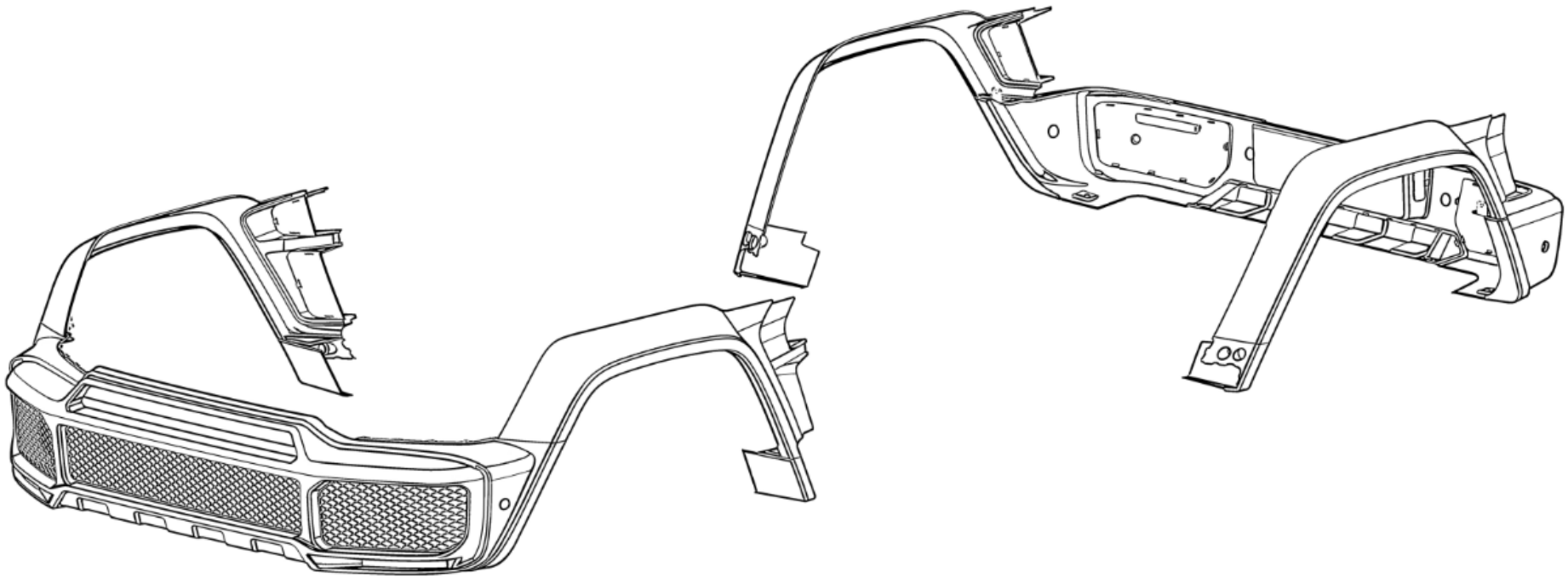
BRABUS Widestar for W463A-G63-AMG, model year 2019
Item number 464-234-00



Assembly instructions

Product video online: https://www.youtube.com/watch?v=vLKOAdU3YOI
www.brabus.com

General information

The product described in these instructions was developed, produced and subjected to extensive quality controls in compliance with the necessary safety requirements. To ensure proper and safe functioning and rule out danger for persons and objects, this product must be installed appropriately and according to the explanations on the following pages. The components should only be installed by trained, qualified staff having the necessary expertise and technical experience in the field of motor vehicles as well as the required tools. Furthermore, the specialist workshop carrying out the installation work should have access to the Mercedes-Benz Workshop Information System (**WIS**).

Read the assembly instructions carefully and install the components in the specified order.
Before starting the installation, check the components included in the scope of delivery for completeness according to the BRABUS parts catalogue. Disassemble/assemble standard components according to the Mercedes-Benz Workshop Information System.
The assembly time for the BRABUS Widestar body kit is about 20 hours (without adhesive curing times). Pay attention to cleanliness during the assembly and observe the bonding instructions on pages 4 & 5.

Painting instructions

The following components must be painted <u>prior</u> to their installation and should be available in an already painted condition at the beginning of the installation:

- Front and rear shells of the fender attachments (car colour)
- Front and rear running board caps (car colour)
- Design elements of the fender attachments, front and rear (contrasting colour)
- PDC brackets visible to the outside or their inlays visible from the outside (car colour)
- Front bumper (car colour) and upper inner radiator housing (suggested paint for radiator housing: black, matt finish)
- Rear bumper (car colour) and inlays around reflectors, left and right (contrasting colour)
- Design underride guard elements, front and rear (contrasting colour)
- PTS sensors for grille, rear bumper 2x (suggested paint for PTS sensors in case of unpainted grilles: black, matt finish)

As contrasting colour, BRABUS recommends *Glasurit MFA12.00*.
Use the outer packaging of the Widestar aerodynamic components for the safe transport of the components to the paint shop and return transport of the painted parts.

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- Assembly of the Widestar front bumper	64 - 81

Annex:

Paint documentation forms to be handed over to the paint shop.

Wet bonding instructions



Important

- Pretreatment -

The adhesive surfaces must be clean, dry and free of grease.
To achieve optimum adhesion, it is necessary to mechanically roughen the surface using **240**-grit sandpaper or to use a primer/adhesion promoter.

After roughening, the adhesive surfaces must be cleaned with silicone remover in two stages to remove any grease and release agent residues.
The cleaning cloth should be changed after each process.
To fix the bonded components in place until the adhesive has cured, we recommend using suction clamps (e.g. Würth, item number 069155210).

Technical data concerning the delivered adhesive **Teroson MS 937**:

Component A, density, white, grey, black, approx. 1.5 g/cm^3:
Skin formation time, min*: approx. 5 to 15
Curing speed, mm/24 hrs: approx. 4
Shore hardness A (ISO 868, durometer A): approx. 50
Tensile strength (acc. to ISO 37), MPa: 3.0
Elongation at break (acc. to. ISO 37, speed 200 mm/min), %: approx. 220
Stress at 100% strain (acc. to ISO 37), MPa: approx. 2.0
Change in volume (acc. to DIN 52451), %: <2
Processing temperature, °C: 5 to 40
Service temperature, °C: -40 to +100
Short-term (up to 1 hr), °C: 120
* ISO 291 standard atmosphere: 23 °C, 50% relative humidity



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!

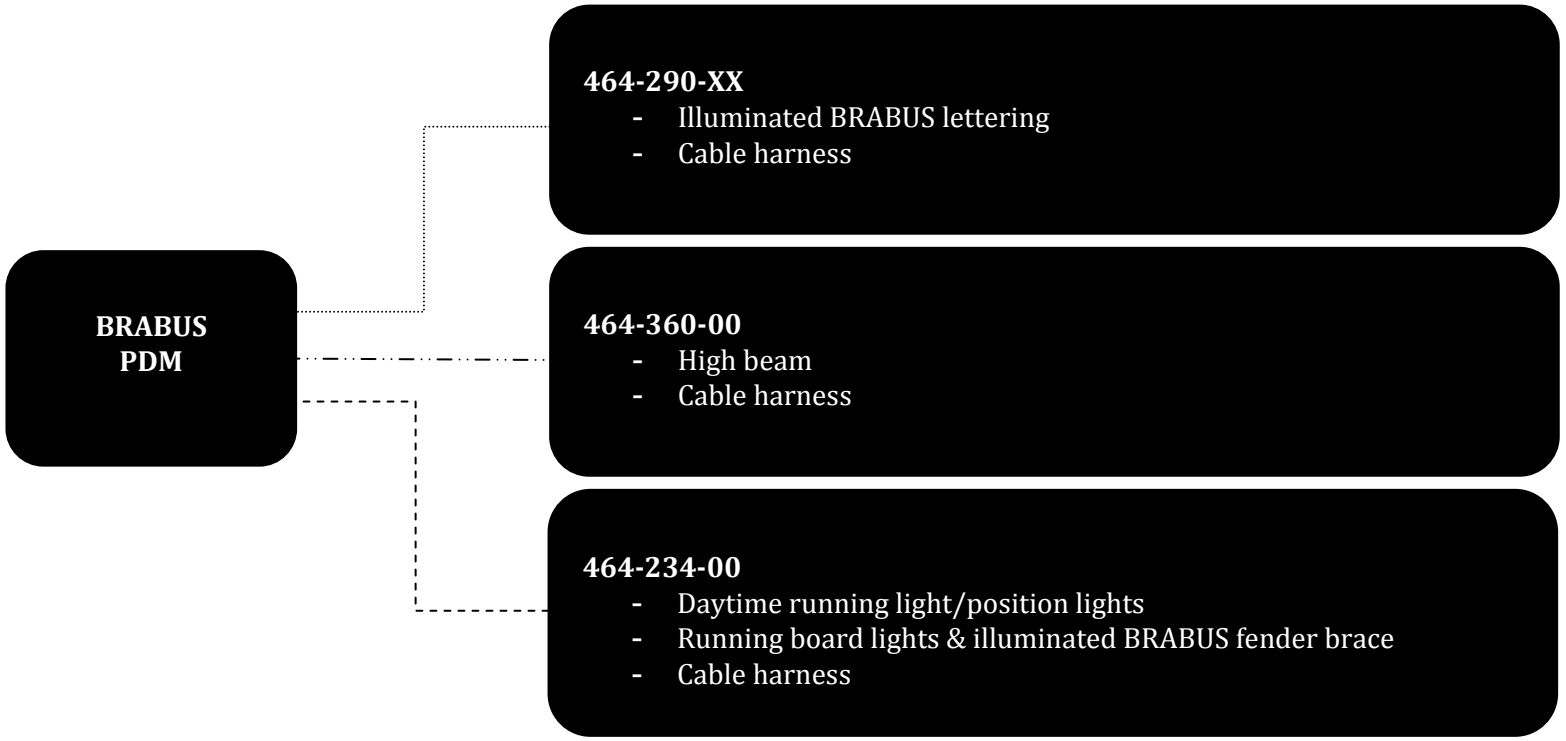
- Workpieces to be bonded should be pressed on over the entire surface after they have been bonded.

- The final adhesive force of the VHB adhesive tape is only achieved after 72 hours (at a room temperature of approx. 20 °C).

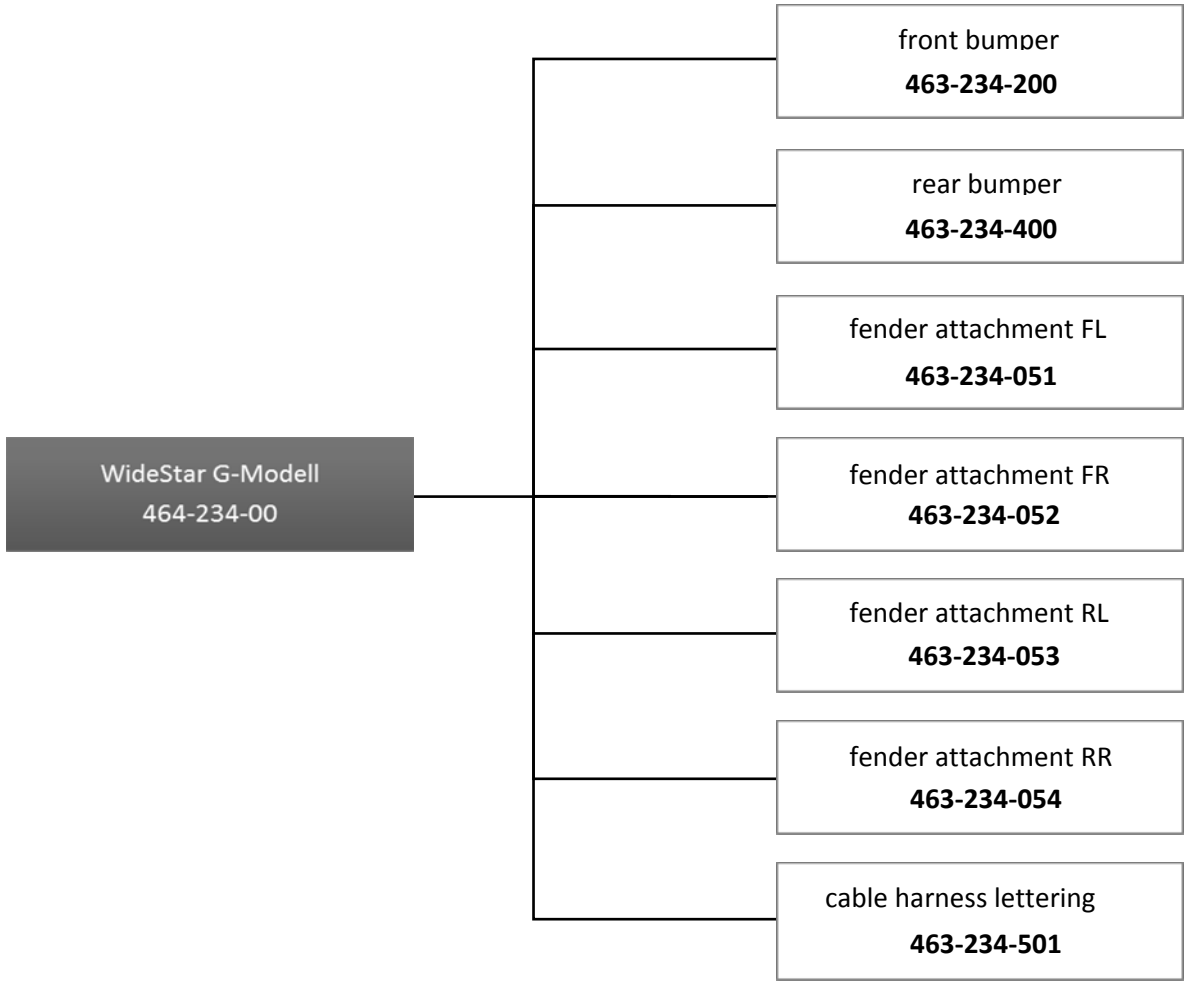
Heat has an accelerating effect on reaching the final adhesive force.

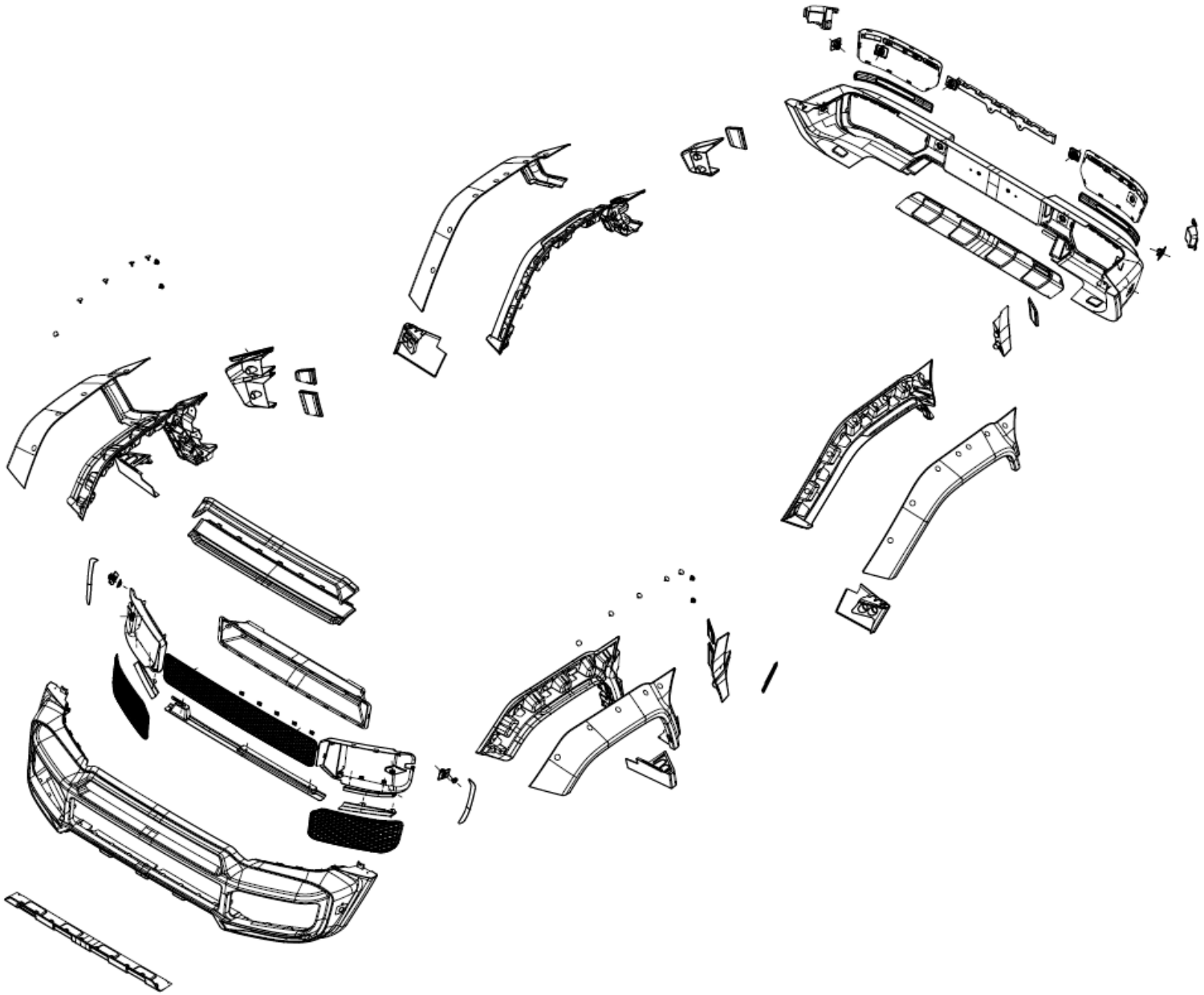
First, the Brabus PDM is to be installed and the further electrical connections to be carried out, then the Widestar body kit is assembled.

The lateral BB logos and the daytime running/position lights are supplied with voltage via the **BRABUS PDM** (**464-PDM-00**).
The connection cables of the electrical components for the front bumper attachment are simply connected to the corresponding output of the **PDM**.
When installing the **BRABUS PDM**, observe the corresponding installation instructions.
Attention: The BRABUS PDM is required 1x per vehicle.



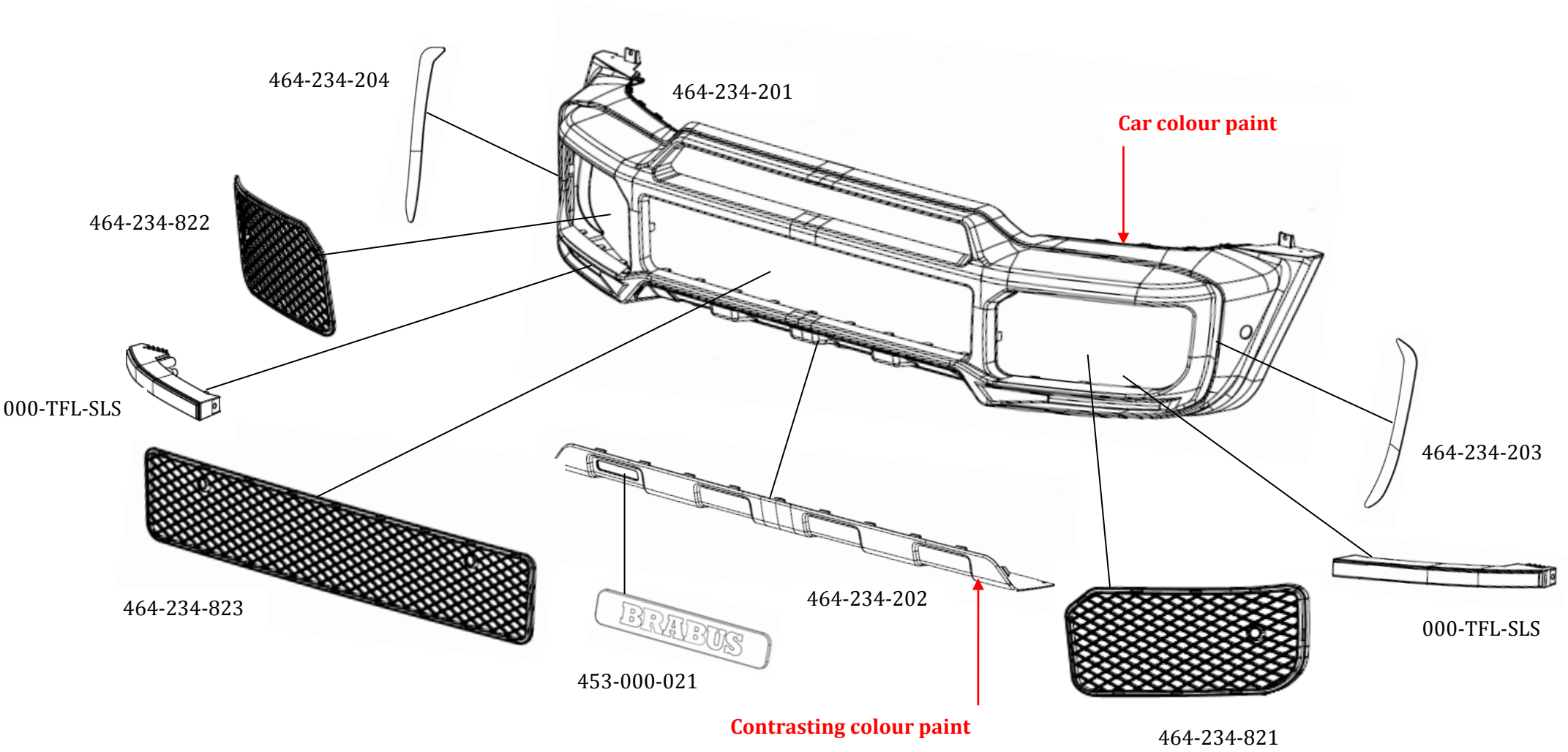
Presentation of the BRABUS Widestar scopes of delivery





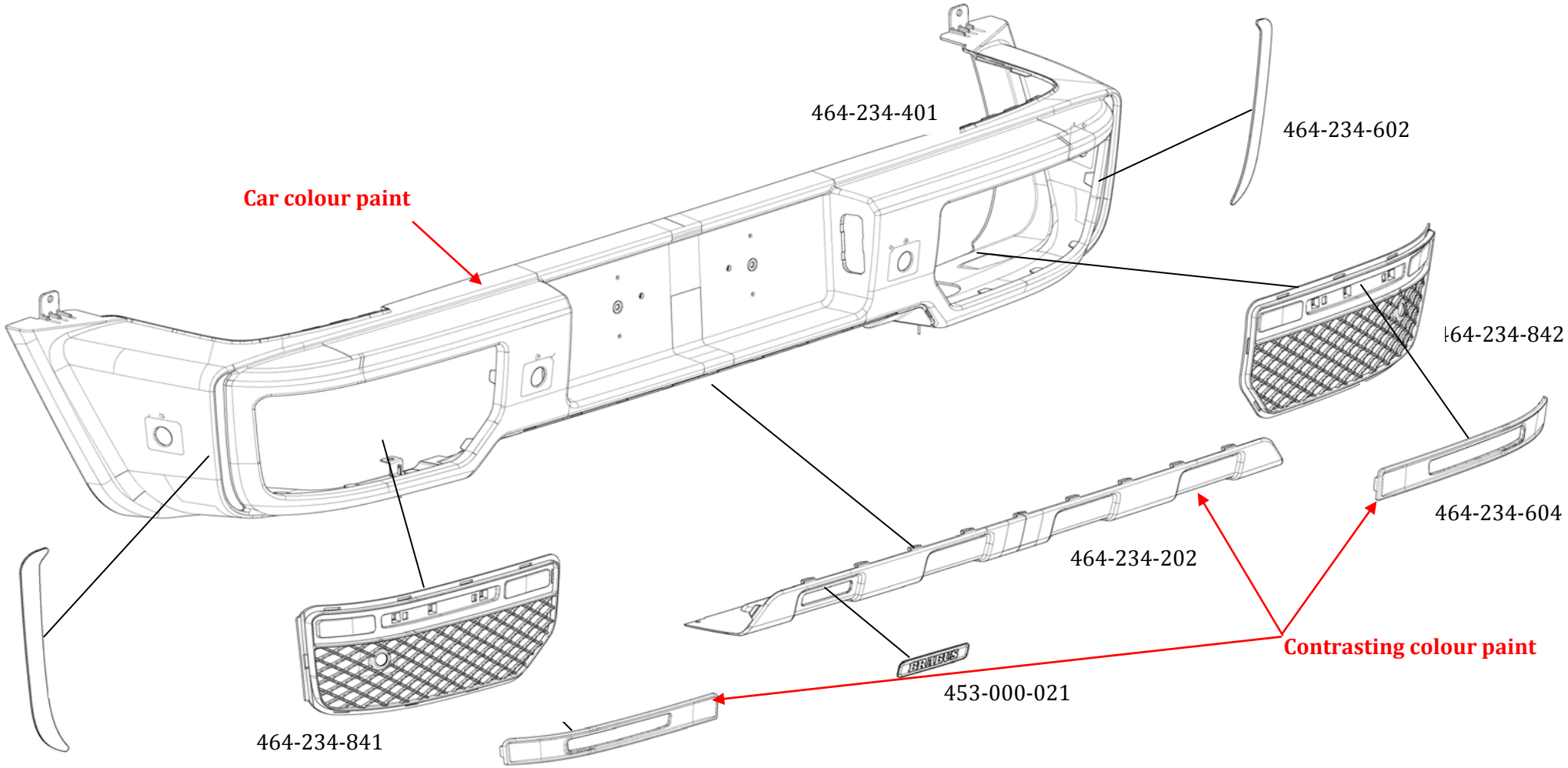
464-234-20 Widestar front bumper and external components

- Front bumper made of polyurethane with design grilles, LED position lights and implied underride guard made of ABS.



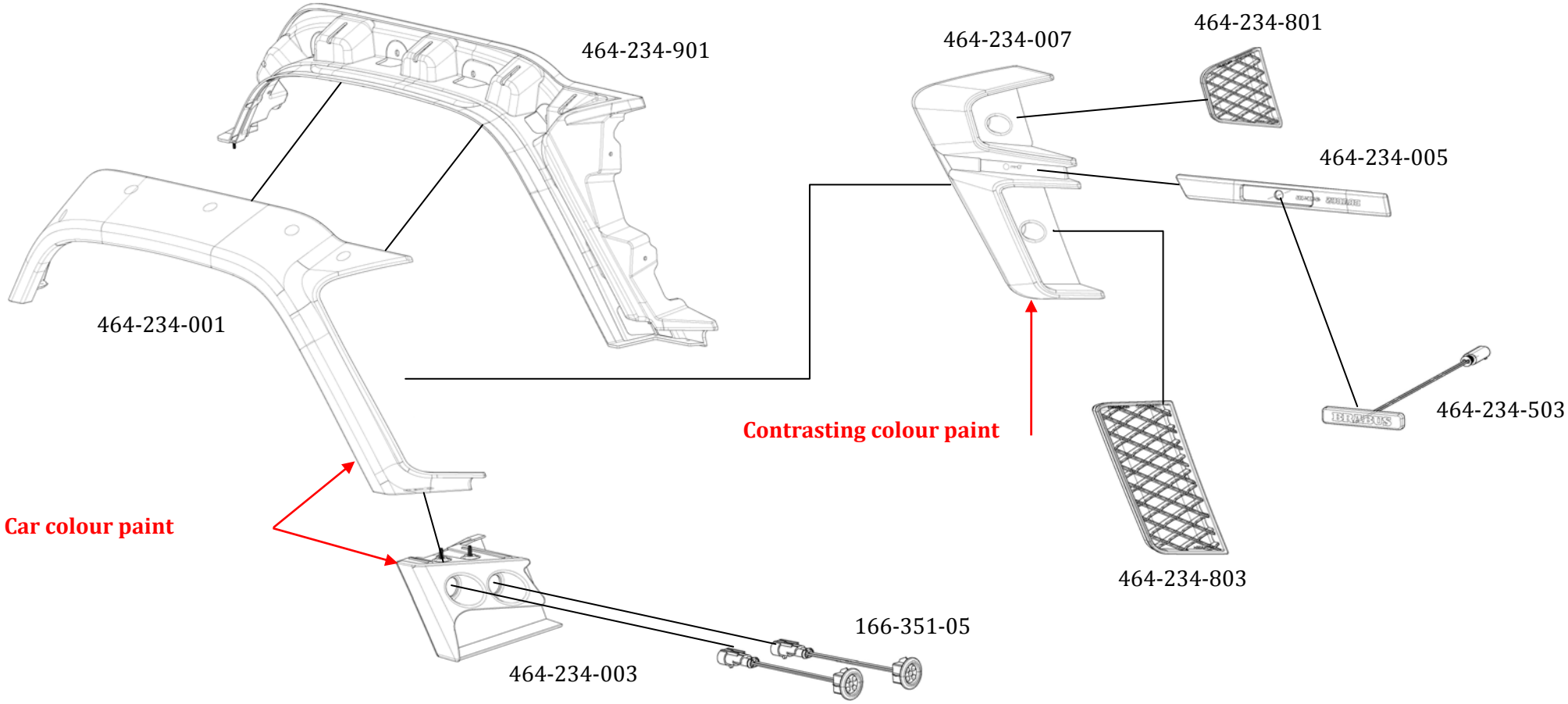
464-234-40 Widestar rear bumper and external components

- Rear bumper made of polyurethane with design grilles,
  trims to support the standard reflectors and implied underride guard made of ABS.



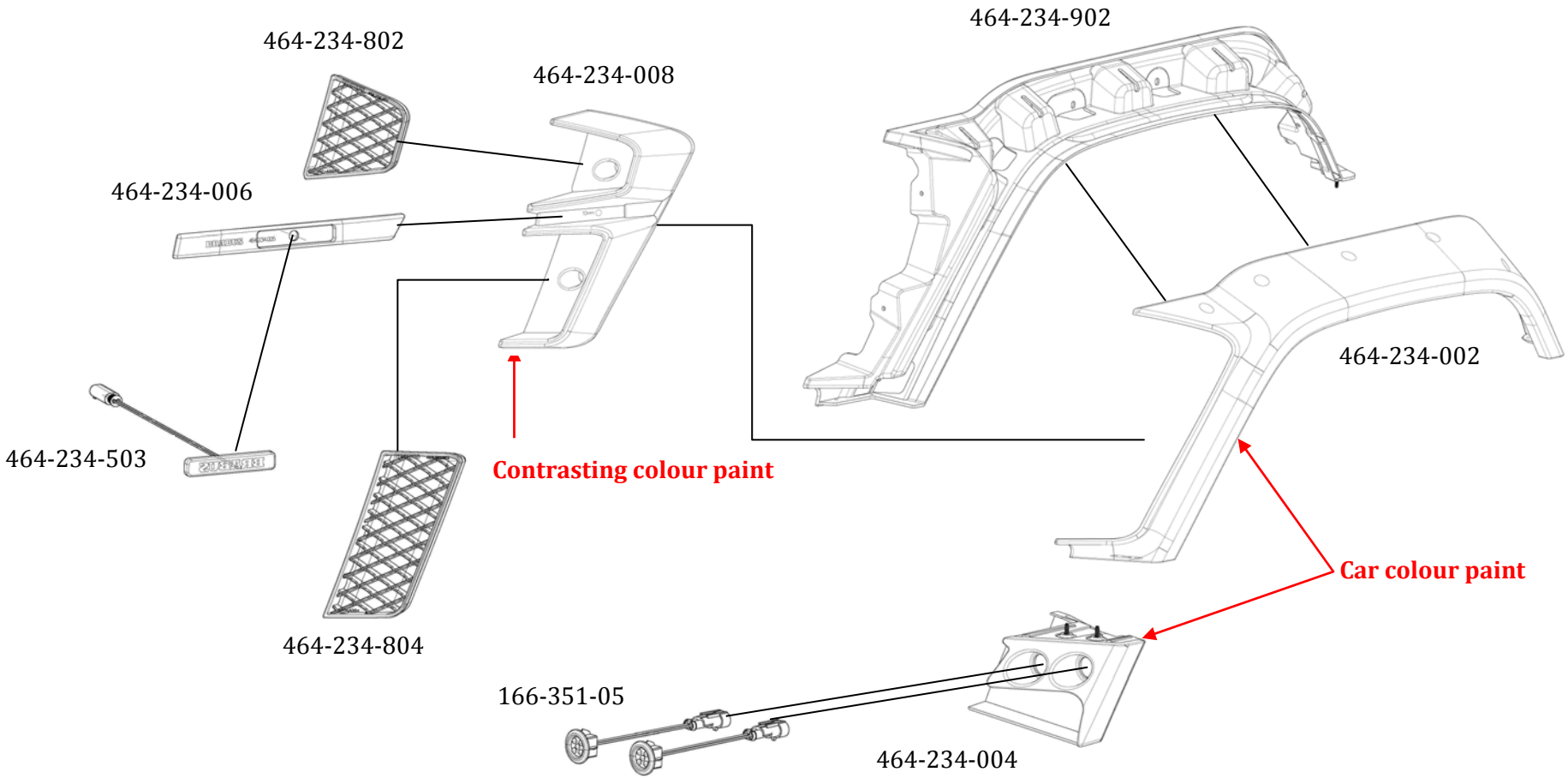
464-234-51 Front left fender attachment and components

- Fender attachment made of polyurethane, including design frames, grilles and design brace.
- Running board end cap made of polyurethane with LED running board light.



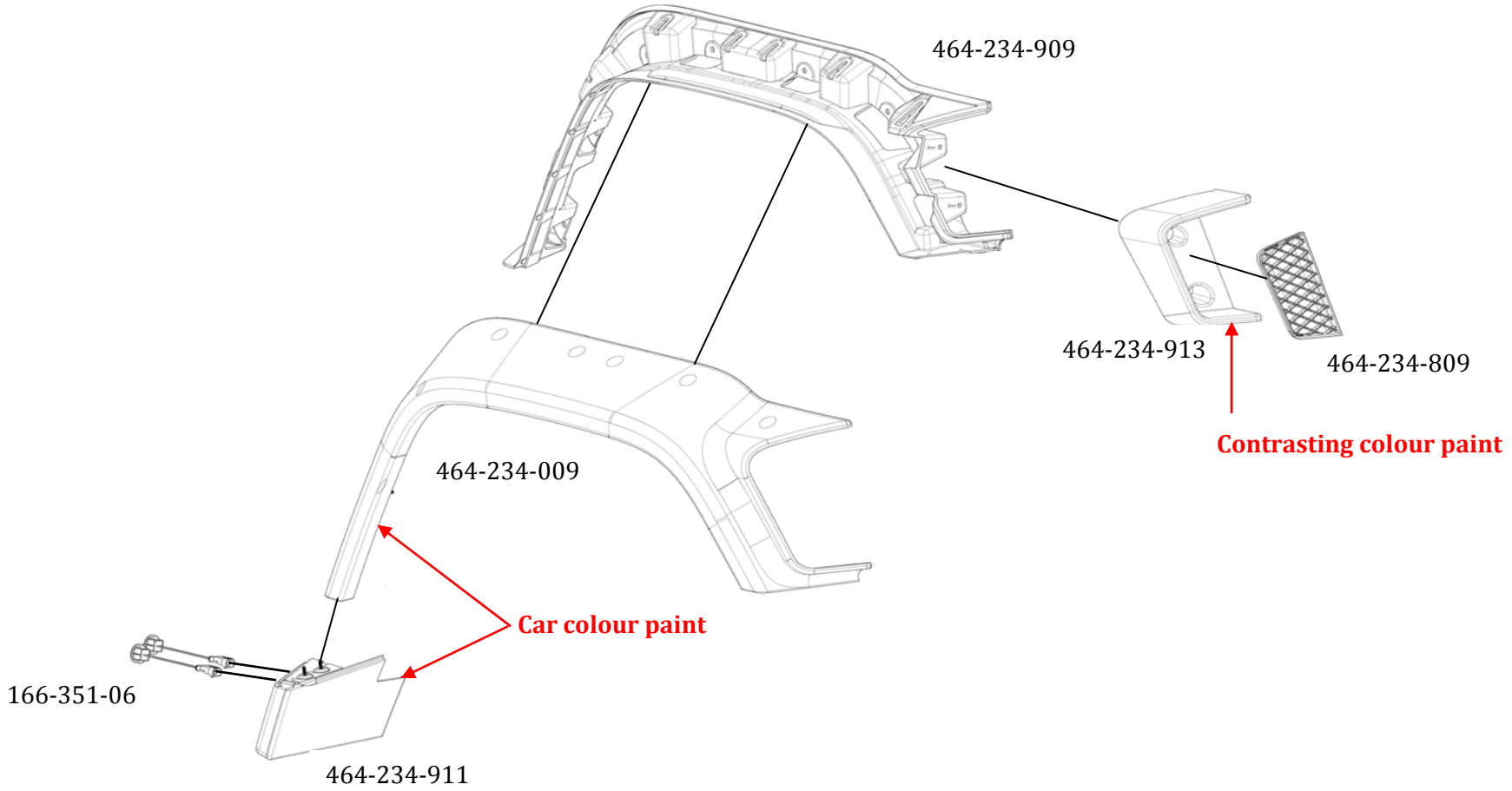
464-234-52 Front right fender attachment and components

- Fender attachment made of polyurethane, including design frame with grilles and design brace.
- Running board end cap made of polyurethane with LED running board light.



