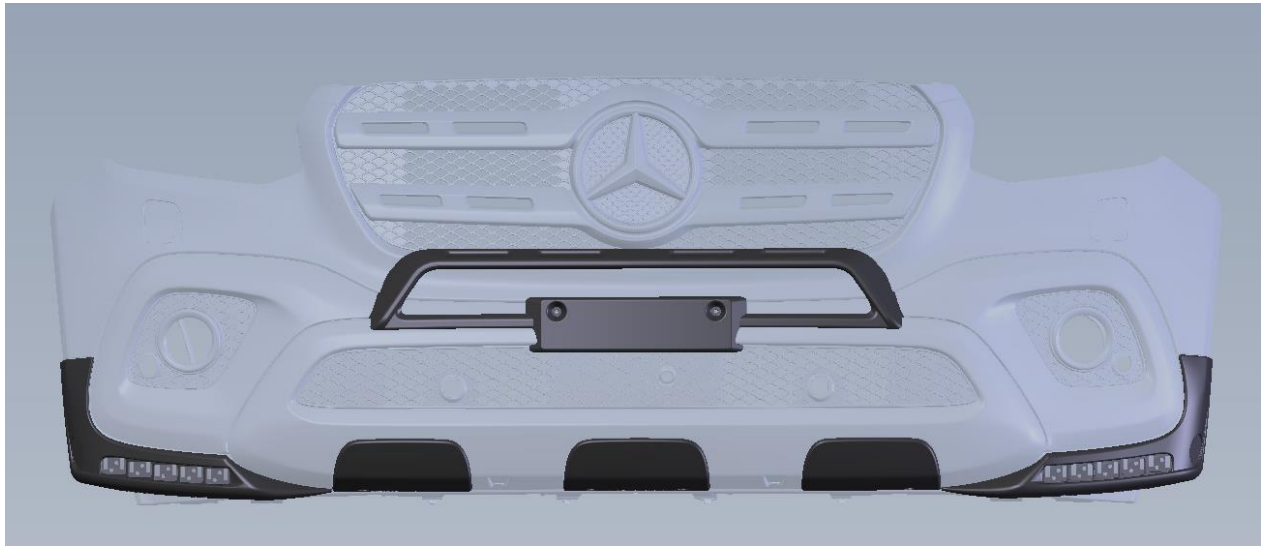
Installation guide for Mercedes-Benz X-Class, type W470

Front bumper attachments incl. daytime running lights **470-210-00**

Center front bumper attachment **470-220-00**

Underride protection attachments **470-215-00**



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.
Check the content of delivery prior to installation, check the seating of the parts prior to painting.

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 degreased.

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.

Urgently avoid pointwise bonding!

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Included in delivery of **470-210-00**:

1x	Left front bumper attachment	470-210-01
1x	Right front bumper attachment	470-210-02
1x	Left LED light bracket	470-210-07
1x	Right LED light bracket	470-210-08
1x	LED light set	91000HI-5S
10x	LED frame black	3472
2x	BB-badge	000-521-BB
2x	Adhesive kit 80ml	B28/008

Included in delivery of **470-220-00**:

1x	Center front bumper attachment	470-220-01
1x	Trim grille for center front bumper attachment	470-220-09
1x	Plastic cover	470-220-02
1x	Number plate attachment	470-220-10
1x	Adhesive kit 80ml	B28/000-8

Included in delivery of **470-215-00**:

1x	Left underride protection attachment	470-215-01
1x	Right underride protection attachment	470-215-02
1x	Center underride protection attachment	470-215-03
1x	Adhesive kit 80ml	B28/000-8

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- Remove the right entrance plastic cover, the right lower a-pillar trim and the glovebox-lid according to Mercedes-Benz workshop information system.

- Remove the front bumper according to Mercedes-Benz workshop information system.

- Print the templates on the last page of the installation guide (original size!) and cut the templates.

- Lay the templates to the left and right lower front bumper edge according to images below.





- Mark the cutting areas to the front bumper using a washable marker.

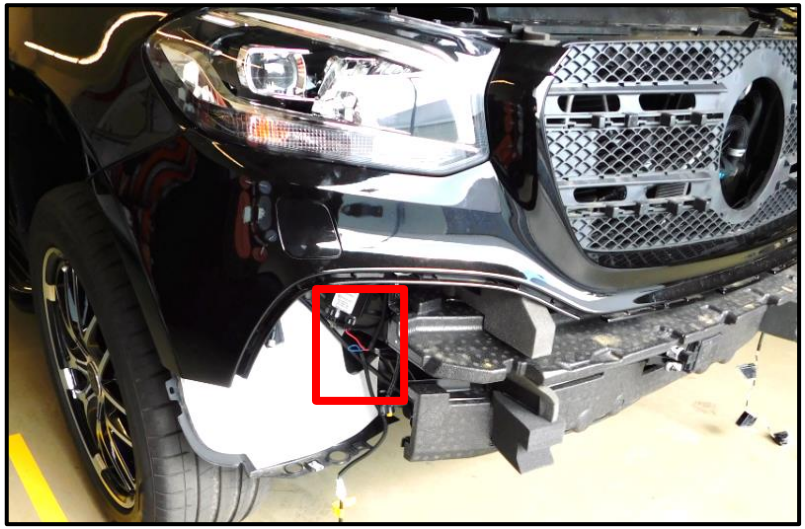
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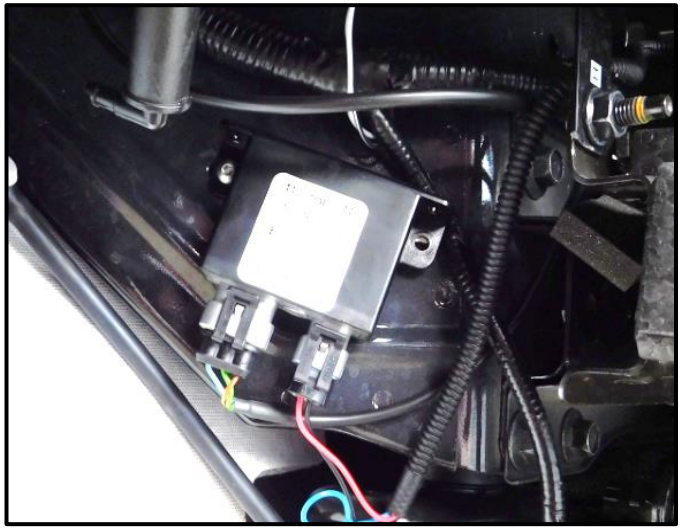
- Cut the marked areas out of the front bumper using a suitable tool. Deburr the cutting edges. Hold the front bumper attachments to the front bumper and check for flush seating, extend the cut-outs, if necessary.



