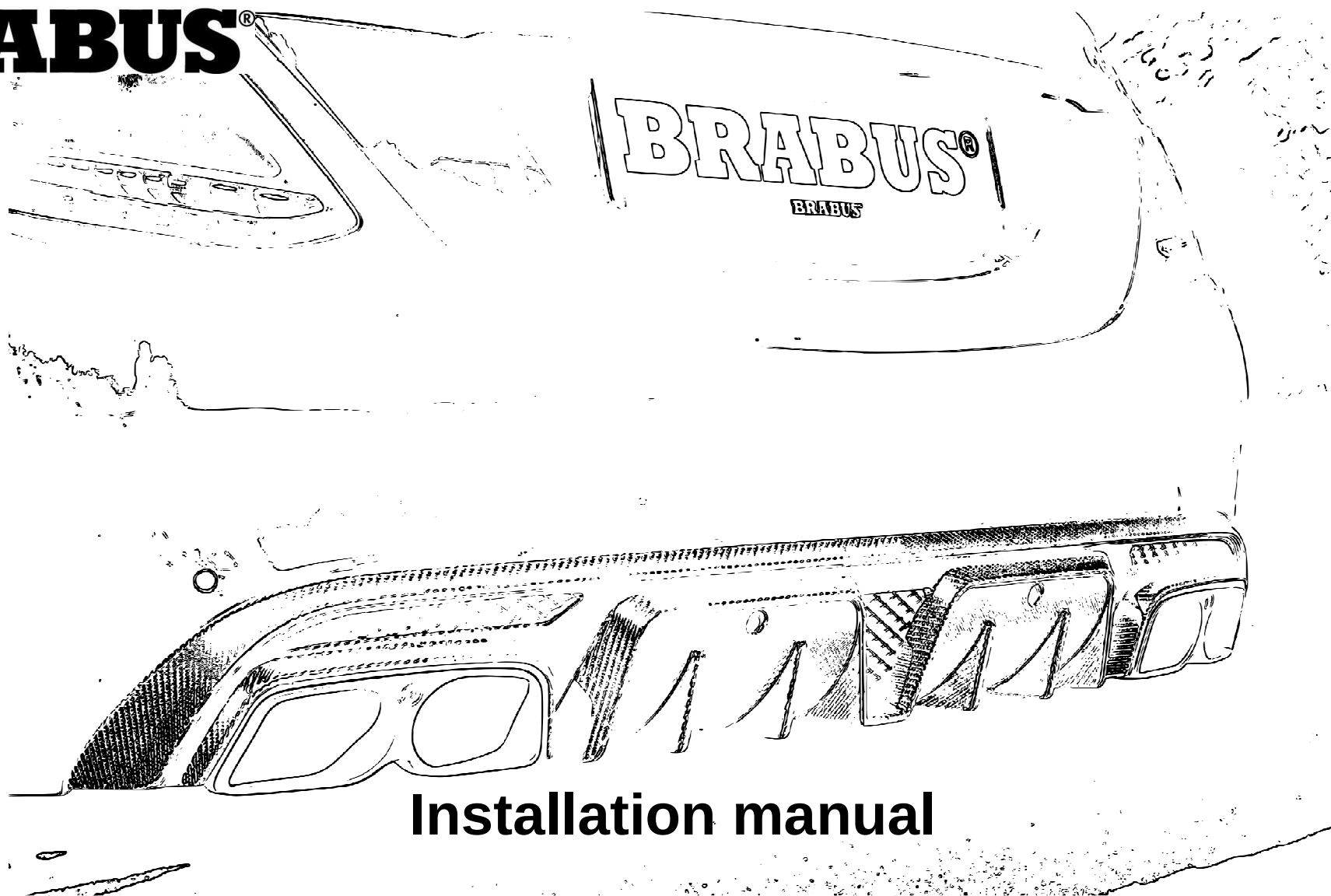




205-678-63 / 205-463-00_10
Valve controlled sports exhaust system and carbon-fibre rear diffuser for W/S 205 / C63 AMG

BRABUS®



Installation manual

Offizielle Technologie-Partner



Mitglied im VDN

English



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 supplied parts as detailed next page prior to assembly.

The Stainless steel valve controlled sports exhaust system only can be assembled in combination with the Brabus carbon-fibre rear diffusor (article-no. 25-463-00_10).