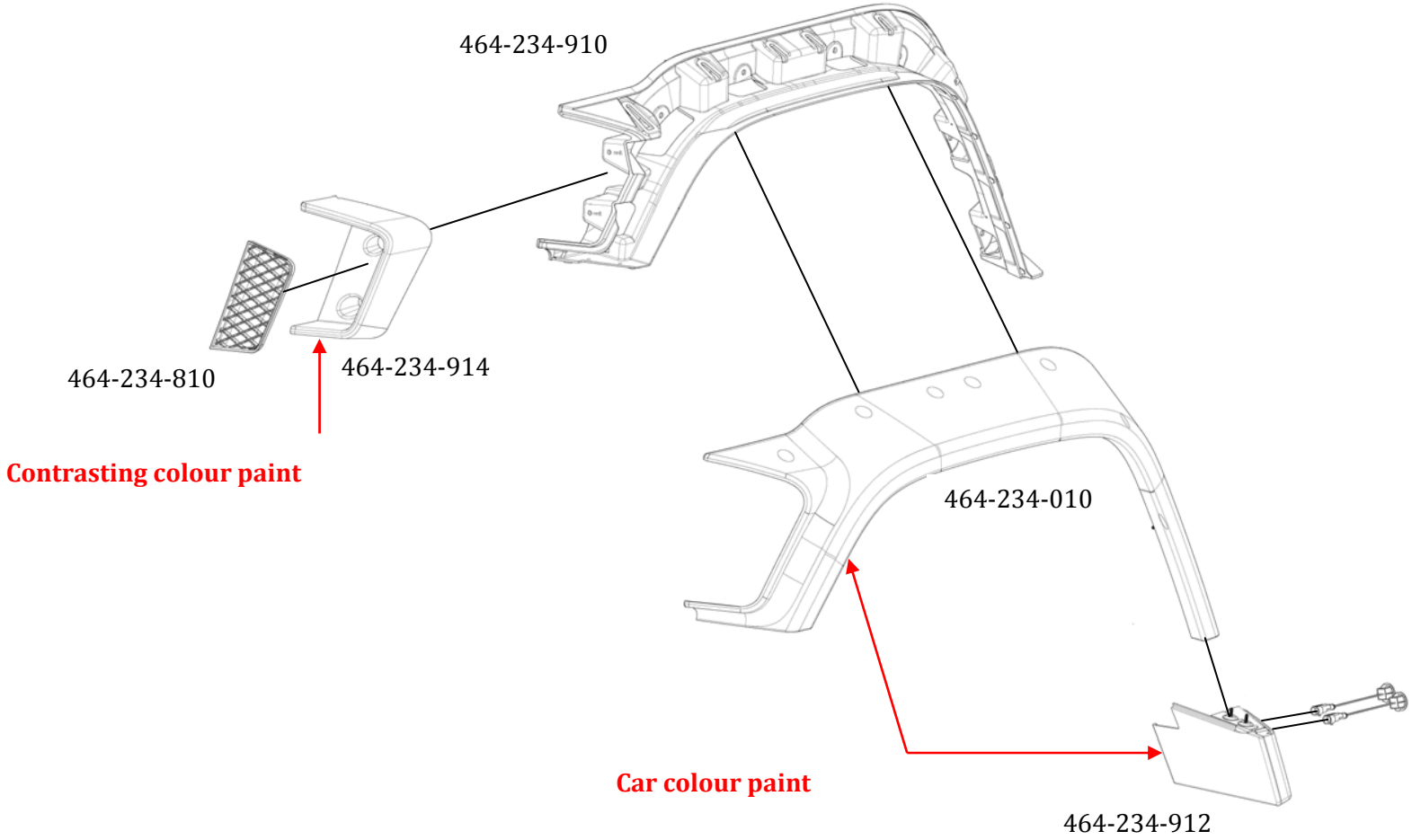
464-234-53 Rear left fender attachment and components

- Fender attachment made of polyurethane, including design frame with grille.
- Running board end cap made of polyurethane with LED running board light.



464-234-54 Rear right fender attachment and components

- Fender attachment made of polyurethane, including design frame with grille.
- Running board end cap made of polyurethane with LED running board light.



Scopes of delivery of assembly kits/PTS kits:

464-234-920

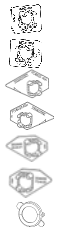
Kleinteilesatz Frontschürze Widestar
Assembly kit front bumper Widestar

38 x	Q0007371V000000000
14 x	2300154A
1 x	453-000-21
9 x	61786113
9 x	WE245 026 68
1 x	464-234-919
2 x	013403916
4 x	042236520

PTS-464-020

PTS Halter-Set Frontschürze Widestar
PTS bracket kit front bumper Widestar

1 x	PTS-464-021
1 x	PTS-464-022
1 x	PTS-464-023
1 x	PTS-464-024
1 x	PTS-464-025
1 x	PTS-464-026
2 x	PTS-464-027



PTS-464-200

PTS Klebepad-Set Frontschürze Widestar
PTS adhesive pad kit front bumper Widestar

3 x	PTS-464-051
2 x	PTS-464-052
2 x	PTS-464-053



464-234-952

Kleinteilesatz Verbreiterung Widestar vorne L/R
Assembly kit fender attachment Widestar front L/R

10 x	22023640
4 x	23006250
2 x	166-351-05
1 x	464-234-503
1 x	2300154A



464-234-940

Kleinteilesatz Heckschürze Widestar
Assembly kit rear bumper Widestar

20 x	Q0007371V000000000
2 x	2300154A
1 x	464-234-502
1 x	453-000-021
10 x	61786113
10 x	WE245 026 68



PTS-464-040

PTS Halter-Set Heckschürze Widestar
PTS bracket kit rear bumper Widestar

1 x	PTS-464-041
1 x	PTS-464-042
1 x	PTS-464-043
1 x	PTS-464-044
1 x	PTS-464-045
1 x	PTS-464-046
2 x	PTS-464-047
2 x	PTS-464-048



PTS-464-400

PTS Klebepad-Set Heckschürze Widestar
PTS adhesive pad kit rear bumper Widestar

6 x	PTS-464-051

464-234-954

Kleinteilesatz Verbreiterung Widestar hinten L/R
Assembly kit fender attachment Widestar rear L/R

11 x	22023640
2 x	23006250
2 x	166-351-05
1 x	2300154A



= Front

= Fender attachments

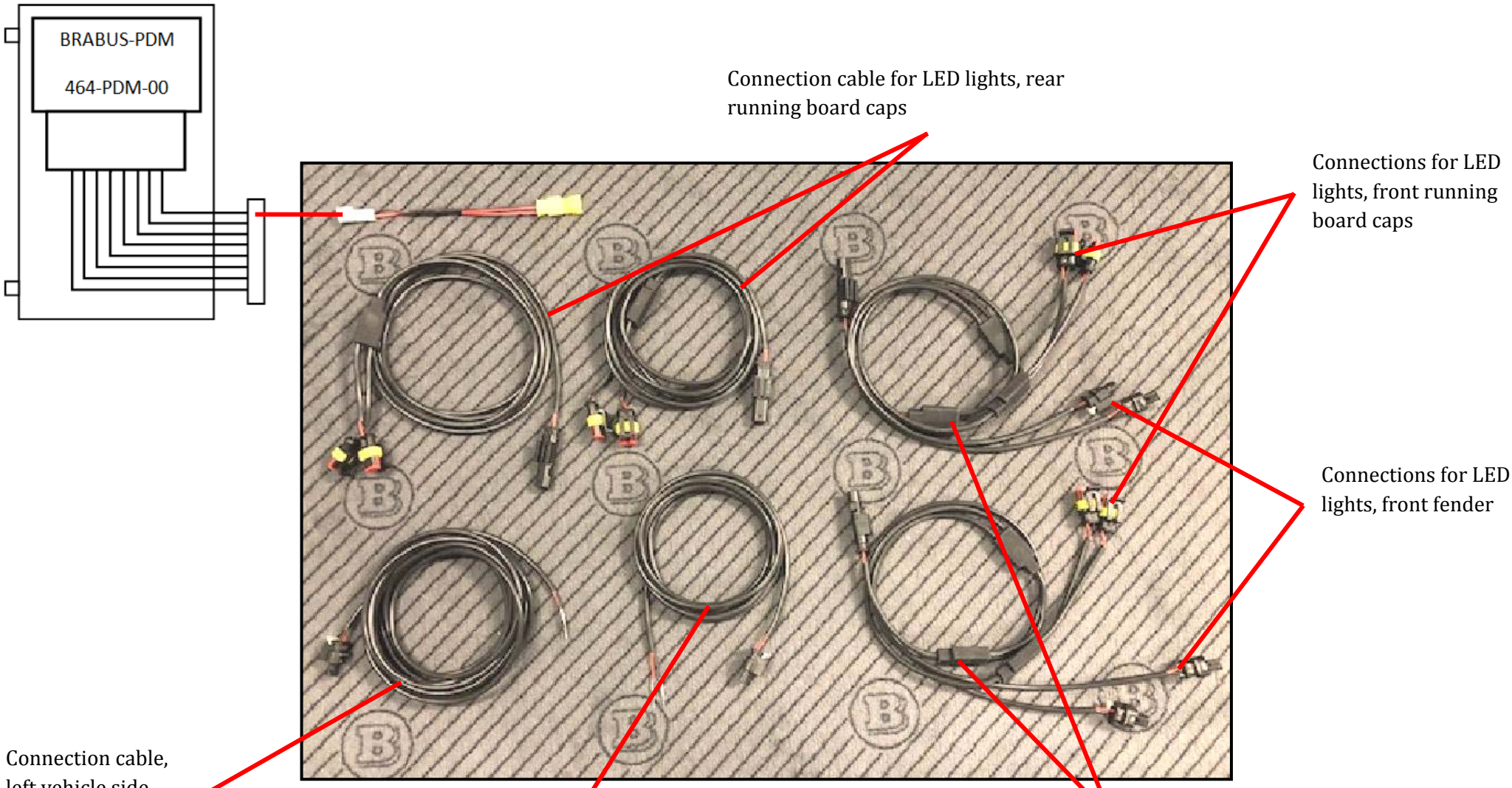
= Rear

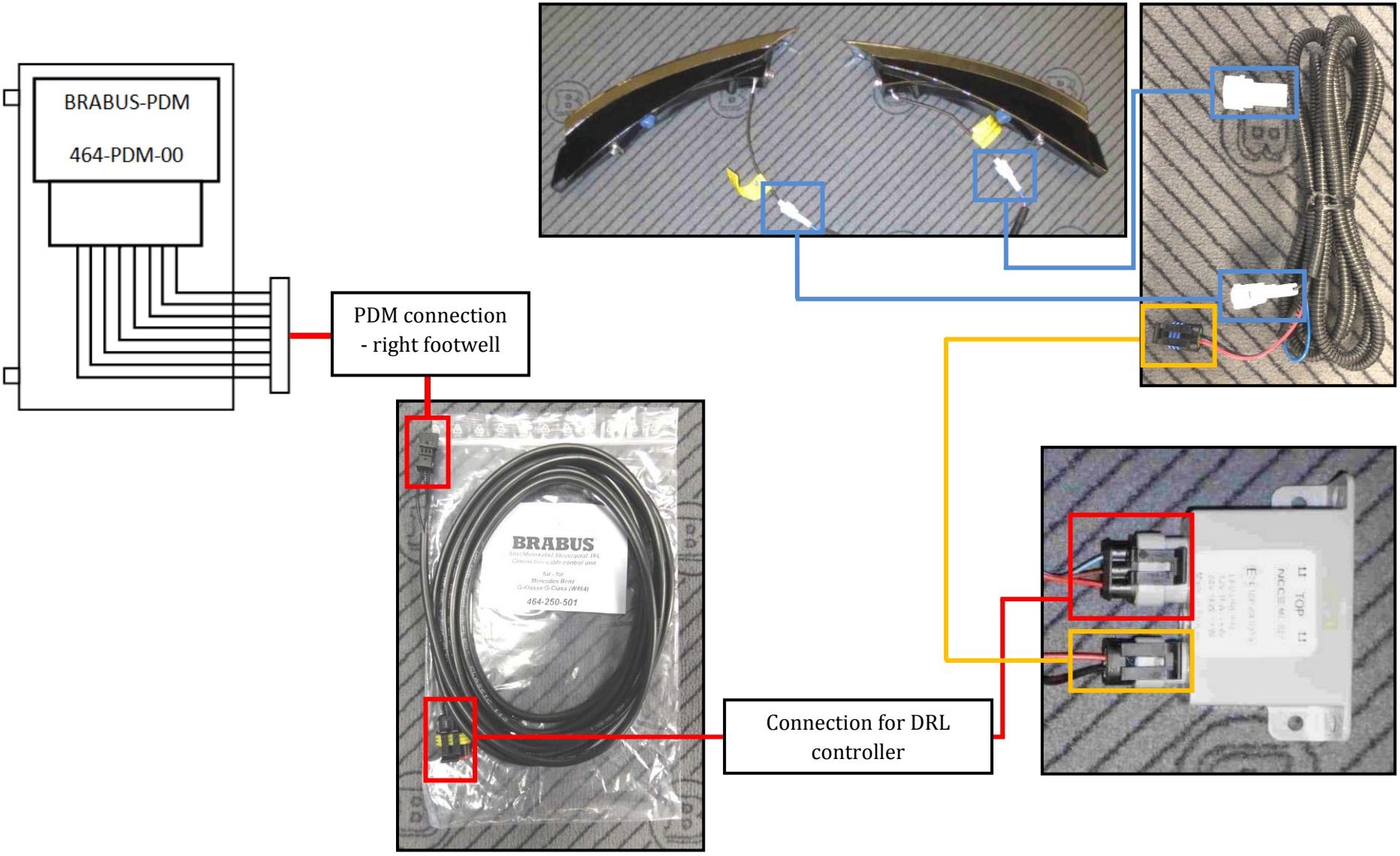
- Disconnect the earth connection of the vehicle battery in the boot of the vehicle.
- Disassemble the standard assemblies marked below according to the Mercedes-Benz Workshop Information System.
- Dismantle the standard assemblies. The standard components marked on pages 35 & 58 will still be used.
- Disassemble the radiator housing.
- Disassemble the front left and right entry panel.
- Disassemble the front and rear wheel arch liners.
- Install the BRABUS PDM (464-PDM-00) in the vehicle according to the product-specific assembly instructions.
- Disassemble the centre carrier and the inner metal bracket of the rear bumper.



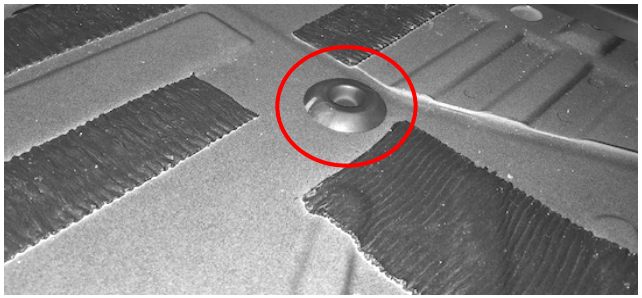


Installation of the electrical components




BRABUS-PDM
464-PDM-00
PDM connection
- right footwell
BRABUS
464-250-501
Connection for DRL
controller

Lift the floor covering on the right vehicle side and remove the rubber plug shown.

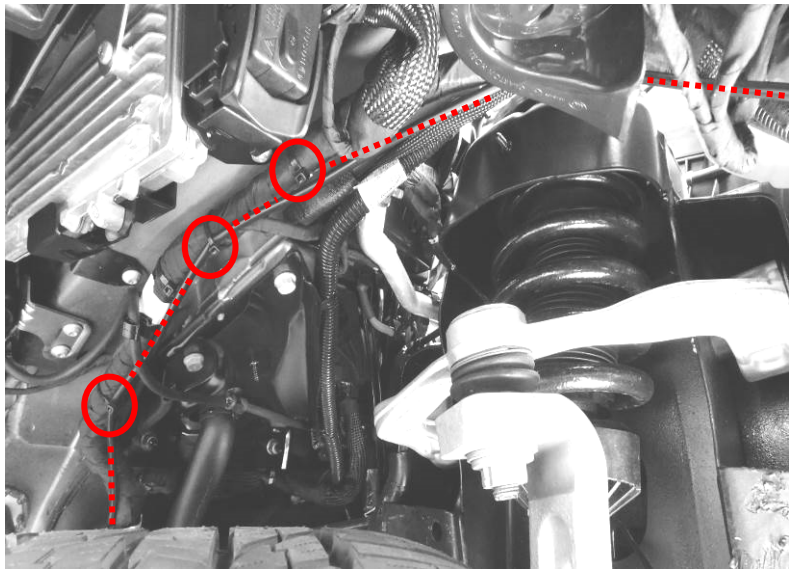


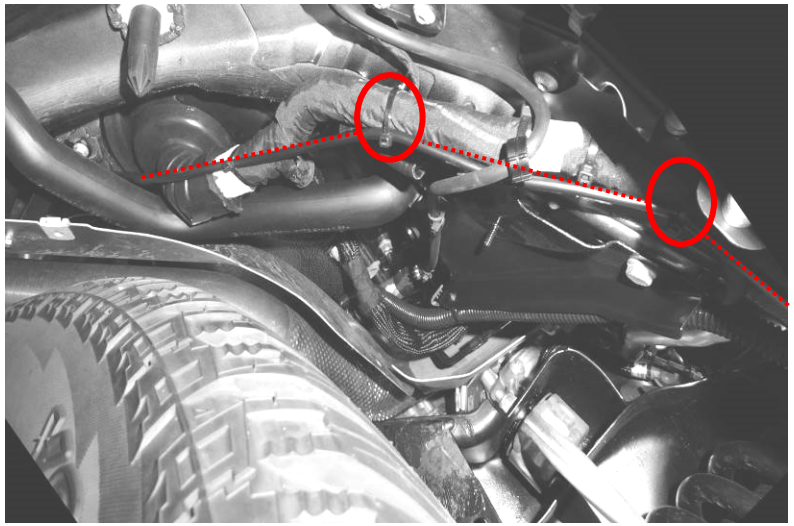
Connect the Widestar cable harness for the <u>right</u> vehicle side and the daytime running light cable harness to the outputs of the BRABUS PDM (ensuring that the colours match), lay them in the footwell and then through the rubber plug to the outside and in the front right wheel arch using the draw cord.



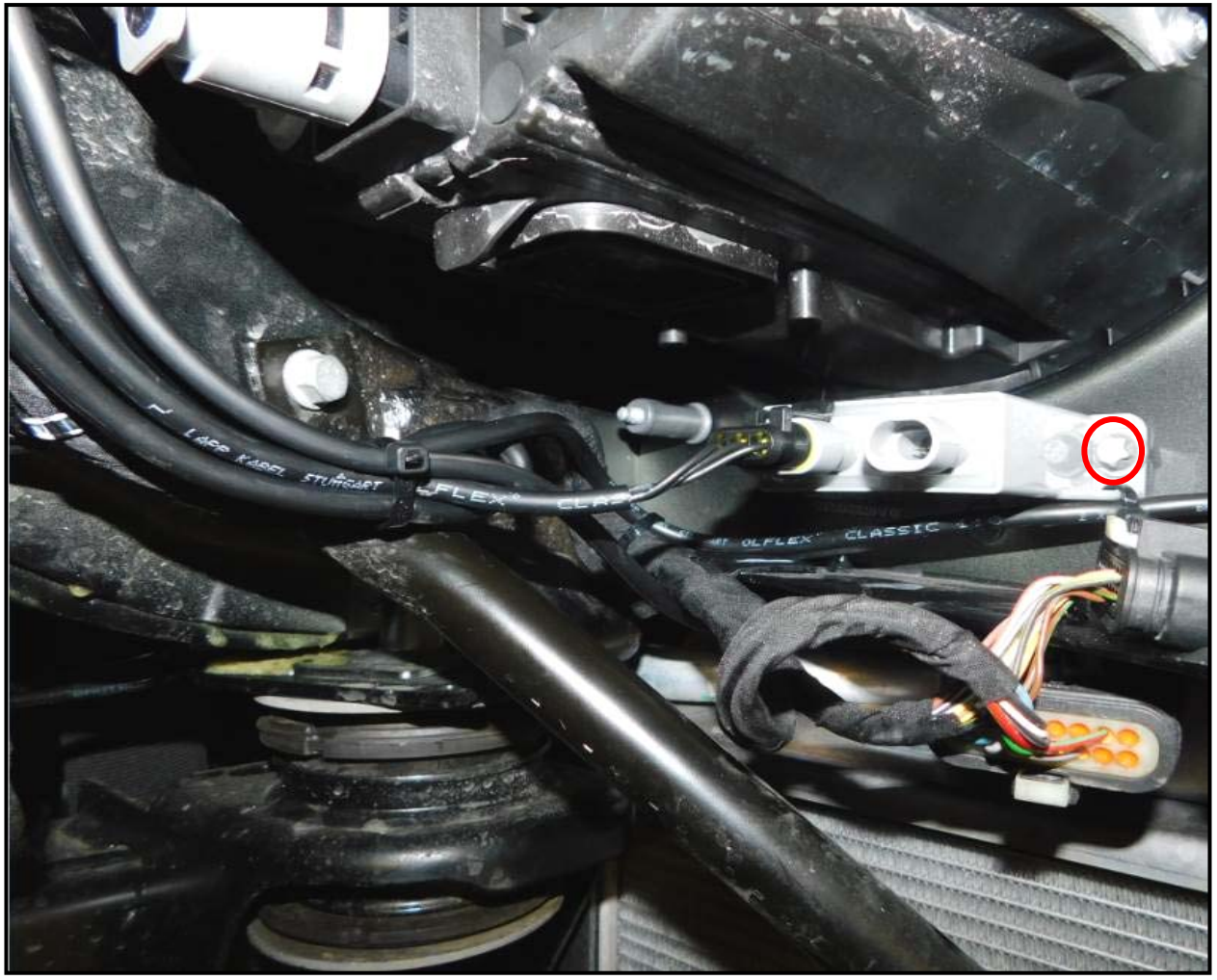


Lay the daytime running light cable harness to the vehicle front as shown and fix it in place along the cable route using cable ties.





Attach the cable holder of the cable harness to the edge at the frame. Use the delivered Torx screw to screw the daytime running light controller to the front longitudinal member on the outer right-hand side in the position shown (above the intercooler, widen the screw-in opening at the controller to Ø6 mm). Connect the electric cable of the daytime running lights to the controller.

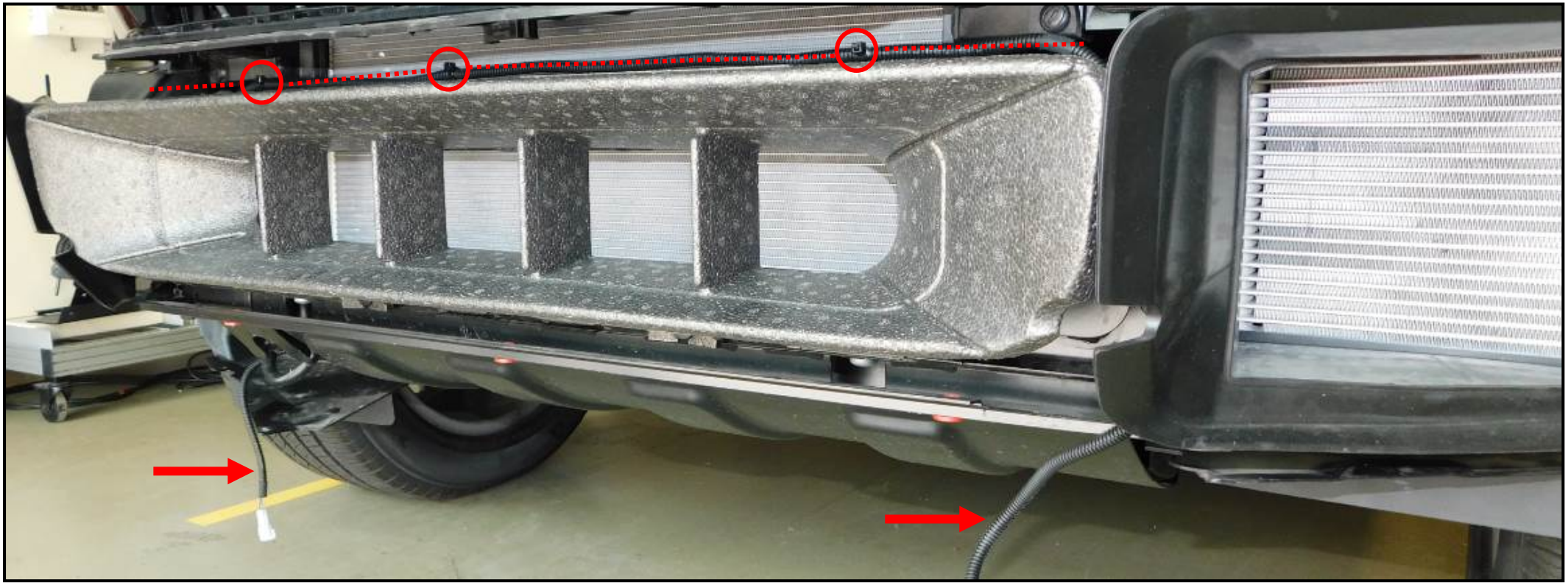


Connect the daytime running light cable harness to the controller.

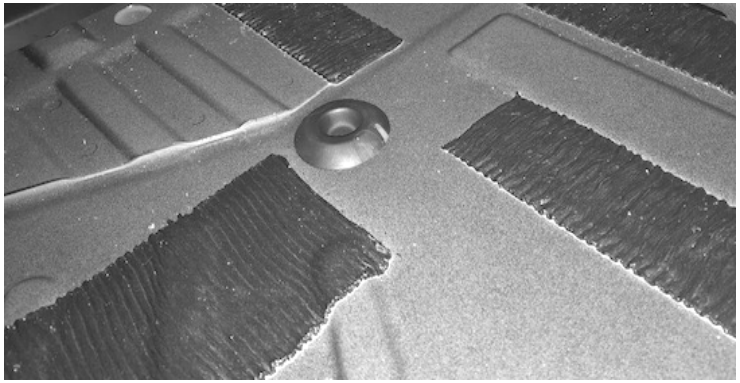
The short cable remains on the right vehicle side and the long cable is laid on the front cross member to the left vehicle side. Fix the cables in place in suitable positions using cable ties.

If the connection cables are too short for the required cable laying, use the delivered extension cables.

Measure the cable lengths, lay the cables in loops where necessary and fix them in place in suitable positions using cable ties.



Connect the Widestar cable harness for the <u>left</u> vehicle side to the BRABUS-PDM ensuring that the colours match. Lay the cable harness below the dashboard to the left vehicle side. Lift the floor covering on the left vehicle side and remove the rubber plug shown.



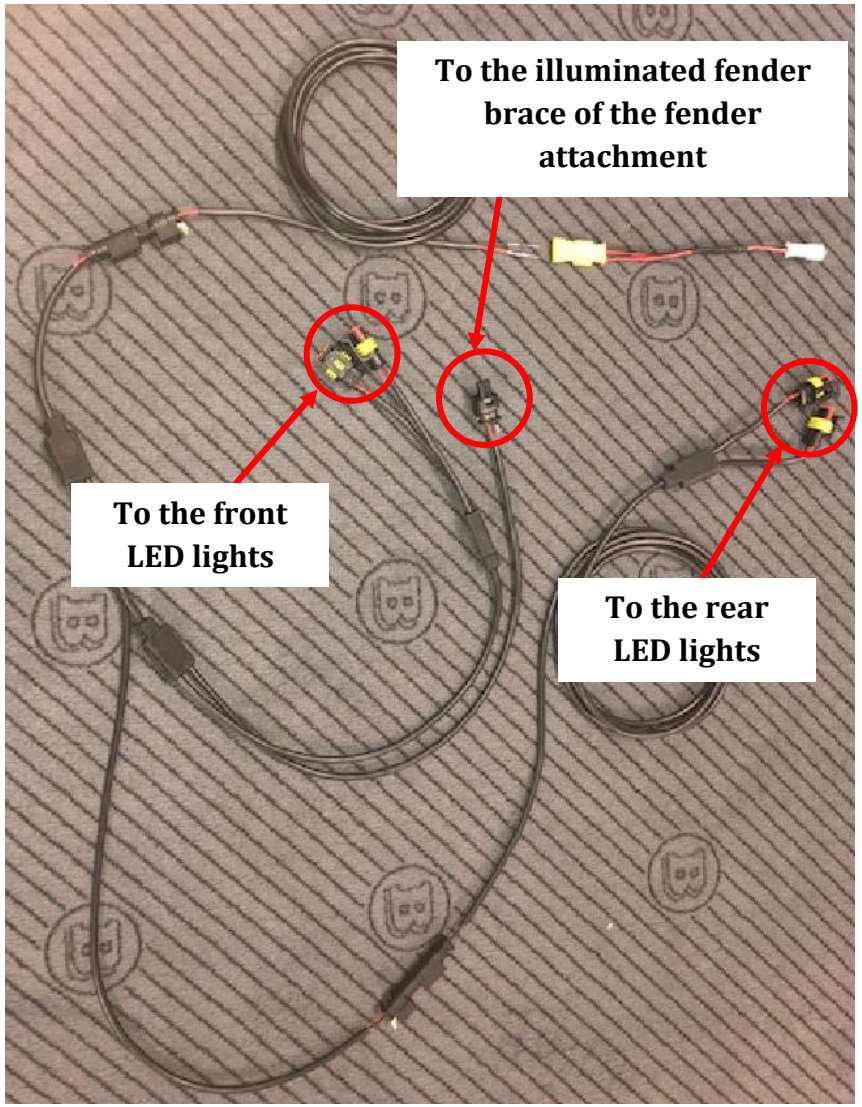


Lay the Widestar cable harness for the <u>left</u> vehicle side through the rubber plug to the outside and in the front left wheel arch using the draw cord.

Lay excess cable harnesses in the two front wheel arches in loops and fix them in place using cable ties.

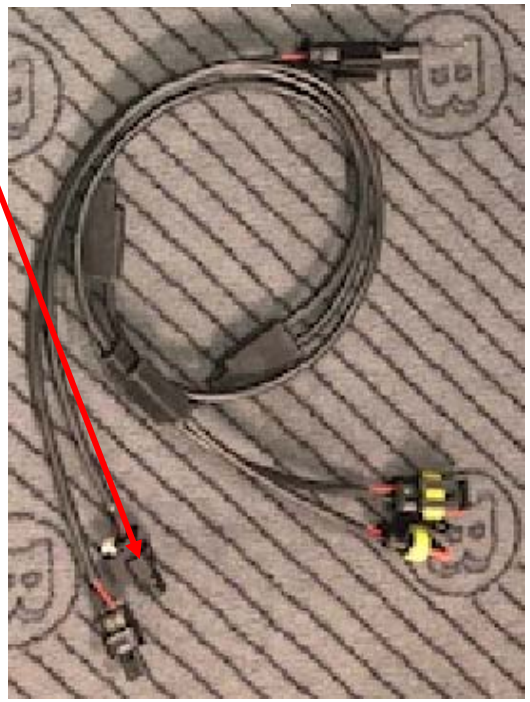


Connect the front cable harnesses to the Widestar cable harnesses.



Connect the cable harnesses for the rear running board caps to the front left/right cable harnesses and lay them to the rear through the left/right running board.

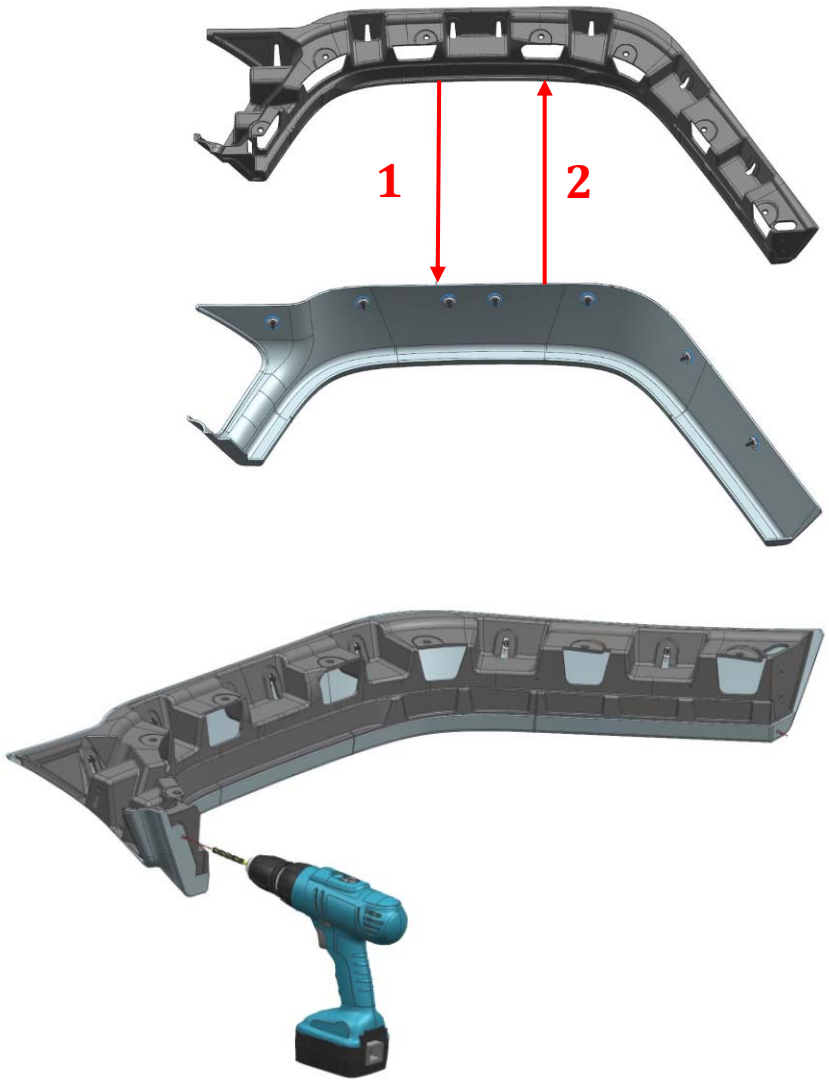




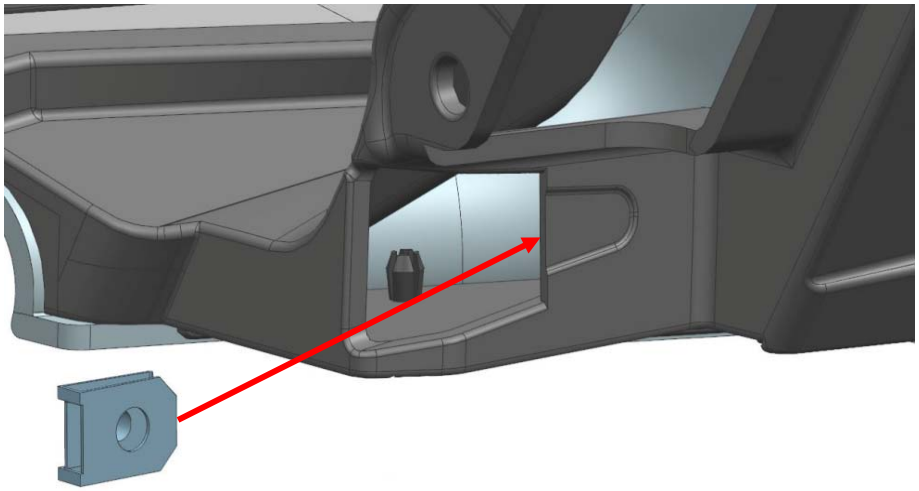


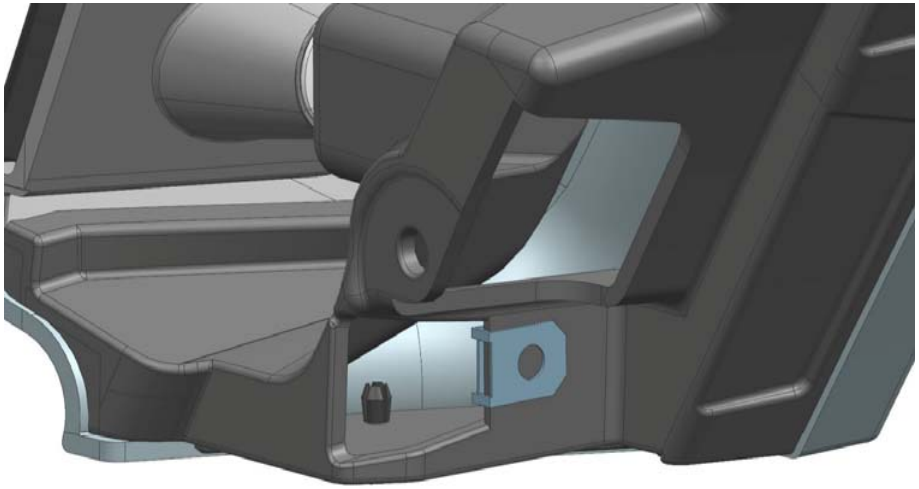
Assembly of the rear fender attachments

Insert the carrier into the shell from above and use a suitable Ø 5.5 mm drill bit to drill hole in the position shown. Remove the carrier from the shell.