5

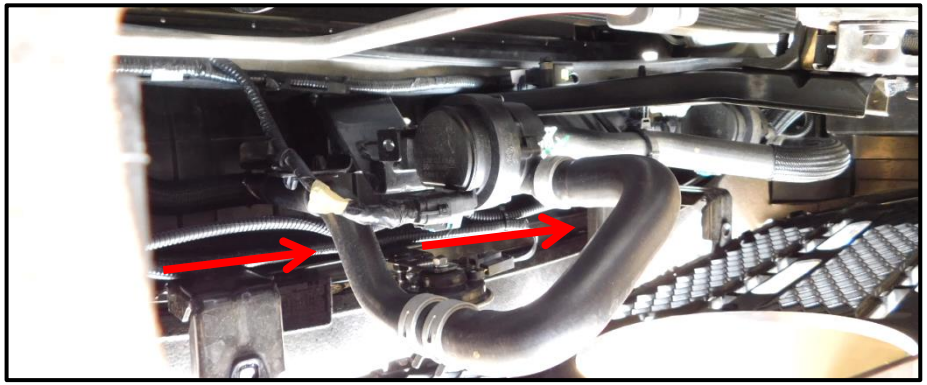
- Bolt the daytime running light control unit to the area behind the front bumper shown (passenger side).



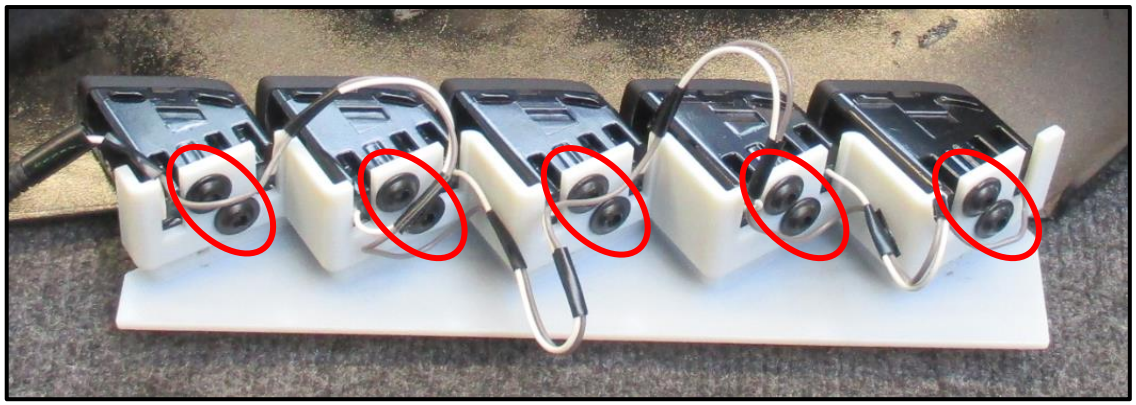


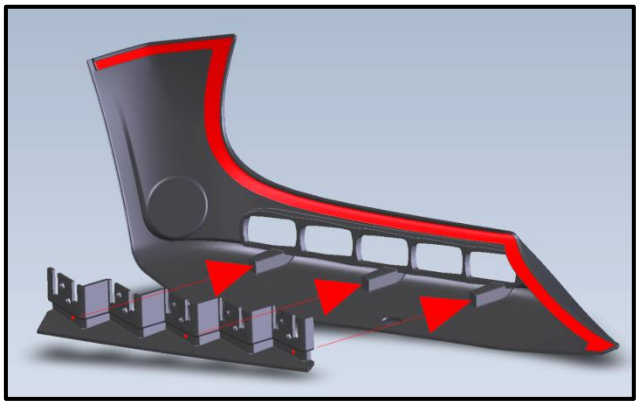
6

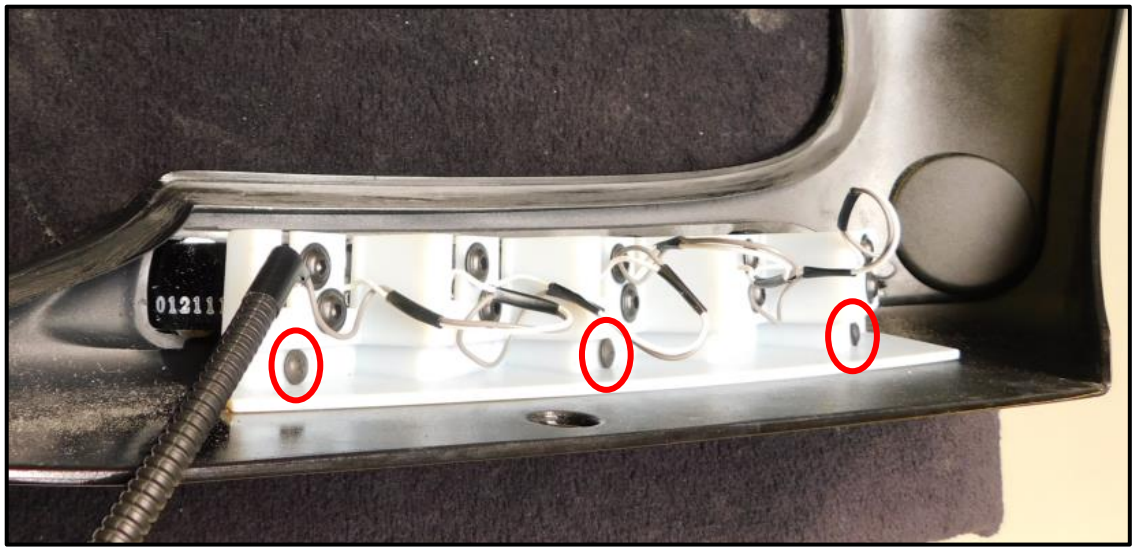
- Connect the wiring harness to the control unit. Route the wiring harness to the fuse and relay box within the engine bay.
- Connect the daytime running light wiring harness to the control unit. Route the connector for the driver‘s side daytime running light along the front cross strut to the driver‘s side, fixate it to standard wires using cable ties.



- Re-attach the front bumper.
- Bolt the LED lights to the LED light carriers.
- Bolt the completed LED light carriers to the front bumper attachments.



