BRABUS®

Carbon fiber front attachments and front inserts for X253, GLC 63 AMG
Article-numbers 253-225-00_10, 2543-235-00_10



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 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 vacuum assembly brackets, (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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Included in delivery of carbon fiber front attachments:

1x	Left carbon fiber front attachment, matte or glossy	253-225-01
1x	Right carbon fiber front attachment, matte or glossy	253-225-02
1x	Adhesive kit	B28/000-8

Included in delivery of carbon fiber front inserts:

1x	Left carbon fiber front insert, matte or glossy	253-235-01
1x	Right carbon fiber front insert, matte or glossy	253-235-02
1x	Adhesive kit	B28/000-8

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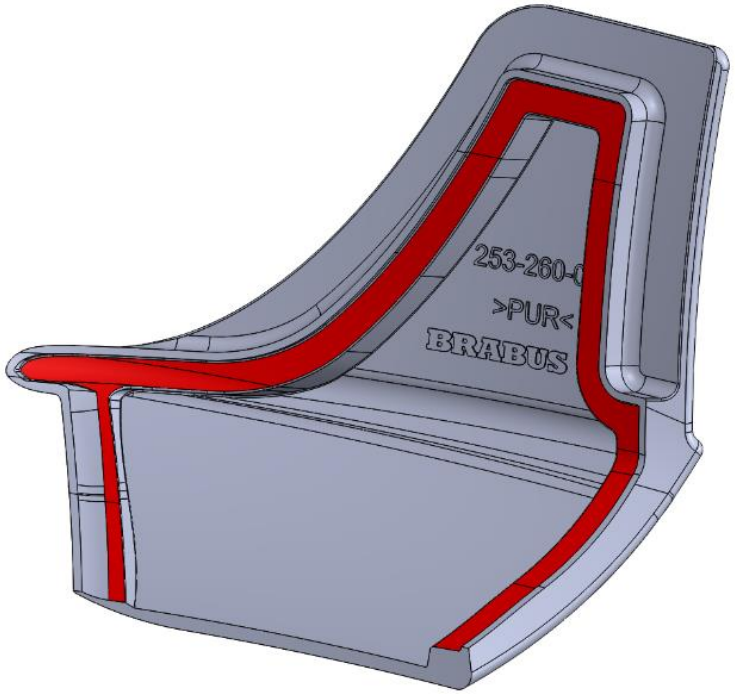
Assembly of front bumper attachment:

- Hold the carbon fiber front attachments to the front bumper according to image. Align the parts flush to the bumper and mark the outer edges to the front bumper using a washable marker.



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- Prepare the bonding areas of the front attachments (marked red) and those of the front bumper for bonding according to bonding hints on page 2.



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

- Bond the front attachments flush to the front bumper and align them according to the markings. Remove excessive adhesive immediately!

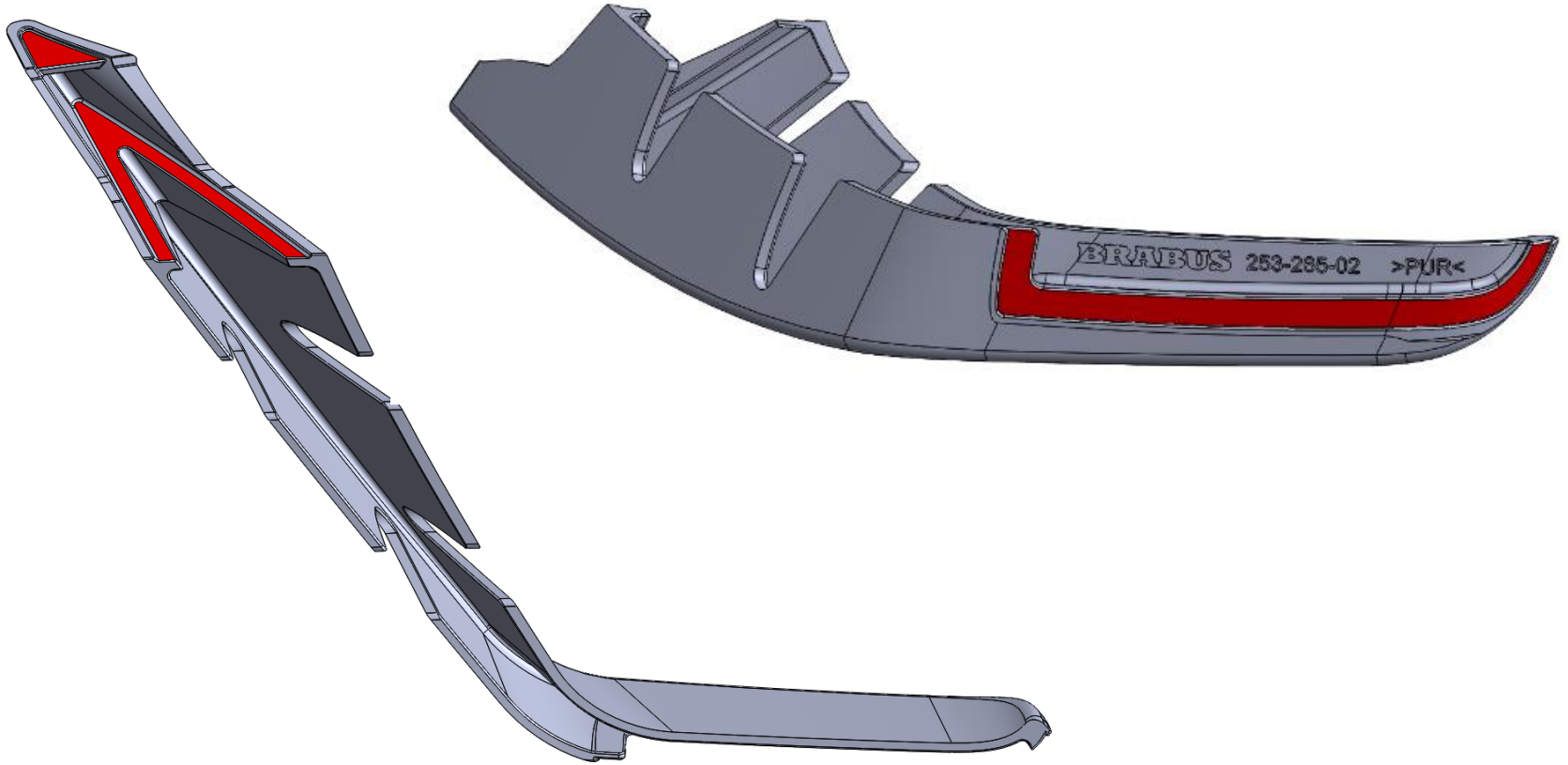
- Fixate the front attachments until the adhesive is finally hardened using appropriate adhesive tape or vacuum assembly brackets.

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Assembly of carbon fiber front inserts:

- Hold the carbon fiber front inserts to the front bumper according to image on page 4. Align the parts flush to the bumper and mark the outer edges to the front bumper using a washable marker.

- Align the front inserts and mark the position of the front inserts to the front bumper using a washable marker. Prepare the bonding areas of the front inserts and those of the front bumper for bonding according to bonding hints on page 2.



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- Apply adhesive to the bonding areas of the front bumper (fig).
- Bond the front inserts flush to the front bumper and align them according to the markings. Remove excessive adhesive immediately.
- Fixate the front inserts until the adhesive is finally hardened using appropriate adhesive tape or vacuum assembly brackets.
- Avoid to wash the vehicle in an automatic washing bay within 24 hours after assembly!

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