Remove the sheet metal nuts of the screw connections to the rear bumper from the original standard attachments and attach them to the fastening points of the carriers of the Widestar fender



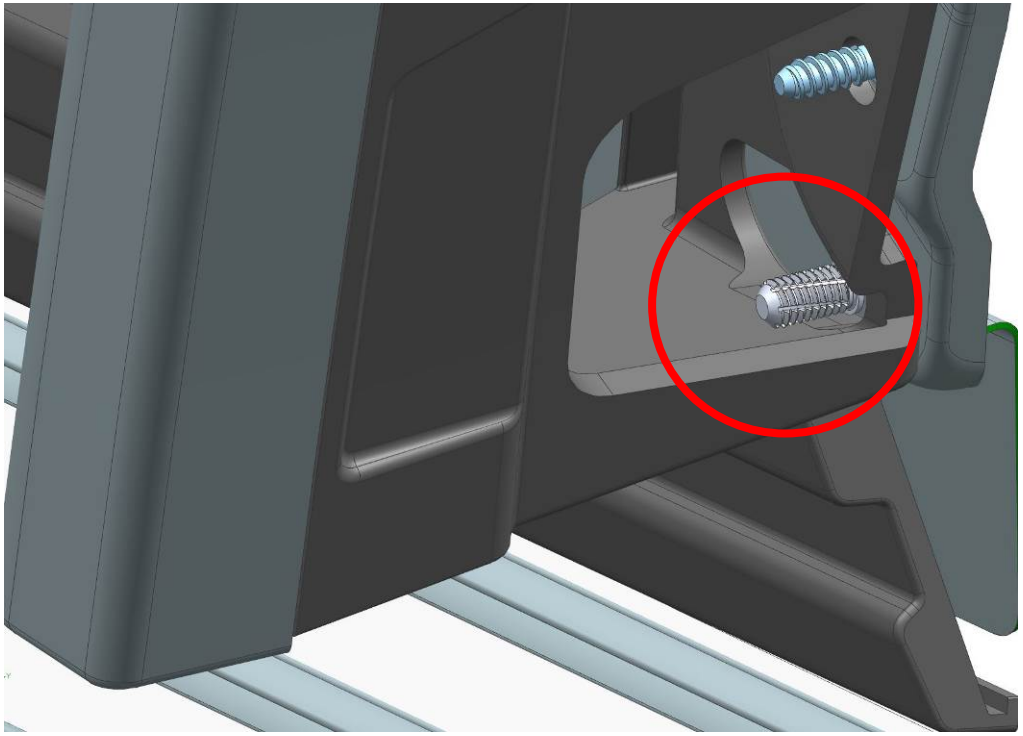


Use sandpaper (240-grit!) to roughen the adhesive surfaces of the shell and carrier which are marked red in the pictures on the following pages and clean them thoroughly afterwards using silicone remover in two stages.

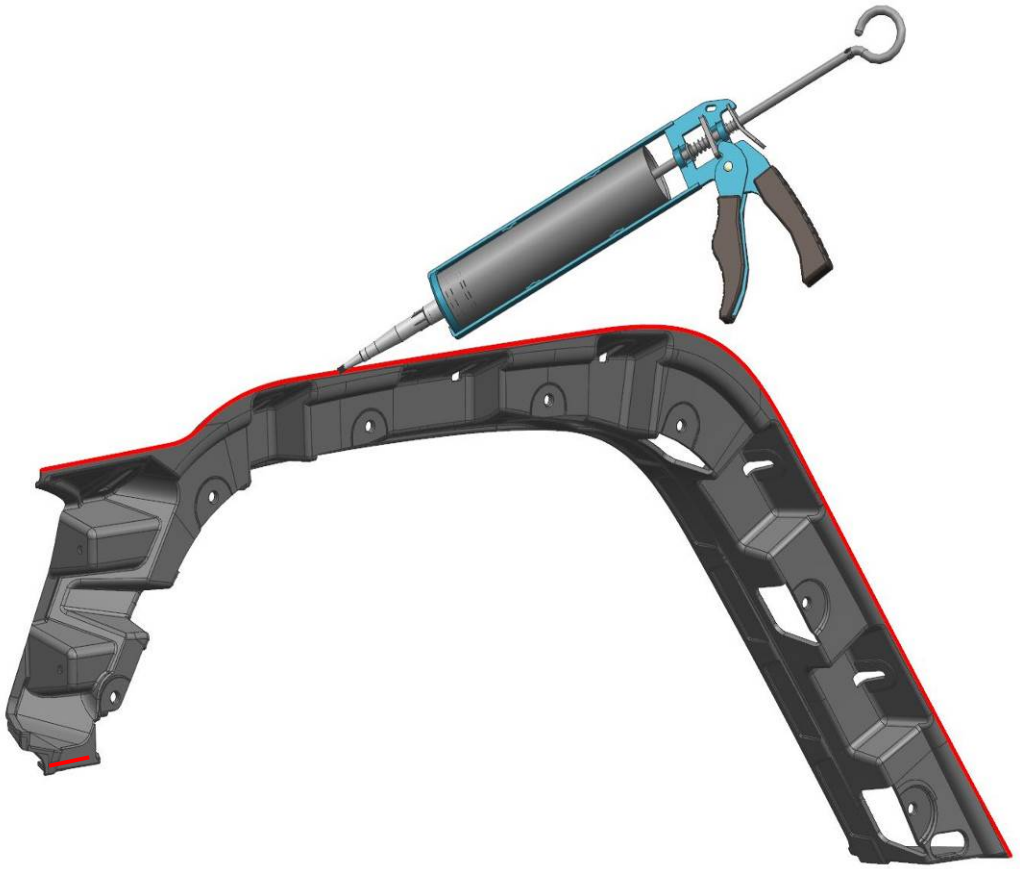
The adhesive surfaces must be free of paint mist and completely free of grease!



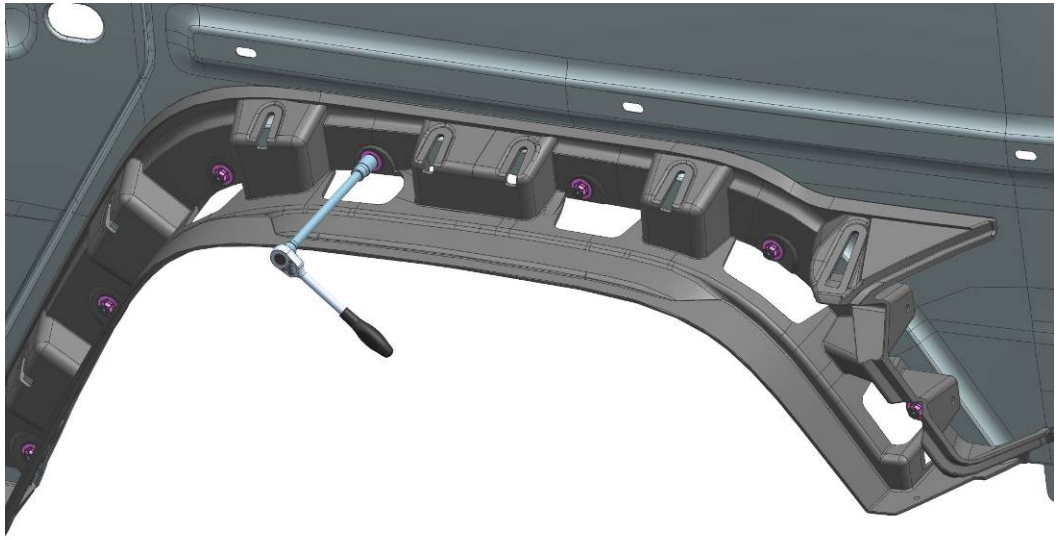
Use a suitable tool to cut the lower standard self-cutting threaded bolt (marked red) to the required length before assembling the carrier and protect the cut surface against corrosion.



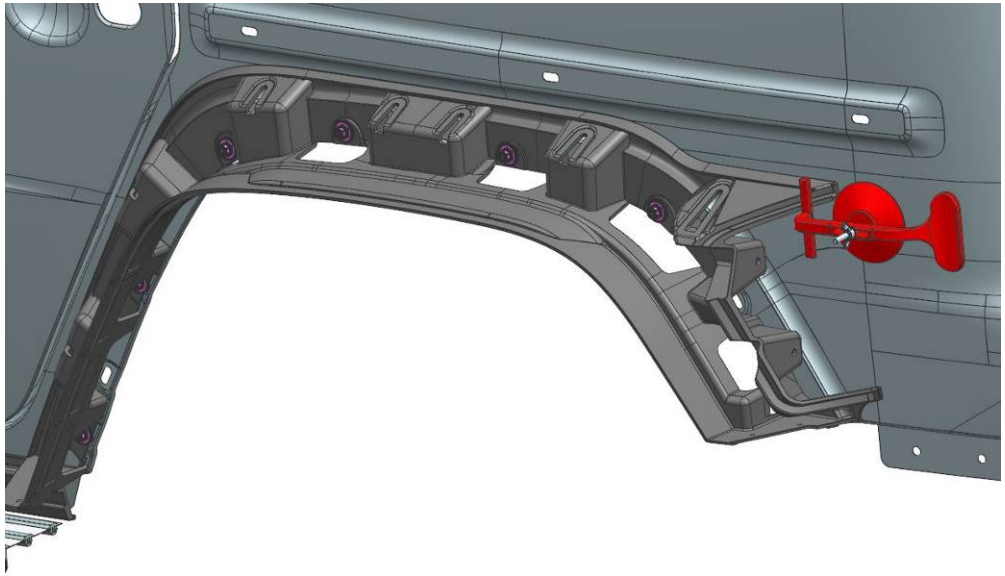
Apply even adhesive beads to the adhesive surfaces as shown. Apply the adhesive beads at a distance of approx. 3 - 4 mm to the outer edges. The opening of the adhesive tip should have a diameter of 4 - 5 mm.



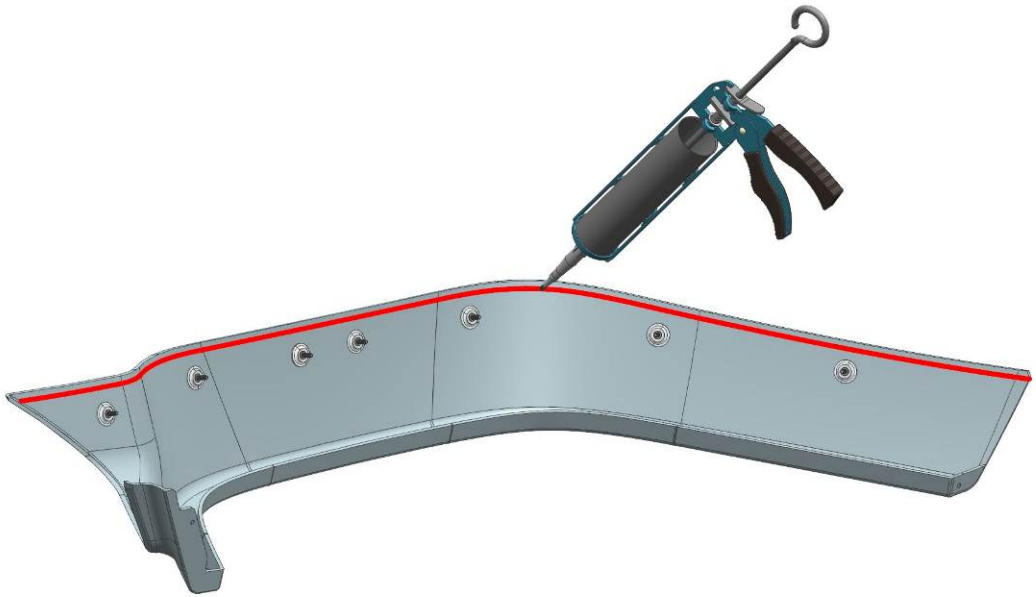
Attach the carrier with the shell to the standard fastening points of the car body and use plastic nuts to screw it in place. The carrier does not have to rest against the car body over the entire surface. Excess adhesive leaking at the edge must be removed using a suitable cleaner.

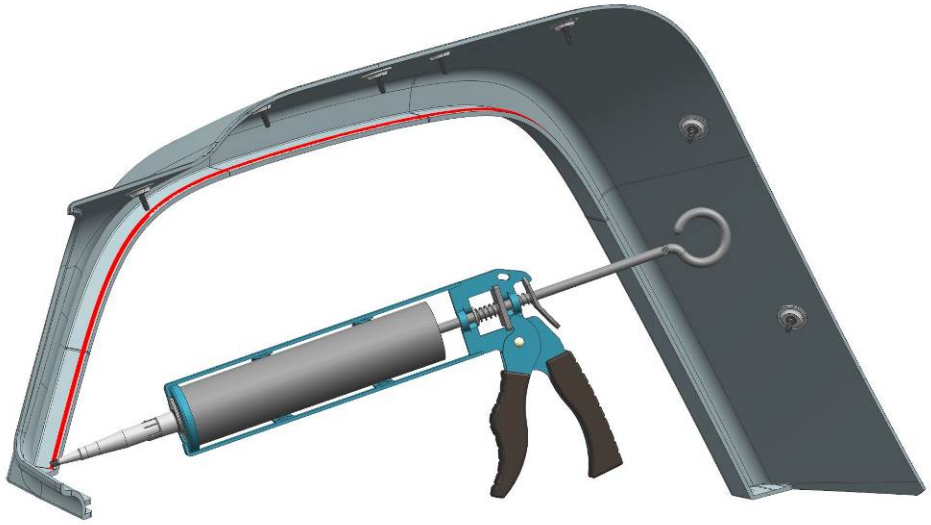


Fix the carrier in place using suitable means as shown until the adhesive has finally cured.



Apply even adhesive beads to the adhesive surfaces as shown. Apply the adhesive beads at a distance of approx. 4 - 5 mm to the outer edges. The opening of the adhesive tip should have a diameter of 4 - 5 mm.

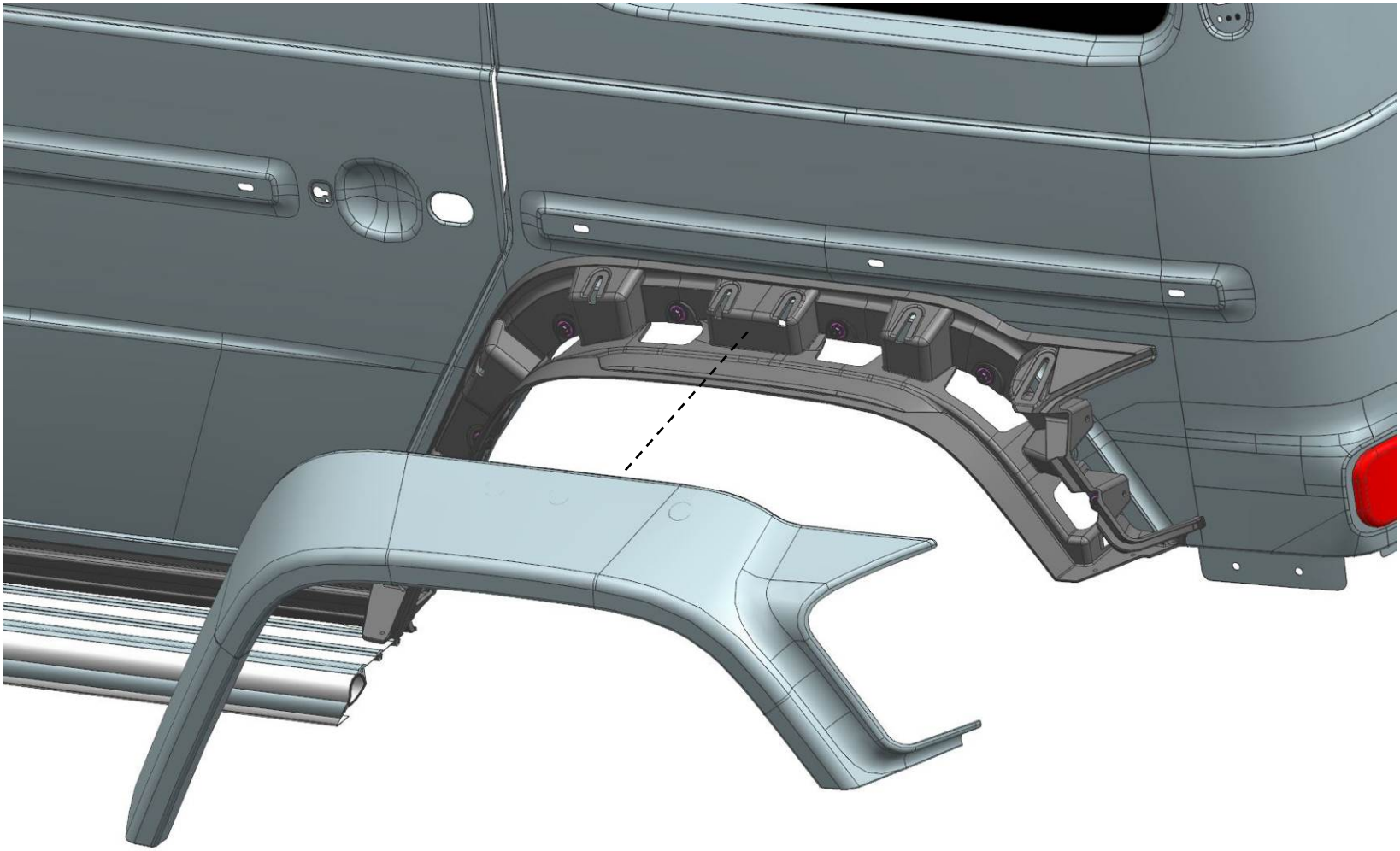




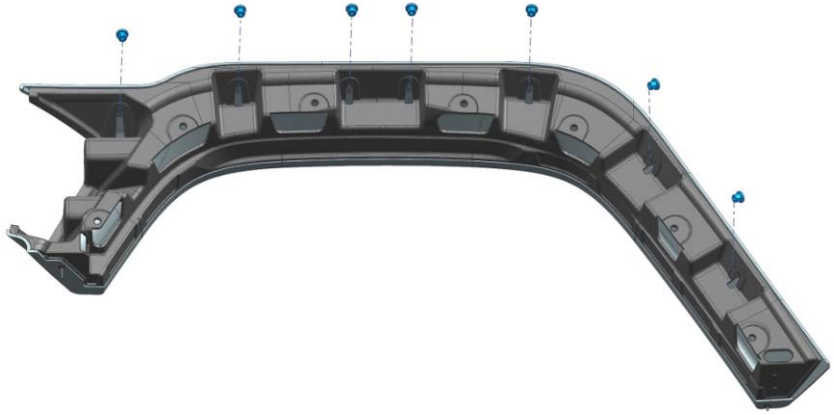




Mount the fender attachment on the carrier and fix it in place using suitable means until the adhesive has cured. Use a fabric tape to fix the fender attachments in place in the transition areas to the rear running board caps until the adhesive has finally cured.



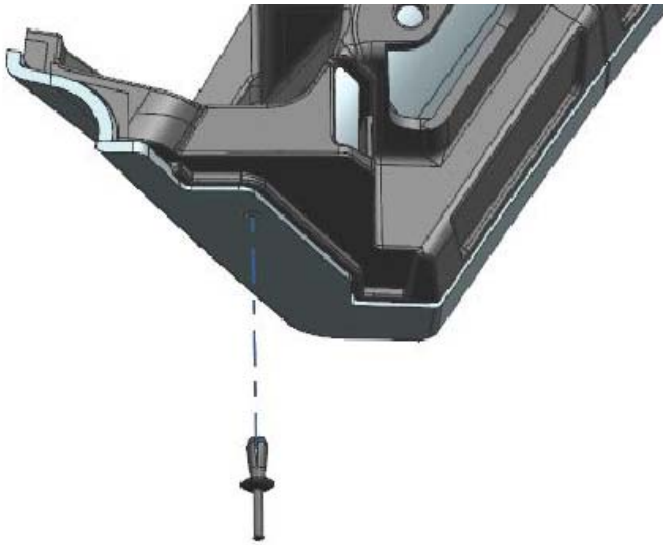
Screw the plastic nuts onto the threads and tighten them hand-tight.





Insert the plastic expanding rivets into the fender attachments as shown.



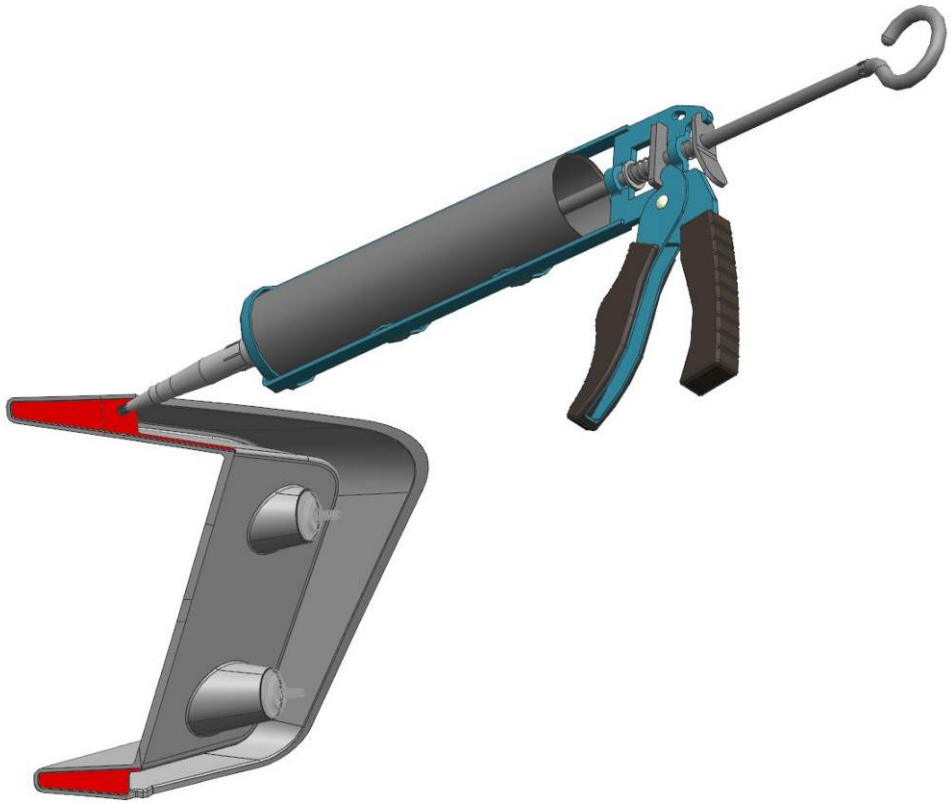


Important:

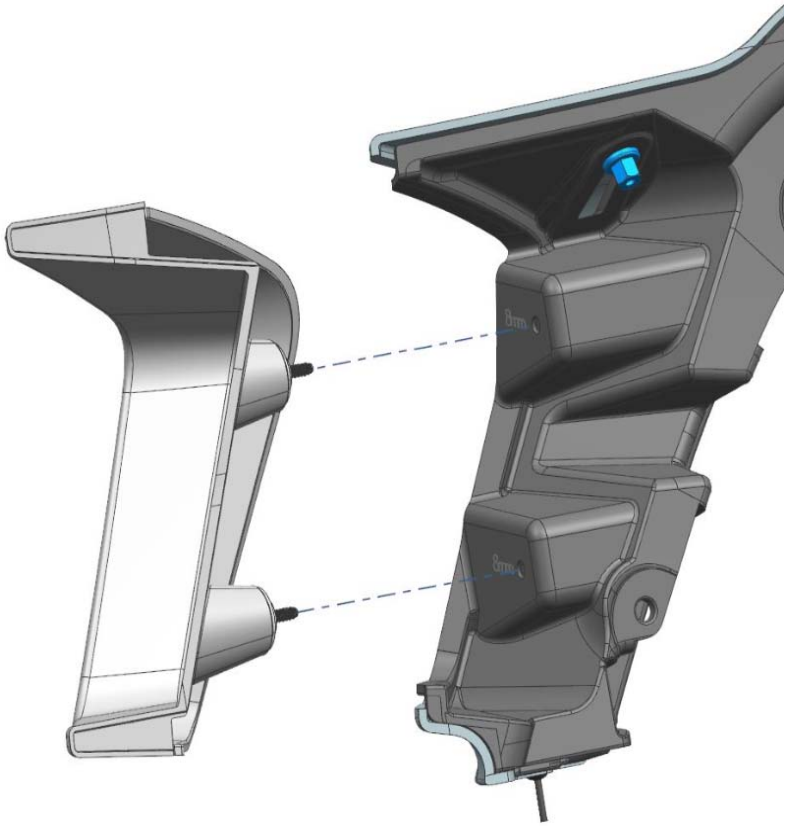
Loosen all plastic nuts used to fasten the rear shells by two turns after the adhesive has cured!



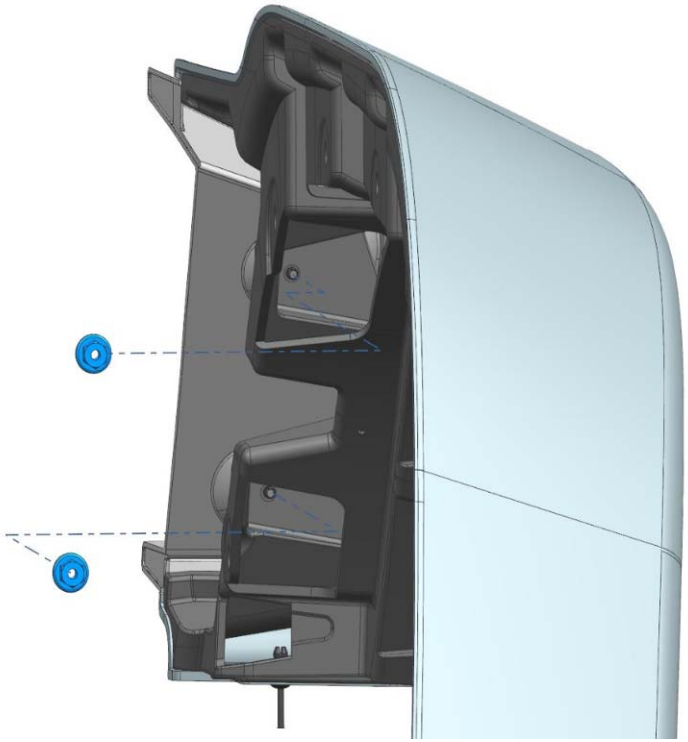
Apply even adhesive beads to the adhesive surfaces as shown. Apply the adhesive beads at a distance of approx. 3 - 4 mm to the outer edges. The opening of the adhesive tip should have a diameter of 4 - 5 mm.



Insert the design air outlets into the rear fender attachments.

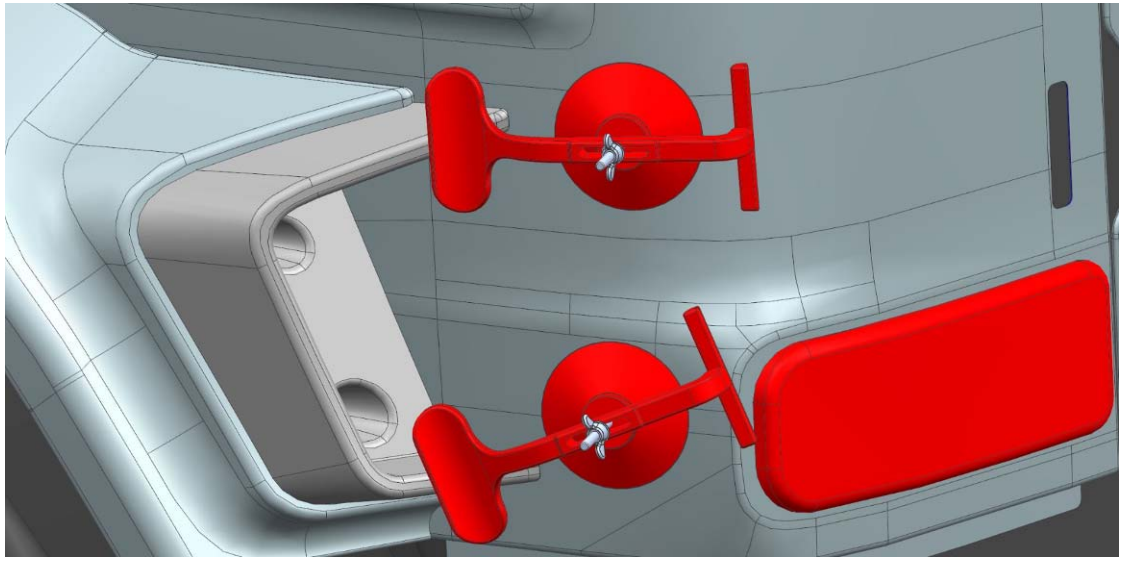


<u>Loosely</u> attach the design air outlets of the rear fender attachments using the delivered plastic nuts (22023640). <u>Do not fasten the nuts at this stage yet!</u>





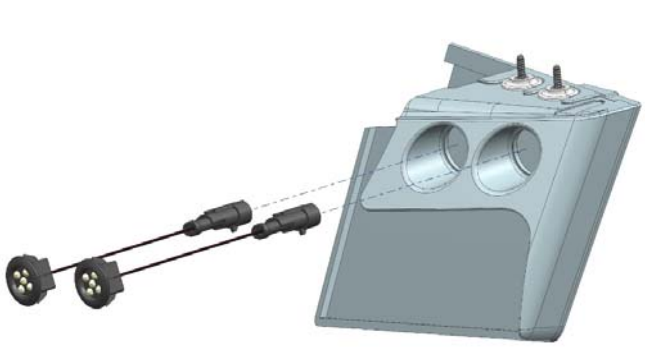
Align the design frame of the rear fender attachments and fix the design frame in place using suitable means as shown until the adhesive has finally cured. We recommend using suction clamps.

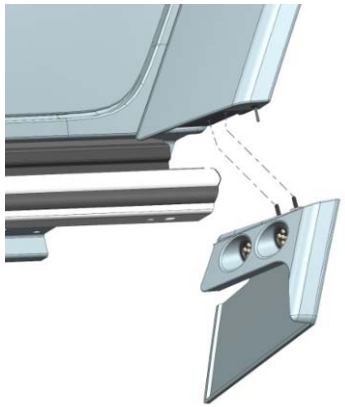


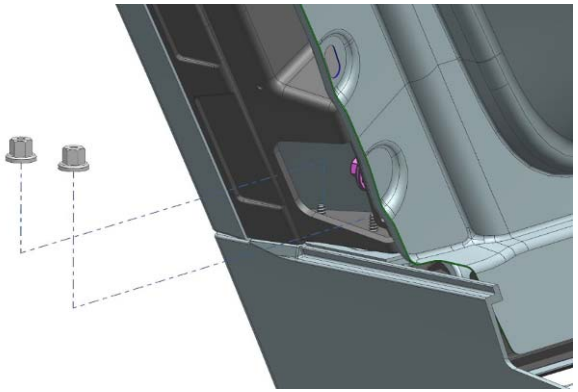
Fasten the plastic nuts of the rear design frames after the adhesive has cured.

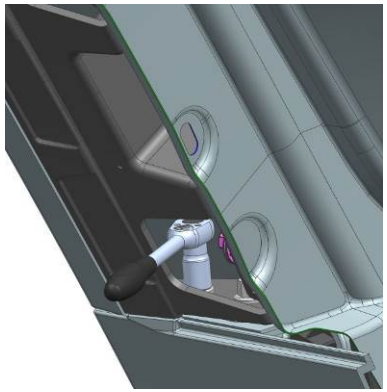


Insert two of the delivered LED running board lights into the rear running board caps (ensuring that they are correctly aligned). Connect the running board light to the vehicle cable harness. Position, align and screw the running board caps between the running boards and rear fender attachments.

