Carbon rear door attachment with illuminated lettering G465
Partnumber: 465-845-CG/CM/DB/SF

BRABUS



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.
Dismantle standard components according to Mercedes-Benz workshop instructions (WIS).
Prior to installation please check the content of the supplied components as detailed below.

Notes on VHB bonding



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!

- Treat surfaces to be bonded with primer (Würth, item no.: 0890024101)

- 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.

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Notes for bonding

The components can be bonded with the supplied adhesive or with PU windshield adhesive in combination with an appropriate primer.

All adhesive surfaces, both those on the vehicle and those on the attachment, must be carefully cleaned and degreased.

We recommend using window adhesive (e.g., Würth, window adhesive "Classic" or "Pro", item no.: WU89002310, WU89002330) in conjunction with acetone (e.g. Würth, item no.: WU893460) and primer (e.g. Würth, item no.: WU890024101).

After cleaning with acetone, the primer is applied to the adhesive surfaces on the vehicle and on the component using appropriate primer brushes (e.g., Würth, Art. No.: WU891650) (apply in one direction only, then allow to flash off!).

Apply an even bead of adhesive to the adhesive edge and bond the part to the vehicle. To remove excess adhesive, we recommend, for example, K+D Cleaner (e.g., Würth, Art. No.: WU89010063).

To hold the components in place until the adhesive has cured, we recommend using clamping suction cups (e.g. Würth, Art. No.: WU069155210).



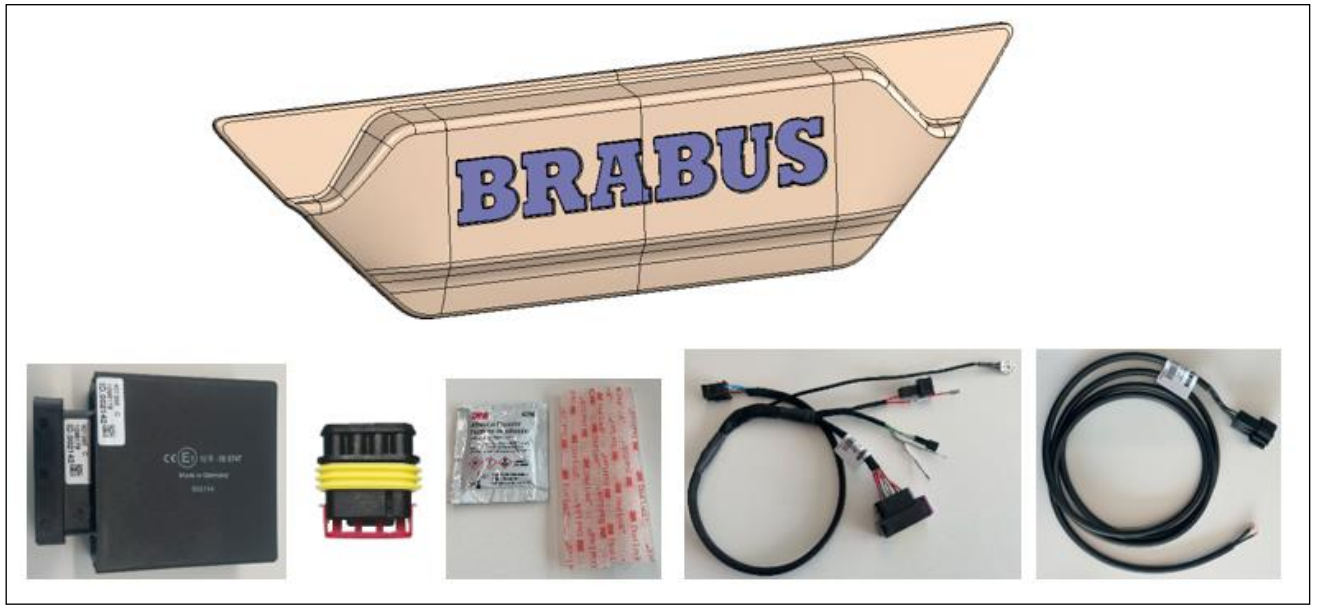
It should be noted that you do not treat the bonding surfaces with primer in the area that can still be seen after bonding the corresponding part! Apply primer only up to a distance of approx. 5mm from the marking!

Observe the bonding instructions, always ensure that all bonding surfaces are clean and free of grease before bonding! Free the bonding surfaces from paint mist before bonding!

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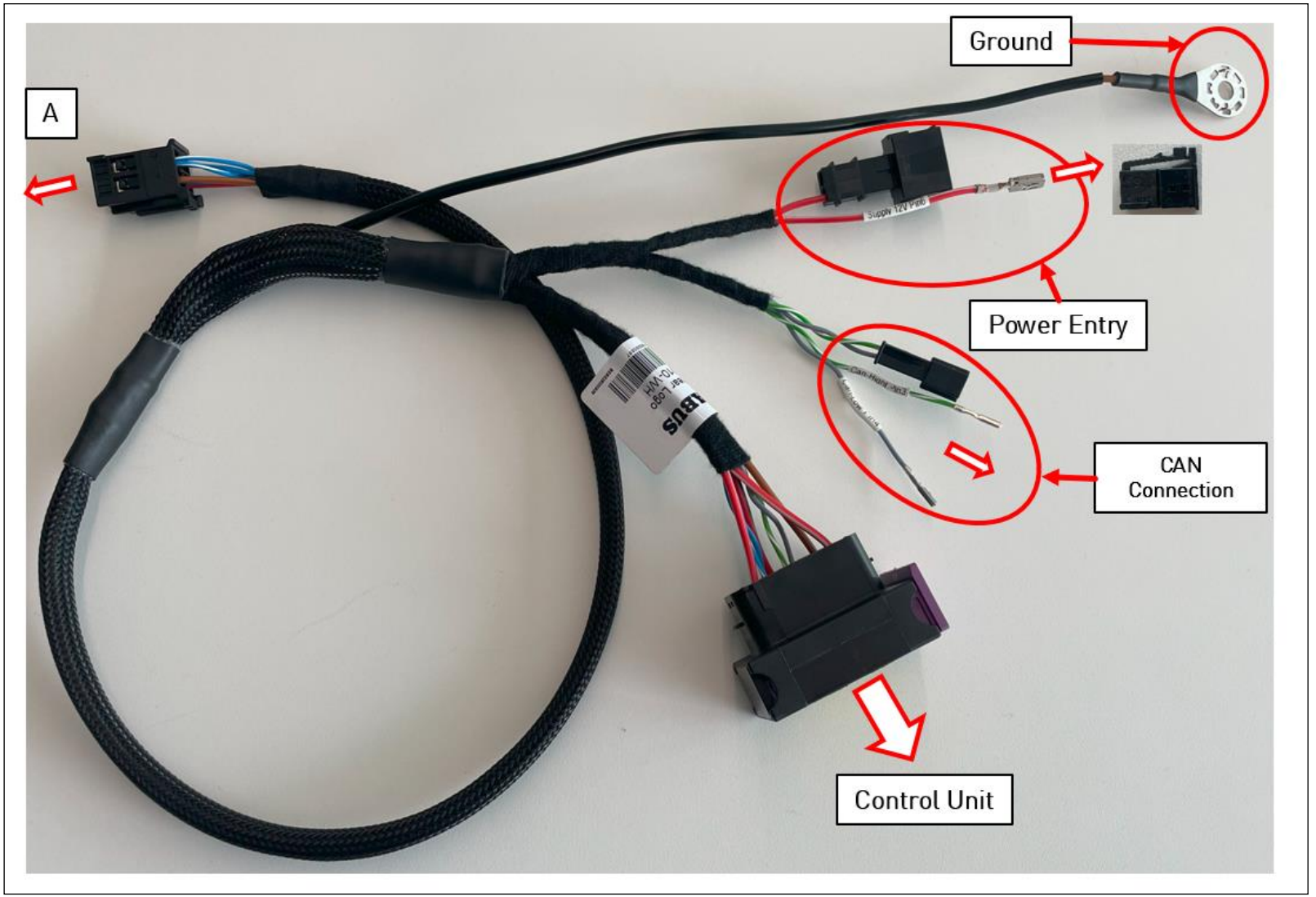
Included in delivery BRABUS:

1x	Assembly rear door attachment with illuminated lettering	465-845-0120-CG/CM/DB/SF-ZB
1x	Rear Logo Wiring Harness	465-845-010-WH
1x	Software rear logo	465-845-900
1x	Connector Housing motor vehicle 4-way waterproof	WU5551034
1x	Drilling template	465-845-000
1x	Adhesive set 80ml	B28/000/8