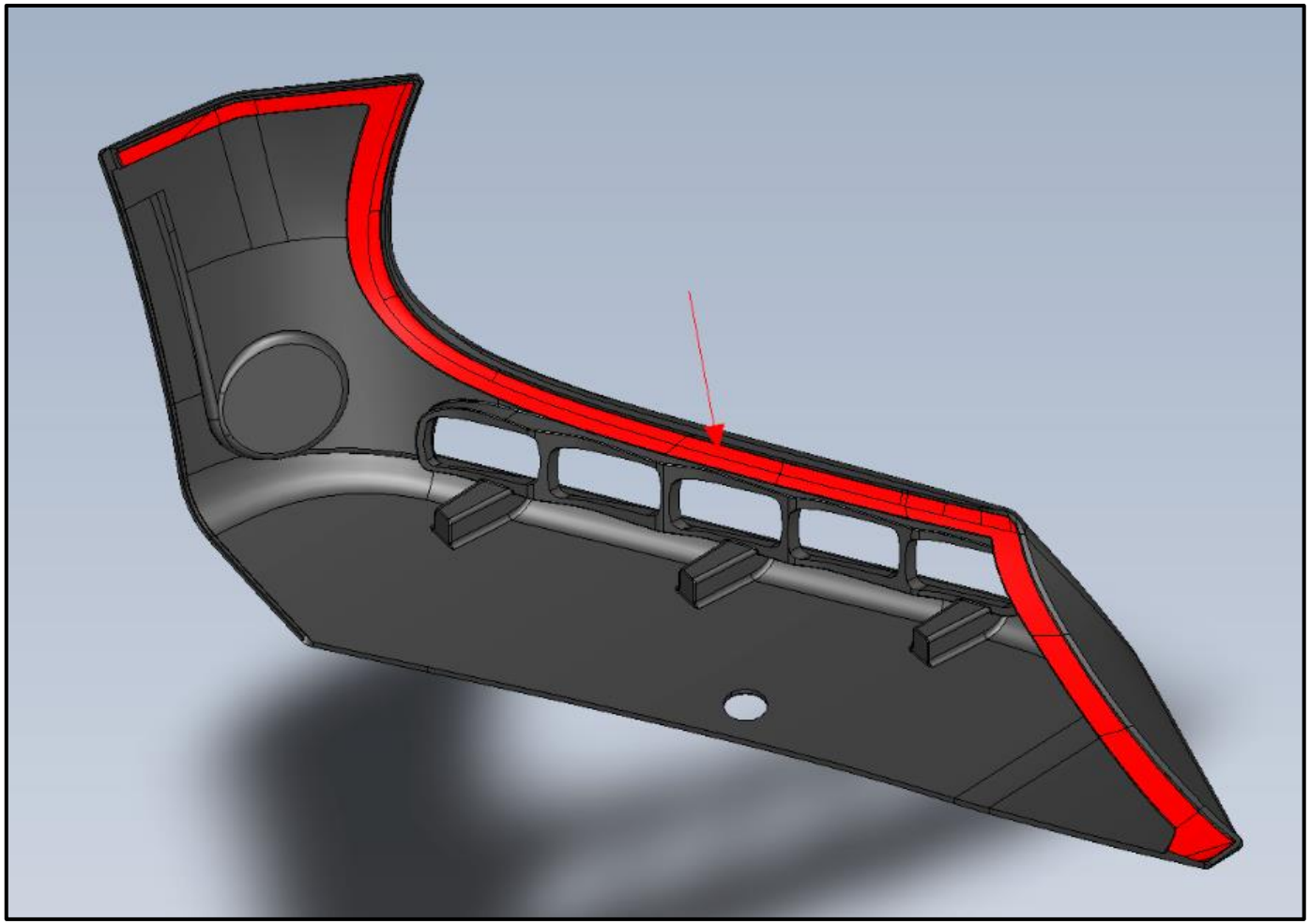




7

- Prepare the bonding surfaces of the front bumper and those of the front bumper attachments (marked red within illustration below) for bonding according to bonding hints on page 3.

8



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

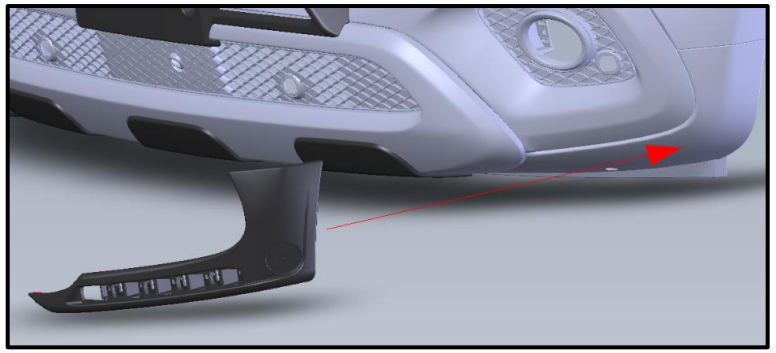
- Connect the plugs of the Brabus wire harness to the LED lights.

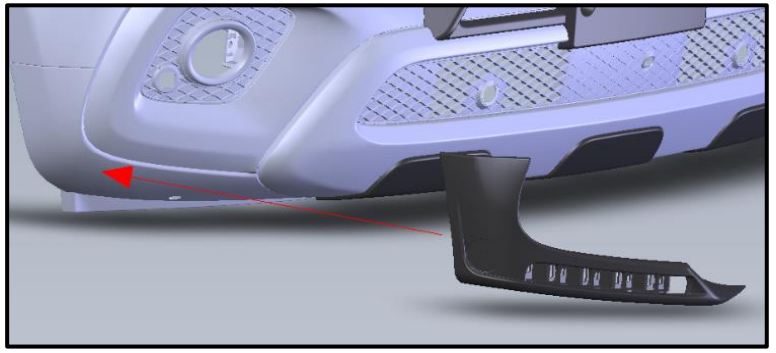
- Bond the front bumper attachments to the front bumper and align them according to the markings. Fixate the attachments until the adhesive has finally hardened.

- Remove excessive adhesive immediately!

- Attach the BB badges supplied to the front bumper attachments. Make sure for sufficient cleanliness and degrease the bonding surfaces.