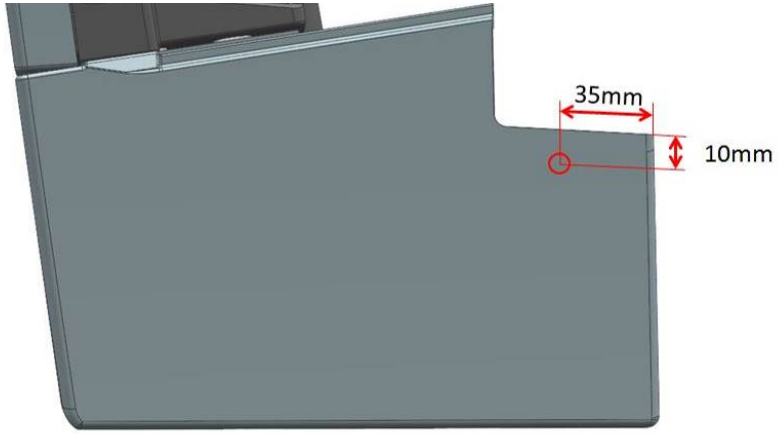


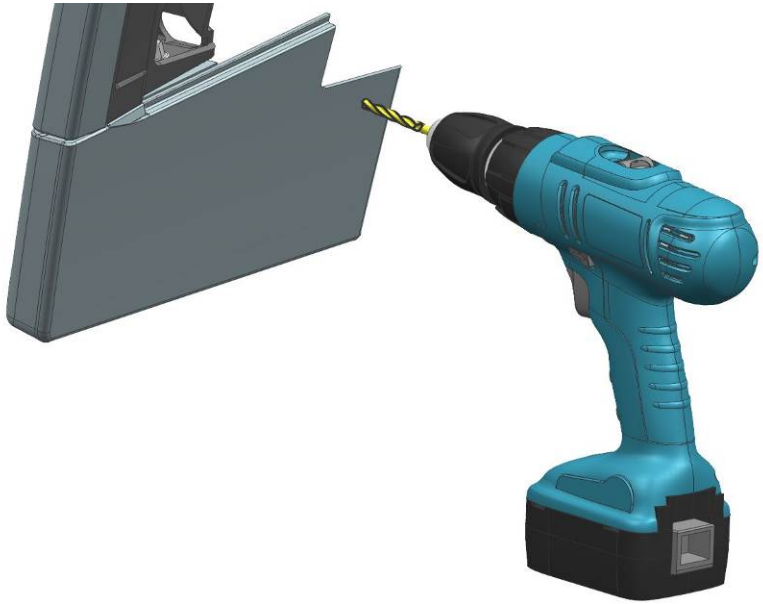




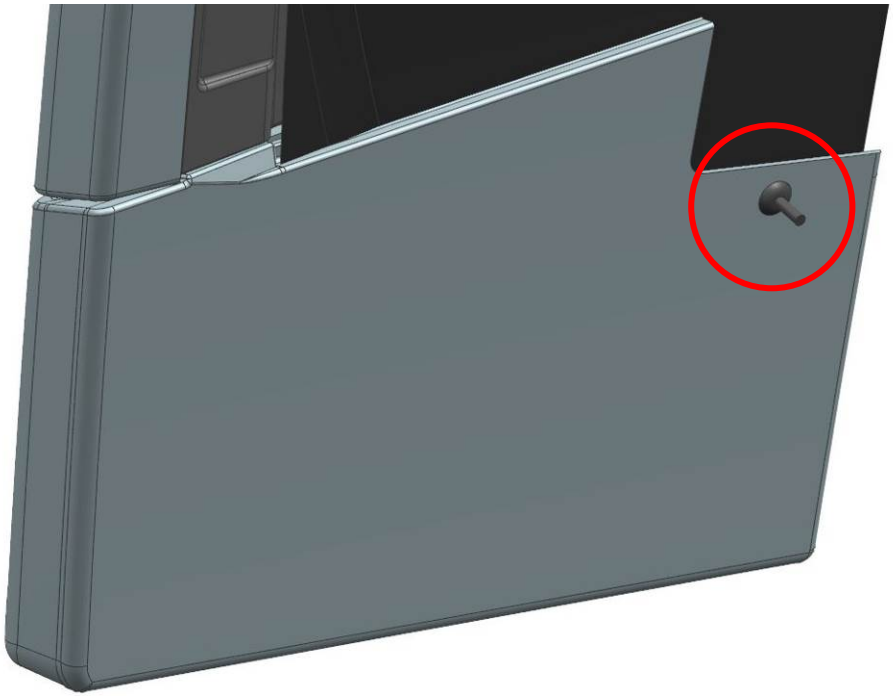


Mark the position shown below at the running board cap. Then drill a hole 5.5 mm in diameter through the running board cap and the standard inner fender in this position.





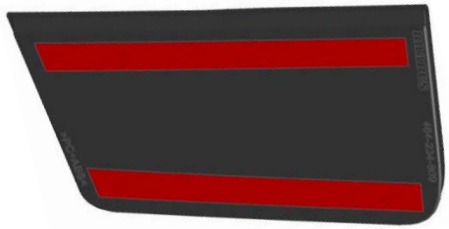
Connect the running board cap and inner fender using the expanding rivet.

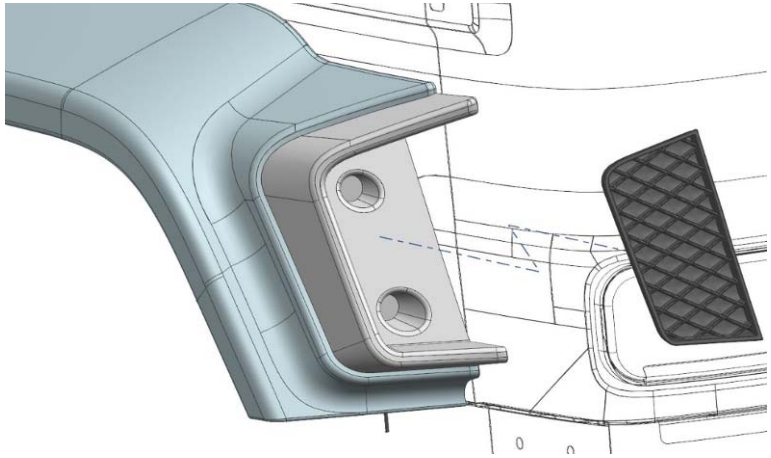


Roughen the adhesive surfaces of the rear design grilles and adhesive surfaces of the rear design frames marked red and thoroughly clean them using silicone remover in two stages.

Apply even adhesive beads of the delivered adhesive to the areas of the design grilles marked red. The opening of the adhesive tip should have a diameter of 4 - 5 mm.

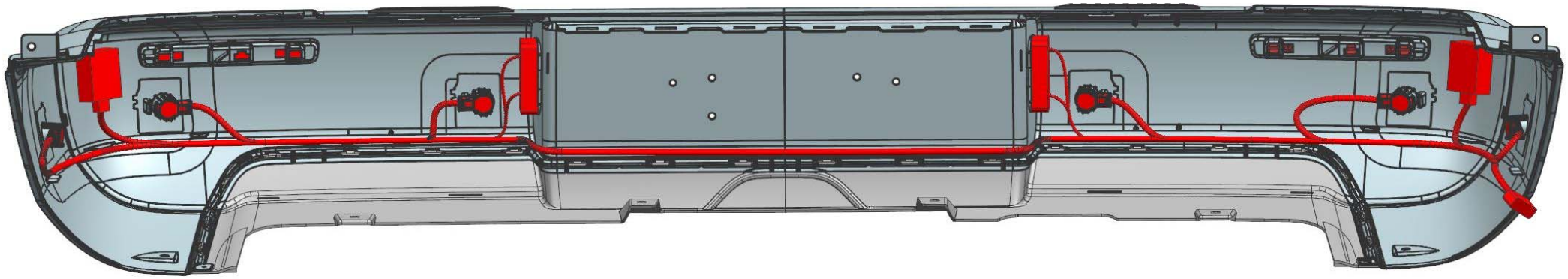
Affix the design grilles to the design frames and align them to the adjacent components. Fix them in place using suitable means until the adhesive has finally cured.



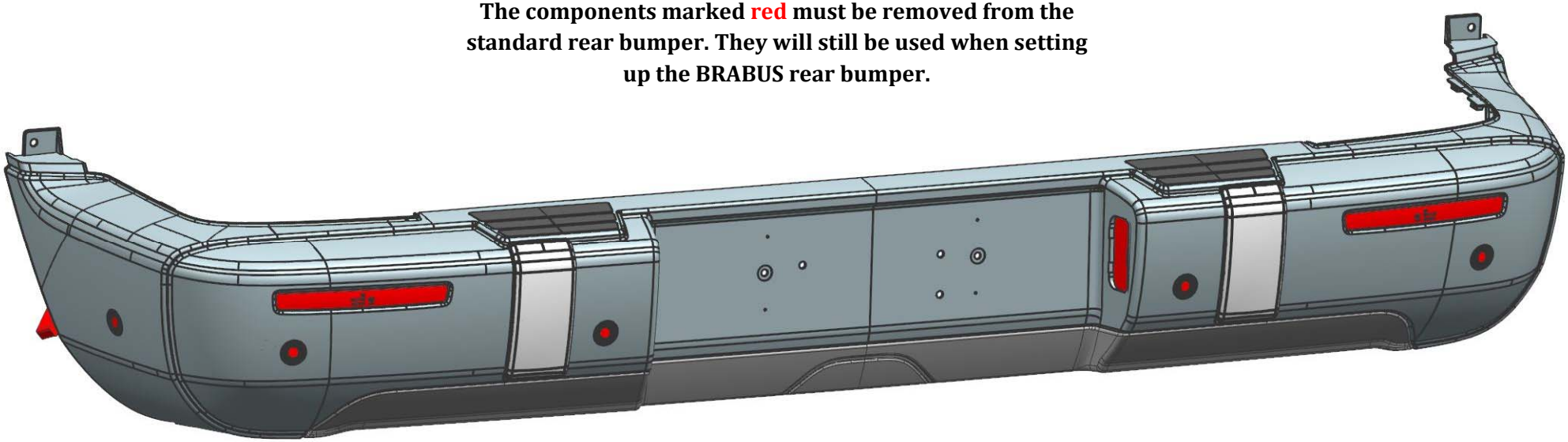


Assembly of the rear bumper

Presentation of the standard rear bumper components which will still be used.

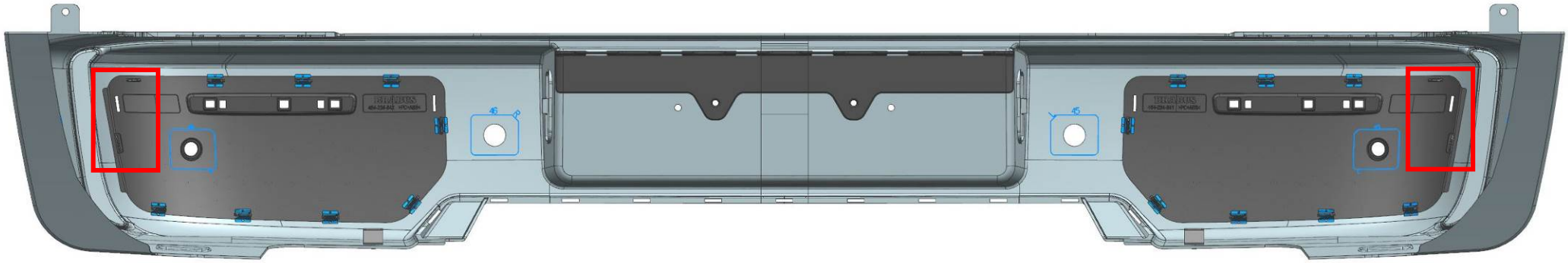


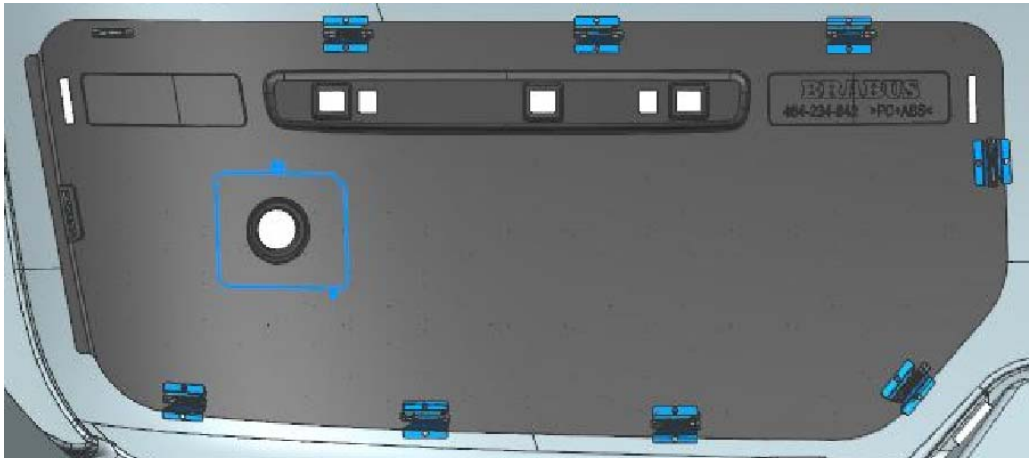
The components marked red must be removed from the standard rear bumper. They will still be used when setting up the BRABUS rear bumper.



Attach the design grilles of the rear bumper on the left- and right-hand side into the BRABUS rear bumper as shown using the delivered Speedfix clips.

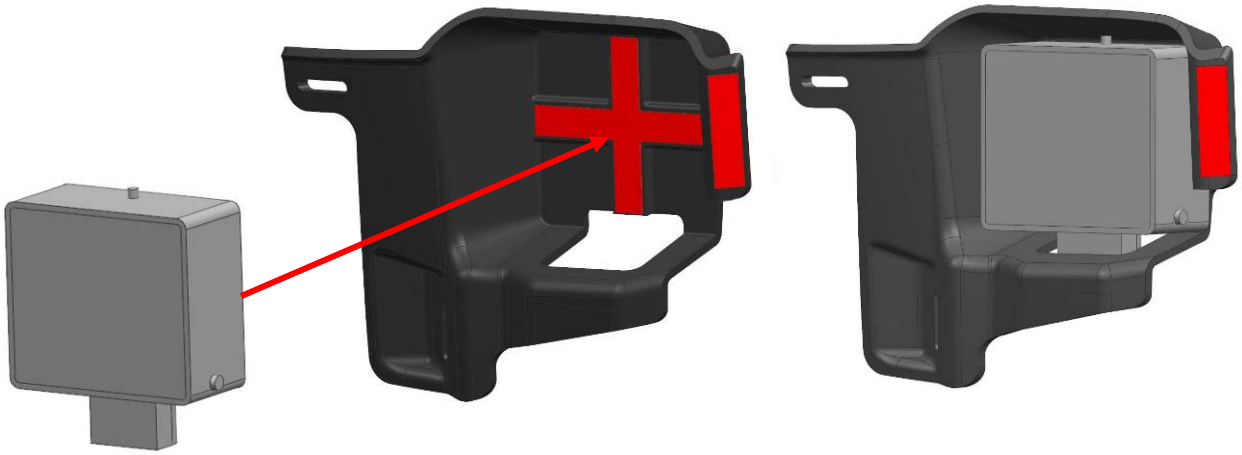
Do not mount the Speedfix clips within the areas framed red yet!



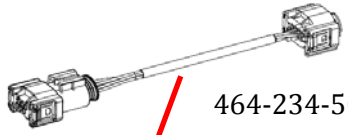


Prepare the rear radar sensors for bonding using <u>silicone remover</u> in <u>two</u> stages. Remove the liners of the VHB adhesive strips and affix the radar sensors to the brackets as shown. Firmly press the radar sensors onto the brackets.

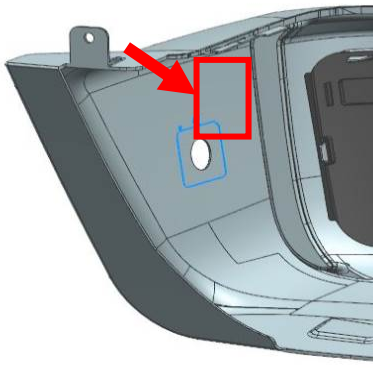
(This work step is not required for vehicles without an SA-Code EA2 Blind Spot Assist.)

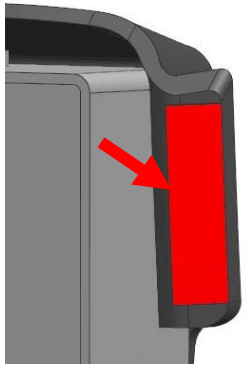


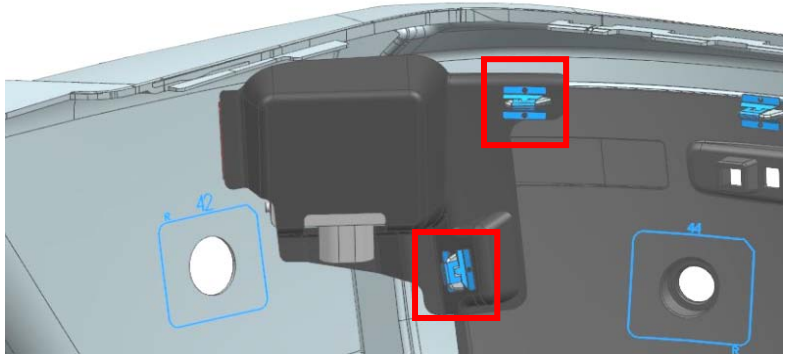
Clean the areas marked red of the rear bumper on the left- and right-hand side using <u>silicone remover</u> in <u>two</u> stages. Remove the liner of the VHB adhesive strips of the radar sensor brackets and affix the radar sensor brackets to the rear bumper as shown. Firmly press on the bonding and fasten the radar sensor brackets using Speedfix clips as shown. Connect the delivered radar sensor adapter cable to the right radar sensor (extension). The radar sensor brackets must also be mounted for vehicles without a Blind Spot Assist SA-Code EA2.

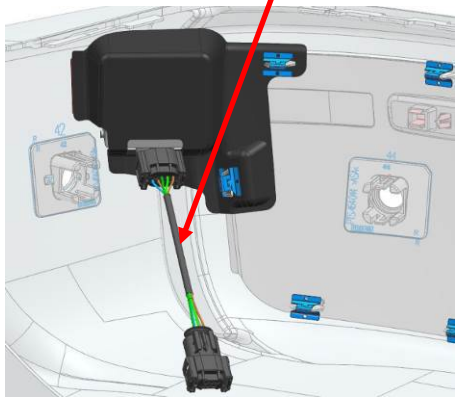


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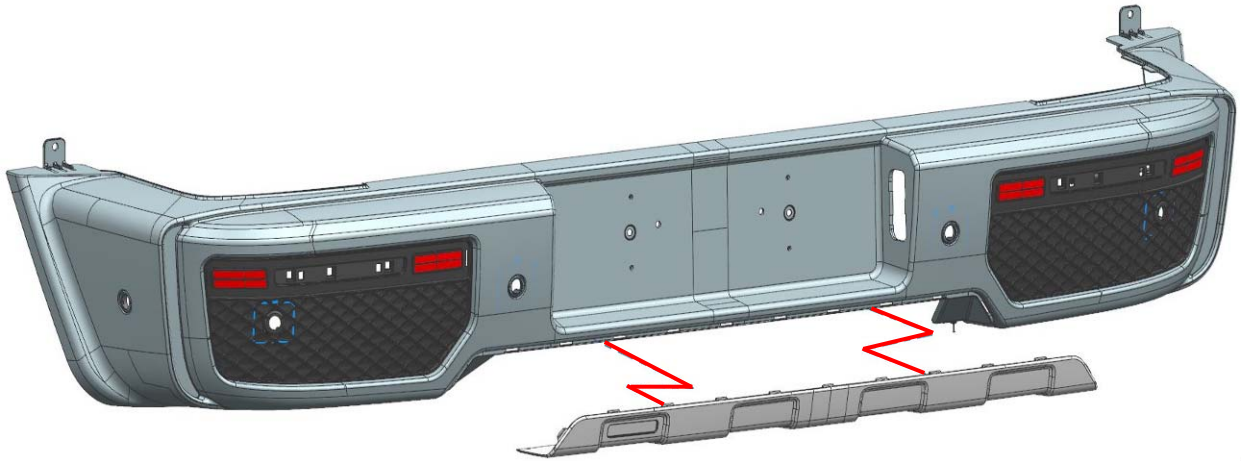


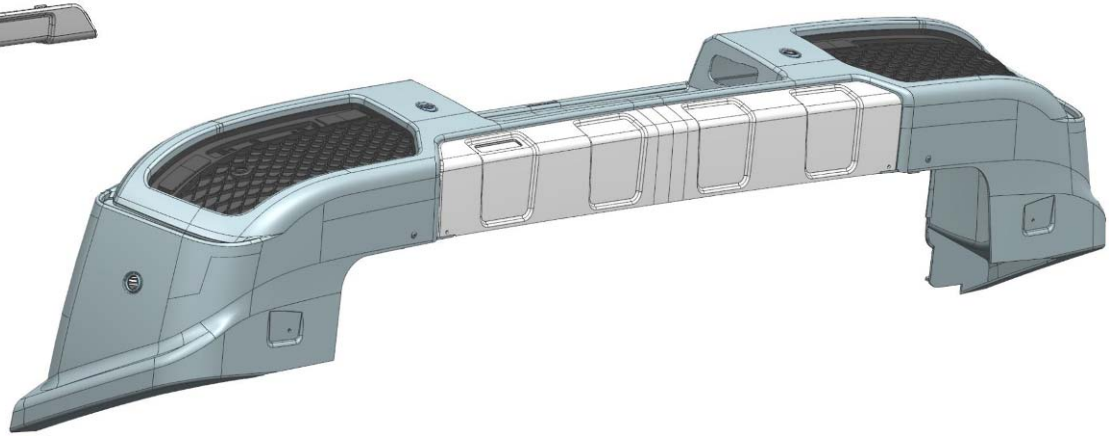


Clip the standard reflectors on the left- and right-hand side into the BRABUS rear

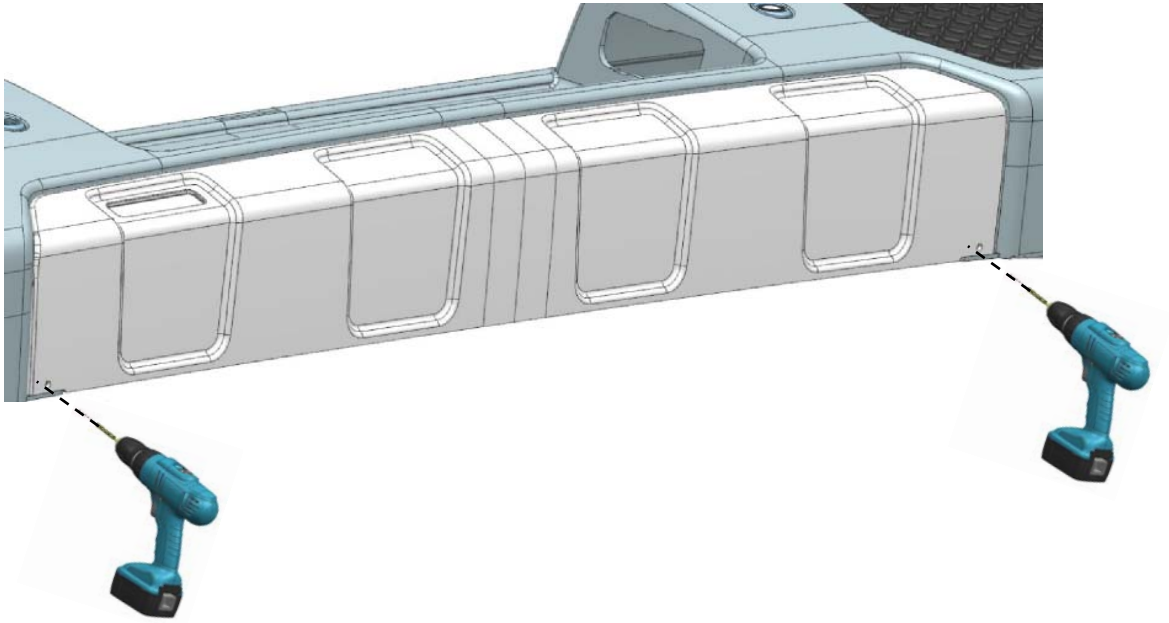


Clip the BRABUS design underride guard into the openings of the BRABUS rear bumper.

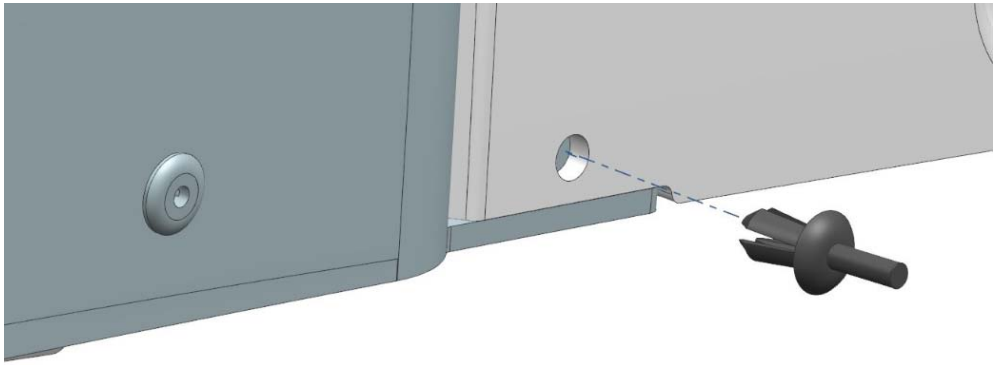




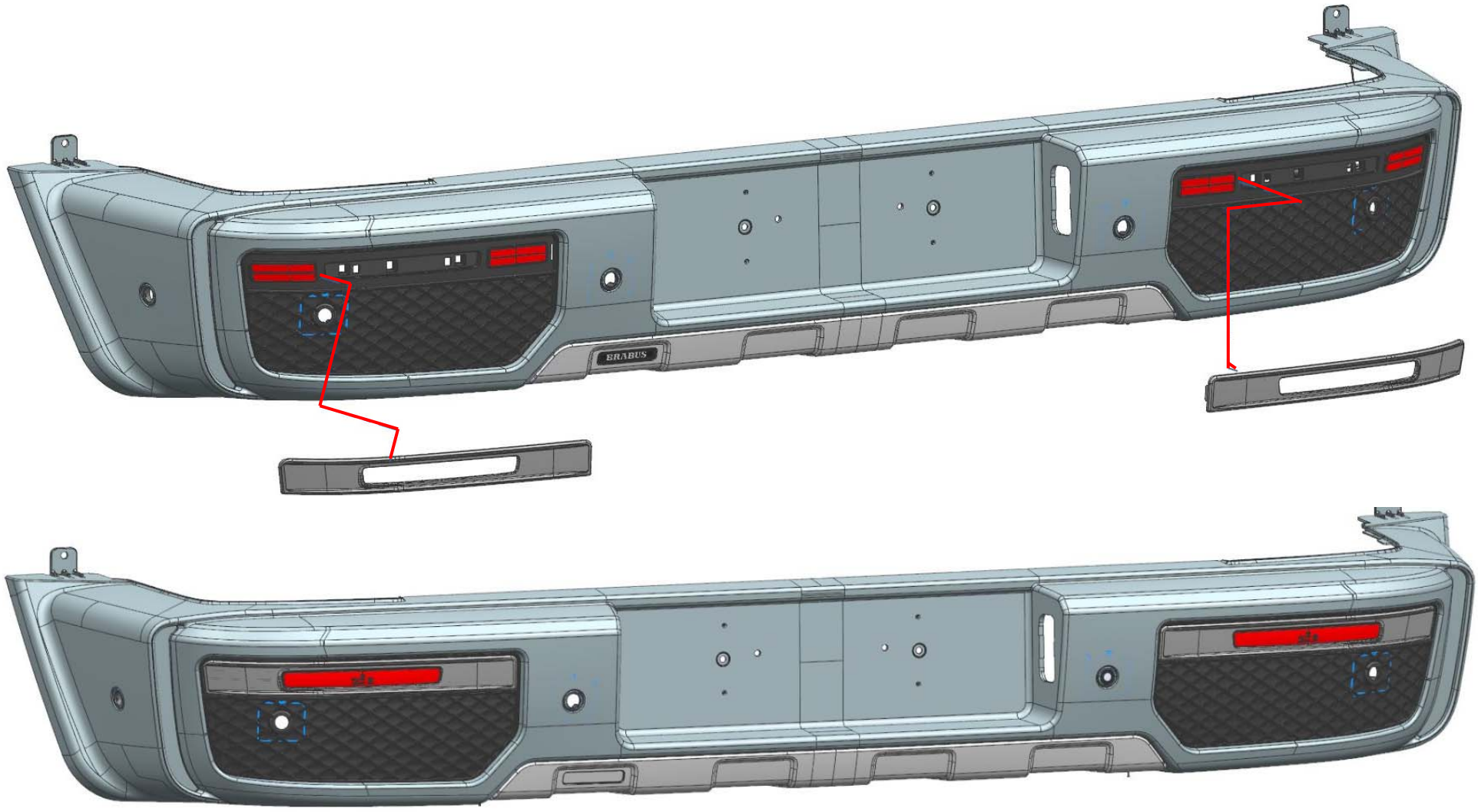
Use a suitable 5.5 mm drill bit and a suitable drilling machine to drill Ø 5.5 mm holes in the BRABUS design underride guard and rear bumper in the positions shown (stamped).



Fasten the BRABUS design underride guard in the lower area on the left- and right-hand side using the delivered plastic expanding rivets.



Clean the adhesive surfaces of the rear bumper trim panels on the left- and right-hand side using silicone remover in two stages. Remove the liners of the VHB adhesive strips at the rear bumper. Affix the trim panels to the recesses of the rear bumper at the same distance all round and firmly press them on.



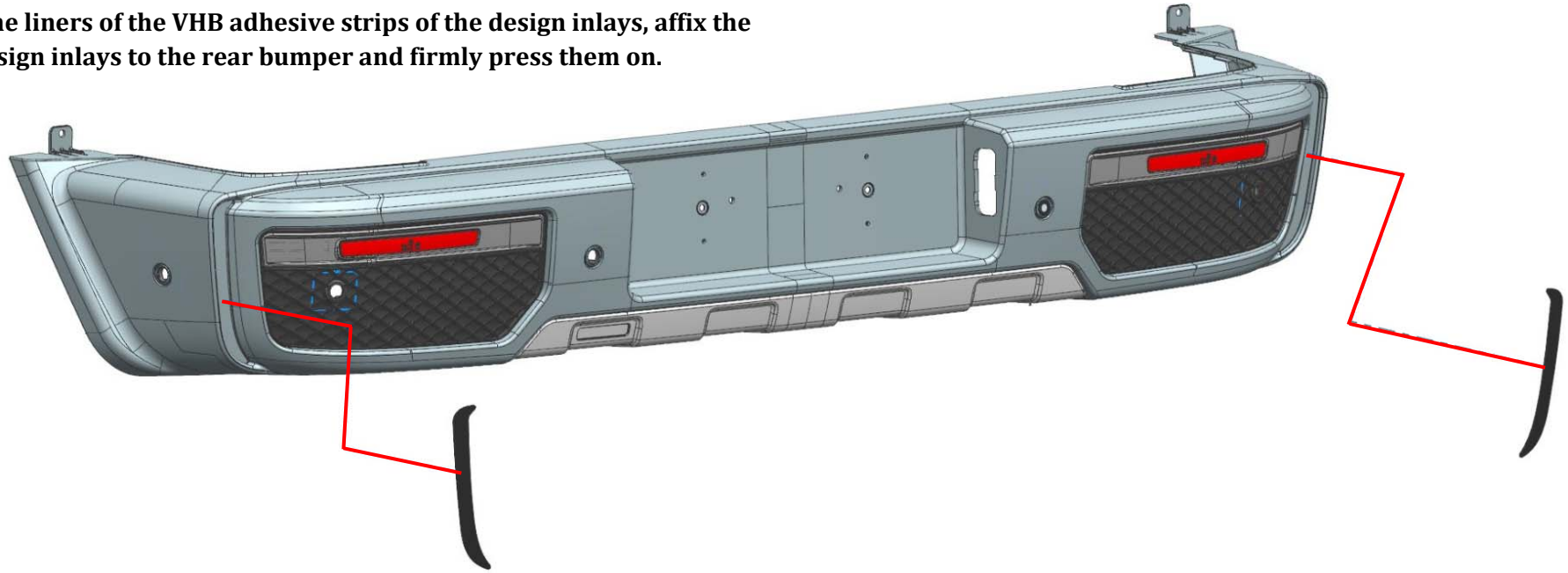
Clean the adhesive surface in the recess of the BRABUS design underride guard using <u>silicone remover</u> in <u>two</u> stages.

Remove the liner of the adhesive strip of the BRABUS lettering, affix the lettering to the recess and firmly press on it.

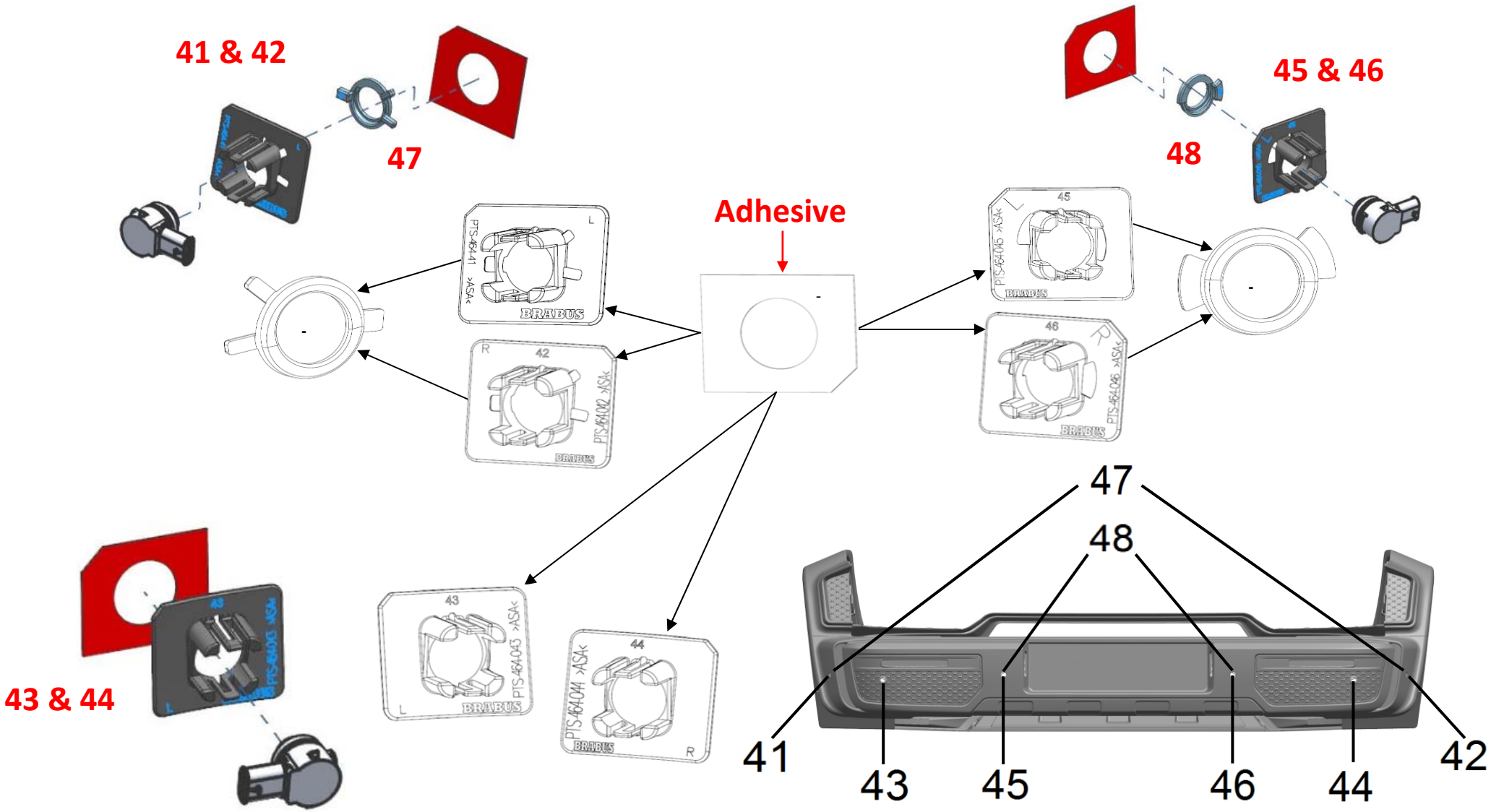


Clean the adhesive surfaces for the BRABUS design inlays on the left and right side in the rear bumper using <u>silicone remover</u> in <u>two</u> stages.

Remove the liners of the VHB adhesive strips of the design inlays, affix the design inlays to the rear bumper and firmly press them on.

