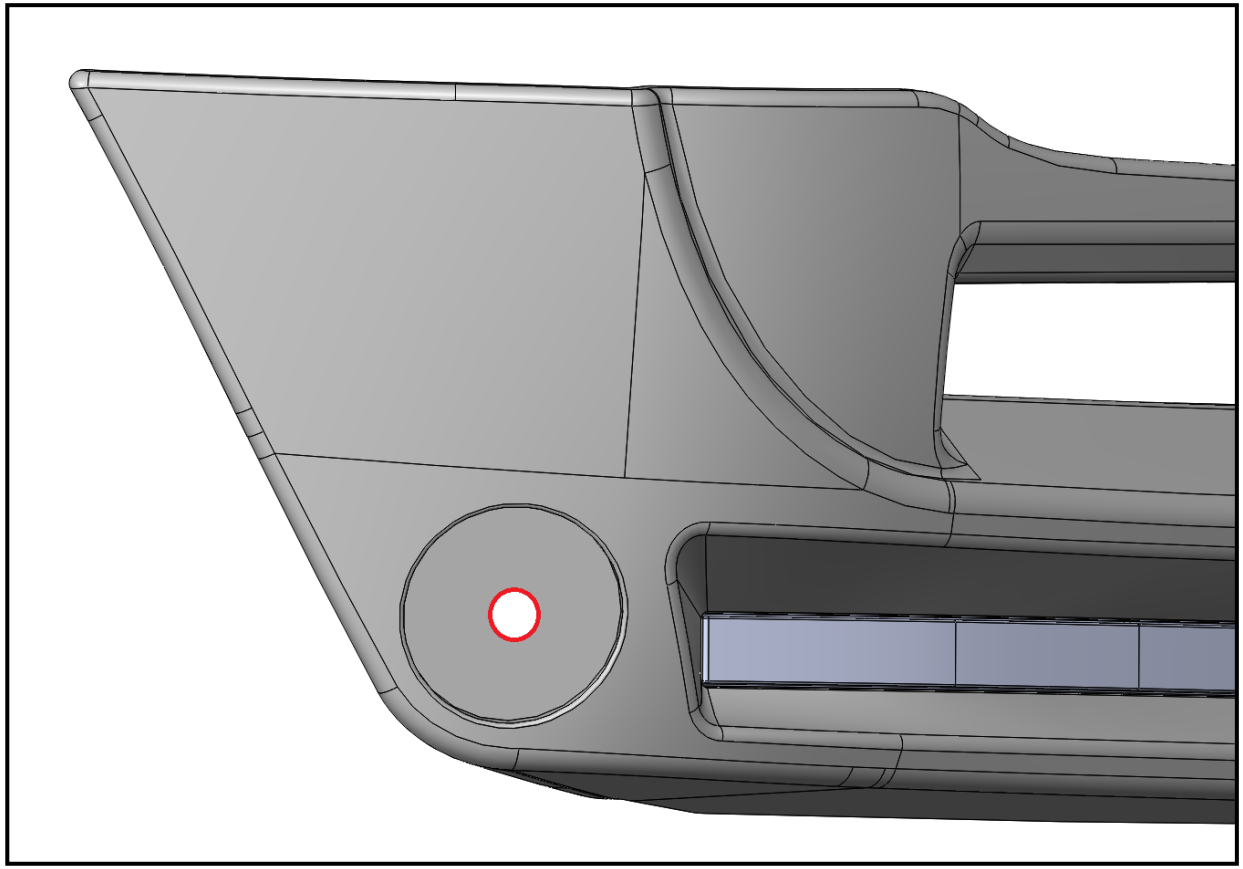


- Repeat the procedure on the opposite side.