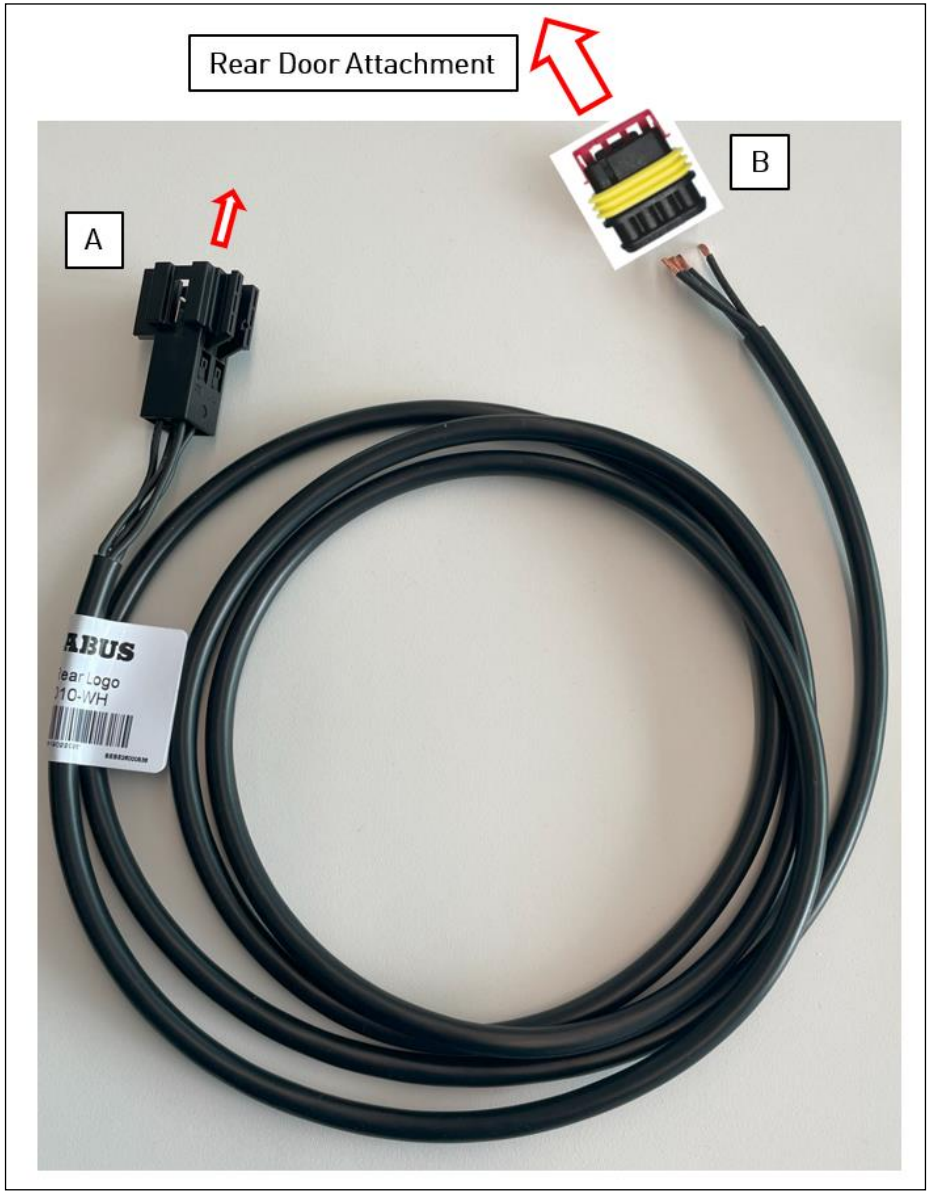


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Electrical Connection:



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Preparations:

- Under the trunk cover, disconnect the ground wire from the vehicle battery.
- Perform all work in accordance with the Mercedes-Benz Workshop Information System.



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- Remove the trim panels on the left side of the trunk and on the rear door.



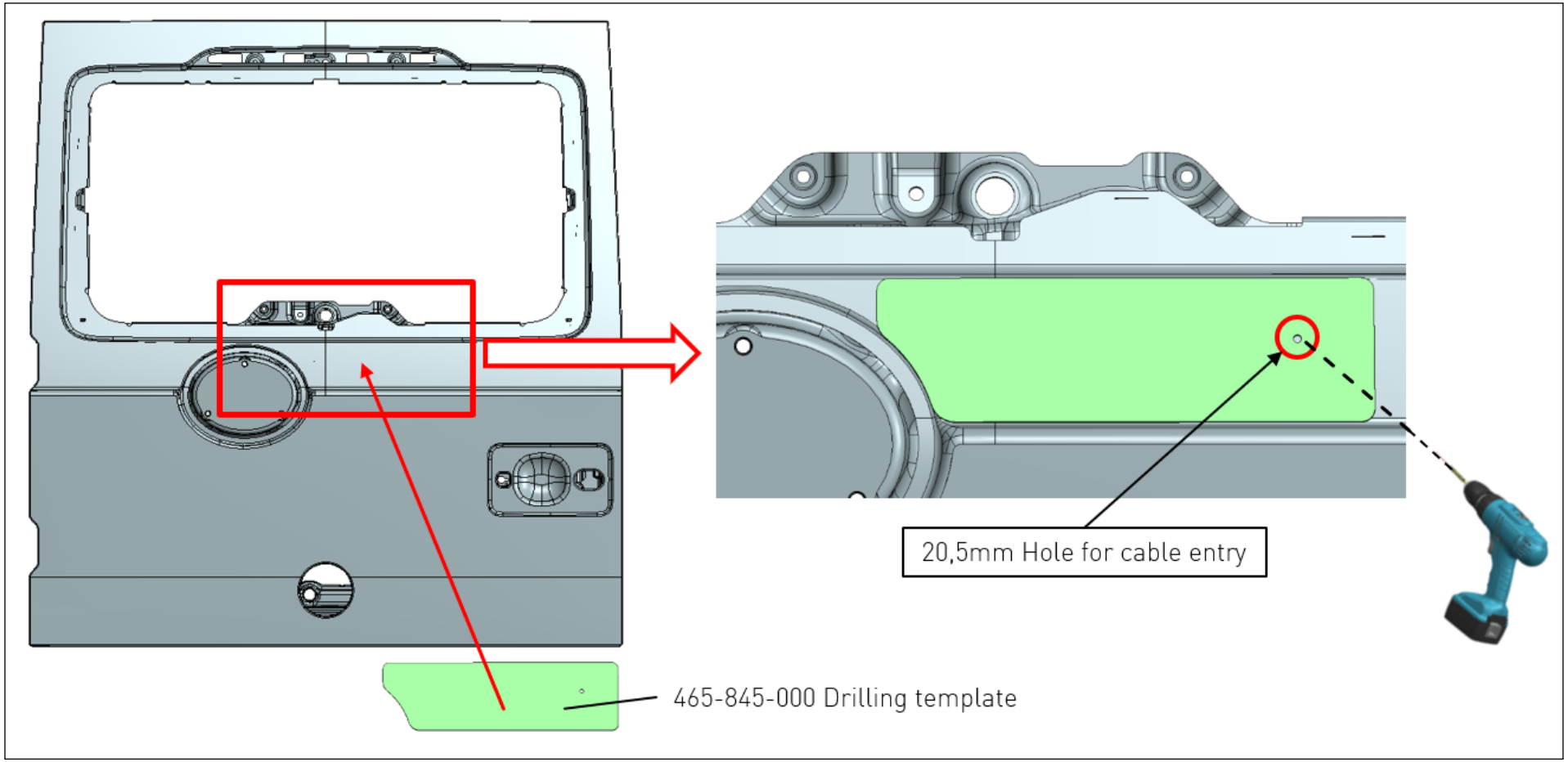
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- Remove the BRABUS carbon spare tire cover and the spare tire.