Included in delivery of Brabus valve controlled sports exhaust system:

1x	Satz of stainless steel rear silencer	205-678-63-ESD
1x	Rear pipe package for sedan and estate version	205-678-63-ARP-L oder 205-678-63-ARP-T
1x	Left tailpipe	166-678-63-ERLB
1x	Right tailpipe	166-678-63-ERRB
8x	Clamp	

Included in delivery of Brabus carbon-fibre rear diffuser:

1x	Carbon-fibre rear diffuser	205-463-01
1x	Clip	Q0007371V000000000
8x	Alloy rivet	914 048 100
1x	Left PDC-bracket	PTS-205-45
1x	Right PDC-bracket	PTS-205-46

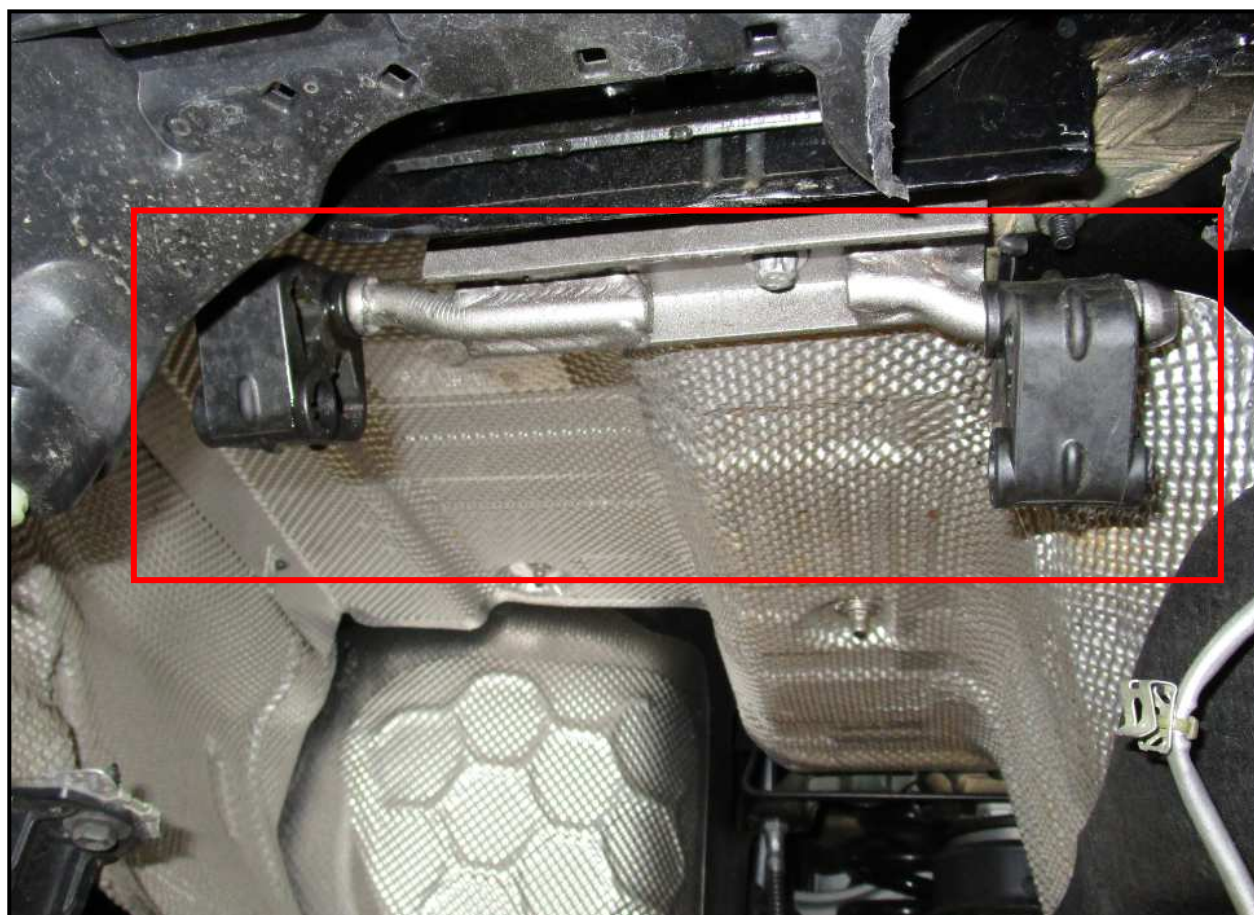
Preparation:

- Lift the car on a suitable platform at the Mercedes-Benz prescribed lifting positions with due regard to valid MB safety guidelines. Remove the trims within the boot compartment to get access to the electrical components shown (battery, control units, rear SAM).
- Remove the standard rear silencers, disconnect the plugs of the standard exhaust valves.
- Remove the rearbumper according to Mercedes-Benz workshop instructions.