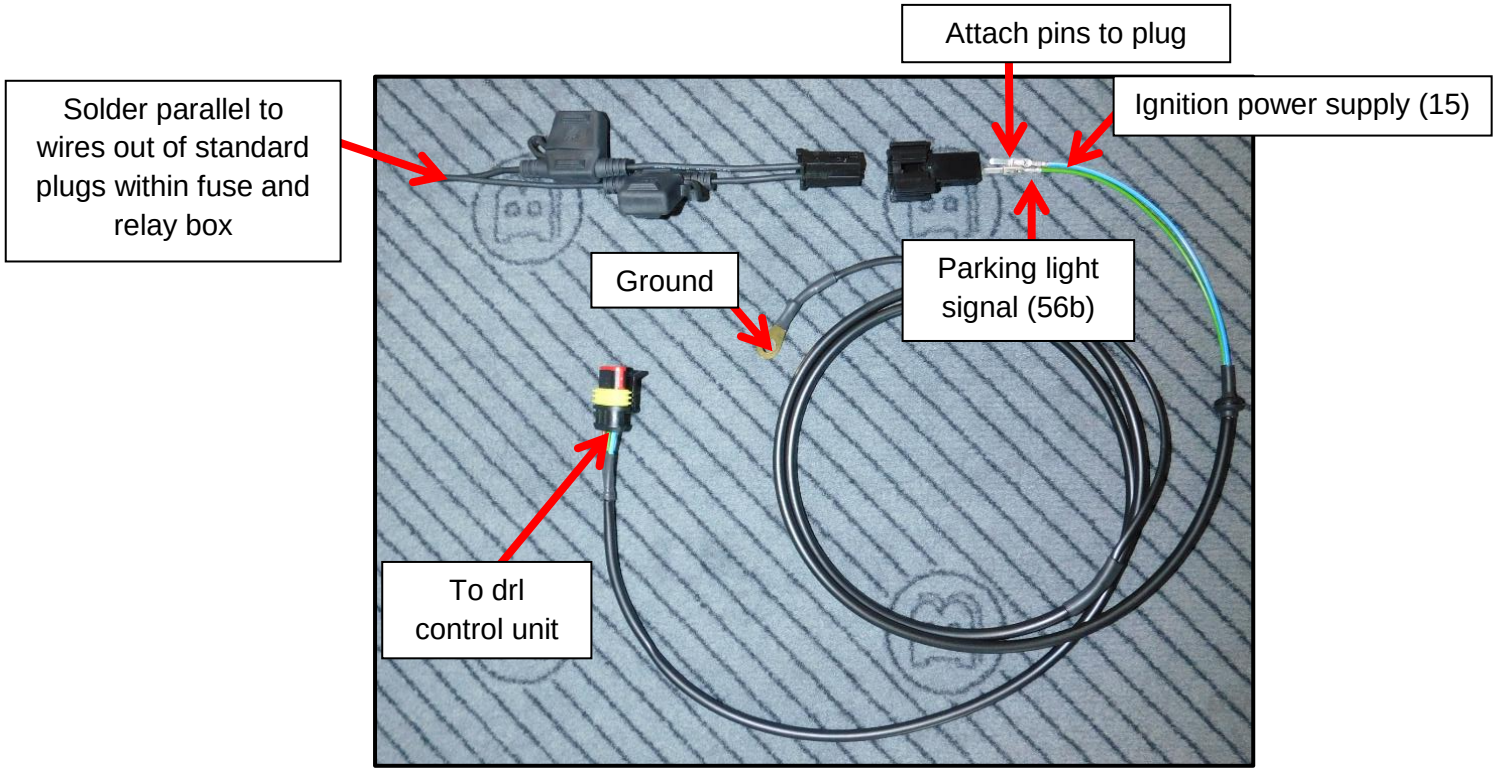


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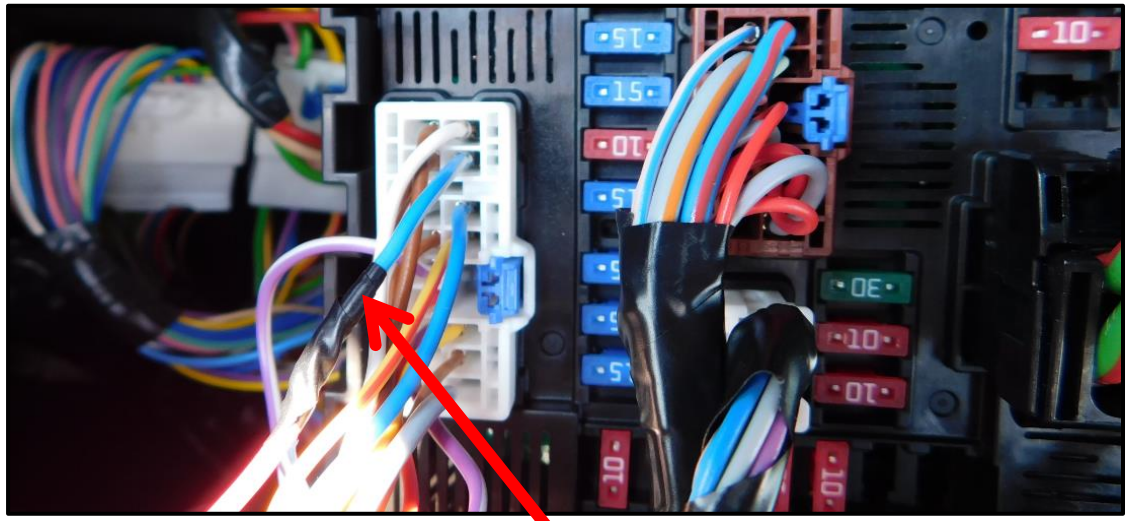
- Bolt the ground ring lug to the ground terminal right within the engine bay.

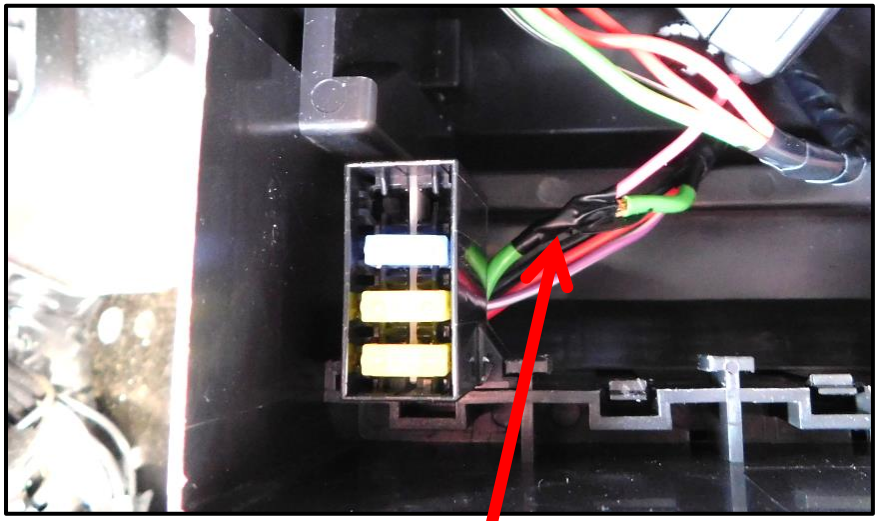
- Route the gn and bl-wh wires through the rubber grommet supplied into the fuse and relay box.