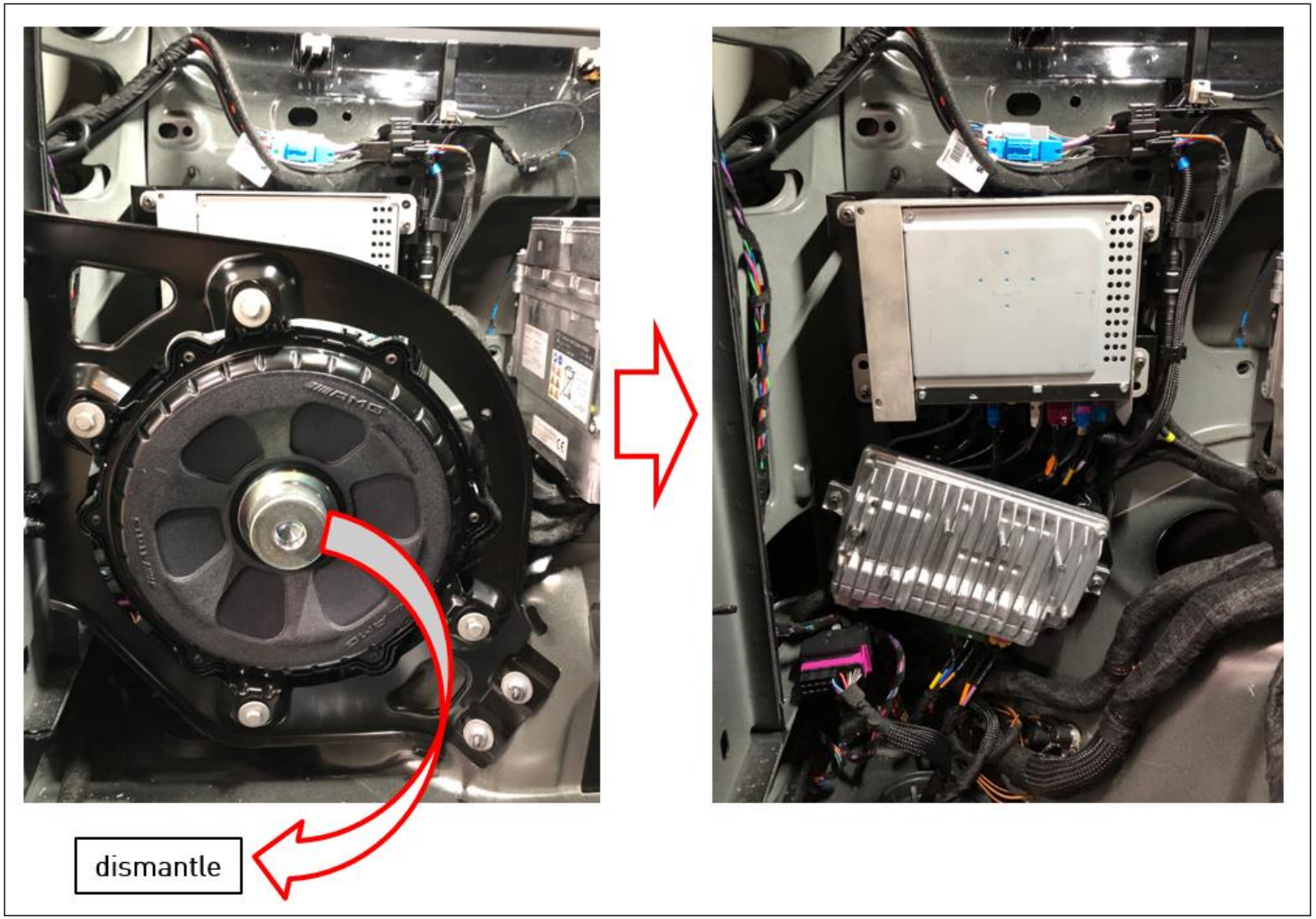
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- Place the drilling template on the tailgate as shown in the sketch and drill a 20.5 mm hole for the cable feed-through of the illuminated rear door attachment.
- Protect the drilled edges from corrosion using appropriate methods.



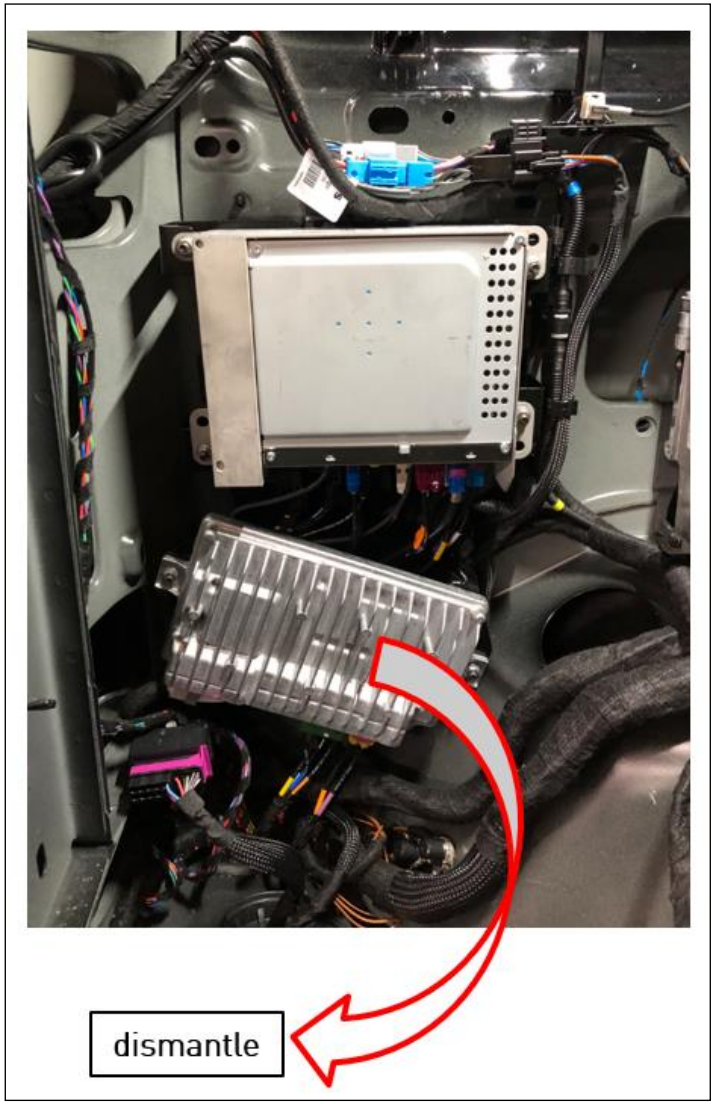
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- Remove the speaker located on the left side of the trunk.
- One mounting point is located in the wheel well; to access it, remove the inner wheel well trim and unscrew the knurled nut on the speaker bracket.
- Loosen the remaining screws now.



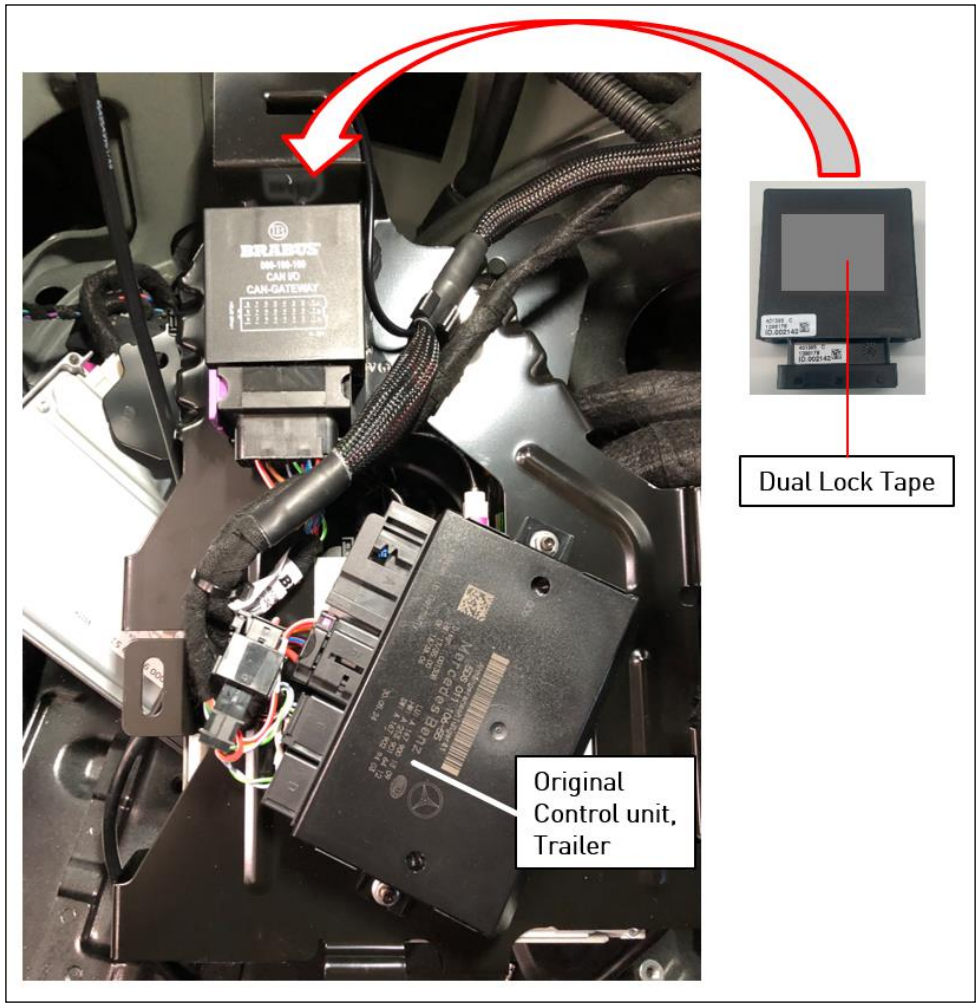
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- Remove the camera control unit.
- Now remove the bracket and fold it down.