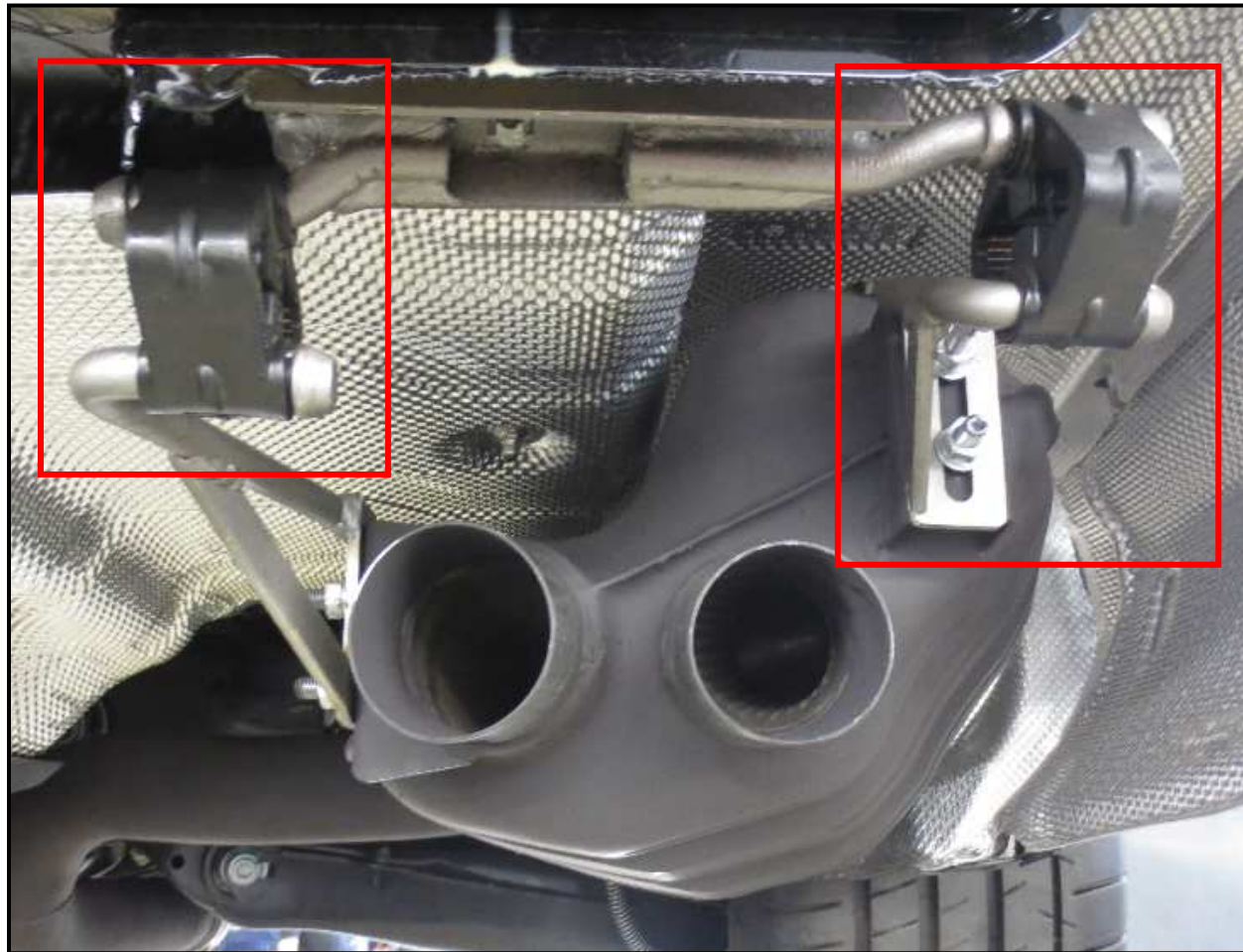
- Attach the brackets to the rear silencers according to images below.