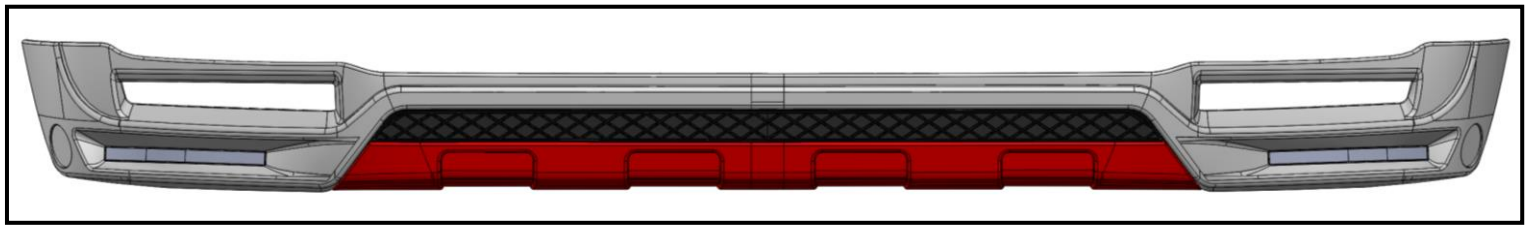
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- Drill Ø10mm holes centred within the logo recesses.
- **Attention:** Do not yet attach the illuminated logos to the front attachment. These are to be aligned and bonded when the front attachment has been assembled.



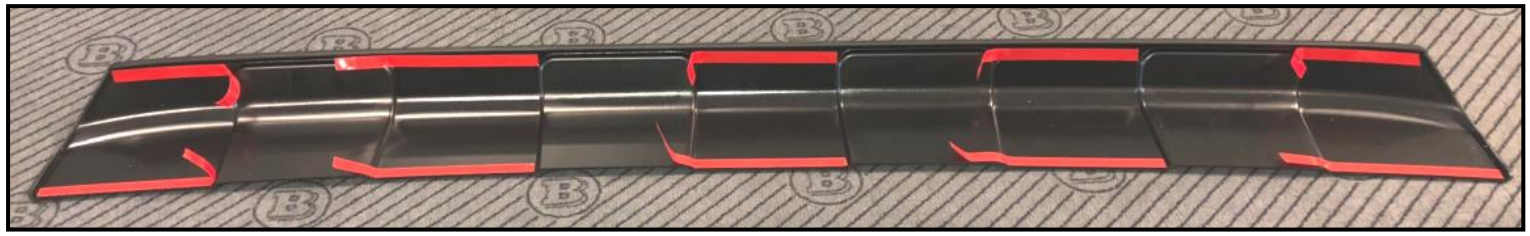
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- Clean and degrease the bonding areas for the underride protection using acetone.



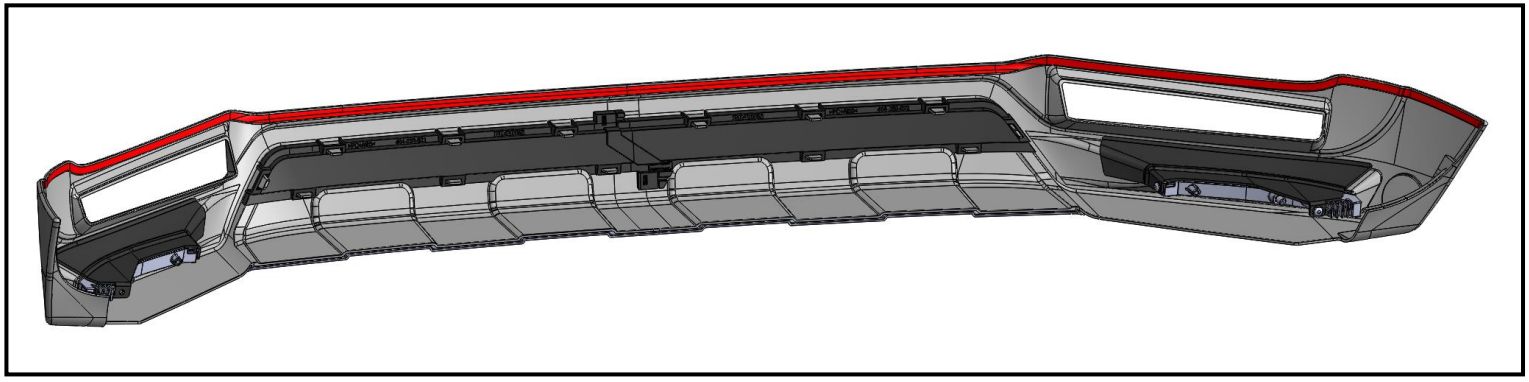
- Fold the protruding areas of the adhesive stripe protection foils up (upper stripes, 90° angle) and down (lower stripes, 90° angle) to make sure these do protrude when the underride protection is put into it's recess on the front attachment.
  Hold the underride protection to the front attachment and align it.