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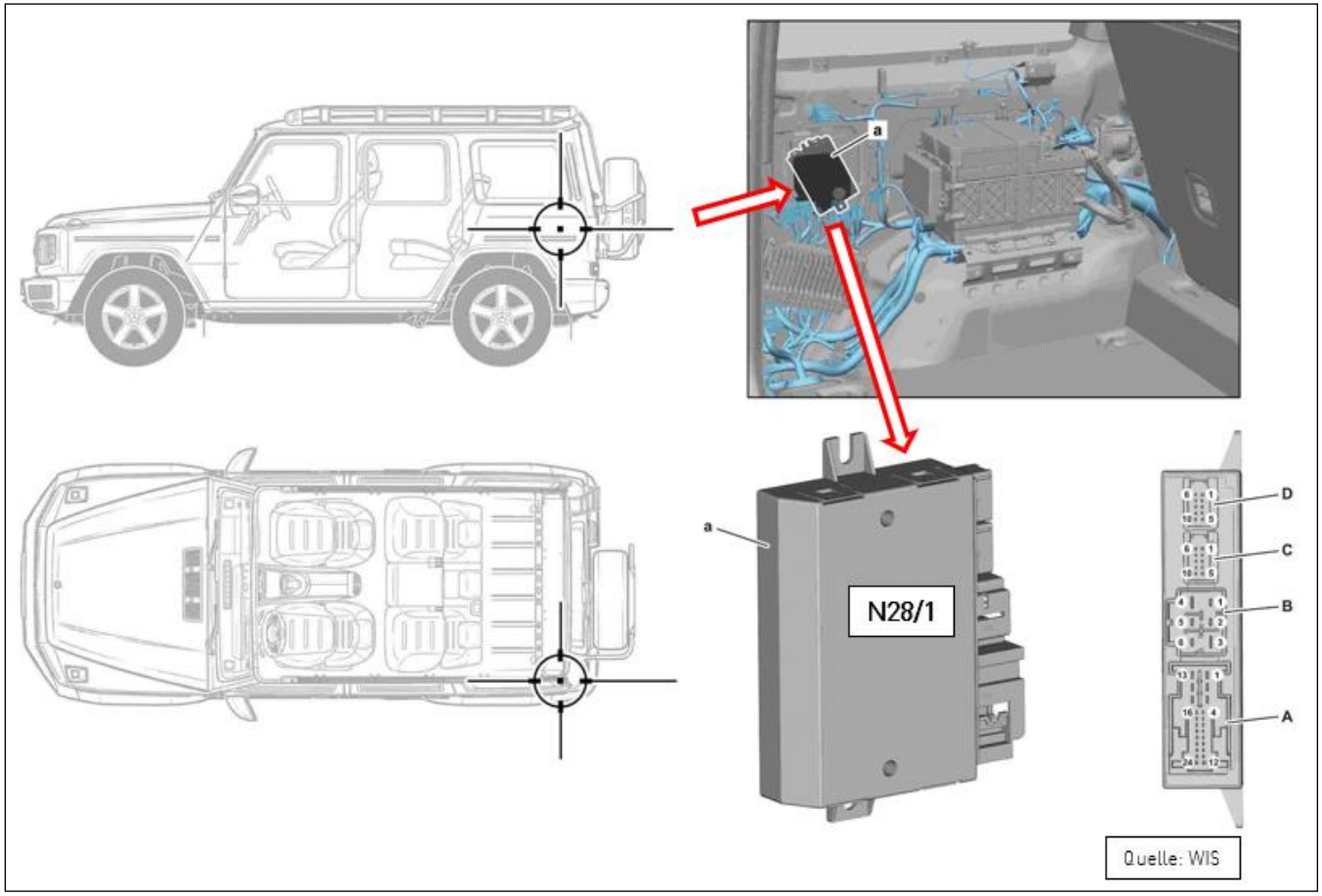
- Degrease the adhesive surfaces of the BRABUS control unit and the bracket, and use the 3M cloth to apply the bonding agent to the adhesive surfaces.
- Remove the protective film from the Dual Lock tape and attach one strip to the control unit, as shown in the diagram, and the other strip to the mount.
- Now place the control unit on the Dual Lock tape of the mount.



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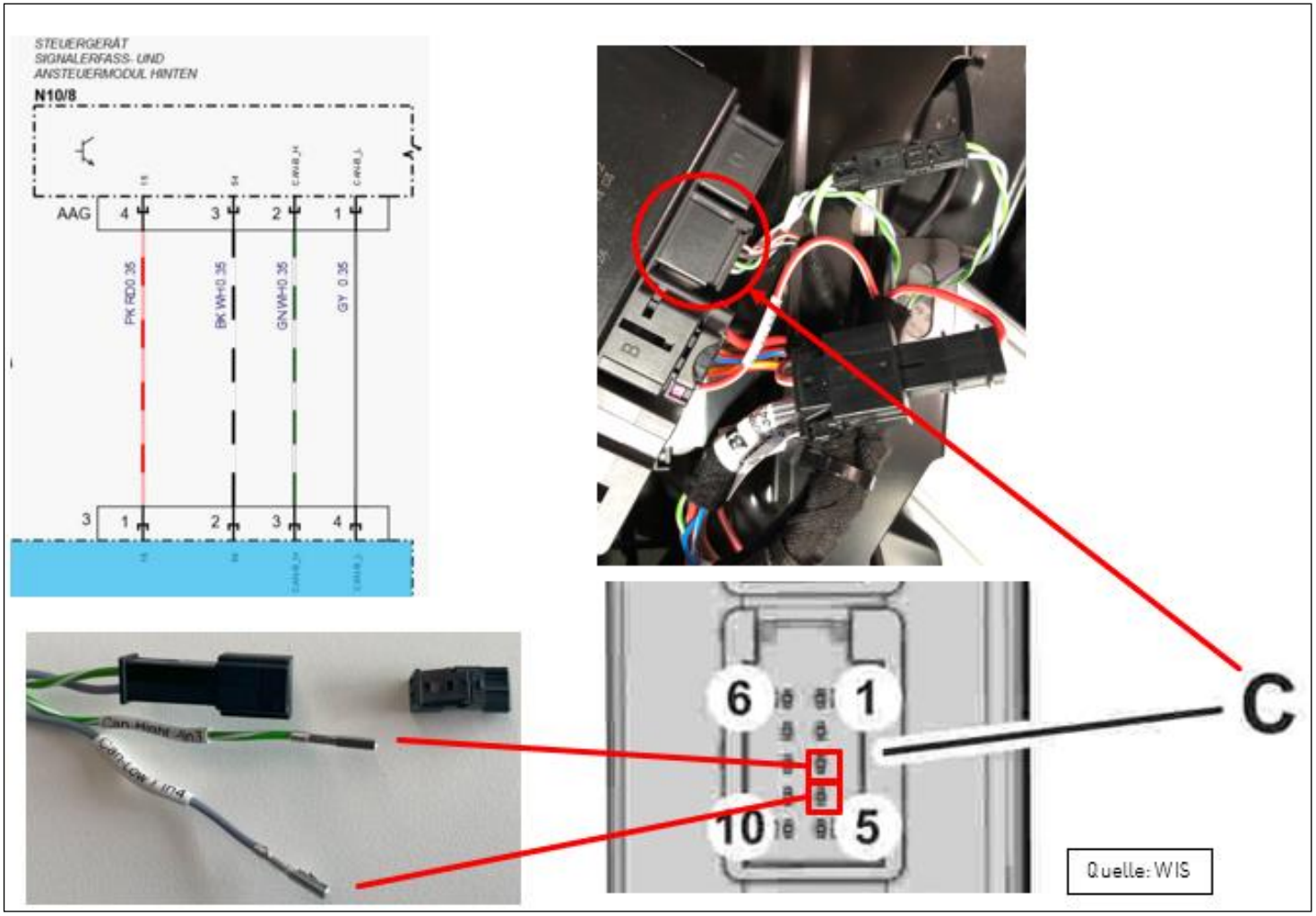
Connecting the illuminated lettering:

- Disconnect the connectors from the N28/1 trailer detection control unit.
- The N28/1 control unit is located in the rear left corner of the trunk. The BRABUS module is connected in series with the original wiring.
- For this reason, the contacts on the original connector must be unpinned. These are then plugged into the connector housings on the BRABUS wiring harness, and the connectors from the BRABUS wiring harness are pinned into the original housing.