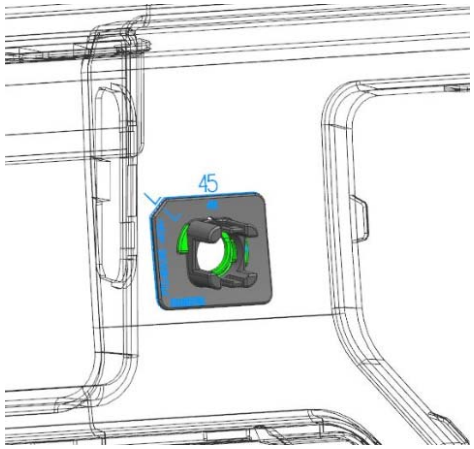


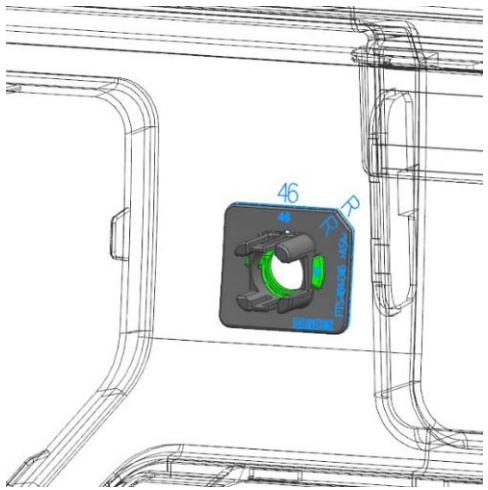
Assignment of the PTS sensor brackets to the inlays and adhesive pads for the rear bumper

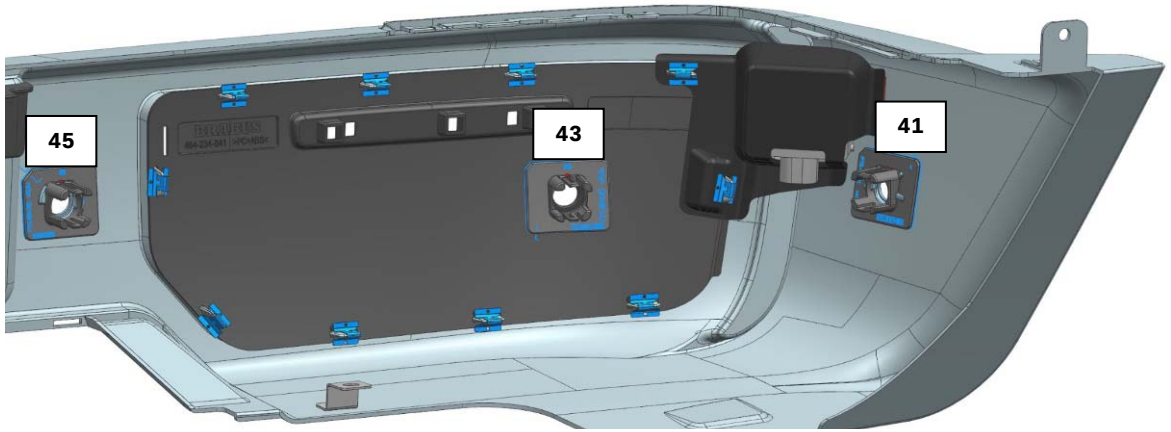


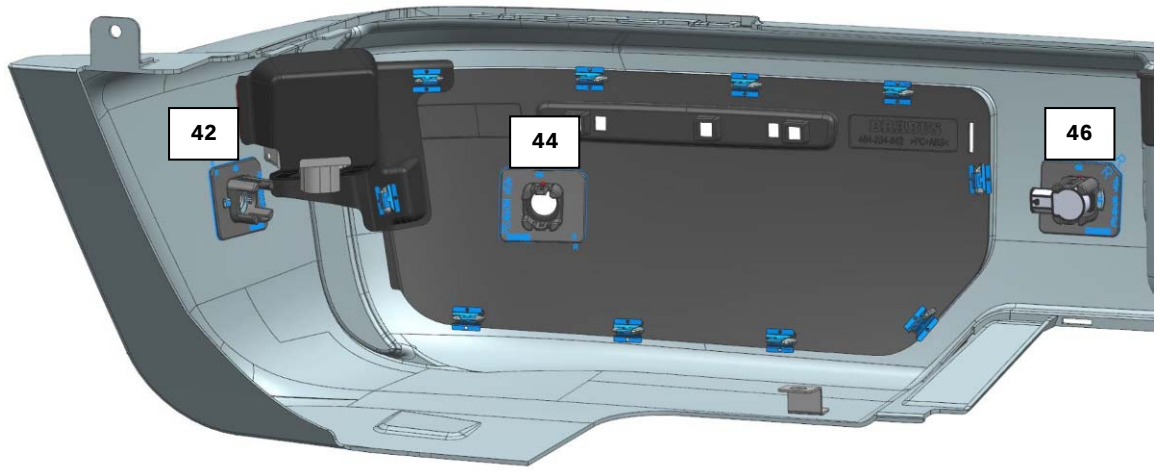
Clean the adhesive surfaces of the PDC sensors in the rear bumper and the adhesive surfaces of the PDC brackets -045 & -046 using silicone remover in two stages.

Affix the VHB adhesive pads with the part numbers -51 to the PDC brackets with the part numbers -45 & -46. Clip the PDC sensors into the PDC brackets. Remove the liners of the VHB adhesive pads. Affix the PDC units to the intended positions at the same distance all round to the hole in the rear bumper. Here, it is absolutely necessary to check the area visible from the outside! Firmly press on the PDC units.



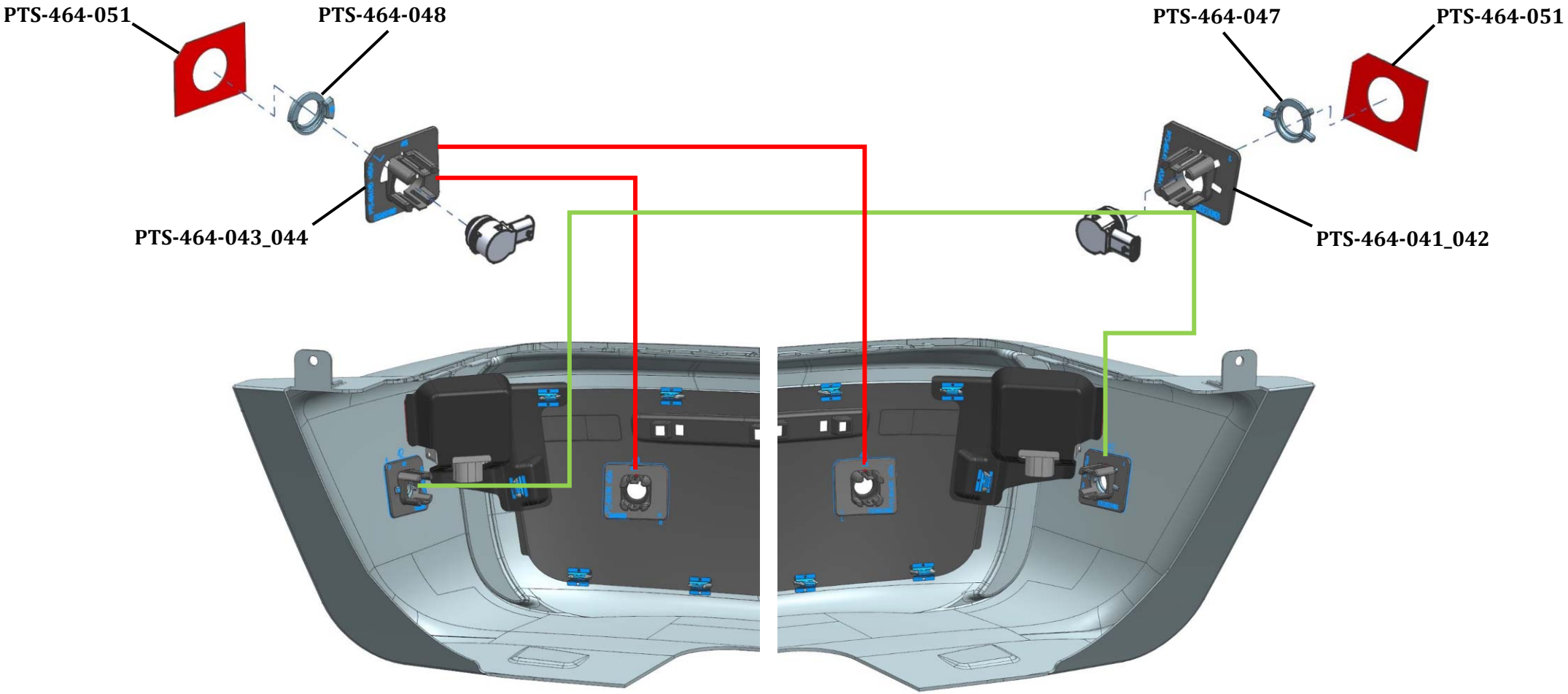




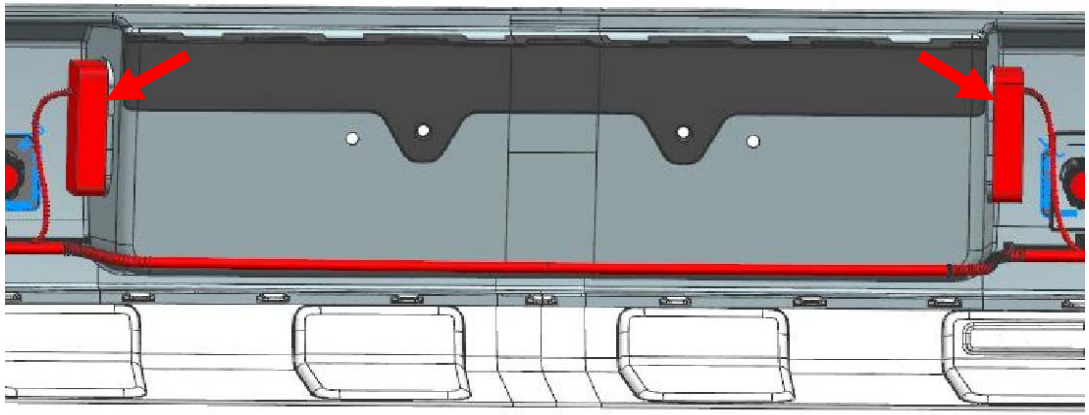


Clean the adhesive surfaces of the PDC sensors in the rear bumper and the adhesive surfaces of the PDC brackets -041, -042, -043 and -044 using silicone remover in two stages.

Clip the PDC sensors into the brackets as shown and equip them with the inlays and the adhesive pads -051. To do this, remove the liners with the sides facing the brackets and affix the pads to the brackets. Firmly press on the VHB adhesive pads and remove the liners from the other sides. Affix the completed PDC units to the intended positions at the same distance all round to the hole in the rear bumper according to the assignment on page 34 and firmly press them on.

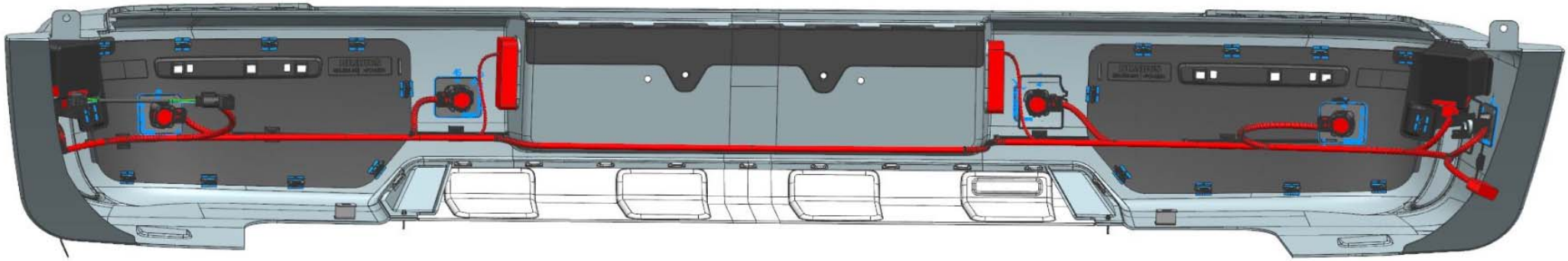


Clip the number plate lights into the BRABUS rear bumper analogously to the standard fastening

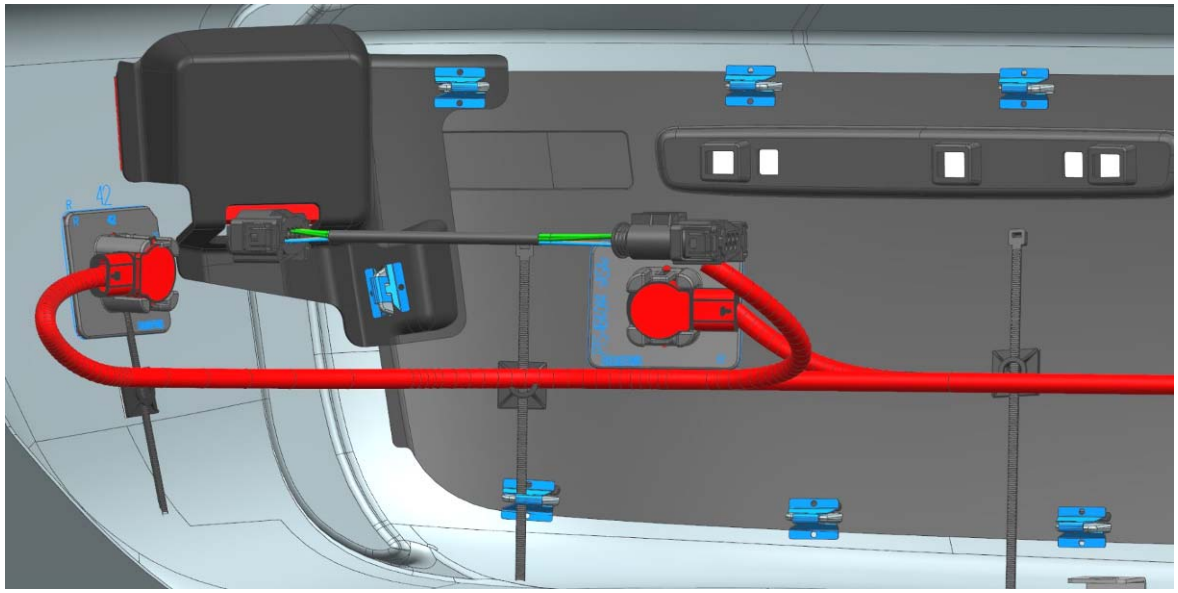


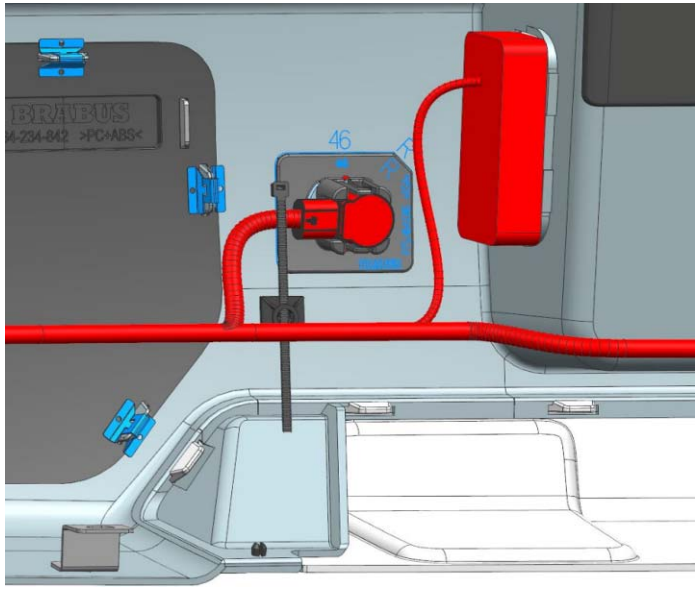
Establish the plug connection of the rear bumper cable harness to the adapter cable of the right radar sensor (only for vehicles with an SA-Code EA2 Blind Spot Assist) and lay the cable harness as shown.

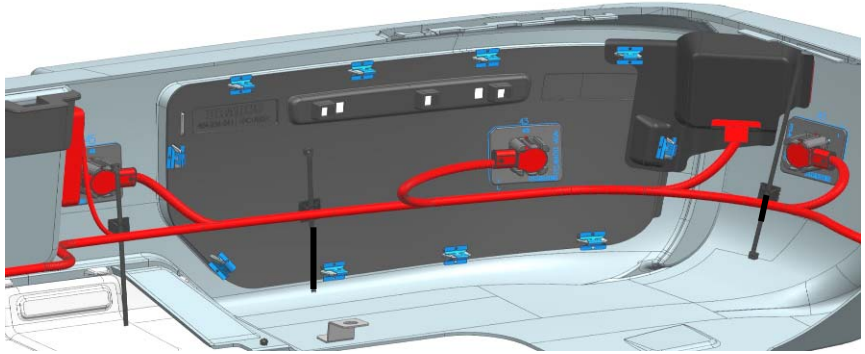
Establish the plug connections of the cable harness to the PDC sensors and number plate lights as well as to the left radar sensor.

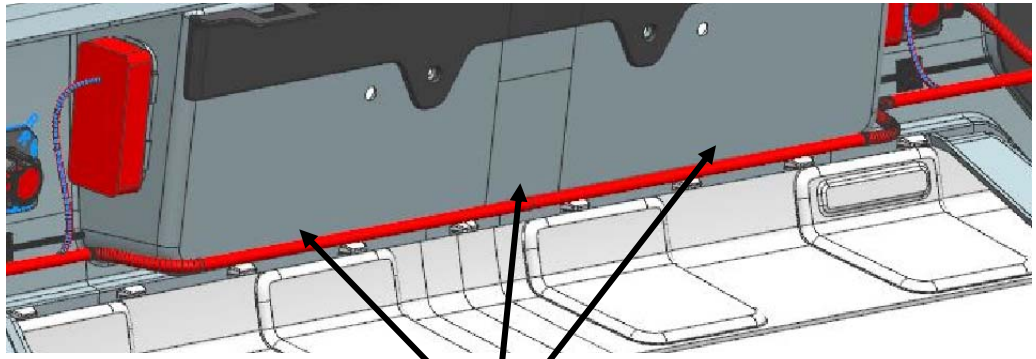


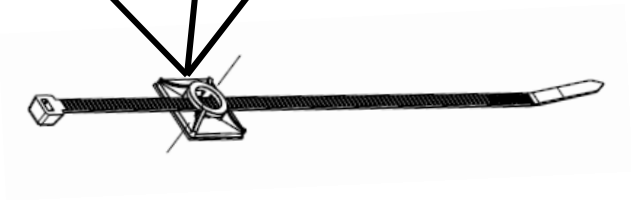
Attach the rear bumper cable harness using cable ties and adhesive pads to the positions shown in the rear bumper. Prior to that, clean the adhesive surfaces of the adhesive pads in the rear bumper using <u>silicone remover</u> in <u>two</u> stages.



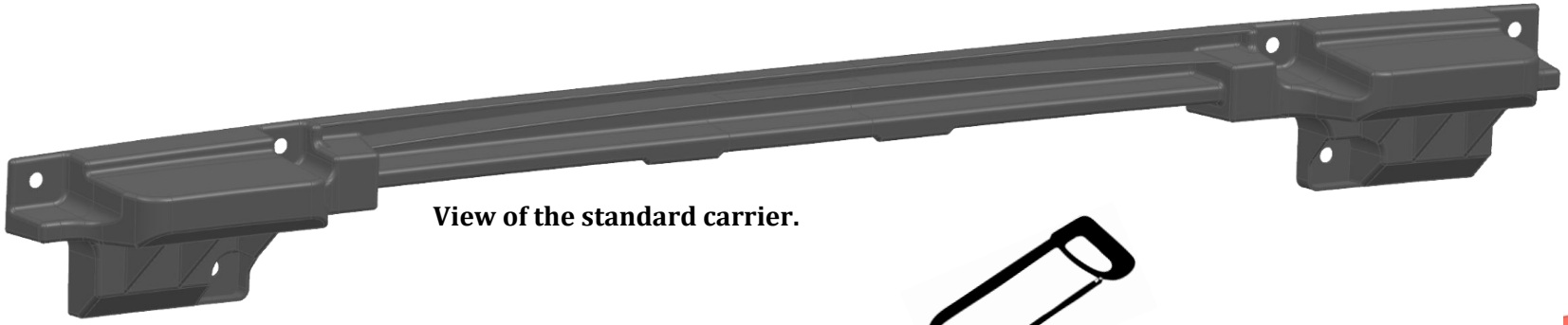




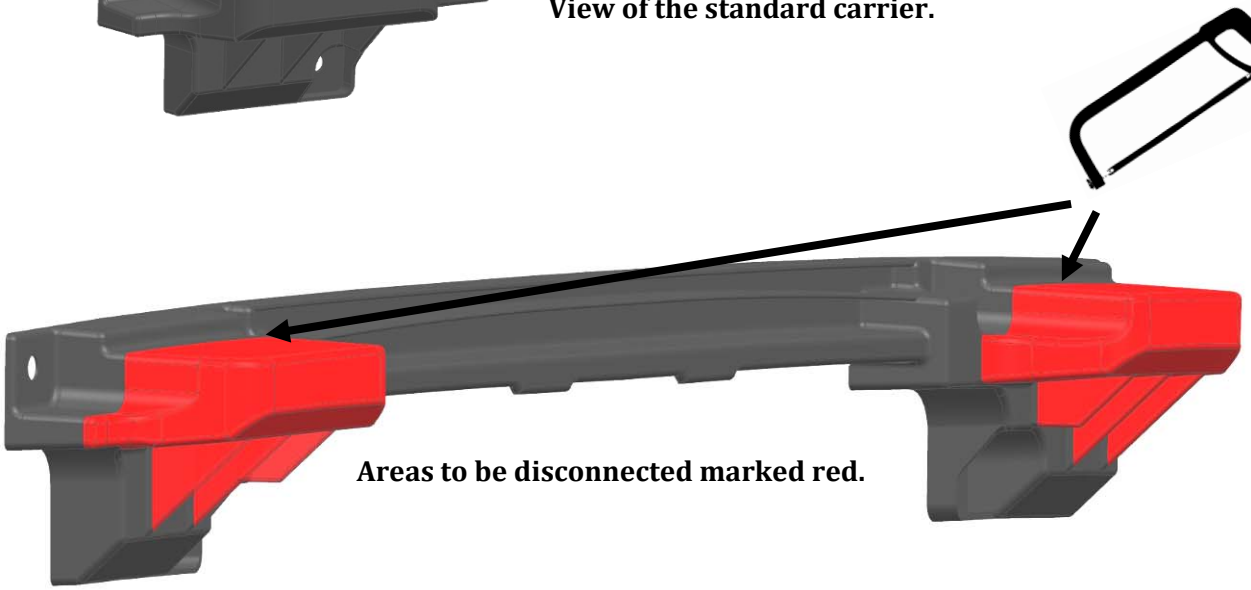




Modify the standard carrier at the rear as shown using suitable sawing tools. The areas

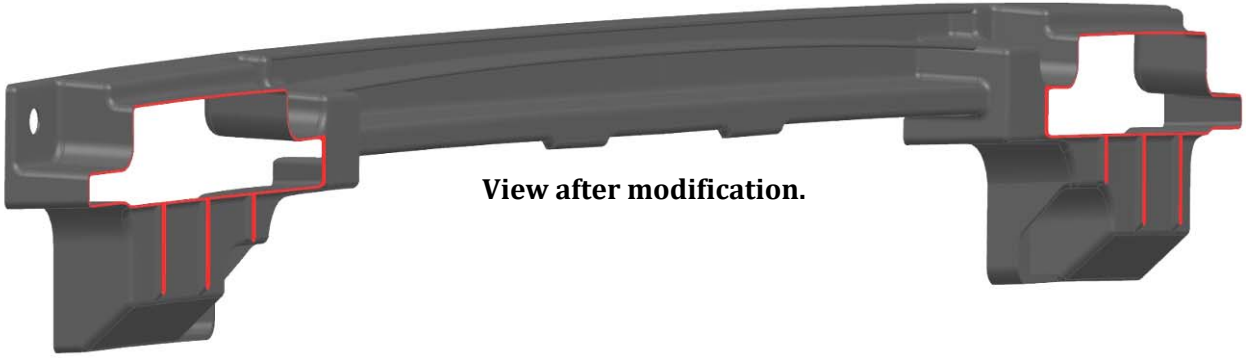


View of the standard carrier.



Areas to be disconnected marked red.





View after modification.

Fasten the wheel arch liners on the inside and drill the outer mounting openings for the assembly of the Ø 7 mm plastic expanding rivets in the carriers of the rear fender attachments.

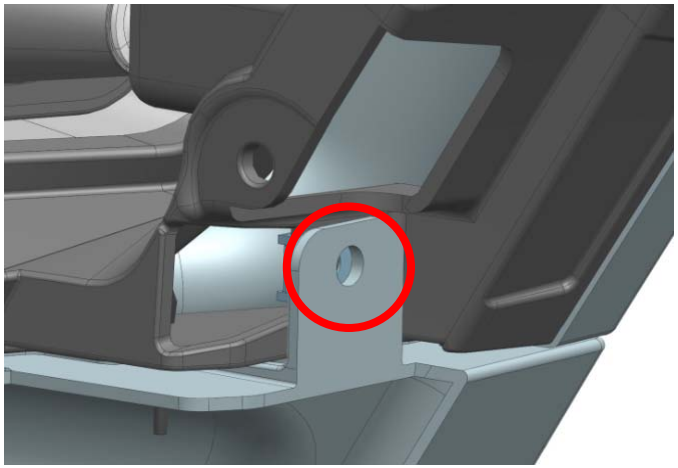
Fasten the wheel arch liners using the standard expanding rivets.



Establish the plug connection of the rear bumper cable harness to the vehicle cable harness. Insert the completed rear bumper into the brackets at the vehicle rear, lock it in place and screw it like the standard component.

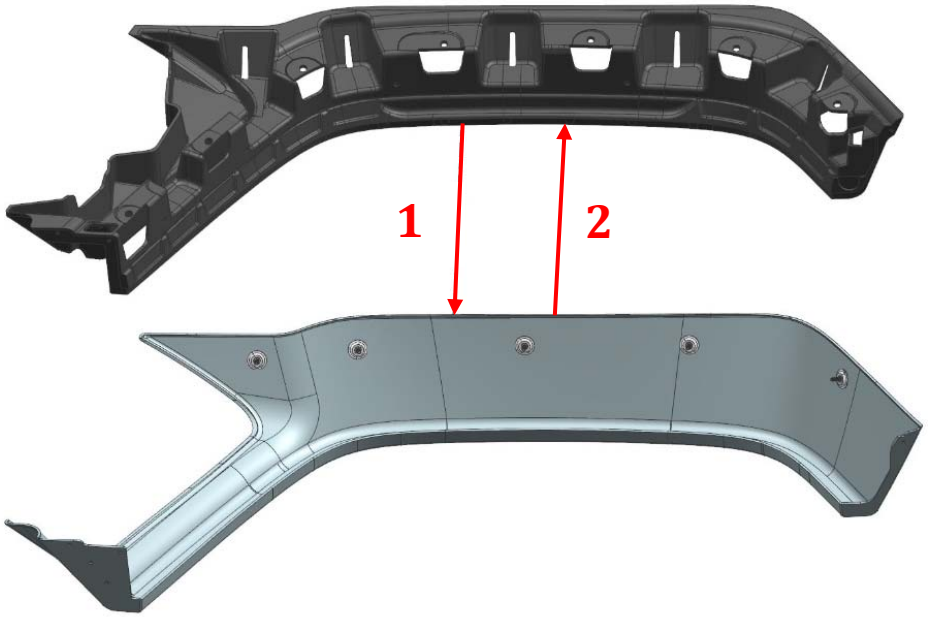


Align the rear bumper to the rear fender attachments and screw it to the fender attachments in the transition area using the standard screws.

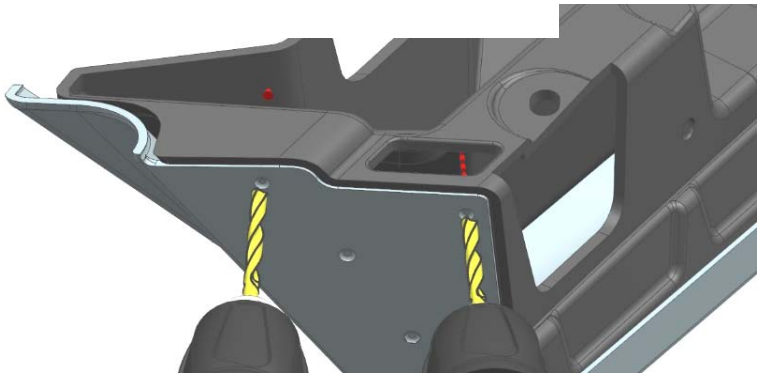


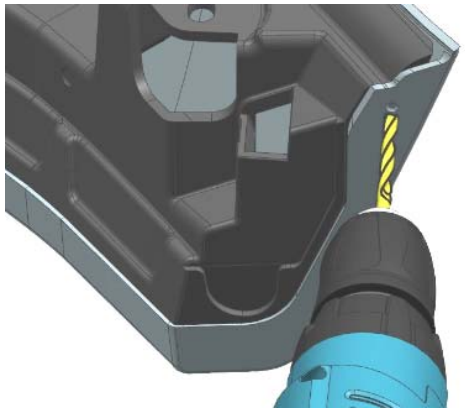
Assembly of the front fender attachments

Insert the carrier into the shell from above and use a suitable Ø 5.5 mm drill bit to drill holes in the positions shown. Remove the carrier again from the shell.

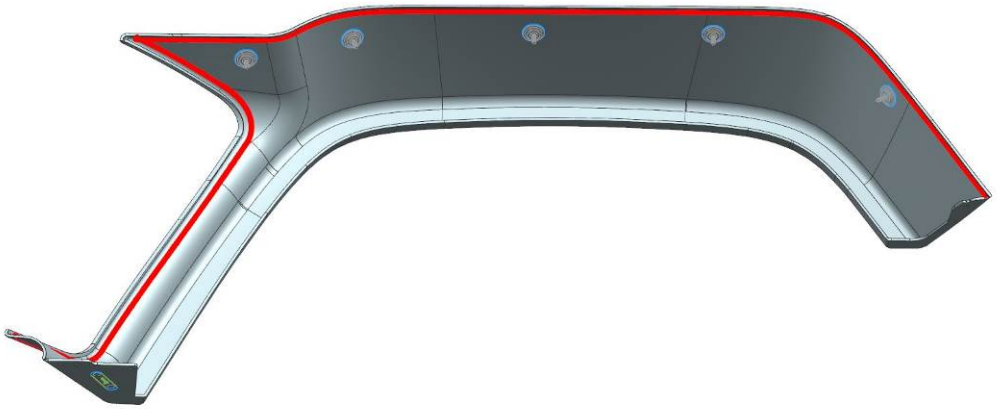


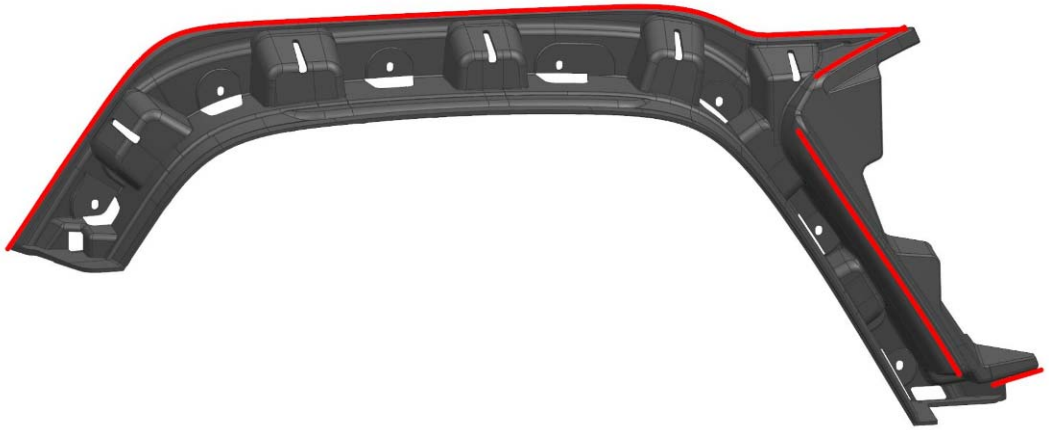




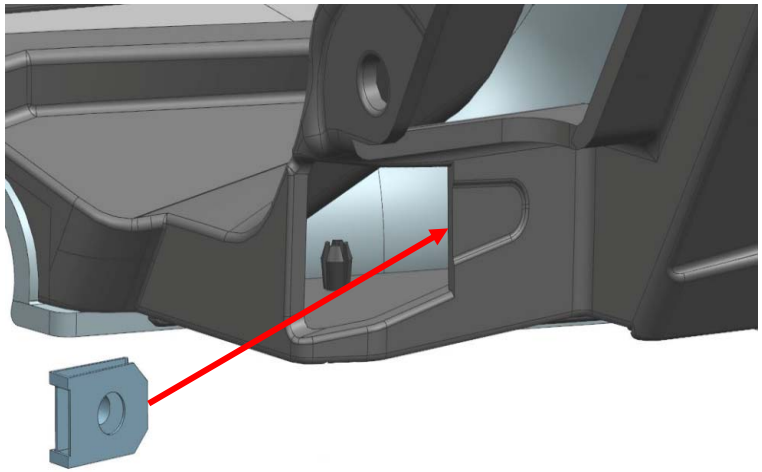


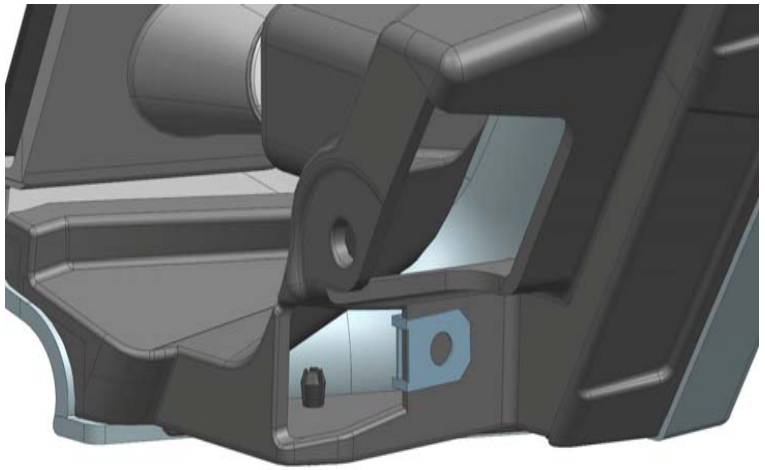
Use sandpaper (240-grit!) to roughen the adhesive surfaces of the shell and carrier which are marked red in the pictures on the following pages and clean them thoroughly afterwards using silicone remover in two stages. The adhesive surfaces must be free of paint mist and completely free of grease!