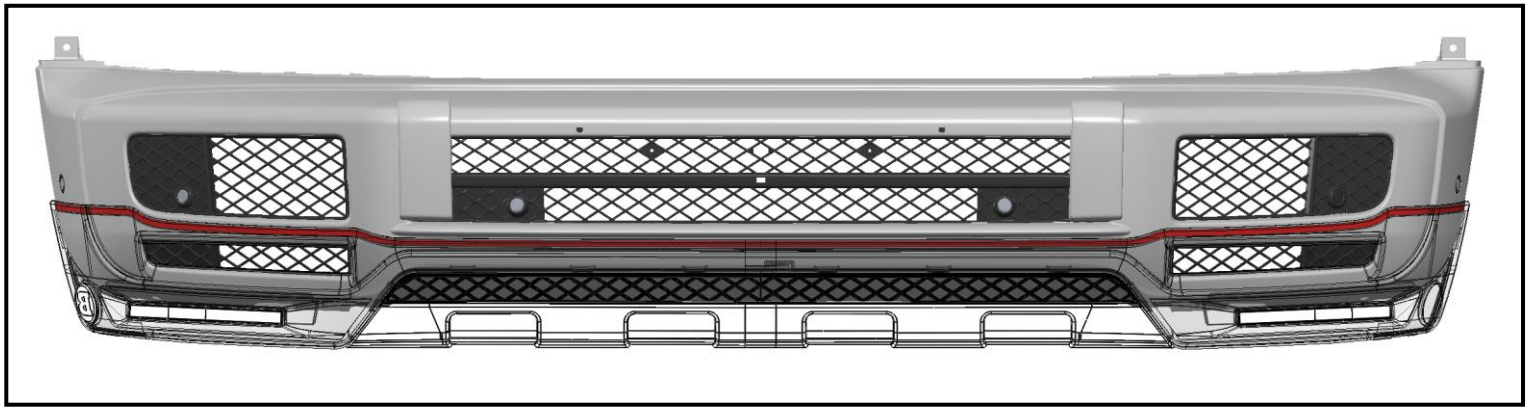
- Push the underride protection to the front attachment, a second person now pulls the upper and lower protection foils out.
  Firmly press the underride protection to the front attachment.