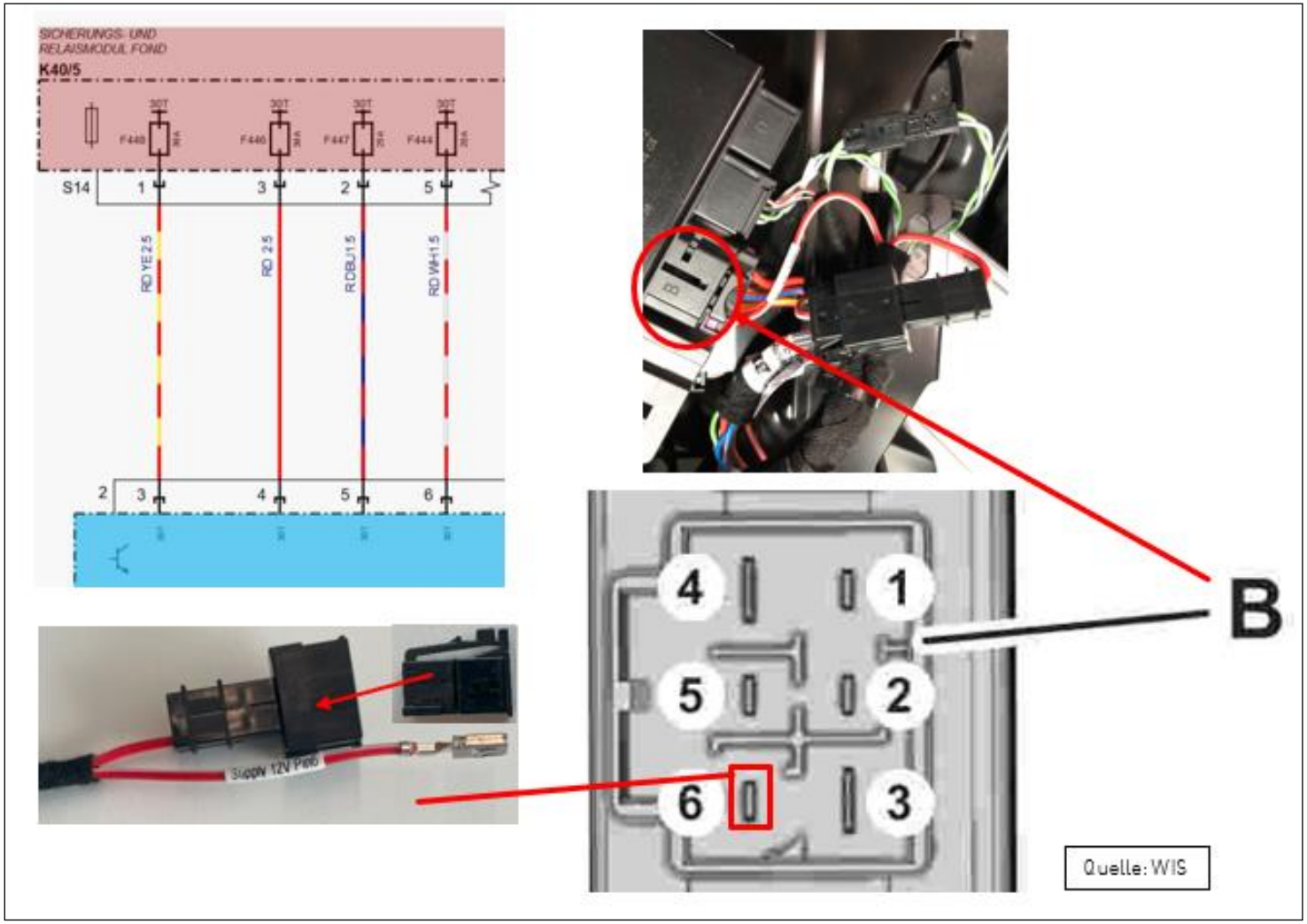
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- In connector C, remove the cables from the sockets for pin 3 (green/white – CAN High) and pin 4 (gray – CAN Low).
- Plug the stripped wires into the connector on the BRABUS wiring harness, matching them to their respective colors.
- Plug the connectors of the BRABUS wiring harness into the vacant slots on the original connector, matching them to the contacts you previously unpinned.
- When connecting any cables, make sure the connector pins are properly engaged.



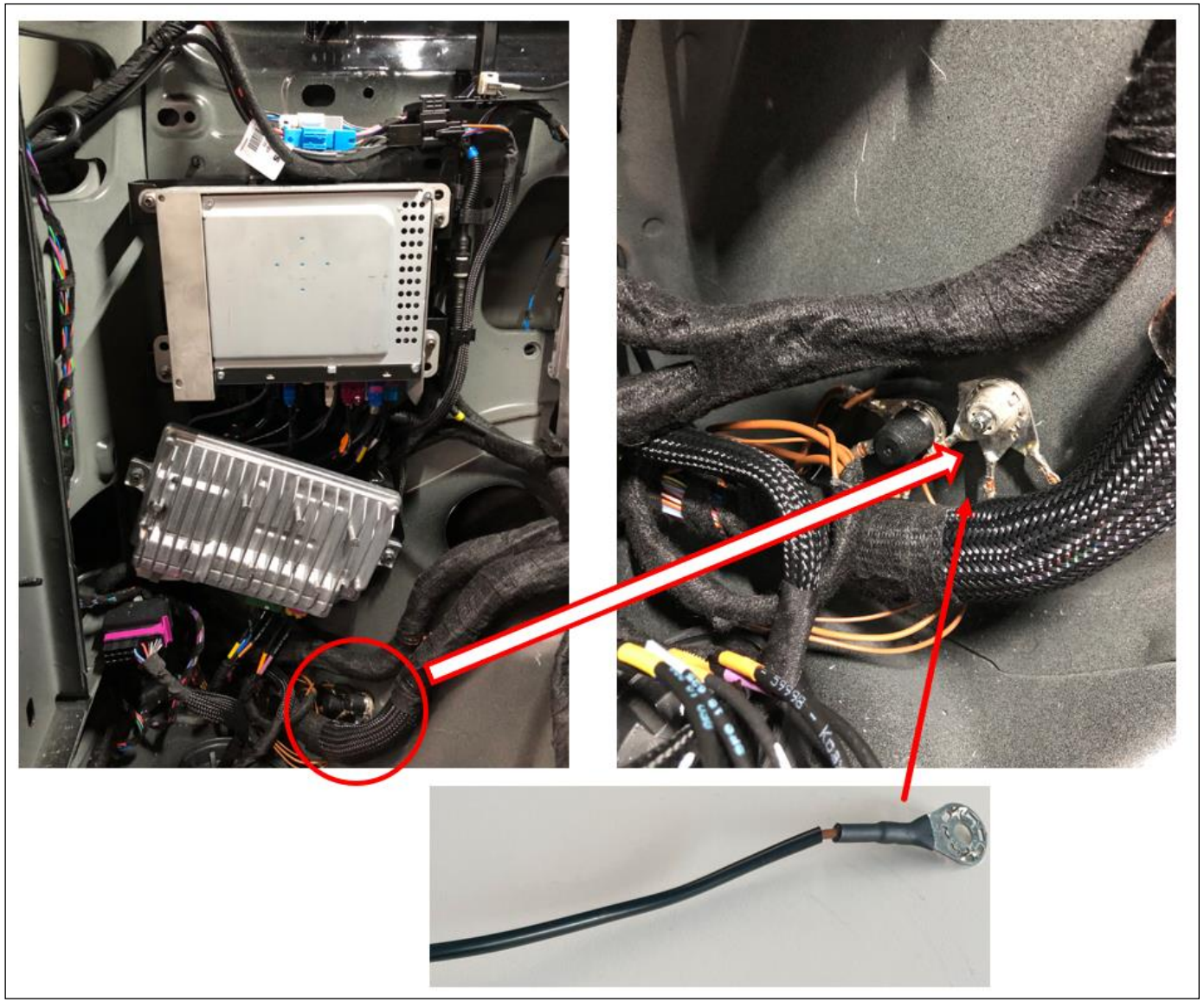
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- In connector B, remove the cable from pin 6 (red/white – voltage).
- Plug the stripped cable into the black connector and connect it to the port on the Brabus wiring harness.
- Plug the loose end of the BRABUS wiring harness into pin 6 of connector B on the Mercedes wiring harness.
- When connecting any cables, make sure the plug contacts are properly engaged.