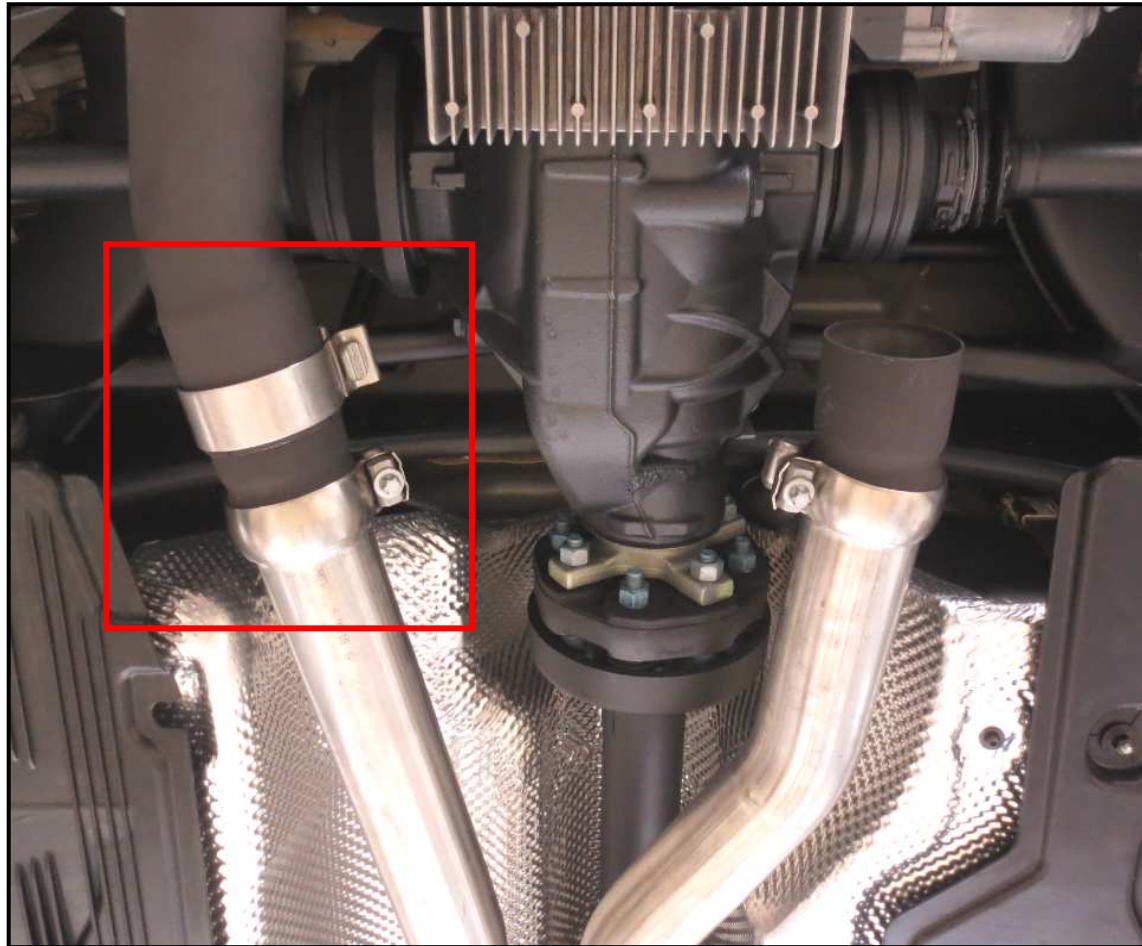
- Replace the rear silencer brackets at the vehicle underbody by using the brackets supplied, according to image below.



- Hang the Brabus rear silencers to the exhaust brackets by using the standard exhaust rubber supports.



- Connect the Brabus rear silencers to the standard exhaust system by using the adapters supplied. The big adapters supplied are not used. Align the rear silencers and pre-tighten the clamps. Make sure the silencers are assembled free of tension and with sufficient clearance.