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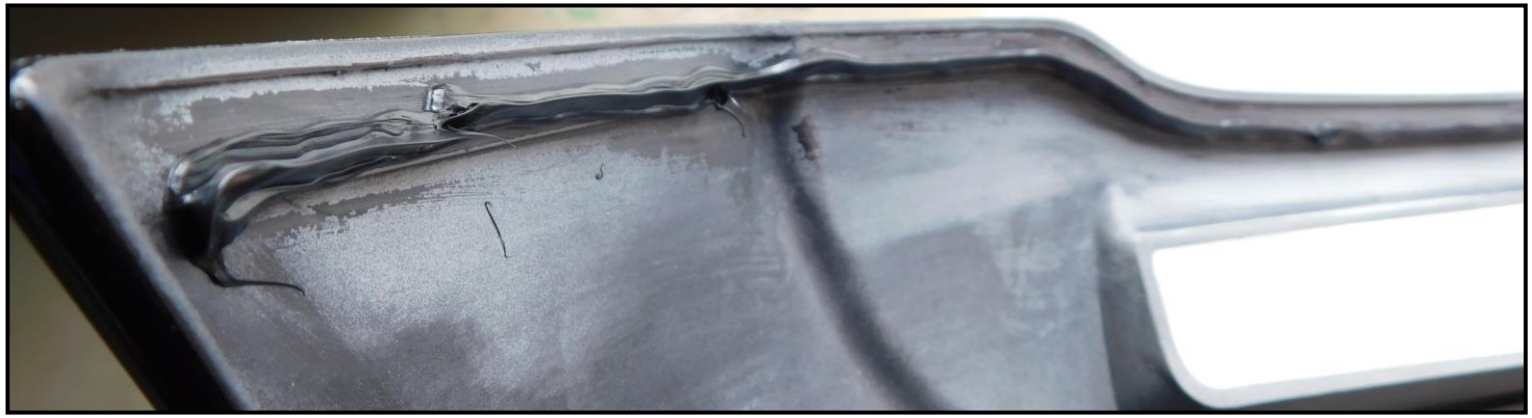
- Preapare the bonding areas of the front attachment and those of the front bumper for bonding according to bonding hints on page 3.
  The bonding areas are marked red within illustrations below.

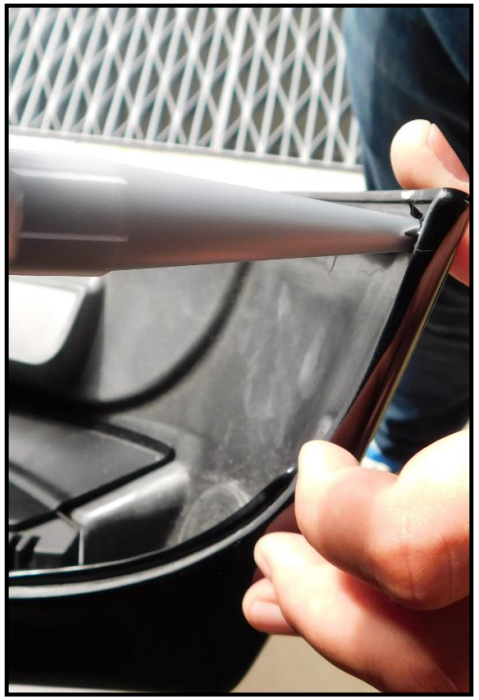




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- Apply even lines of adhesive to the bonding edges of the front attachment.





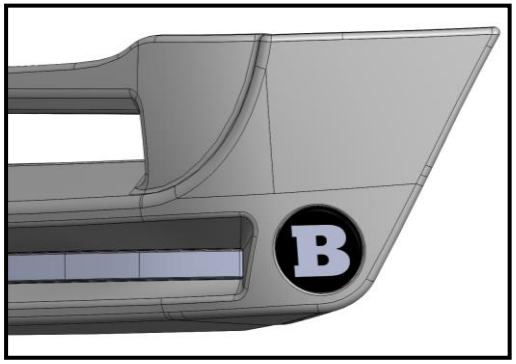
- Bond the front attachment to the front bumper. Align it flush to the front bumper.





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- Remove excessive adhesive immediately!
- Fixate the front attachment using appropriate measures (vacuum brackets, velcro tape) until the adhesive is finally hardened.
- Remove the fixation measures after hardening.
- Connect the DRL wires to the DRL lamps under usage of extension wires supplied (article 1911).
- Connect the wires of the illuminated logos to the logos. Clean and degrease the bonding areas of the illuminated logos. Remove the protection foil on back of the logos and horizontally bond the logos to the front attachment.



- Connect the wiring harness of the illuminated logos to the inverter within the vehicle and connect the DRL wiring harness to the respective port of the PDM.
- Perform a function-check.
- Re-assemble all dismantled components with due regard to Mercedes-Benz workshop instructions.

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