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- Screw the ground ring terminal onto the ground connection point in the rear left corner of the trunk.

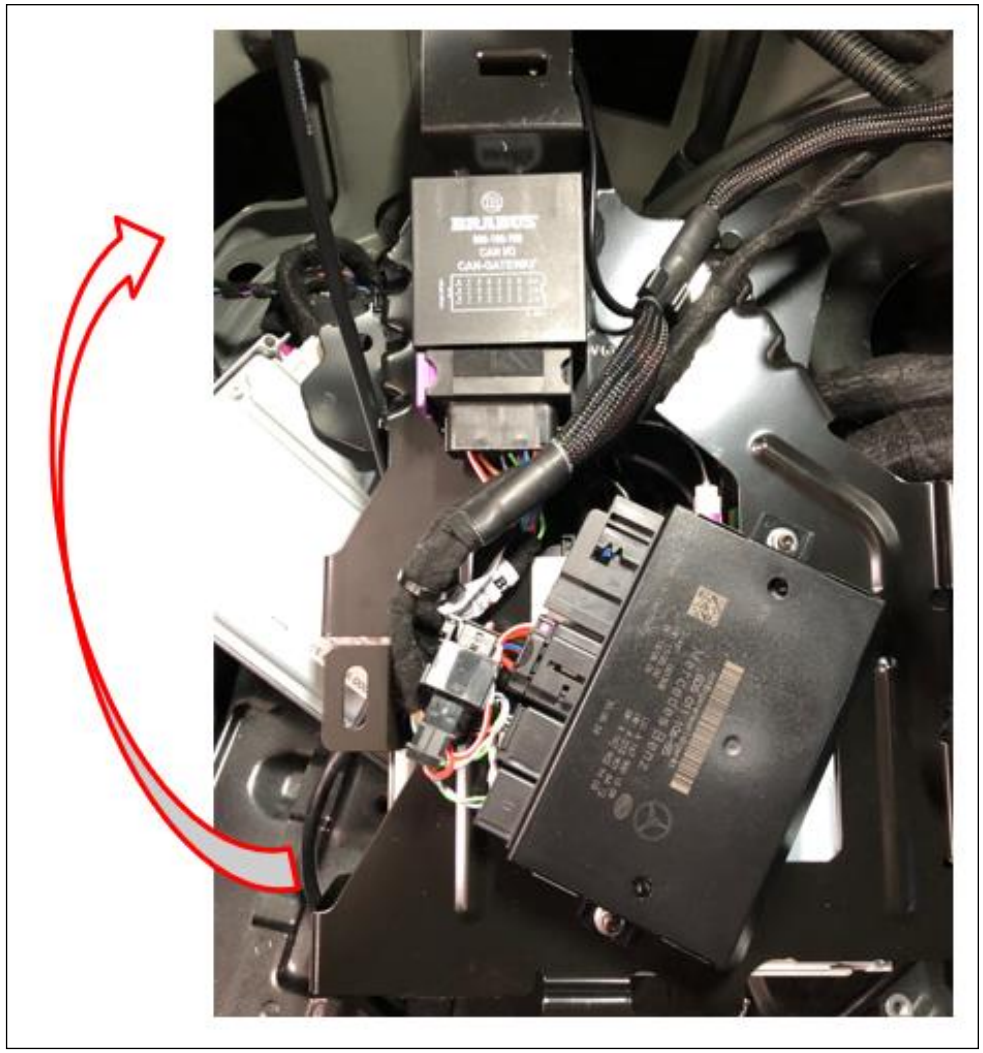


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- Connect the BRABUS wiring harness to the BRABUS control unit.

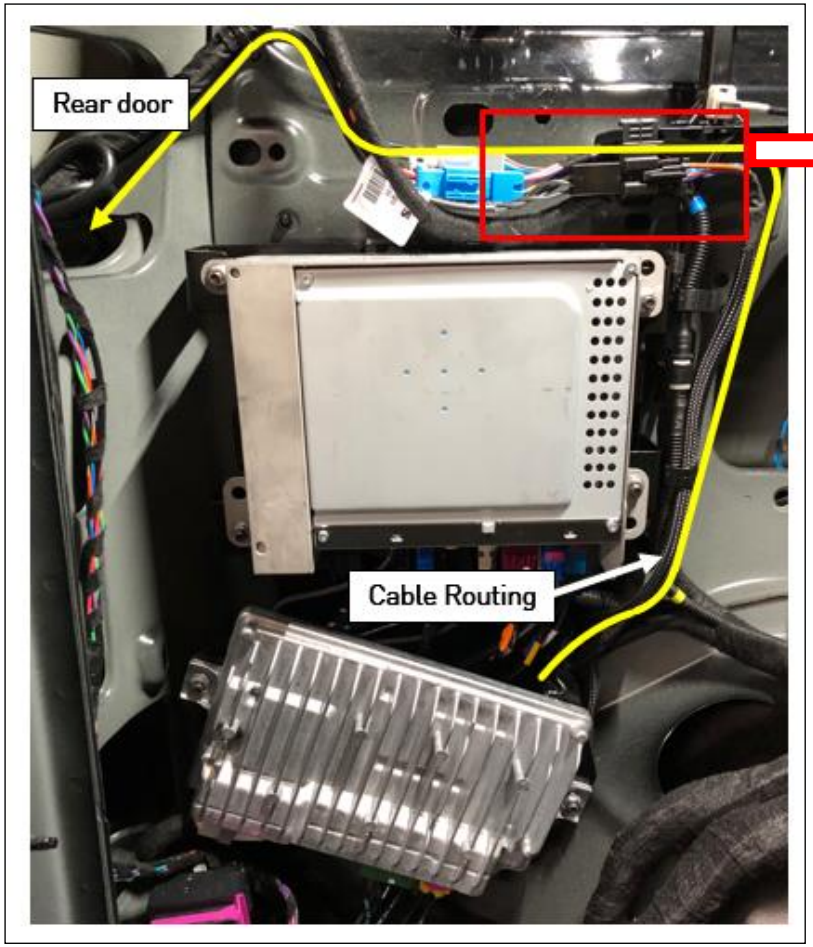
- Swing the mount back to its original position and reattach it to the vehicle.

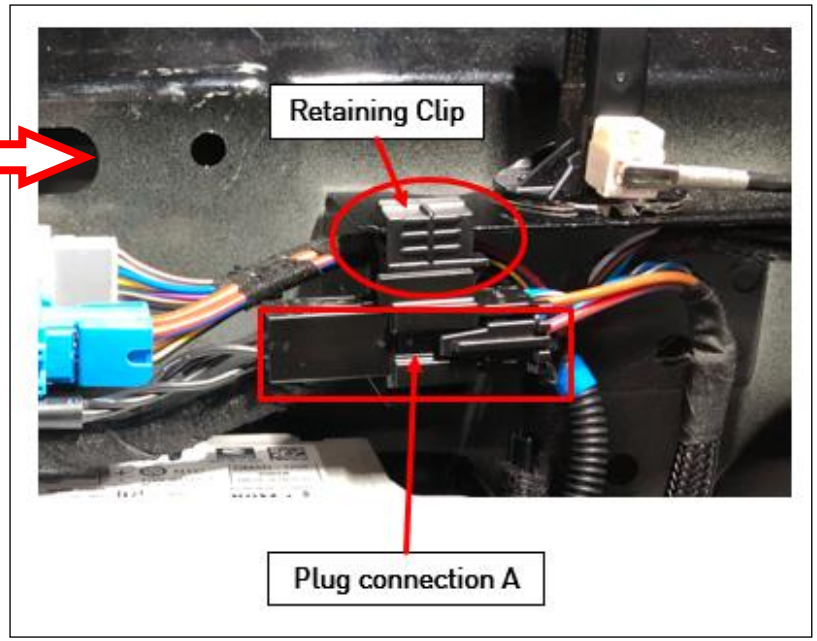
- Now screw the camera control unit onto the mount.