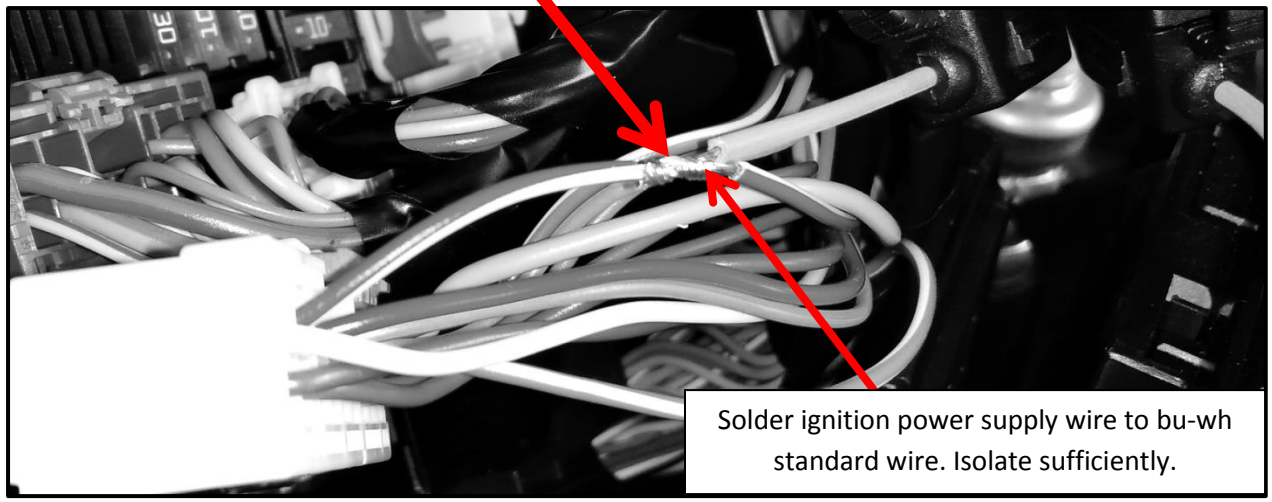


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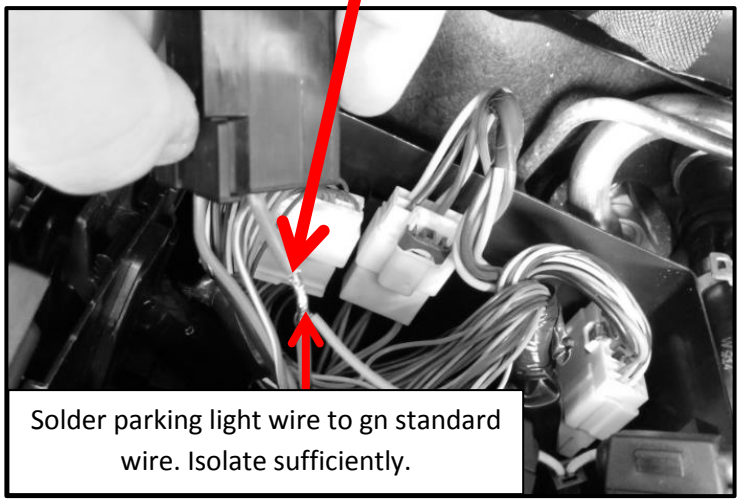
- Solder the wires of the Brabus wiring harness to the wires out of the black and white plug. Sufficiently isolate the soldered areas.







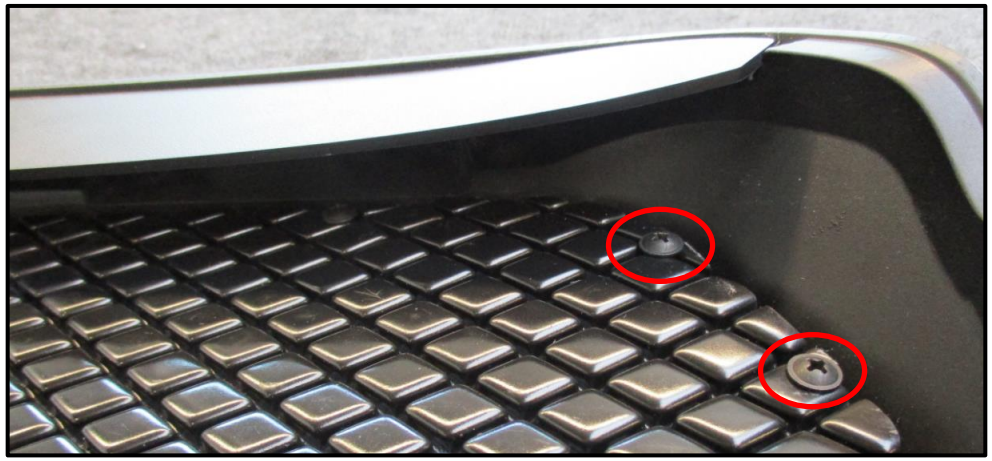
Solder ignition power supply wire to bu-wh standard wire. Isolate sufficiently.

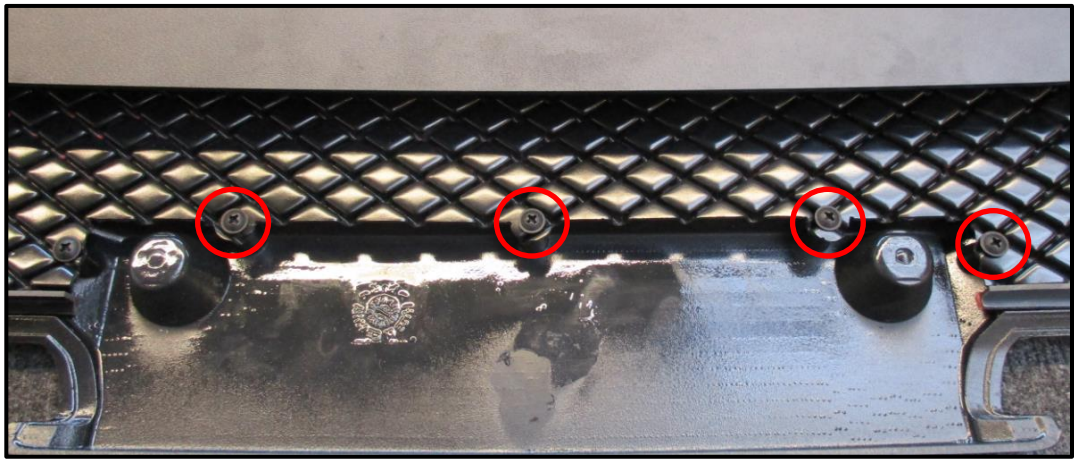


Solder parking light wire to gn standard wire. Isolate sufficiently.