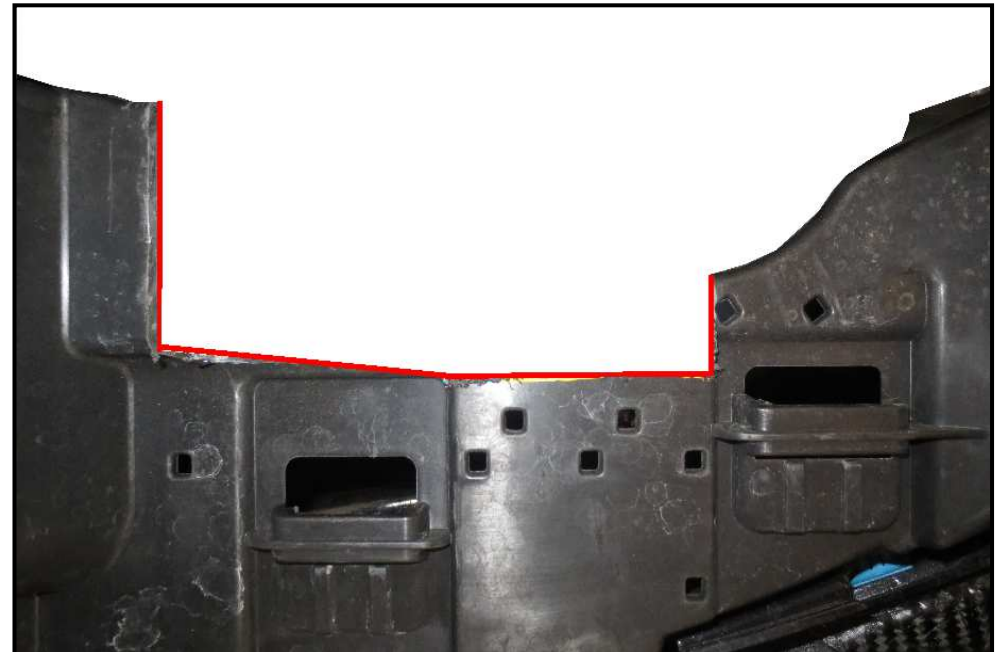
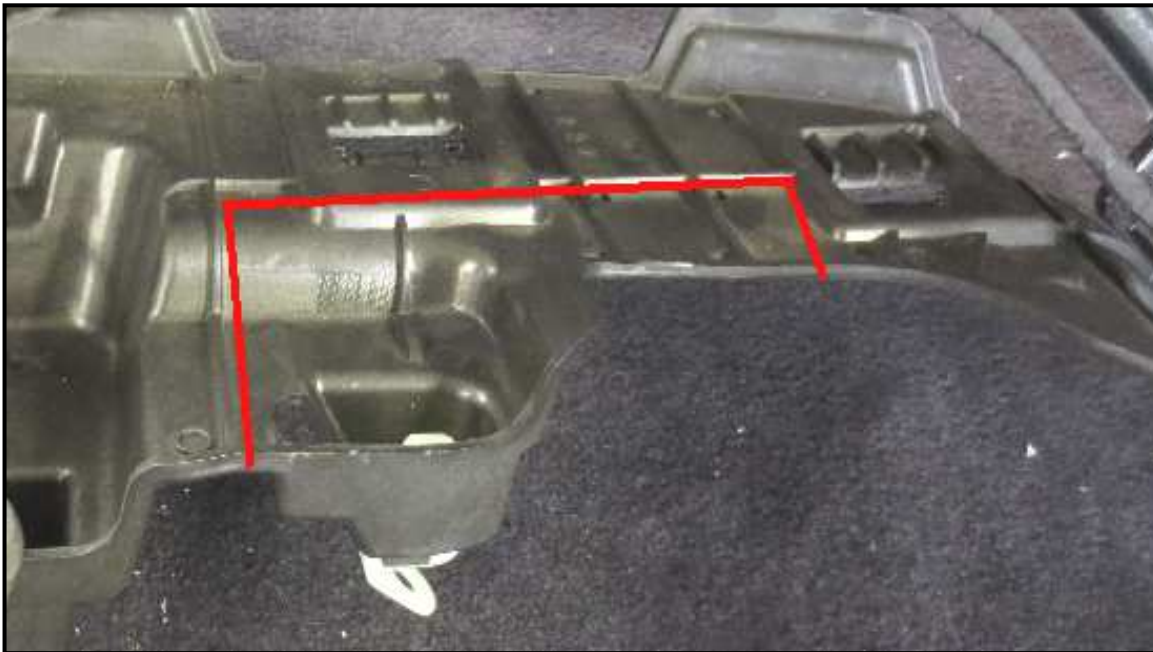
- Remove the standard exhaust bezels from the rearbumper.