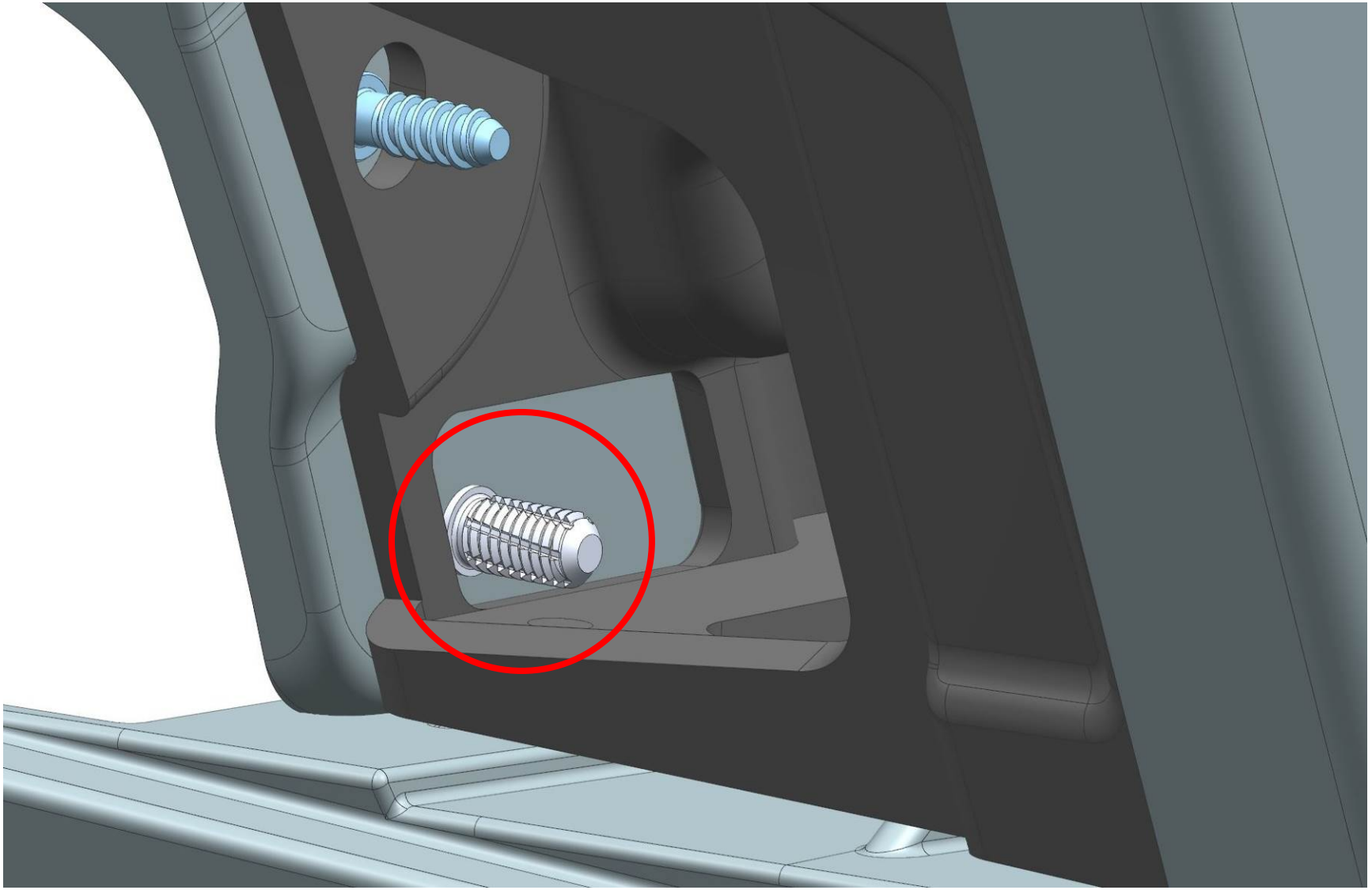


Remove the sheet metal nuts of the screw connections to the front bumper from the original fender attachments and attach them to the fastening points of the carriers of the Widestar fender attachments.

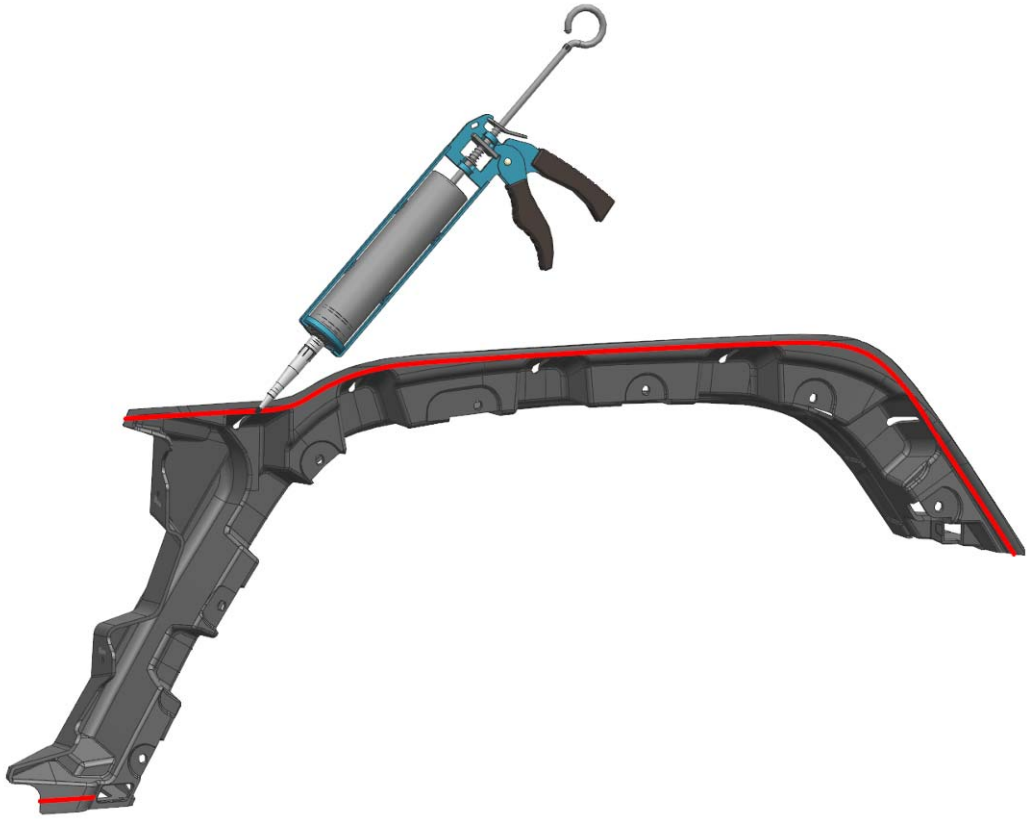




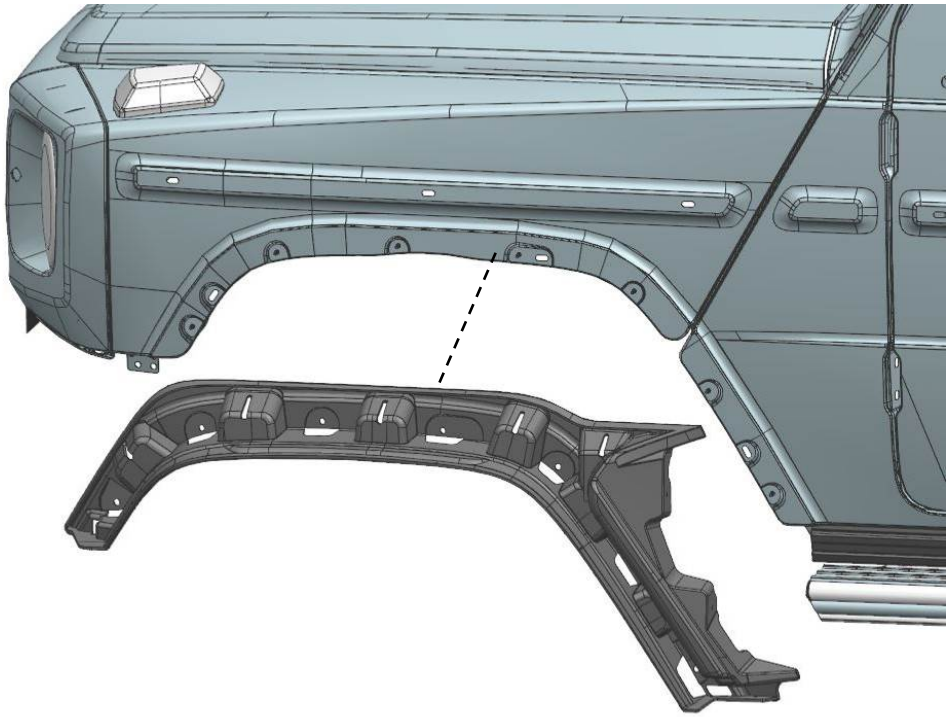
Use a suitable tool to cut the lower standard self-cutting threaded bolt (marked red) to the required length before assembling the carrier and protect the cut surface against corrosion.



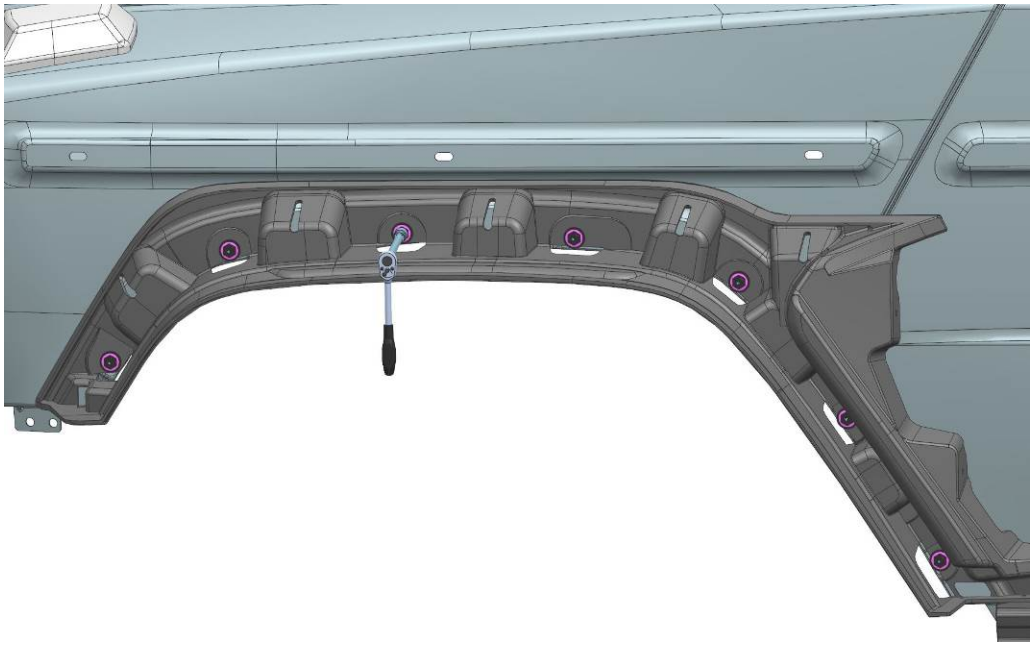
Apply even adhesive beads to the adhesive surfaces as shown. Apply the adhesive beads at a distance of approx. 3 - 4 mm to the outer edges. The opening of the adhesive tip should have a diameter of 4 - 5 mm.



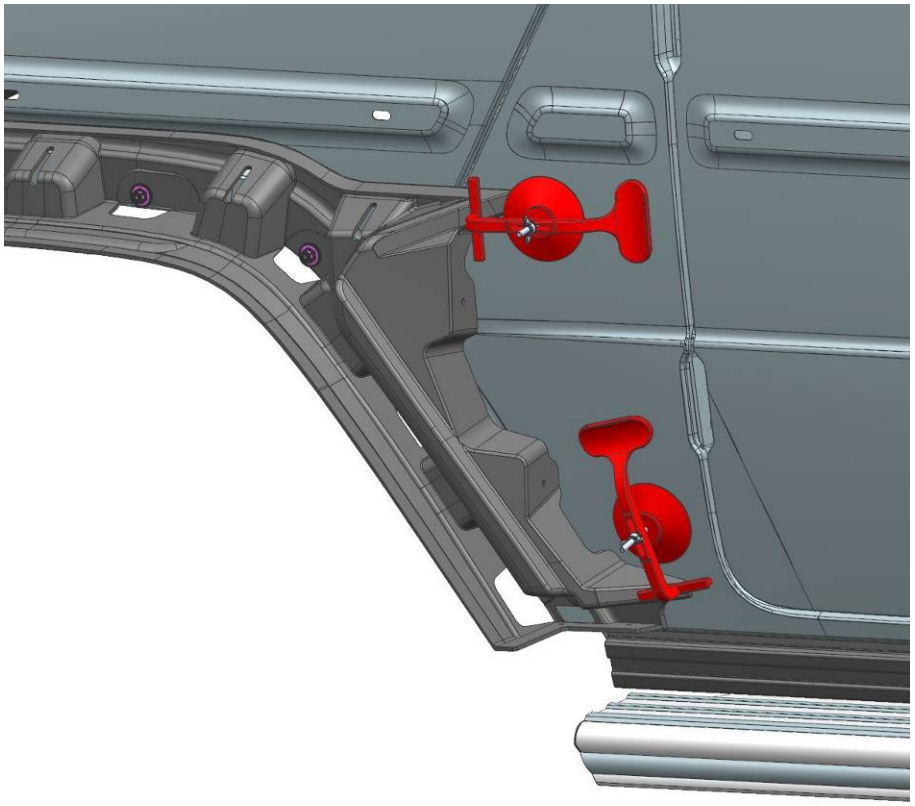
Attach the carrier to the standard fastening points of the car body.



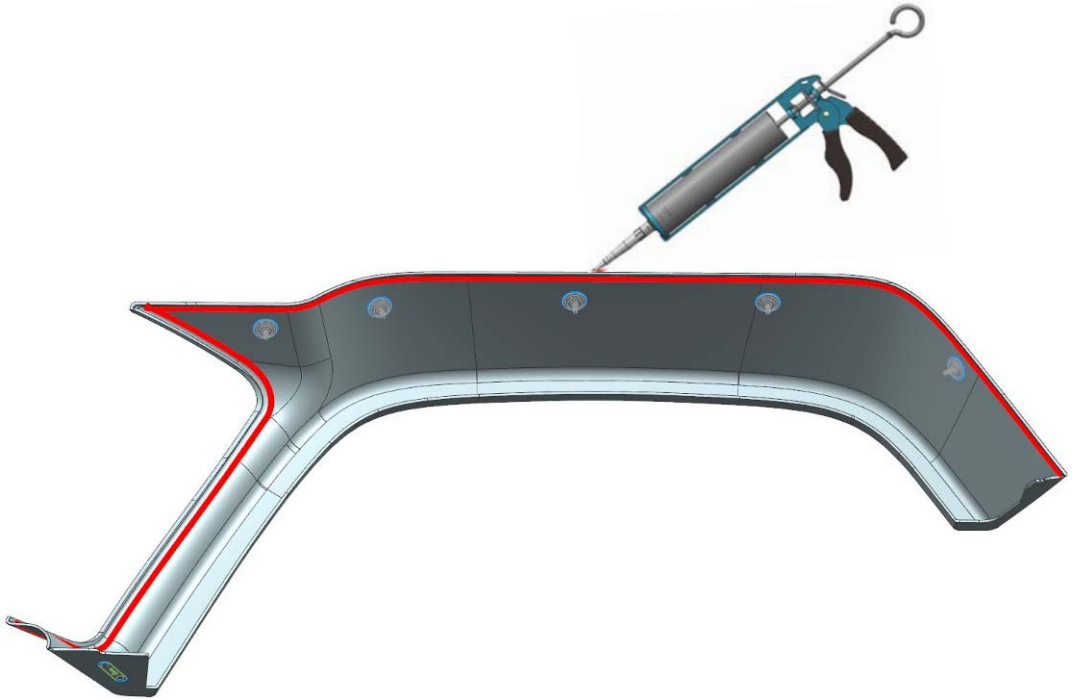
Use plastic nuts to screw the carrier to the standard fastening points. The carrier does not have to rest against the car body over the entire surface.



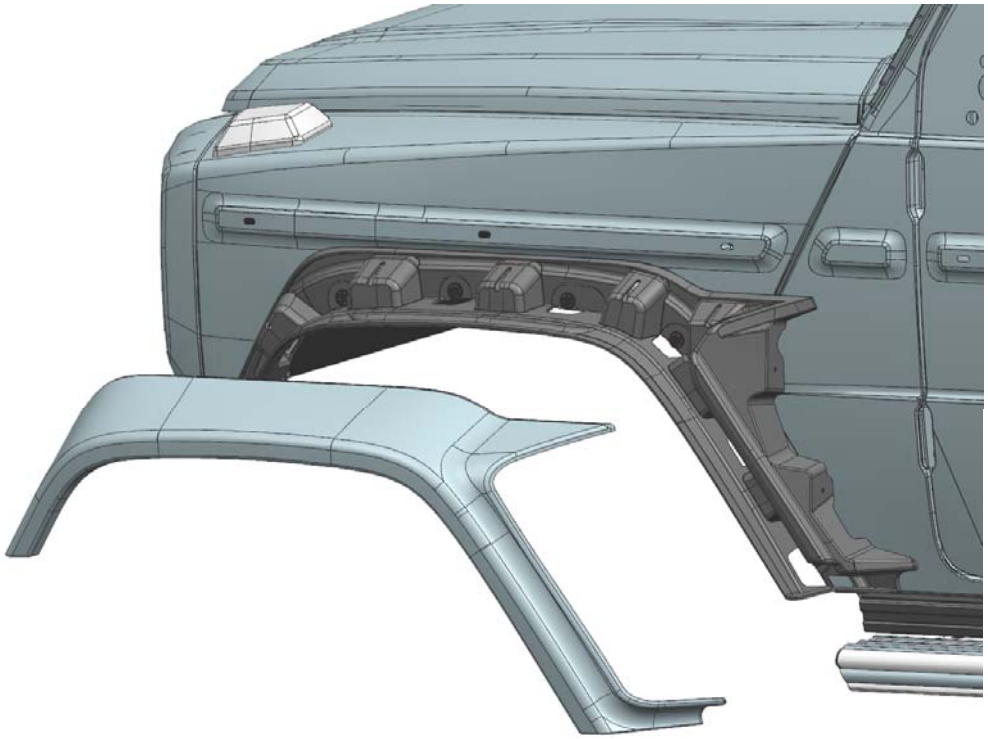
Excess adhesive leaking at the edge must be removed using a suitable cleaner. Fix the carrier in place using suitable means as shown until the adhesive has finally cured.



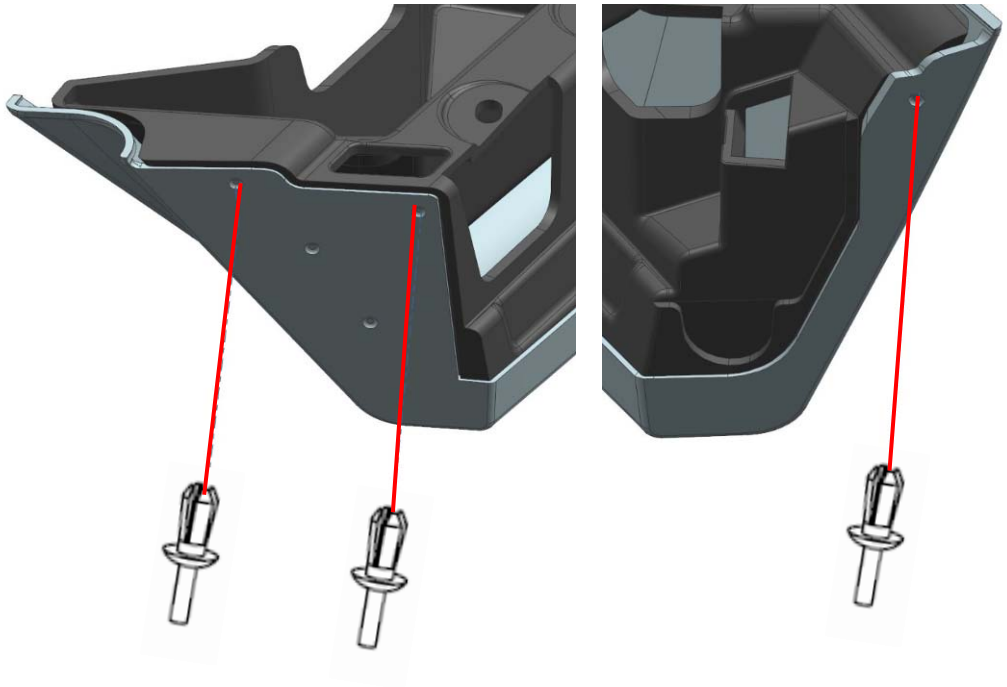
Apply even adhesive beads to the adhesive surfaces as shown. Apply the adhesive beads at a distance of approx. 4 - 5 mm to the outer edges. The opening of the adhesive tip should have a diameter of 4 - 5 mm.



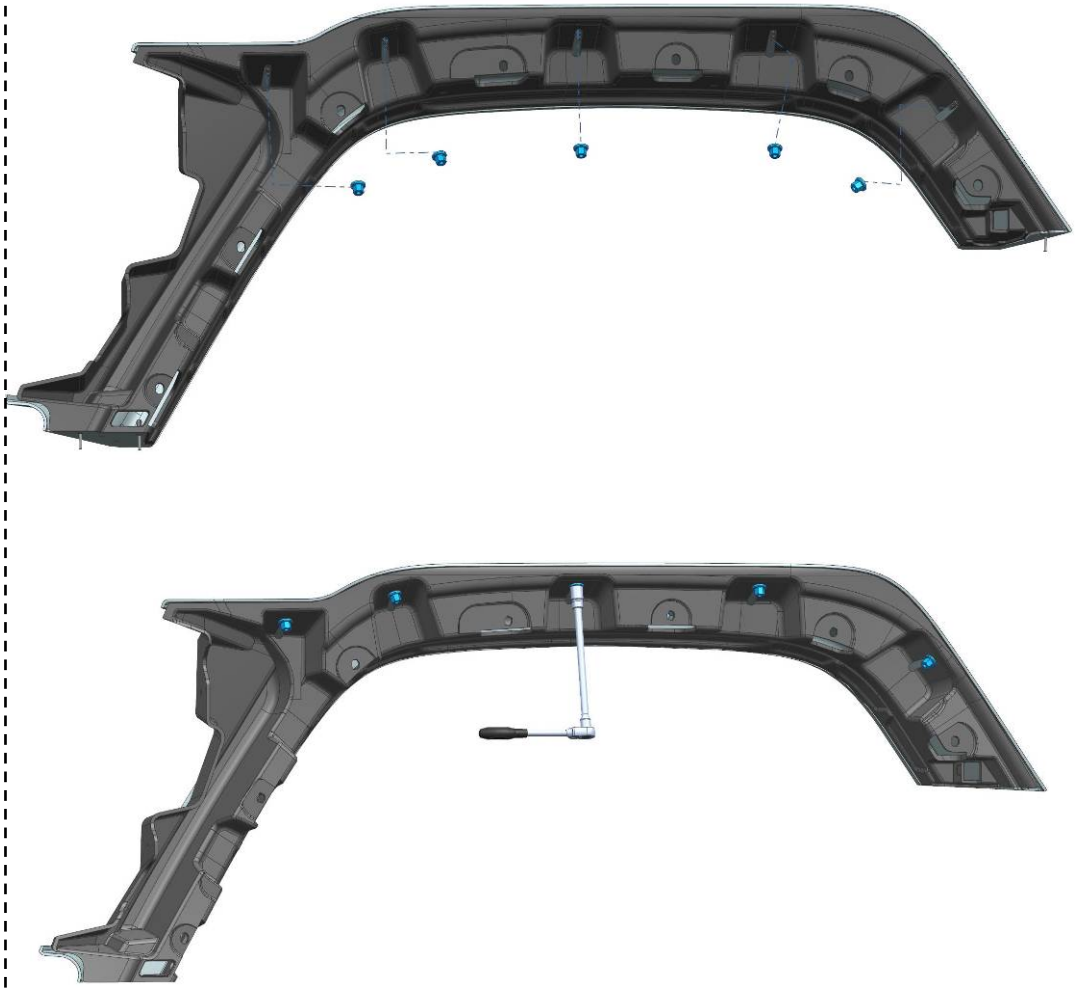
Mount the fender attachment on the carrier and fix it in place using suitable means until the adhesive has cured. Use a fabric tape to fix the fender attachments in place in the transition areas to front rear running board caps until the adhesive has finally cured.



Insert the expanding rivets into the fender attachment as shown.

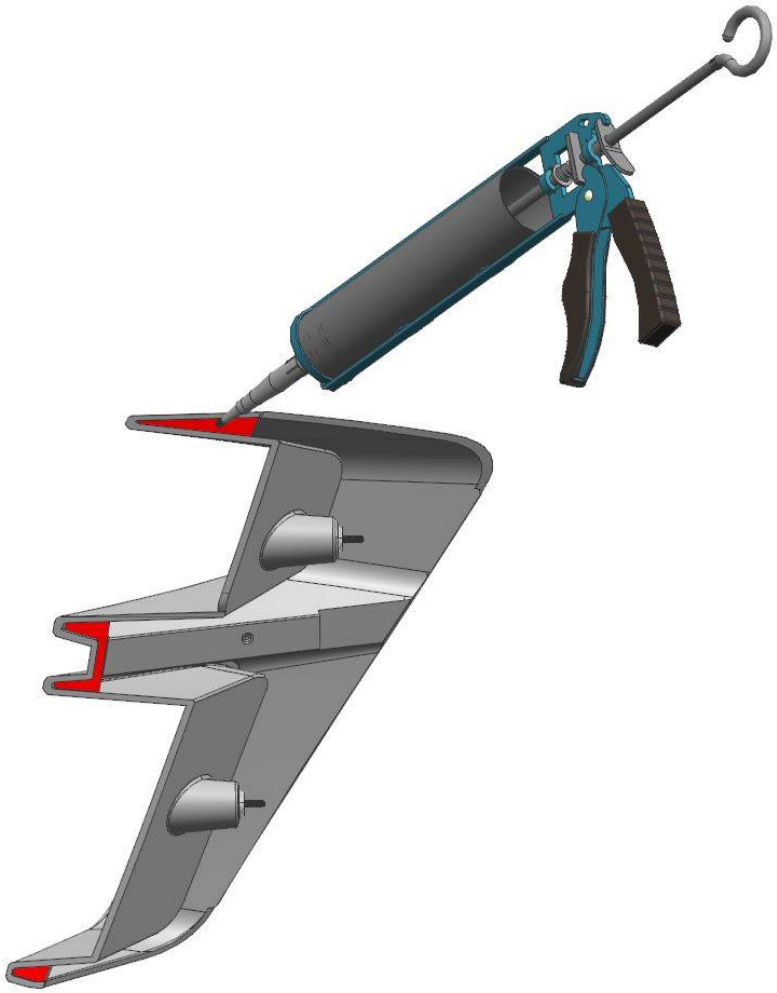


Screw the plastic nuts onto the threads and tighten them hand-tight.



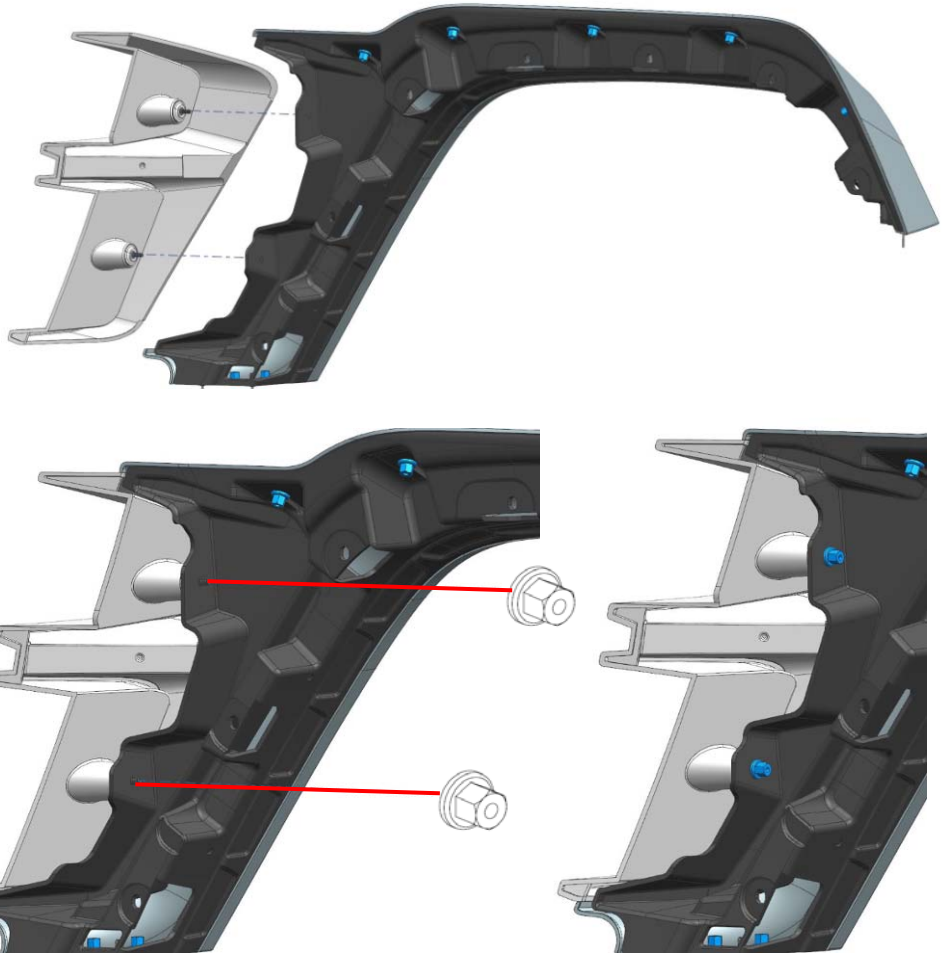
Roughen the adhesive surfaces of the front design frames and thoroughly clean them using <u>silicone remover</u> in <u>two</u> stages.

Apply even adhesive beads of the delivered adhesive to the surfaces marked red. The opening of the adhesive tip should have a diameter of 4 - 5 mm.

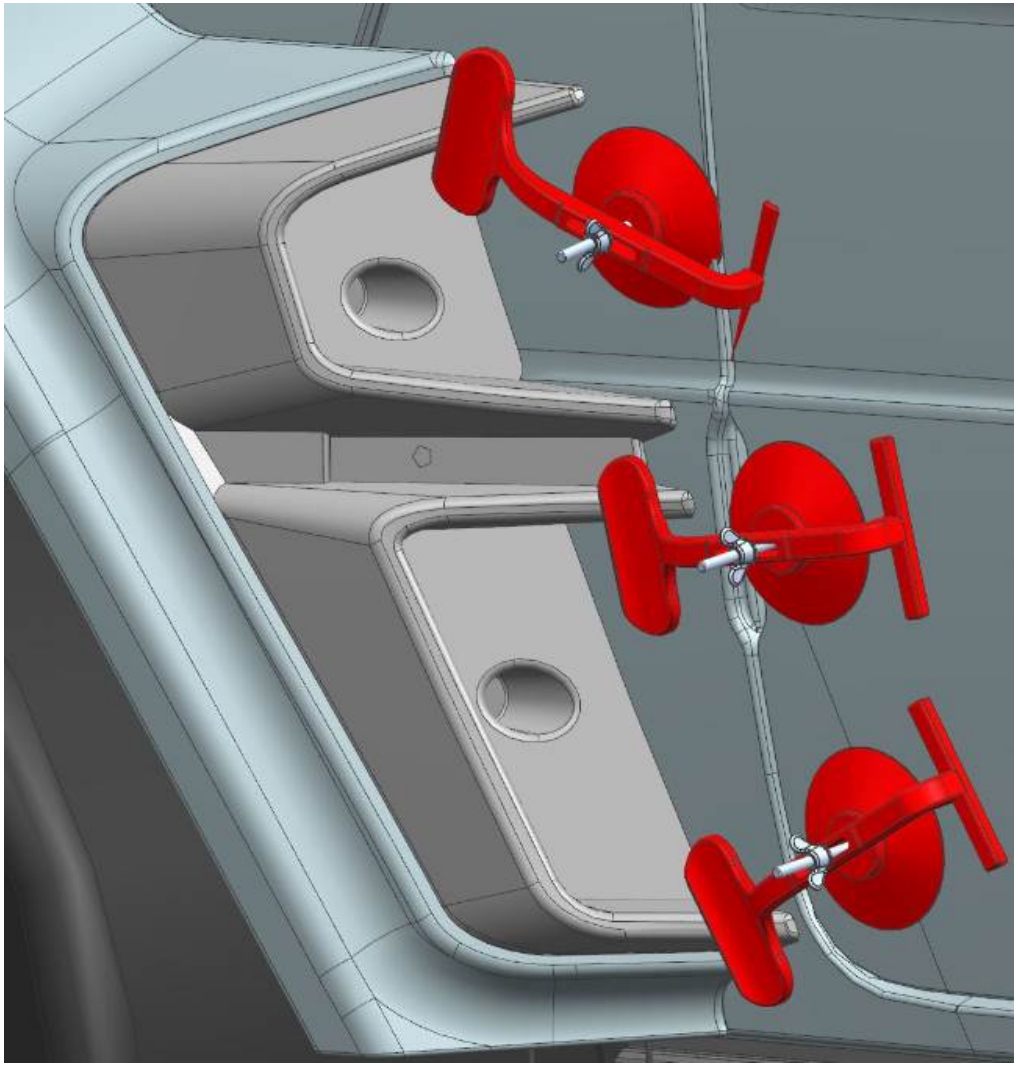


<u>Loosely</u> attach the design air outlets of the front fender attachments using the delivered plastic nuts (22023640).

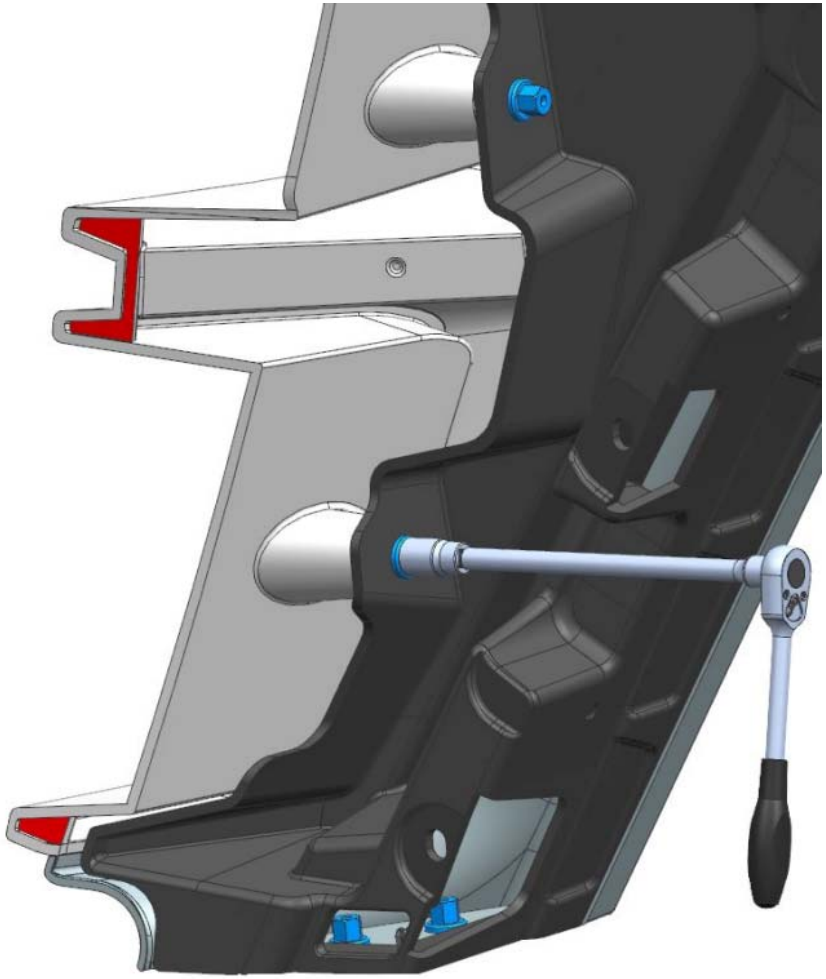
<u>Do not fasten the nuts at this stage yet!</u>



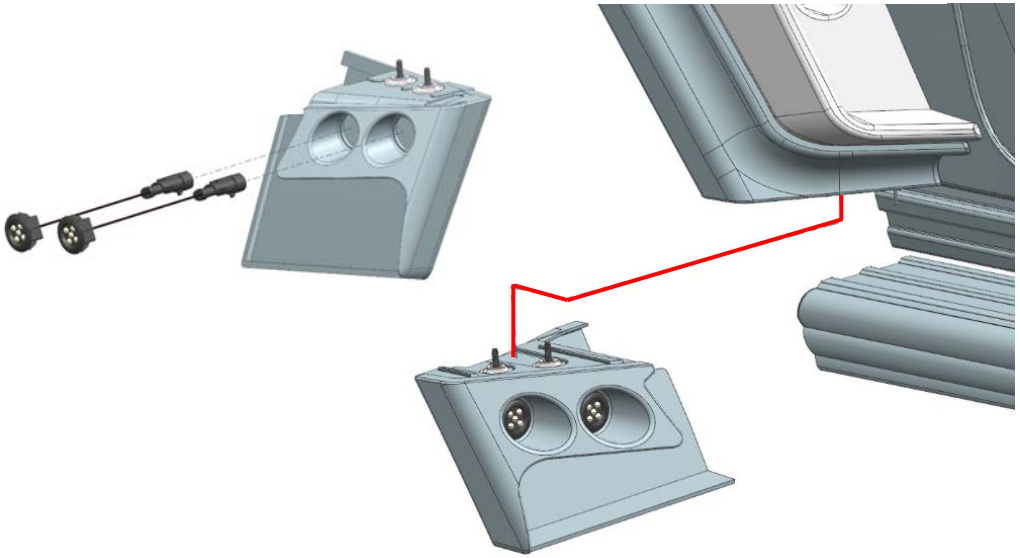
Align the design frames of the front fender attachments. Fix the design frame in place using suitable means as shown until the adhesive has finally cured. We recommend using suction clamps.