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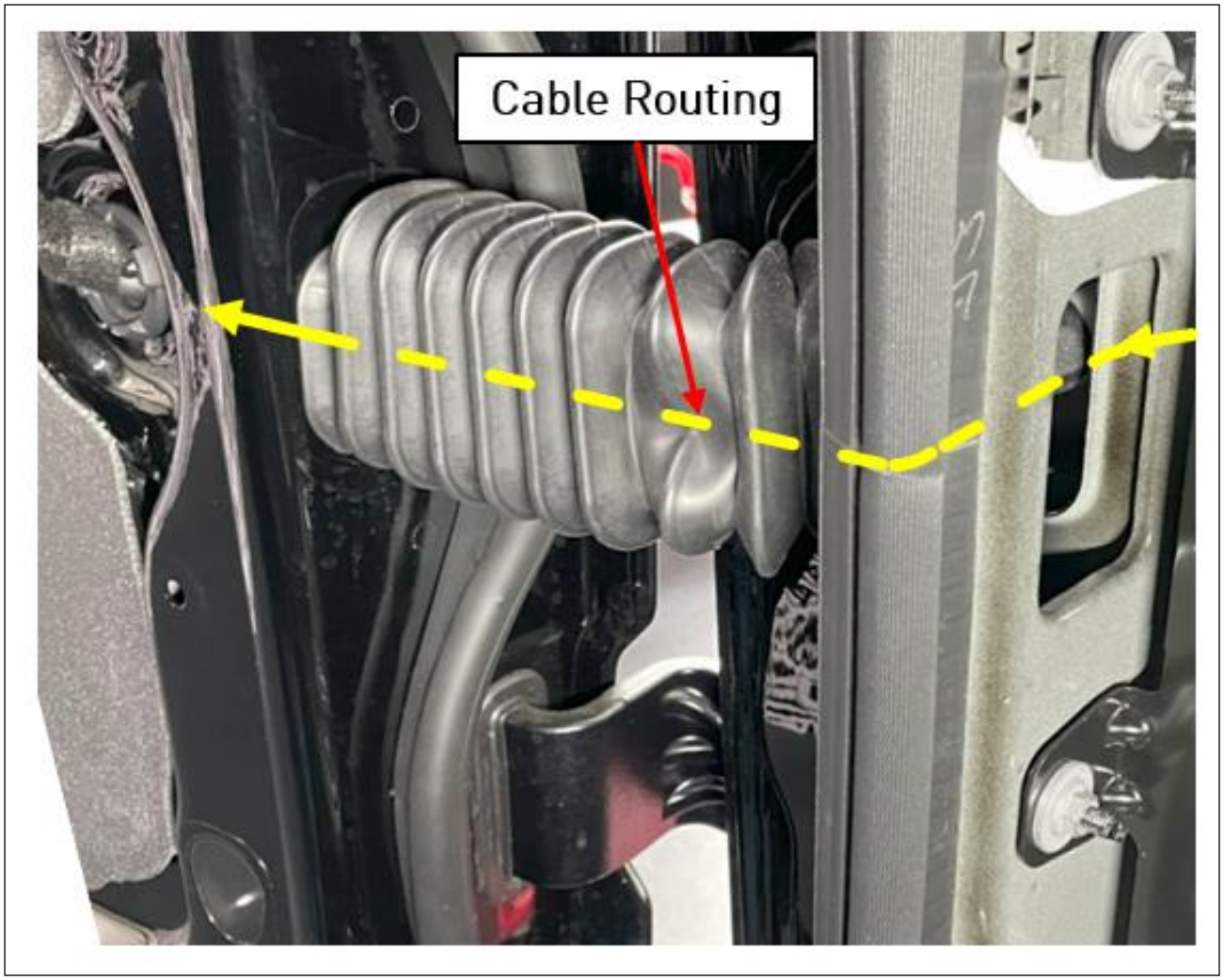
- Route the wiring harness as shown in the diagram and connect the control unit's wiring harness to the connector on the second cable (A).
- Secure the Brabus wiring harness in the position shown using cable ties, and use a retaining clip to hold it in place, making sure the wiring is laid without tension.





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- Route the wiring harness through the rubber grommet into the tailgate, following the diagrams.



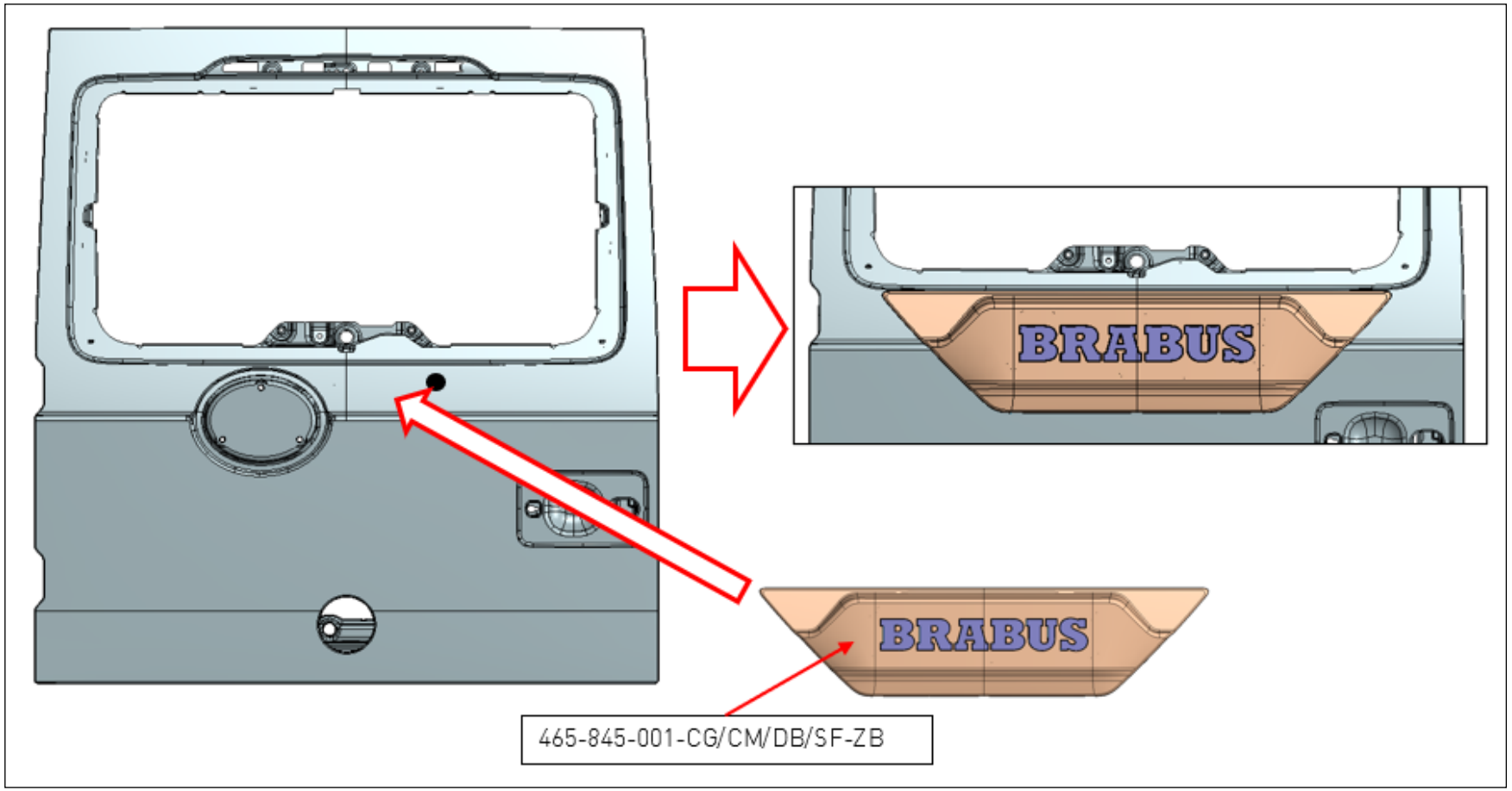
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Attention:

- Before attaching the rear door trim, perform a functional test of the light.