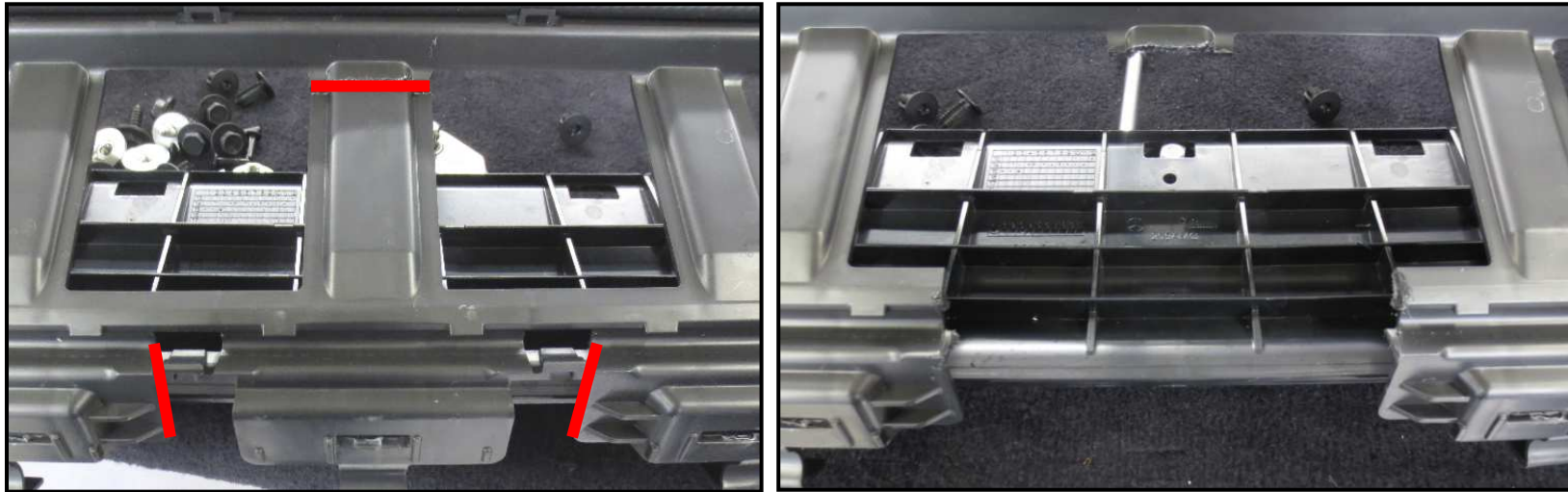
- Remove the standard rearbumper attachment, therefor drill the rivets (connections to the inlays). Remove the center inlay part.



- Cut the red marked areas out of the outer inlay parts using a suitable tool.



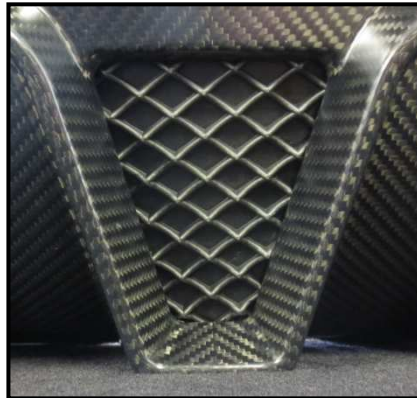
- Cut the red marked area out of the center inlay part using a suitable tool.



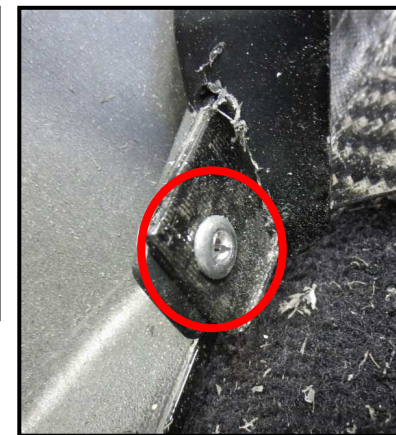
- Bond the PDC brackets supplied to the carbon-fibre rear diffusor using PU adhesive supplied. Attach the PDC sensors to the PDC brackets.



- Bond the plastic trim grilles to the carbon-fibre rear diffusor using PU adhesive supplied.