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- Bolt the trim grille supplied to the center front bumper attachment.



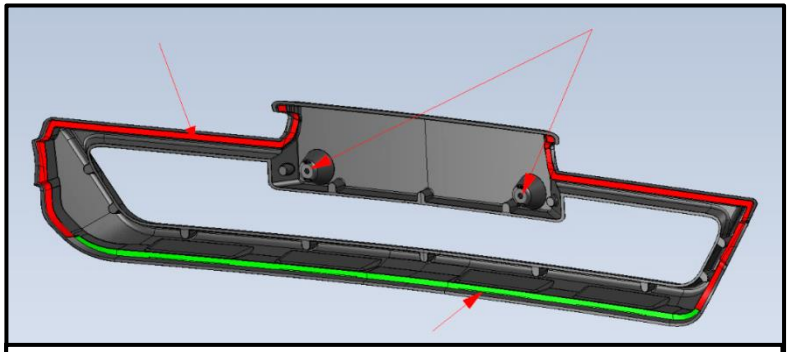


12

- Prepare the bonding surfaces of the center front bumper attachment for bonding.

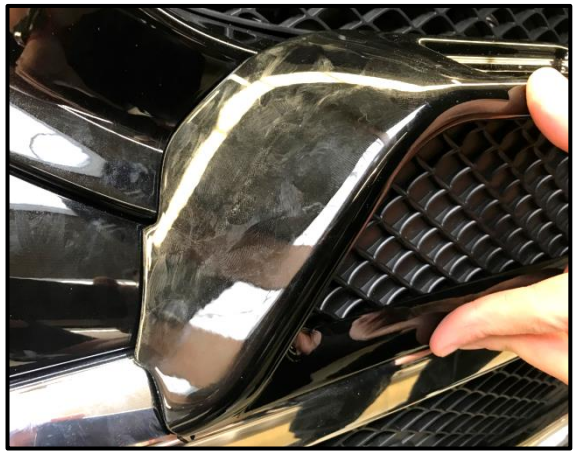
- Bond the plastic cover supplied to the center front bumper attachment, fixate the parts until the adhesive has finally hardened. Remove excessive adhesive immediately!

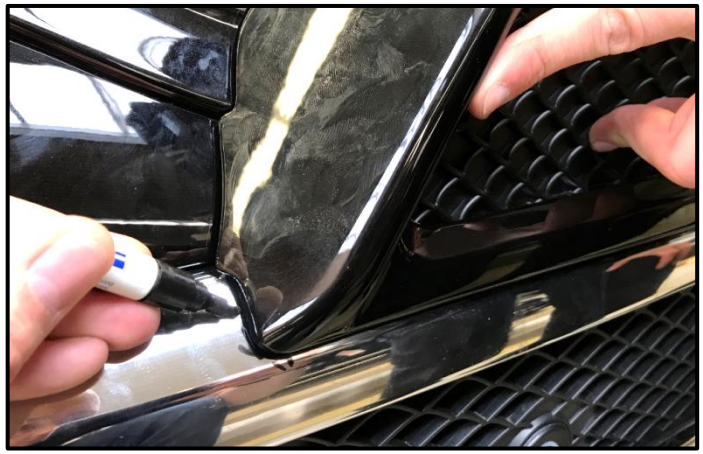




Red marked bonding areas for adherence of the part to the front bumper, green marked area for adherence of plastic cover

- Hold the center front bumper attachment to the front bumper. Align it and mark the outer edges to the front bumper using a washable marker.

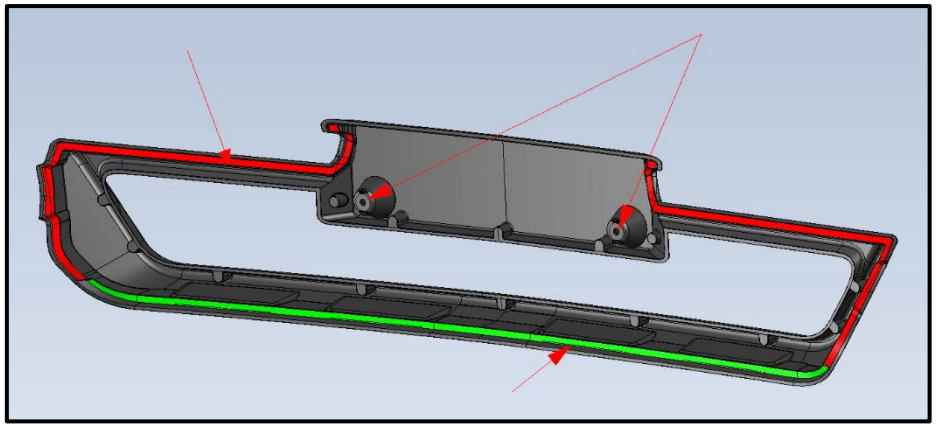






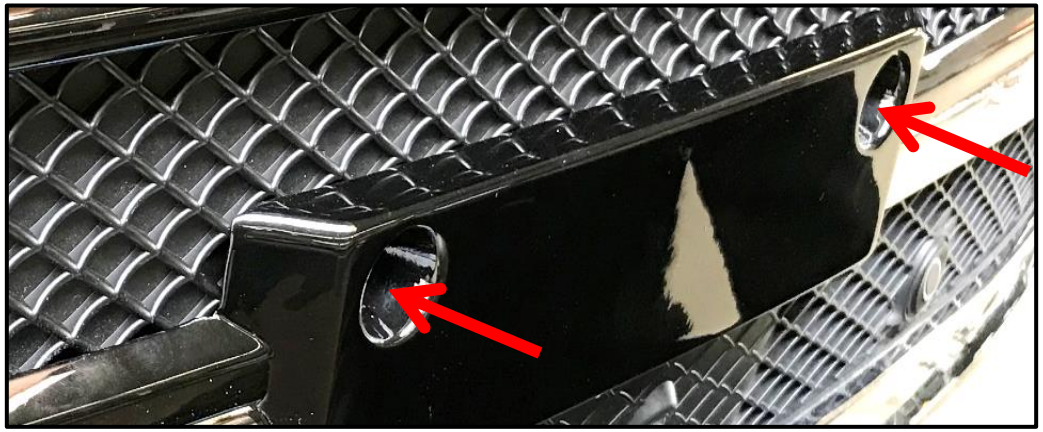
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- Apply even lines of adhesive to the center front bumper attachment.