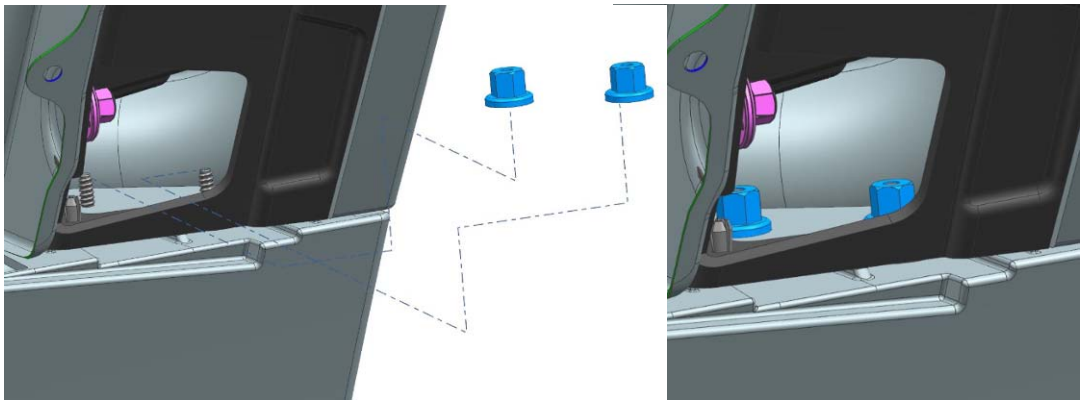


Fasten the plastic nuts of the front design frames after the adhesive has cured.

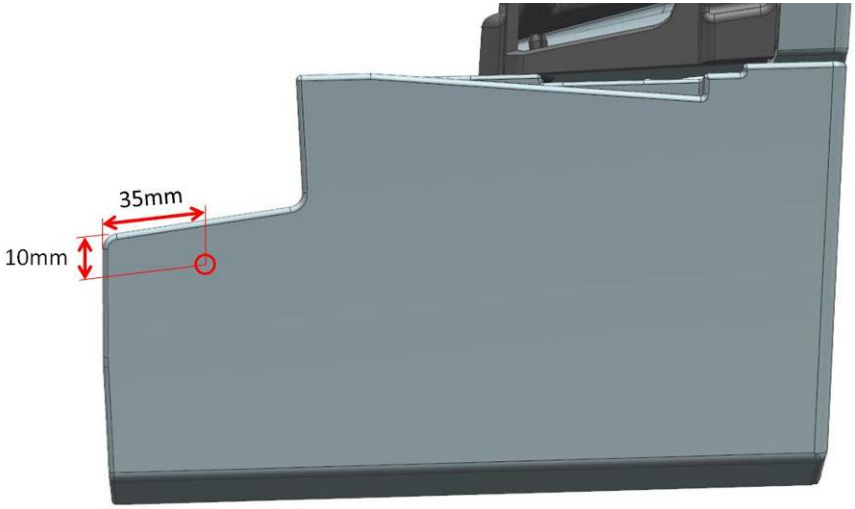


Insert two of the delivered LED running board lights into the rear running board caps (ensuring that they are correctly aligned). Connect the running board light to the vehicle cable harness. Position, align and screw the running board caps between the running boards and rear fender attachments.



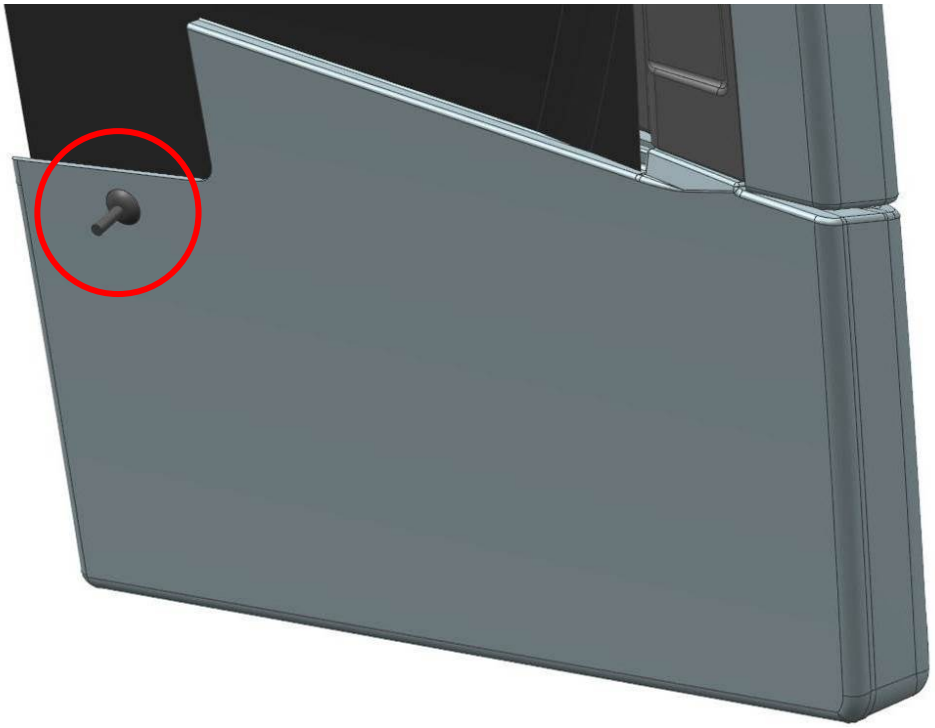


Mark the position shown below at the running board cap. Then drill a hole 5.5 mm in diameter through the running board cap and the standard inner fender in this position.





Connect the running board cap and inner fender using the expanding rivet.

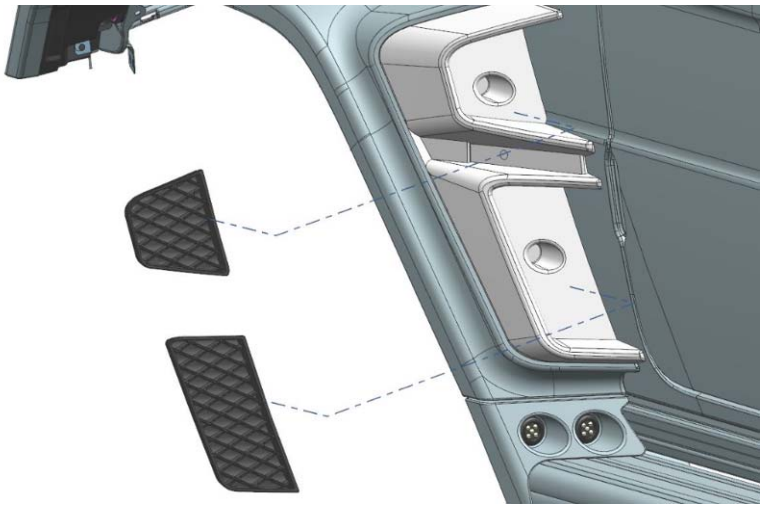


Roughen the adhesive surfaces of the front design grilles and adhesive surfaces of the front design frames marked red and thoroughly clean them using silicone remover in two stages.

Apply even adhesive beads of the delivered adhesive to the areas of the design grilles marked red. The opening of the adhesive tip should have a diameter of 4 - 5 mm.

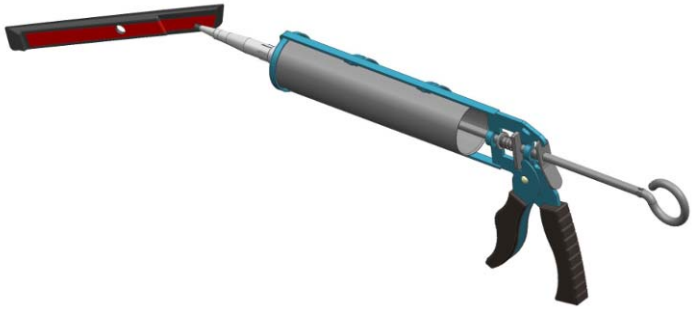
Affix the design grilles to the design frames and align them. Fix them in place using suitable means until the adhesive has finally cured.

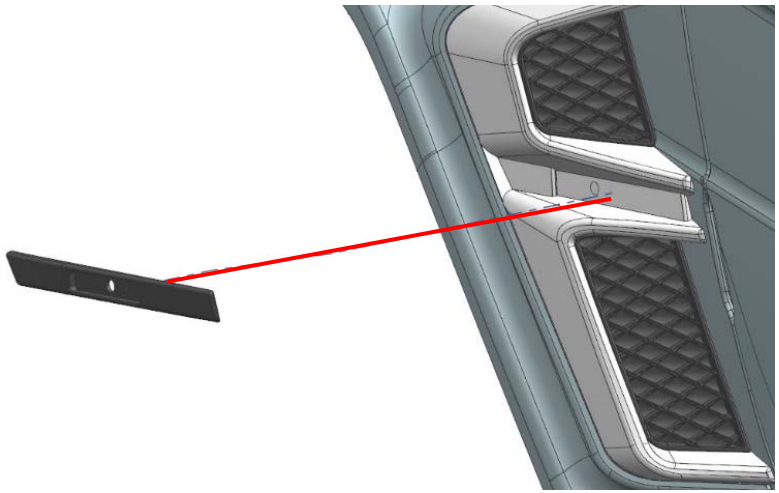




Roughen the adhesive surfaces of the front design frame braces and the adhesive surfaces of the front design frames and thoroughly clean them using silicone remover in two stages.
Apply even adhesive beads of the delivered adhesive to the areas of the design frame braces marked red. The opening of the adhesive tip should have a diameter of 4 - 5 mm.

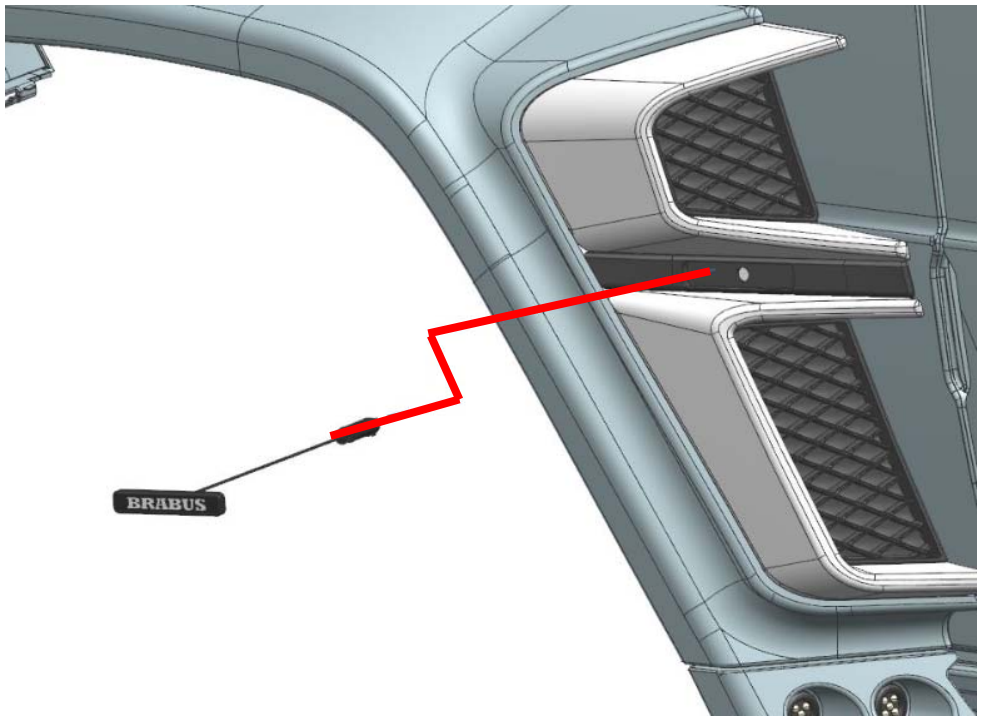
Affix the design frame braces to the design frames and align them. Fix them in place using suitable means until the adhesive has finally cured.





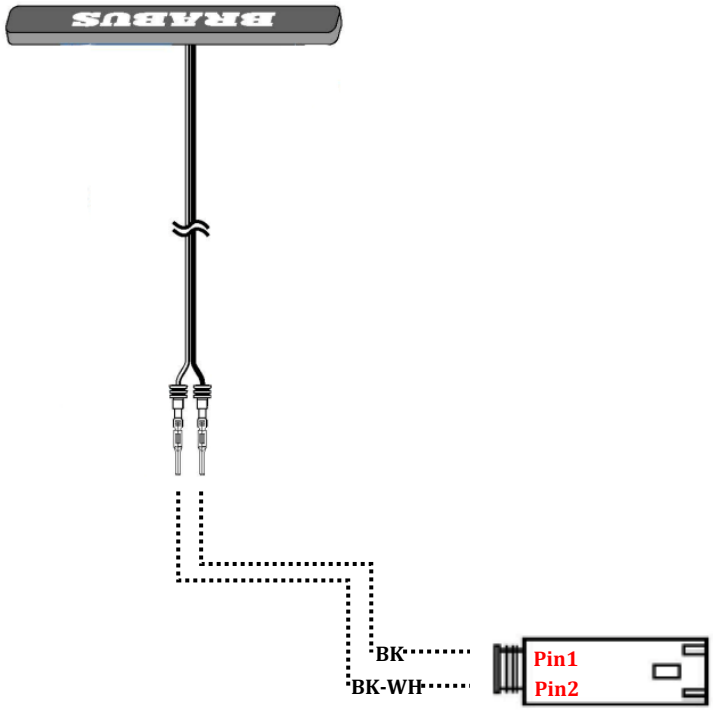
Thoroughly clean the adhesive surfaces of the front design frame braces using silicone remover in two stages. Remove the liner of the VHB adhesive strips of the illuminated logos.

Route the cables for the LED lights of the design frames through the openings of the design frames to the inside, affix the logos to the recesses of the design frame braces and firmly press them on.



Insert the contacts into the delivered plugs and lock them in place according to the assignment below.

Connect the illuminated logos to the vehicle cable harness.



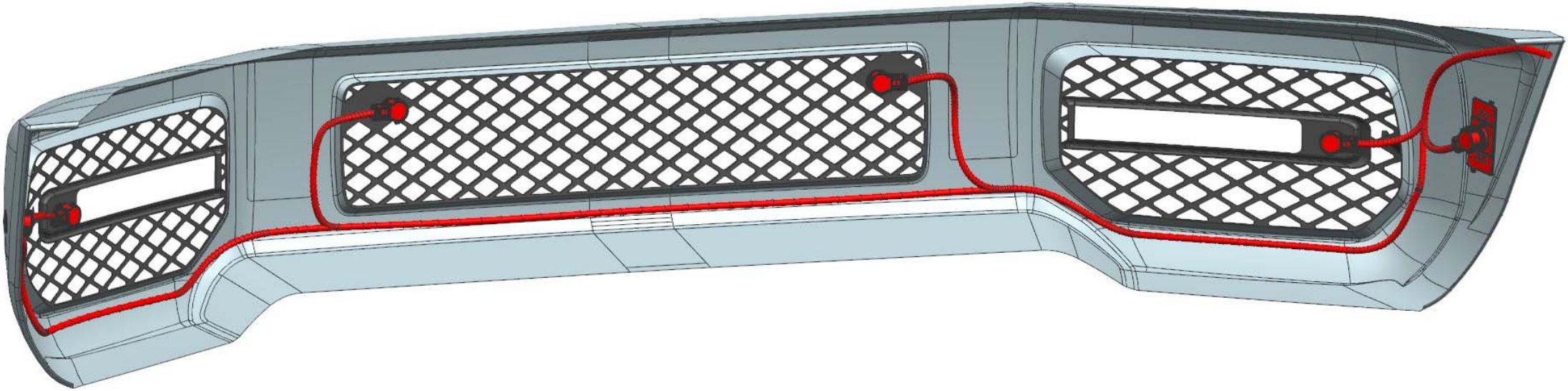
Important:

Loosen all plastic nuts used to fasten the front shells by two turns after the adhesive has cured!



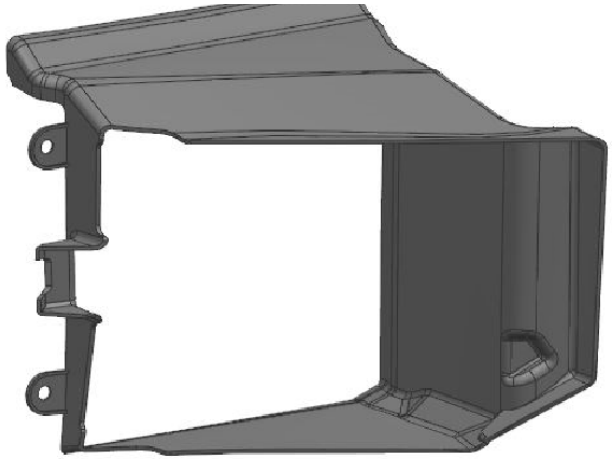
Assembly of the front bumper

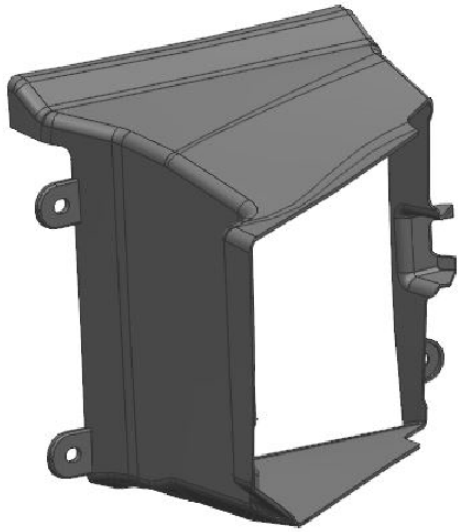
Presentation of the front bumper components which will still be used



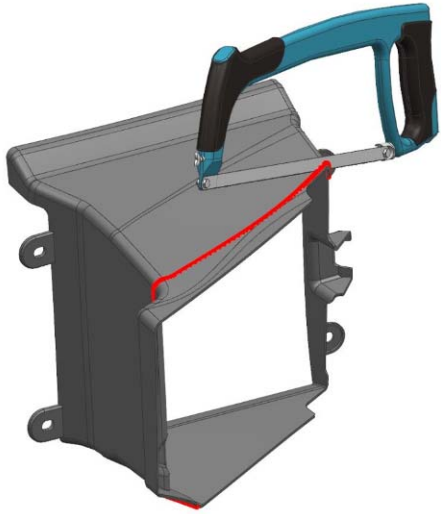
The components marked red must be removed from the standard front bumper. They will still be used when setting up the BRABUS front bumper.

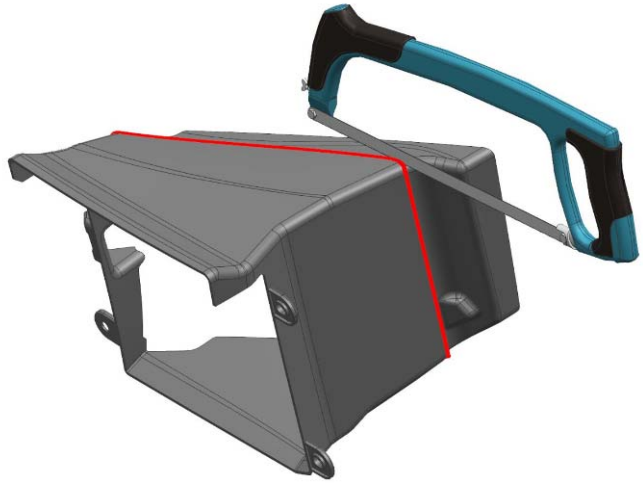
Disassemble the standard radiator housings in front of the intercoolers.

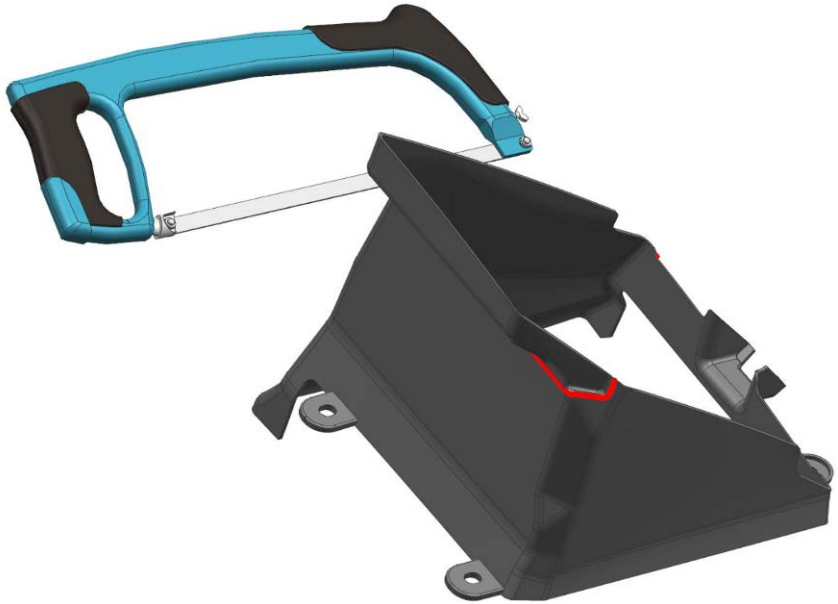




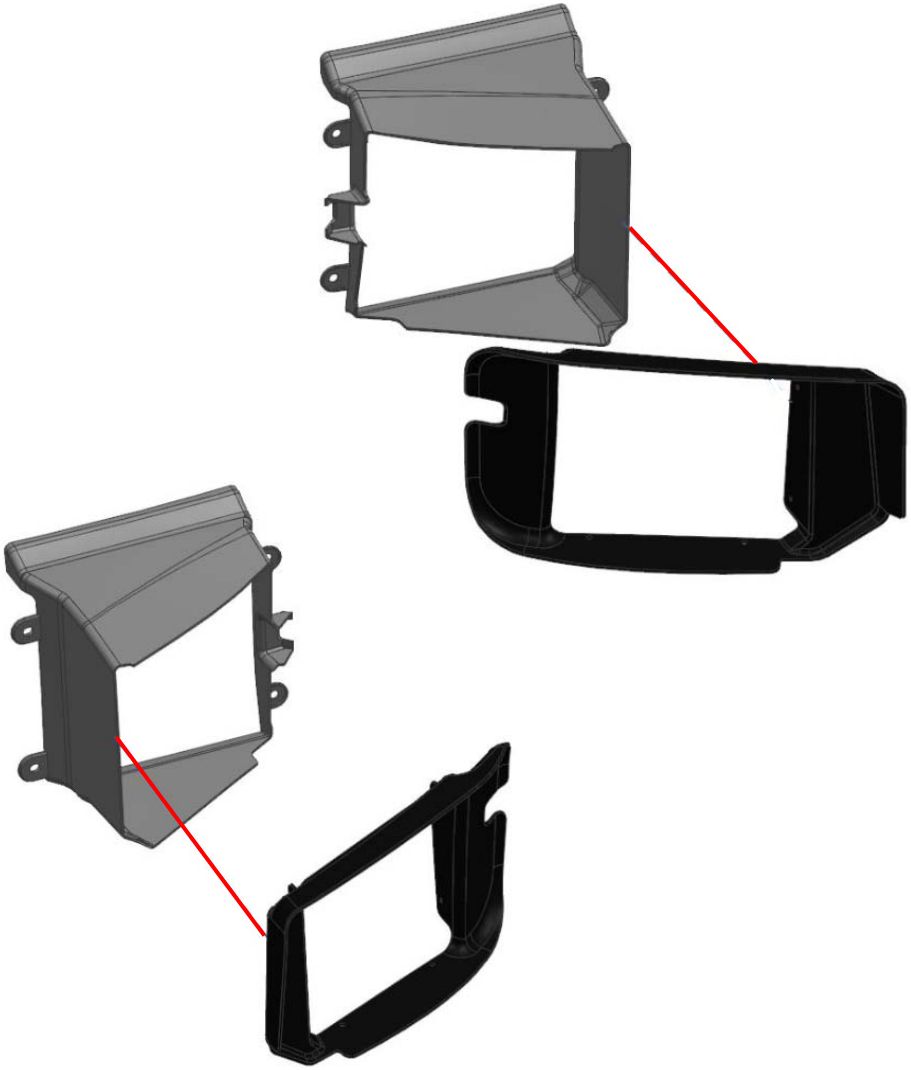
Use suitable tools to process the radiator housings as shown and using the cutting pattern 464-234-915D and deburr the cut edges.



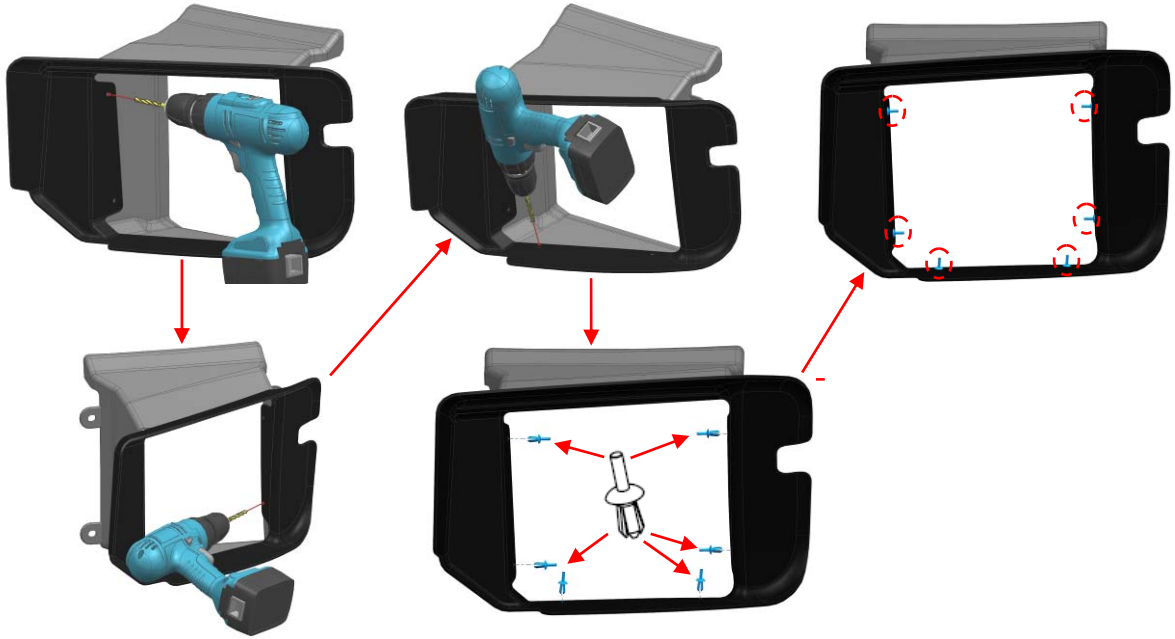


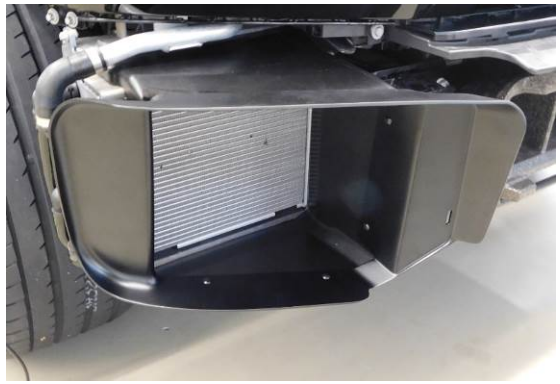


Attach the delivered air ducts to the processed radiator housings as shown.



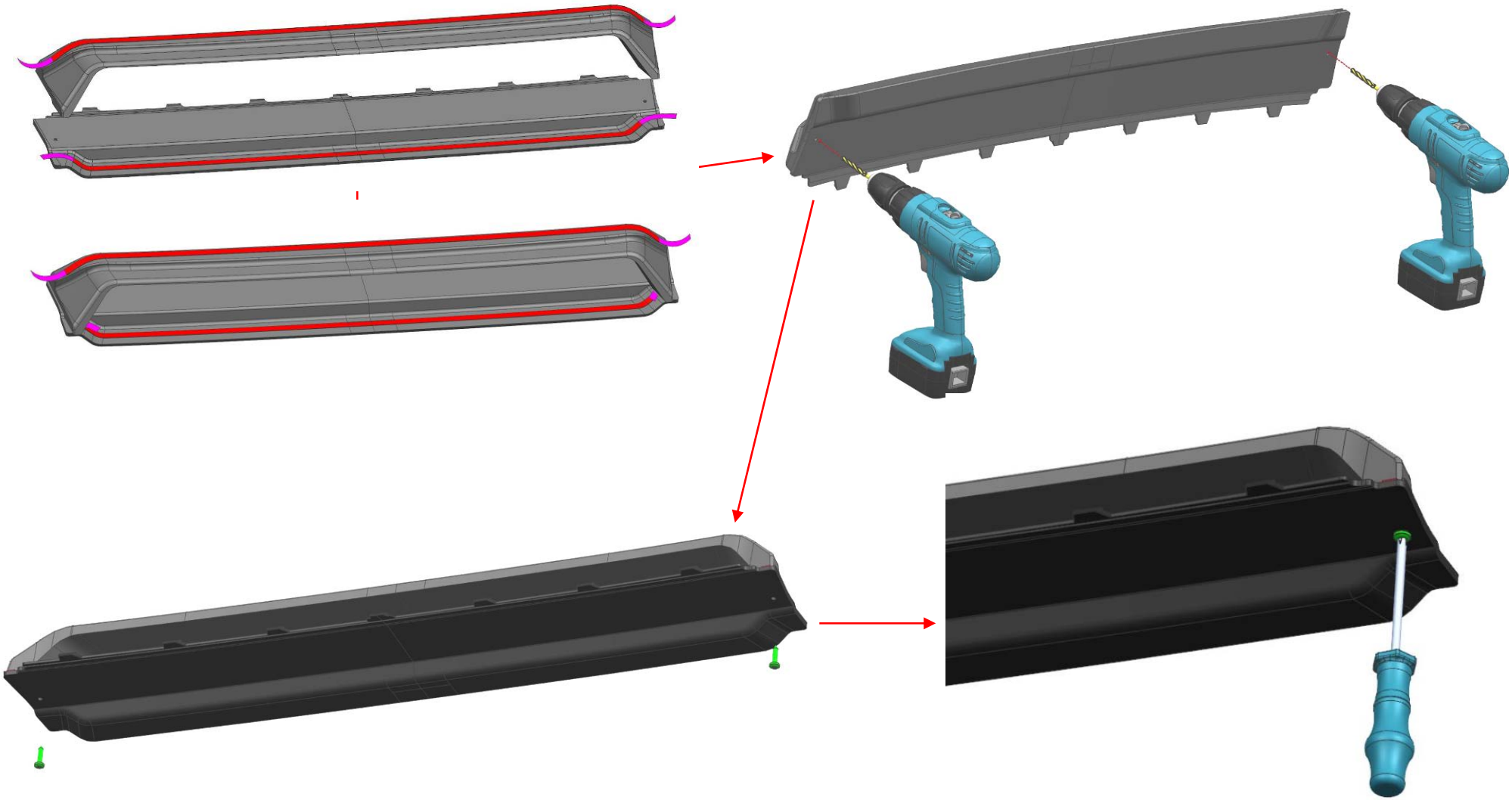
Drill six Ø 5.5 mm holes in the radiator housings as shown and connect the air ducts to the radiator housing using the delivered plastic expanding rivets. Fasten the radiator housings to the vehicle.



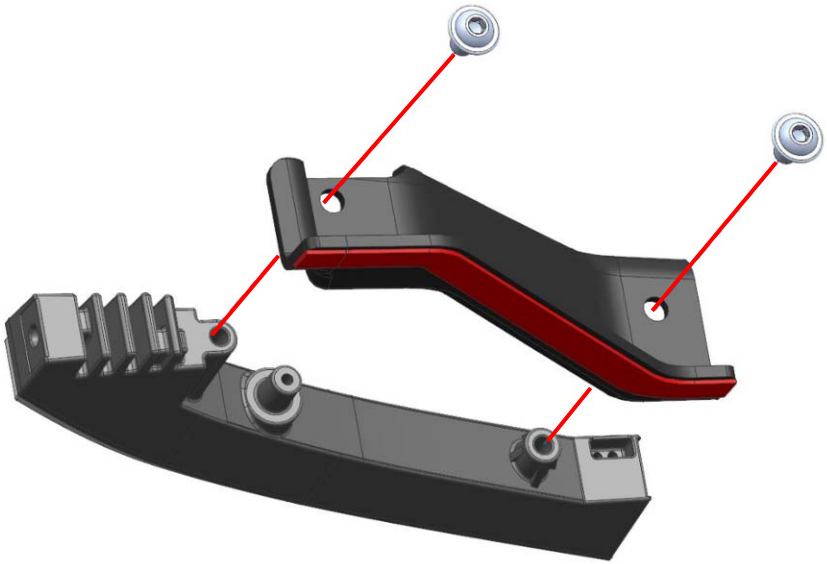


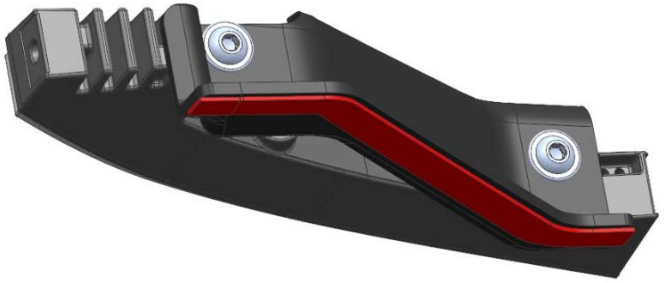


Connect the radiator housings of the front bumper to each other. Drill Ø 2.5 mm holes in the positions shown and connect the radiator housings to each other using the delivered tapping screws.



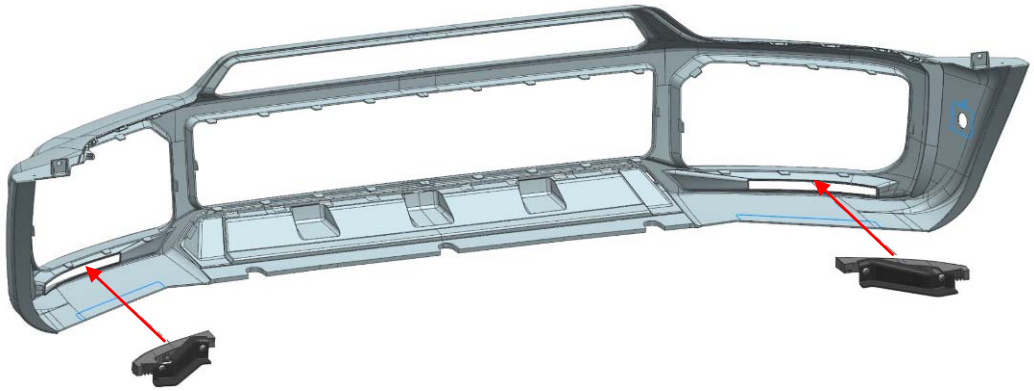
Screw the LED daytime running lights to the DRL brackets using the delivered screws.