- Attach the carbon-fibre rear diffuser to the apertures of the rearbumper. Align it and fixate it using clips supplied. If necessary, shorten the lugs of the rear diffuser using a suitable tool. Enlarge the outer apertures using a suitable tool, if necessary and fixate the rear diffuser at the outer areas using alloy rivets supplied.



- Attach the center plastic inlay to the rearbumper and connect it to the outer plastic inlays using alloy rivets supplied.



- Fixate the rearbumper wiring harness to the plastic inlays.

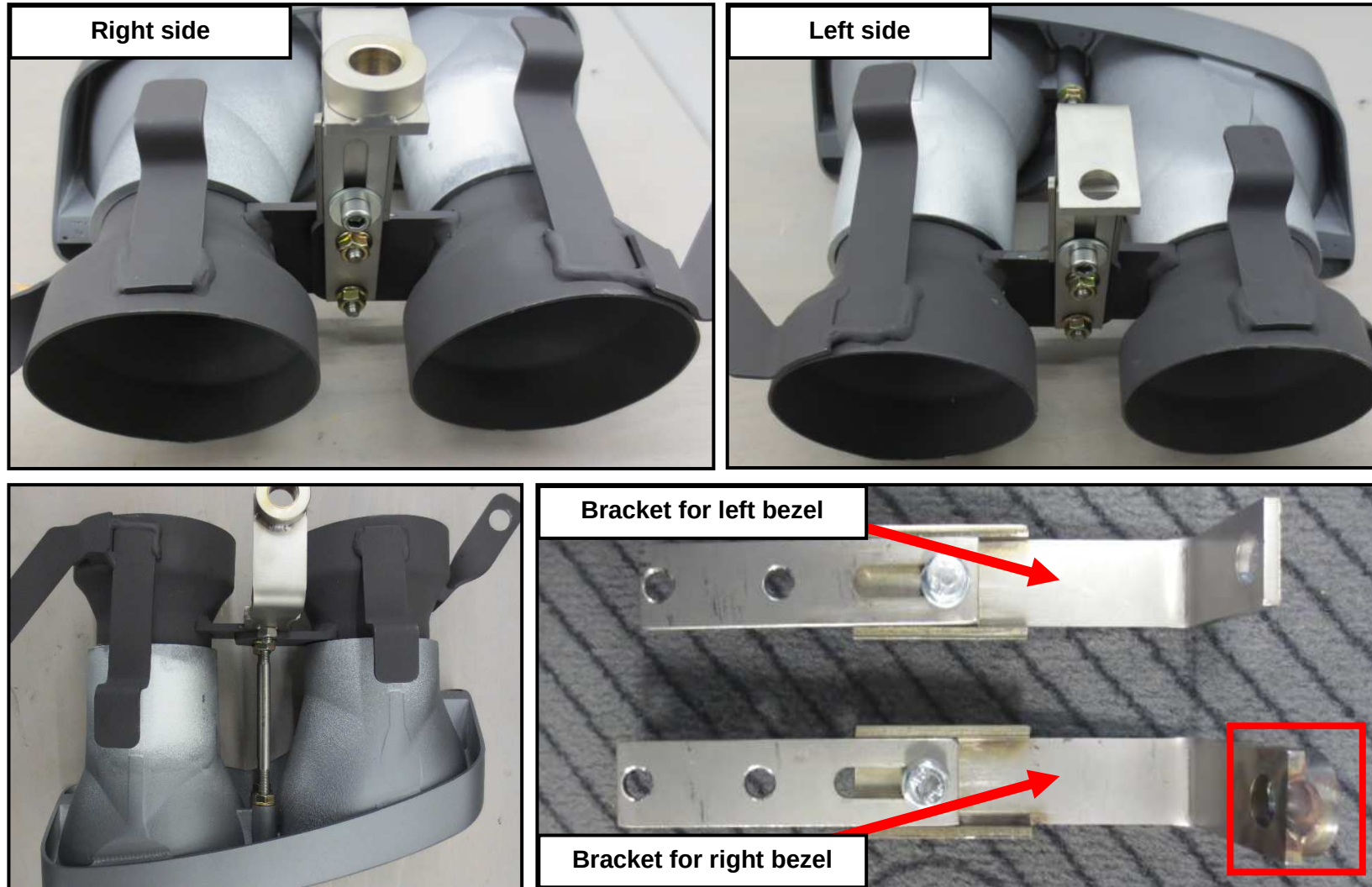
- Connect the rearbumper wiring harness and re-attach the completed rearbumper.
- Drill holes into the carbon-fibre rear diffusor for connection to the inner and outer plastic inlays and connect the parts by using alloy rivets supplied.