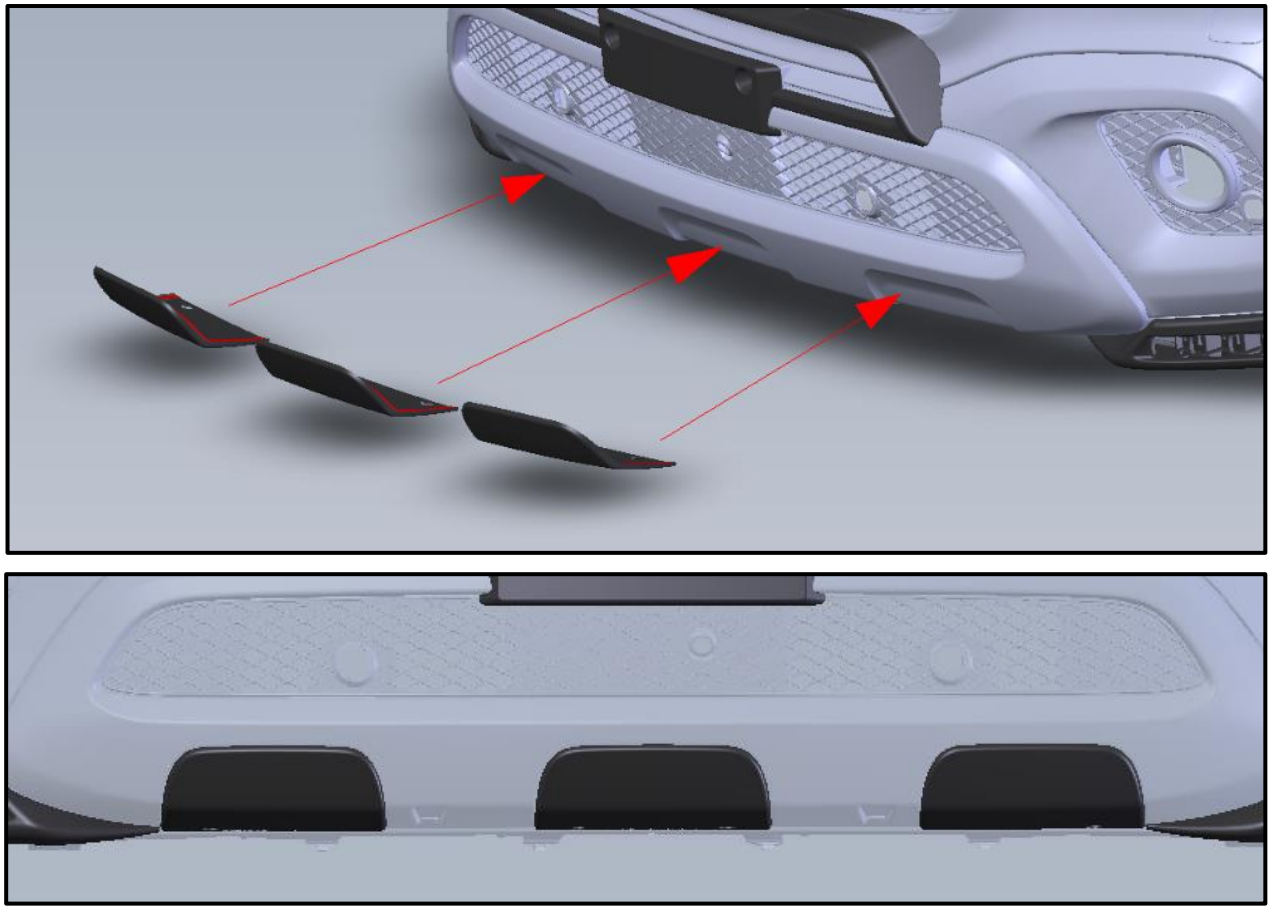
- Bond the center front bumper attachment to the front bumper. Fixate it using appropriate meaures (e.g, duct tape) until the adhesive has finally hardened. Remove excessive adhesive immediately!

- Bolt the front bumper attachment to the front bumper after the adhesive has hardened.



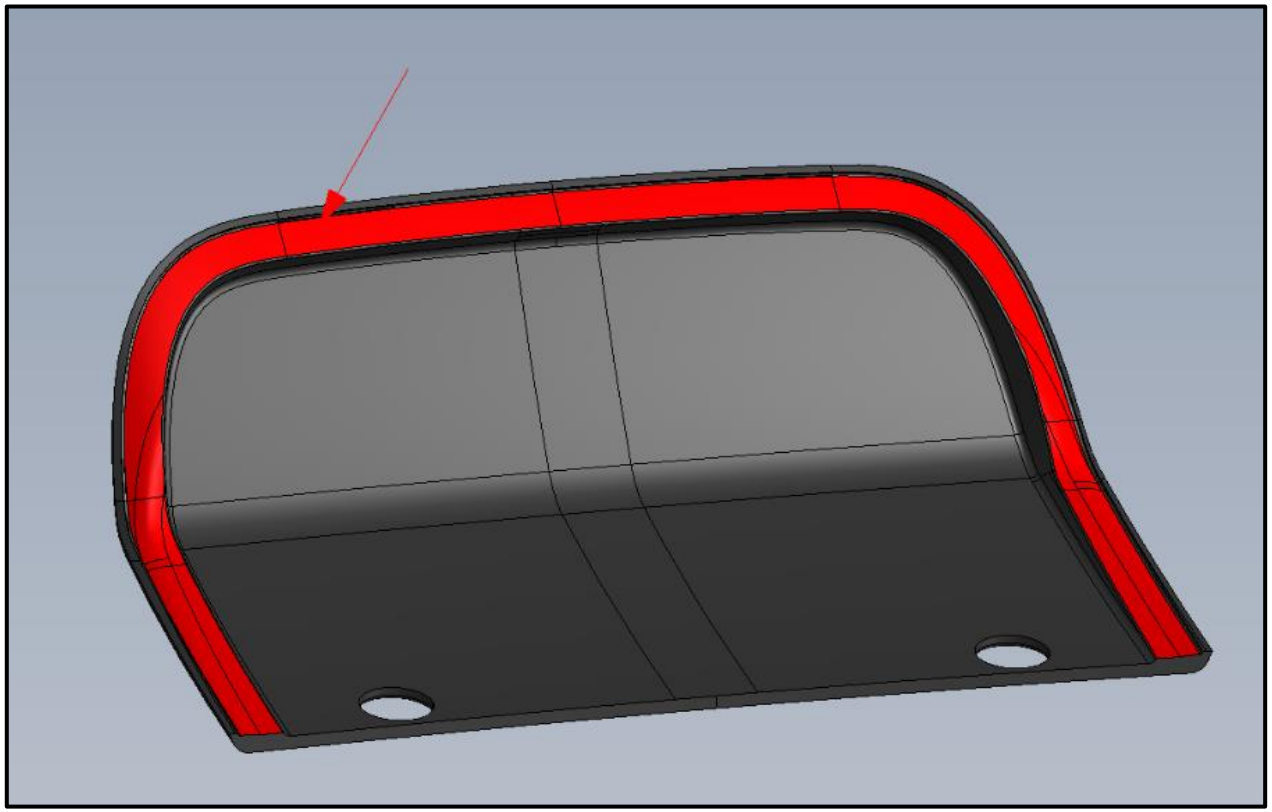
- Hold the lower front bumper underride attachments to the front bumper. Align the parts and mark the outer edges to the front bumper using a washable marker.