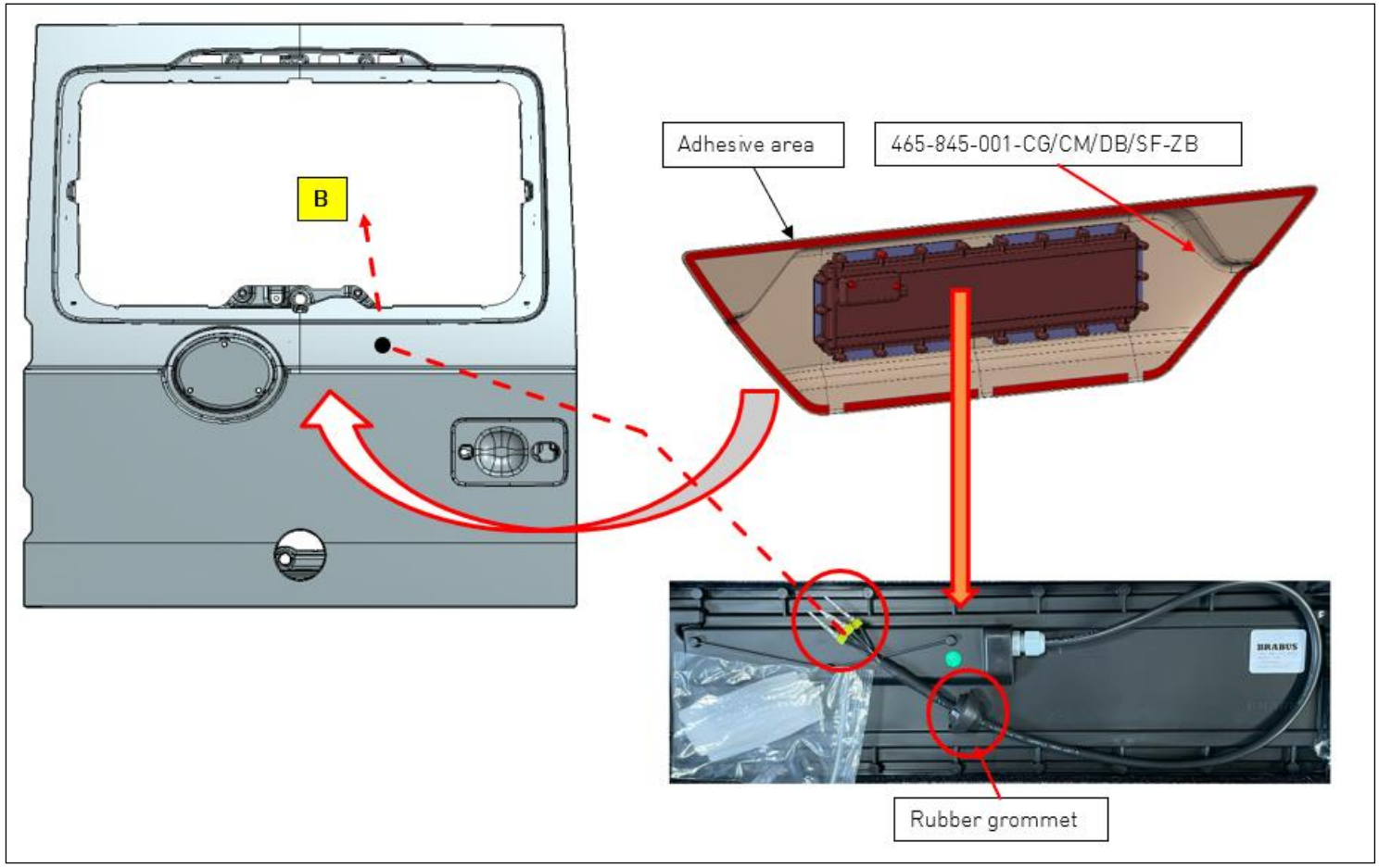
- Hold the BRABUS tailgate trim piece against the rear door and, after aligning it, mark its position on the rear door with a washable marker.

- Prepare the bonding surfaces of the rear door and the rear door attachment for bonding according to the bonding instructions.



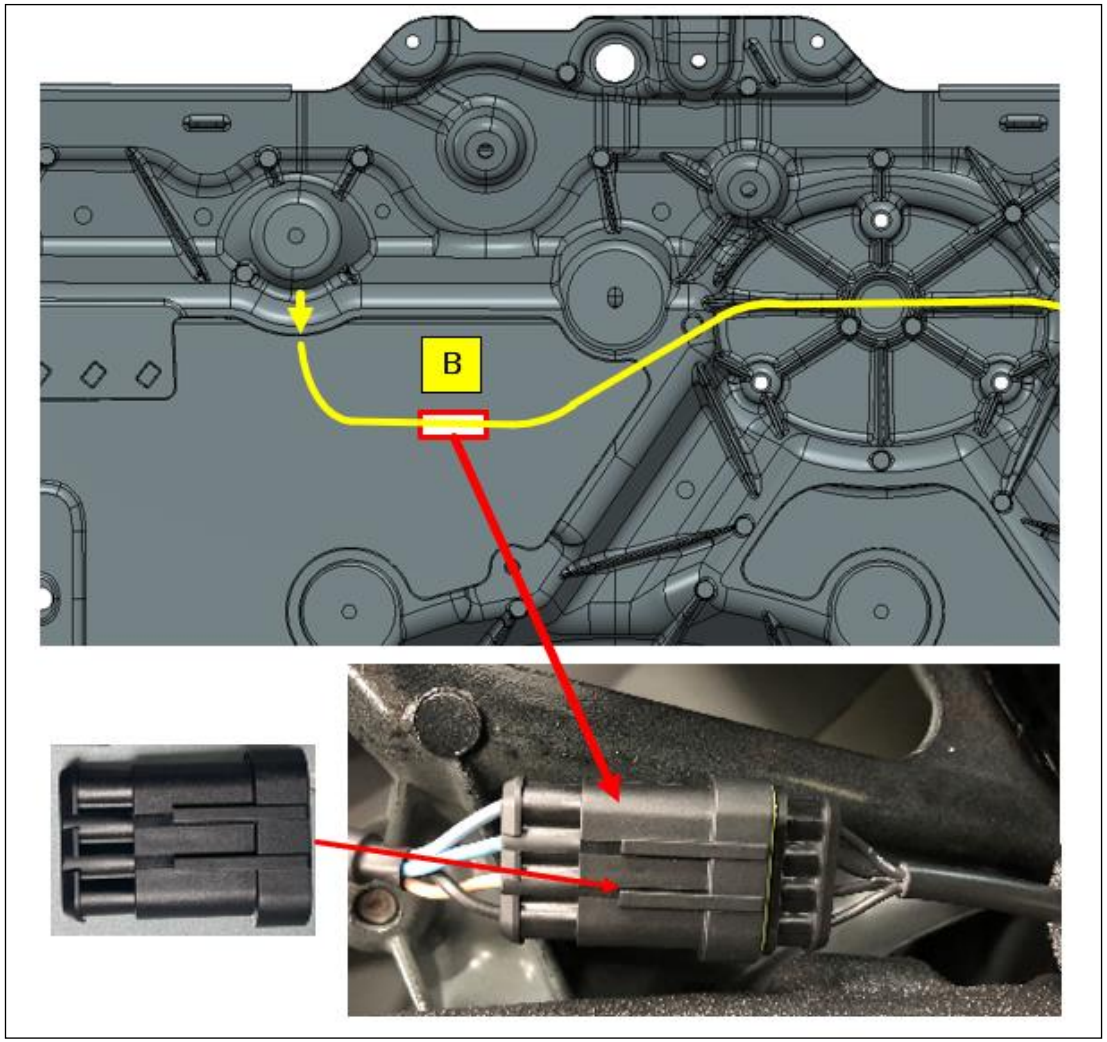
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- Thread the light's connection cable through the hole in the tailgate, making sure the rubber grommet fits securely in the tailgate.
- Apply even beads of adhesive to the adhesive surfaces of the rear door attachment.
- Glue the rear door attachment to the rear door and remove any excess adhesive immediately!
- Secure the component using appropriate means (clamping suction cups, adhesive tape) until the adhesive has fully cured.



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- Insert the 4 loose cable ends of the tailgate attachment, as marked 1–4, into the 4-pin connector housing.
- Connect the two cable assemblies (B) to each other, making sure they snap into place properly.
- Secure the Brabus wiring harness in a suitable location using cable ties, ensuring that the wiring is laid without tension.



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- Reconnect the ground wire to the vehicle battery.
- Reinstall all the trim parts that were removed and perform a functional test.



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Bohrschablone 465-845-000