- Disassemble the tow hook cover according to images below, attach the upper part to the rearbumper.



- Assemble the Brabus exhaust bezels according to images below. These are connected to the funnels by using threaded rods and lock nuts supplied. Also attach the adjustable tailpipe brackets to the exhaust bezels.



- Attach the completed exhaust bezels to the notches of the outer plastic inlays of the rearbumper. Image below shows the single funnels, just as illustration how the complete bezels are to be assembled. Align the exhaust bezels and fixate them to the outer fixation points using the standard assembly material.

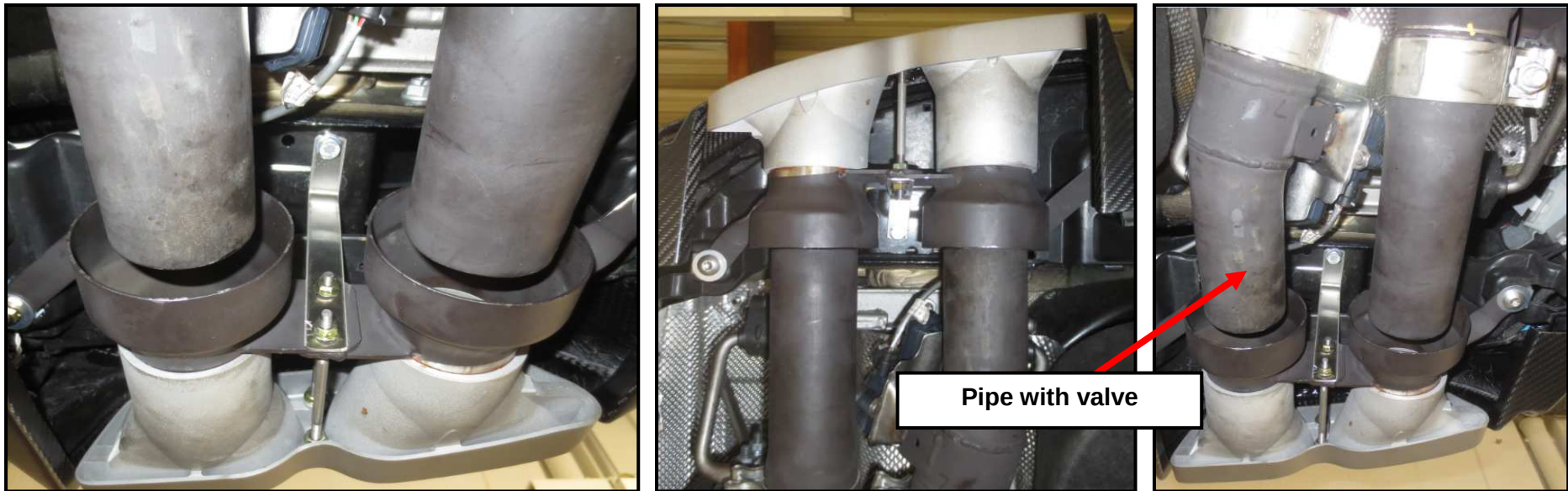


- Mark the position for the upper fixation hole to the rear cross bar using a suitable marker (at position pointed by red arrow). The bracket shown is just an illustration, the brackets supplied are of a different type.
- Loosen and remove the exhaust bezels.
- Drill 13.2mm holes into the rear cross bar at the marked positions using a suitable drill.
- Seal the bores and attach the threaded bushings to the holes of the rear cross bar.

- Assemble the bezels to the brackets and tighten the bolts. Take care for proper alignment and for sufficient fixation of the upper bolt.



- Bolt the connection pipes to the rear silencers according to images below.
- Align the connection pipes so that these are centered within the funnels of the exhaust bezels. Take care for sufficient clearance of the exhaust valves.



- Finally tighten all bolt connections.
- Connect the standard plugs to the exhaust valves of the Brabus exhaust system.
- Perform a test-drive and check the function of the exhaust valves.
- Re-check the alignment of the exhaust system after the test-drive, re-align, if necessary.