- Prepare the bonding edges of the front bumper underride attachments for bonding according to bonding hints on page 3.

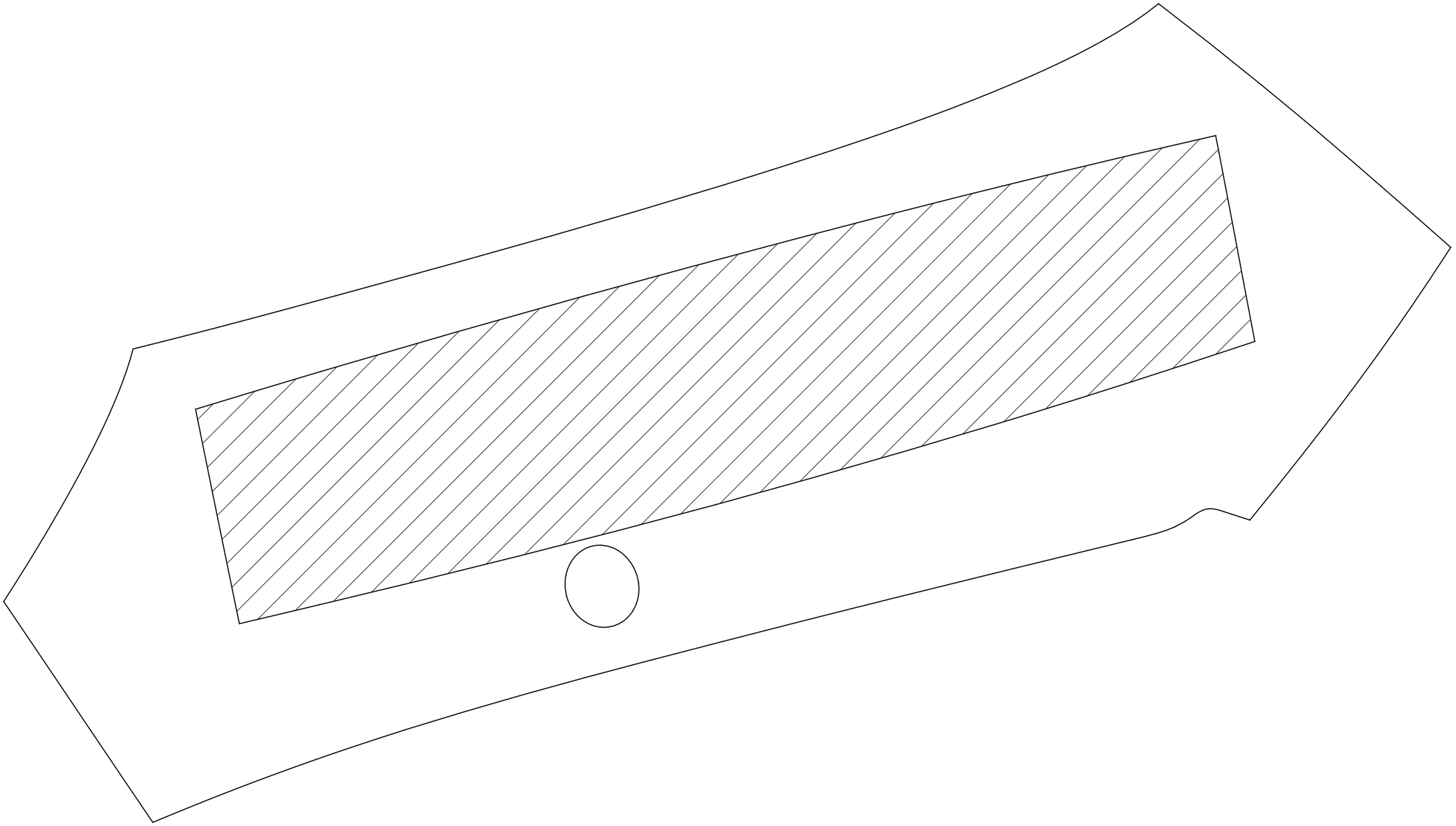


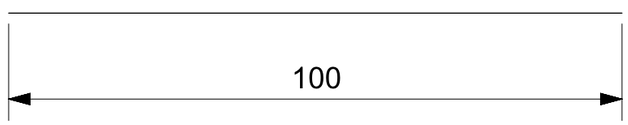
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- Apply even lines of adhesive to the bonding edges of the front bumper underride attachments.
- Bond the front bumper underride attachments to the front bumper. Align the parts and fixate them using appropriate measures (e.g. duct tape) until the adhesive has finally hardened. Remove excessive adhesive immediately.



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Änderung/Bemerkung:

	Datum	Name	Signatur
Gezeichnet:	20.04.2018	Brekoff	
Geprüft:			
Genehmigt:			
Qualitätssicherung:			

Toleranz: ISO 2768-m

Werkstoff:

Bauteil	Anzahl

Anwendung:

Oberfläche:

Titel:

470 X-Klasse Schnittschablone TFL Aufsatz

Zeichnungsnummer:

REV: A

A3

Maßstab: 1:1

Gewicht:

Blatt 1 von 1