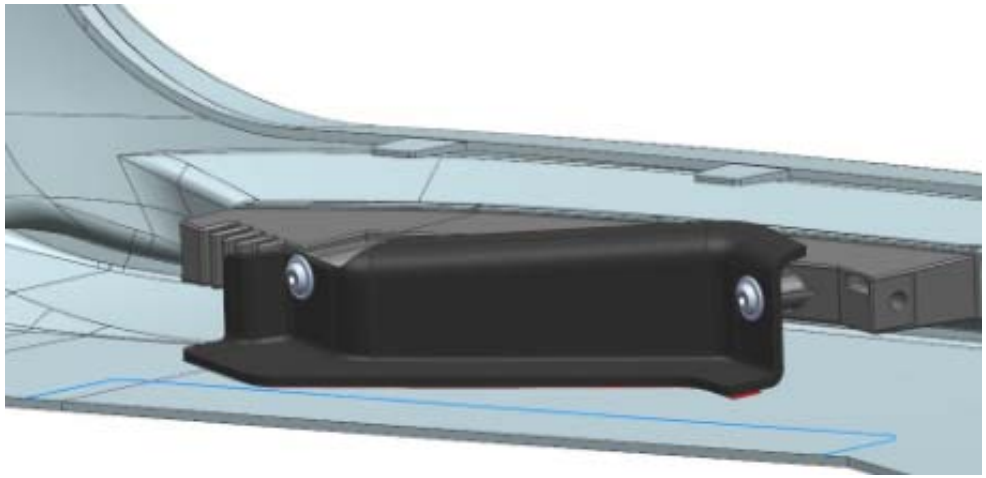




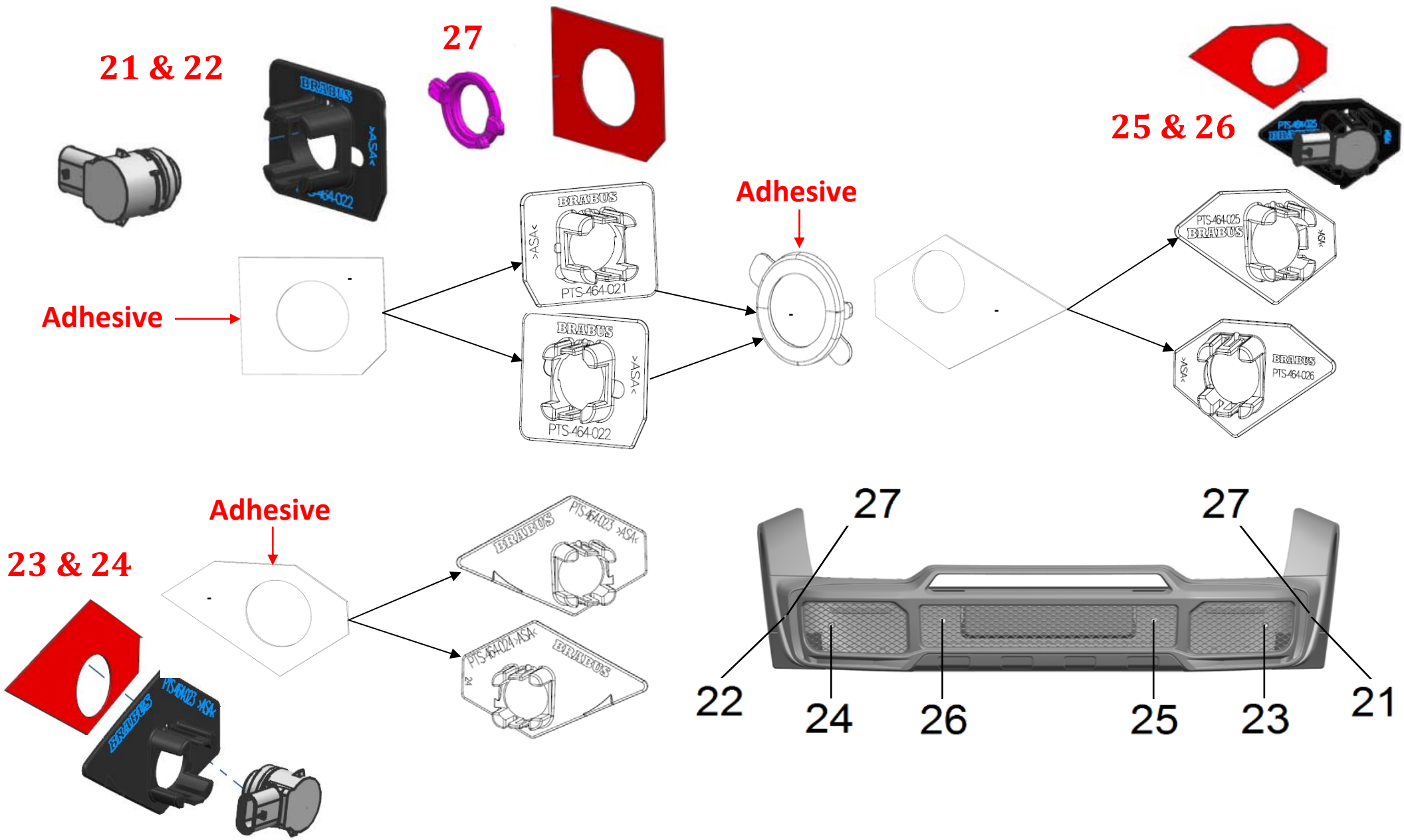
Roughen the adhesive surfaces of the DRL brackets in the front bumper and thoroughly clean them using <u>silicone remover</u> in <u>two</u> stages.

Remove the liners of the VHB adhesive strips of the DRL brackets, align the LED daytime running lights to the front bumper and firmly press them on.



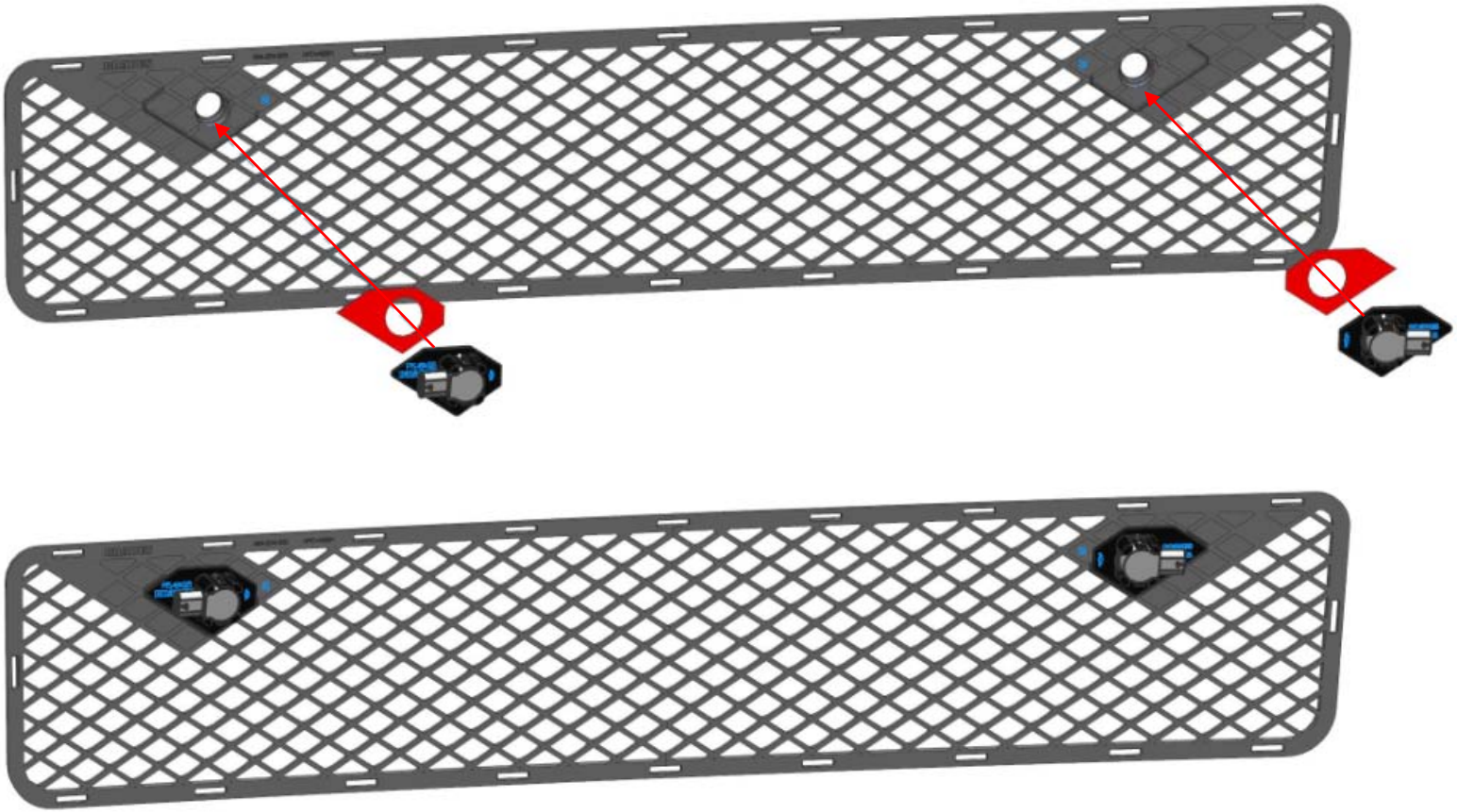


Assignment of the PTS sensor brackets to the inlays and adhesive pads for the front bumper



Clean the adhesive surfaces of the PDC sensors of the centre grille and the adhesive surfaces of the PDC brackets -025 & -026 using silicone remover in two stages.

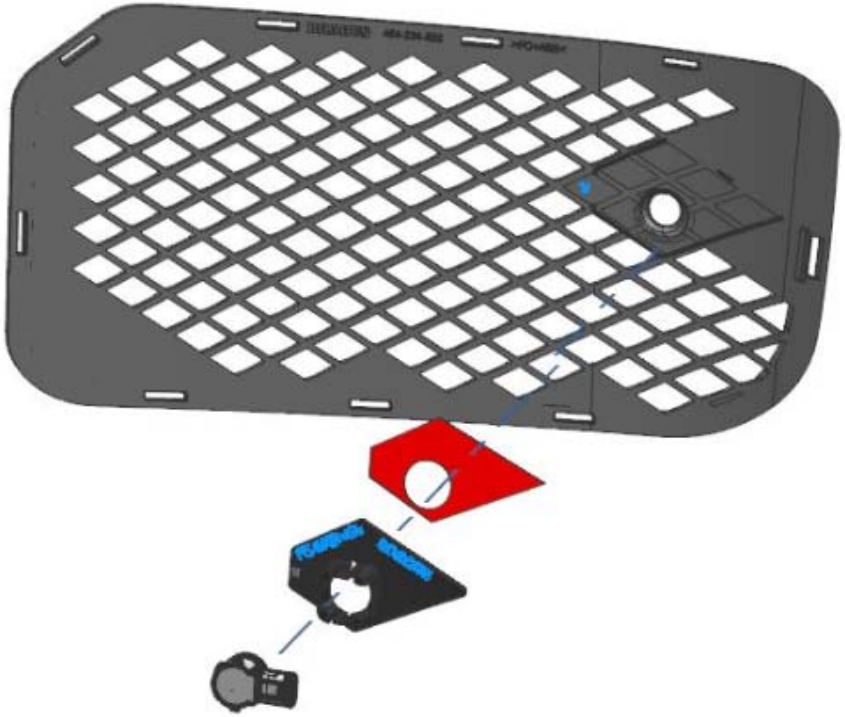
Clip the PDC sensors into the brackets as shown and equip them with the inlays and the adhesive pads -053. To do this, remove the liners with the sides facing the brackets and affix the pads to the brackets. Firmly press on the VHB adhesive pads and remove the liners from the other sides. Affix the completed PDC units to the intended positions in the centre grille at the same distance all round to the hole according to the assignment on page 59 and firmly press them on. Here, it is absolutely necessary to check the area visible from the outside!



Clean the adhesive surfaces of the PDC sensors of the left and right grille and the adhesive surfaces of the PDC brackets -023 & -024 using <u>silicone remover</u> in <u>two</u> stages.

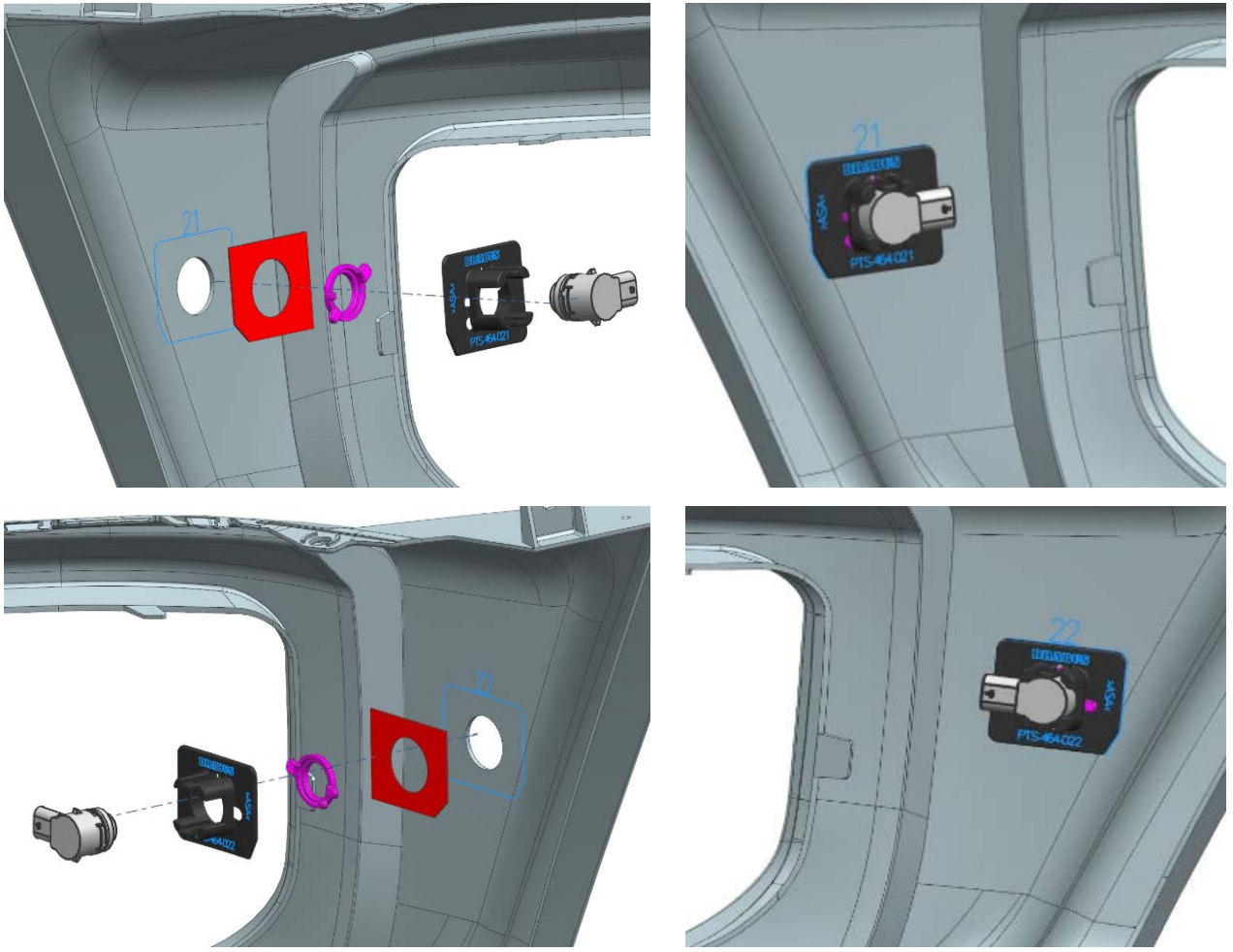
Clip the PDC sensors into the brackets as shown and equip them with the adhesive pads -052. To do this, remove the liners with the sides facing the brackets and affix the pads to the brackets. Firmly press on the VHB adhesive pads and remove the liners from the other sides. Affix the completed PDC units to the intended positions in the left and right grille at the same distance all round to the hole according to the assignment on page 59 and firmly press them on. Here, it is absolutely necessary to check the area visible from the outside!





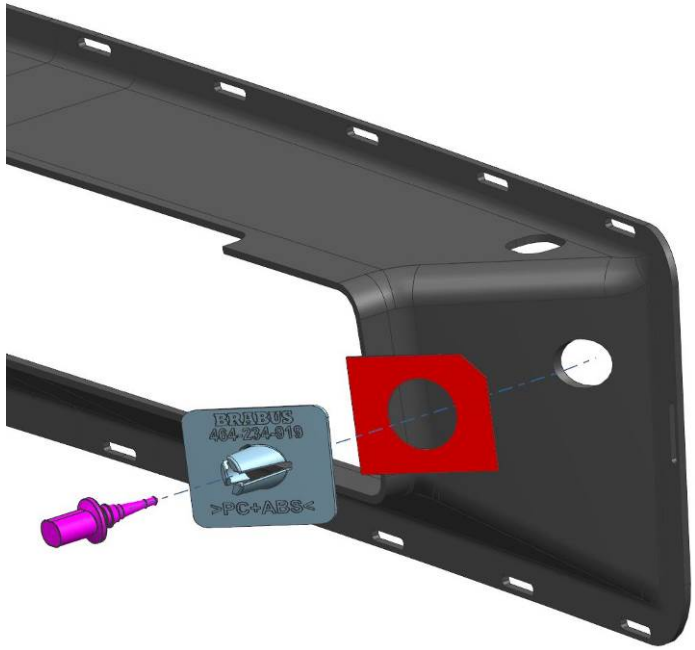
Clean the adhesive surfaces of the PDC sensors of the left and right grille and the adhesive surfaces of the PDC brackets -021 & -022 using <u>silicone remover</u> in <u>two</u> stages.

Clip the PDC sensors into the brackets as shown and equip them with the inlays -27 and the adhesive pads -051.
To do this, remove the liners with the sides facing the brackets and affix the pads to the brackets. Firmly press on the VHB adhesive pads and remove the liners from the other sides. Affix the completed PDC units to the intended positions at the same distance all round to the hole according to the assignment on page 59 and firmly press them on. Here, it is absolutely necessary to check the area visible from the outside!



Clean the adhesive surfaces of the temperature sensor bracket and the centre radiator housing using <u>silicone remover</u> in <u>two</u> stages.

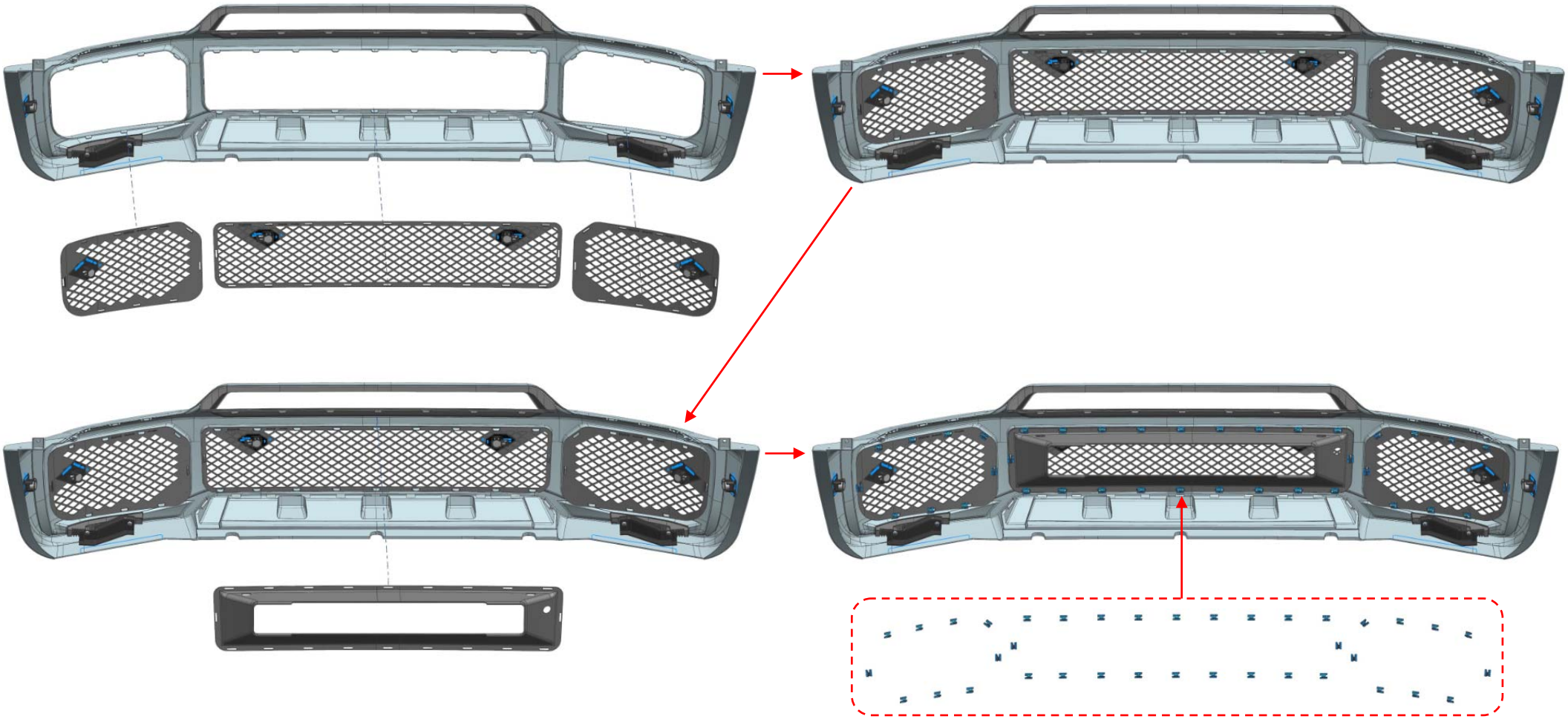
Affix the VHB adhesive pad -51 to the rear side of the bracket and firmly press it on. Remove the liner from the rear side of the adhesive pad and affix the bracket to the radiator housing as shown and firmly press it on. Please make sure that the bracket is positioned centrally to the hole.



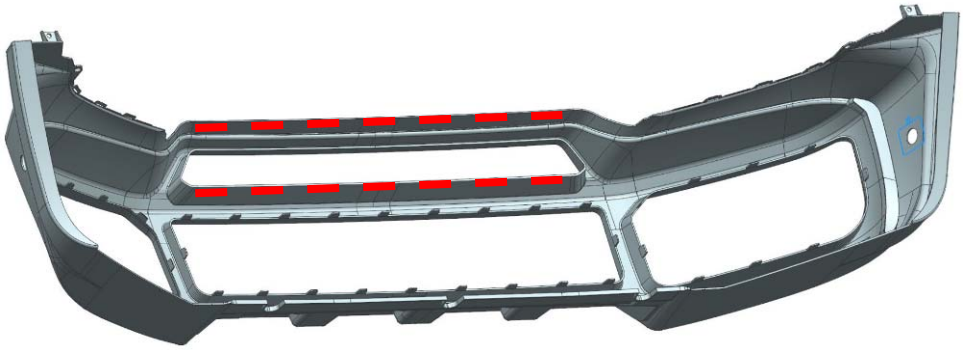




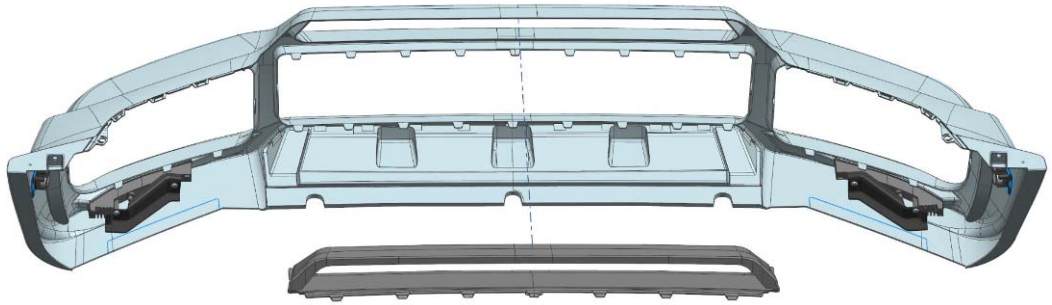
Attach the left, centre and right design grilles as well as the centre radiator housing to the fastening lugs of the front bumper and fasten them using the delivered Speedfix clips.



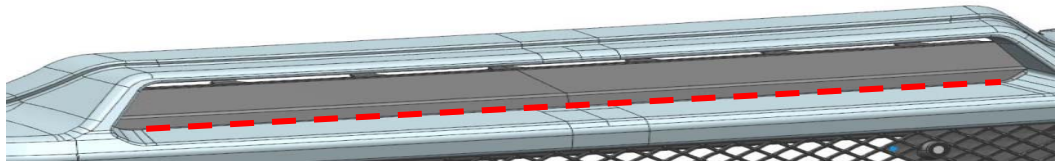
Clean the adhesive surfaces of the front bumper for the centre radiator housing and the adhesive area (marked red) using <u>silicone remover</u> in <u>two</u> stages.



Position the radiator housing in the front bumper and remove the liner from the outside. Affix the radiator housing to the bumper. The radiator housing must be aligned with the front bumper in the front area (marked red below).

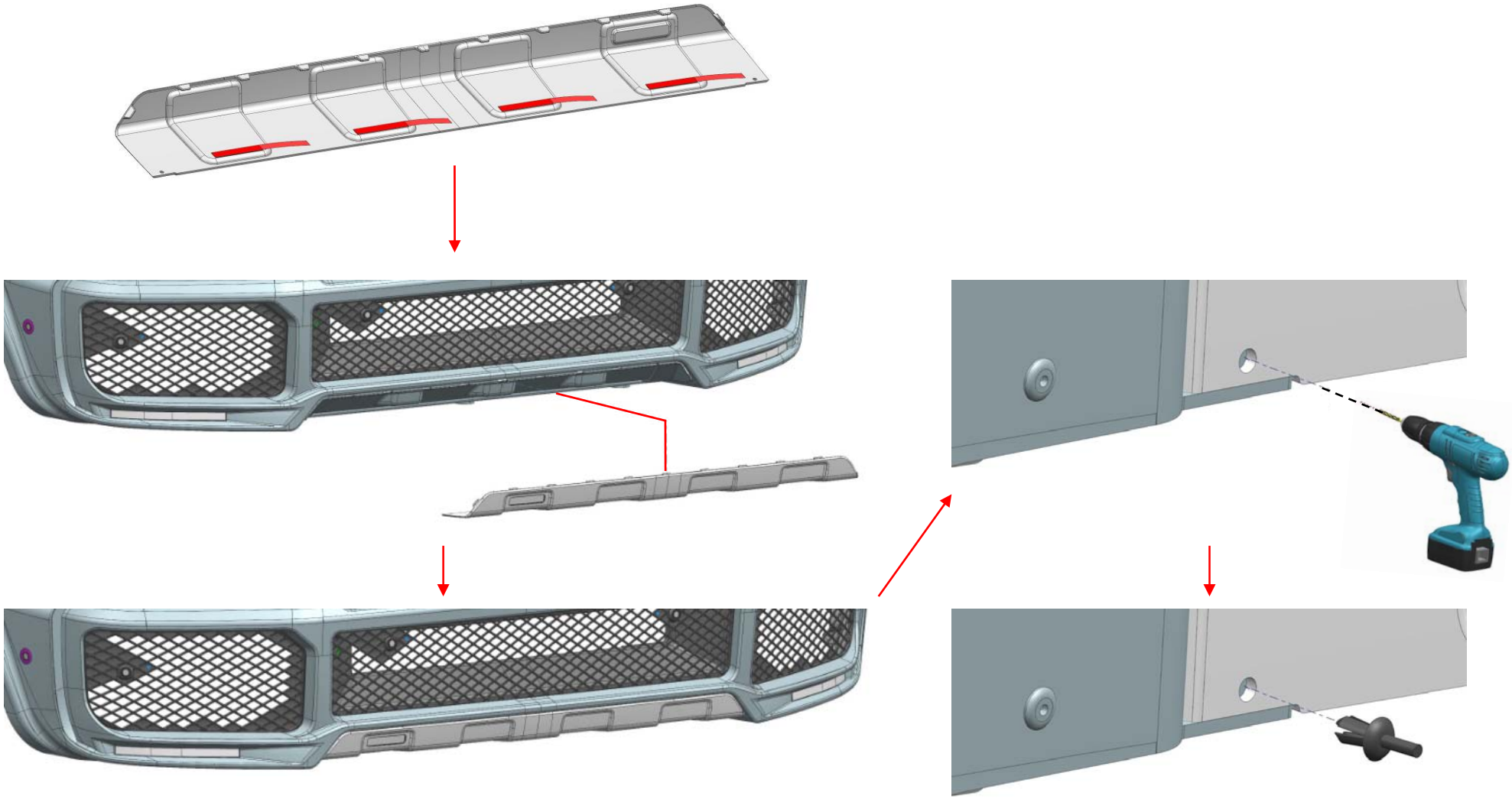






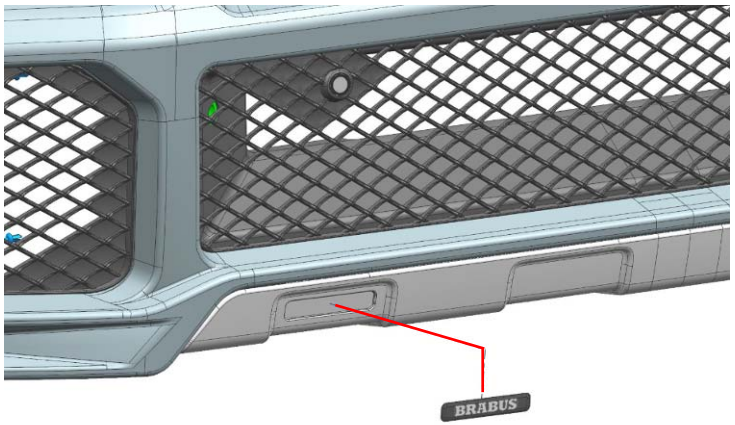
Clip the BRABUS design underride guard into the openings of the BRABUS front bumper. Remove the liner from the 3M adhesive tape and press the adhesive tape onto the bumper. Use a suitable 5.5 mm drill bit and a suitable drilling machine to drill Ø 5.5 mm holes in the BRABUS design underride guard and rear bumper in the positions shown (stamped).

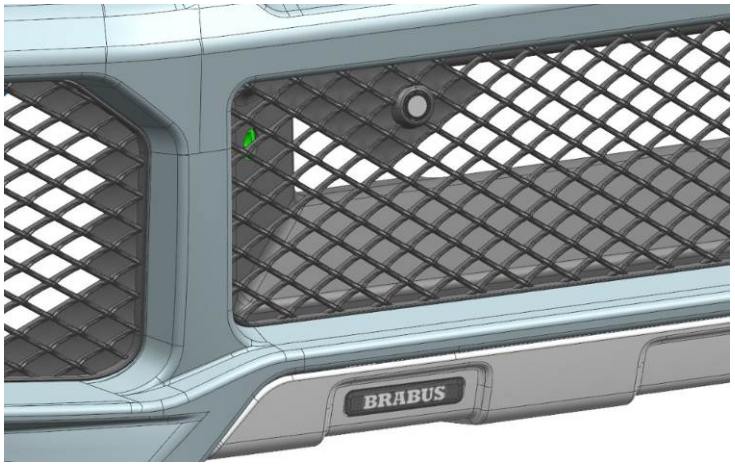
Fasten the BRABUS design underride guard in the lower area on the left- and right-hand side using the delivered plastic expanding rivets.



Clean the adhesive surface in the recess of the BRABUS design underride guard using <u>silicone remover</u> in <u>two</u> stages.

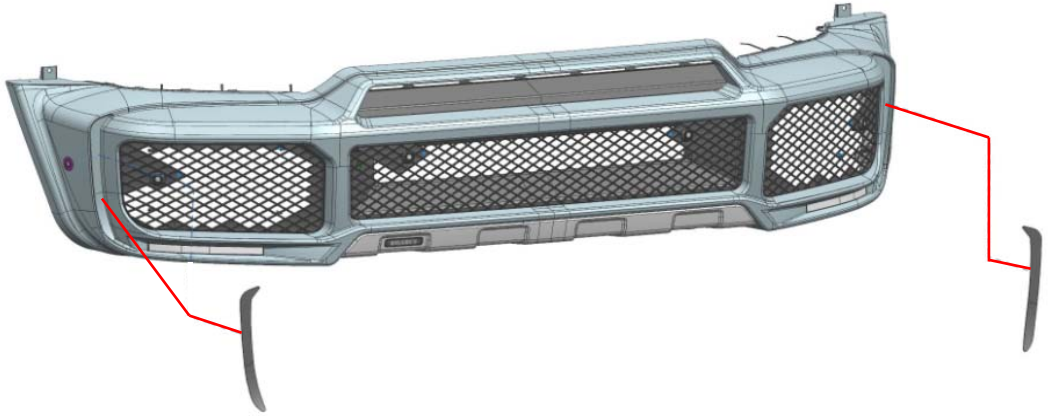
Remove the liner of the adhesive strip of the BRABUS lettering, affix the lettering to the recess and firmly press on it.





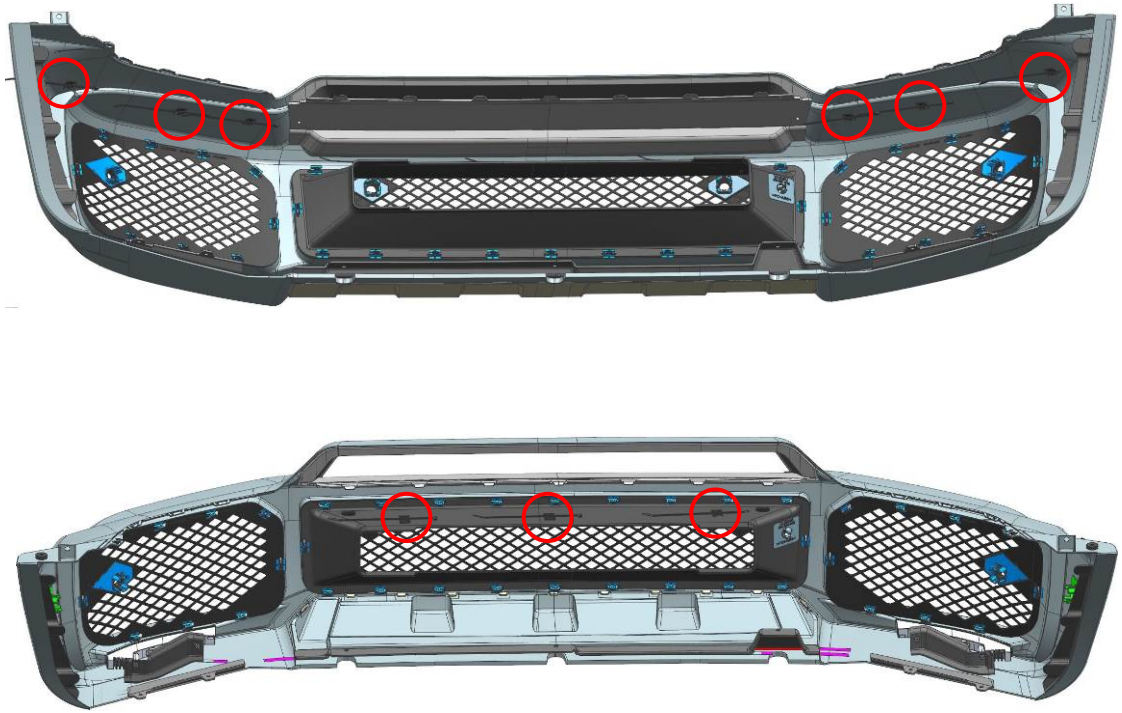
Clean the adhesive surfaces for the BRABUS design inlays on the left and right side in the rear bumper using <u>silicone remover</u> in <u>two</u> stages.

Remove the liners of the VHB adhesive strips of the design inlays, affix the design inlays to the front bumper and firmly press them on.

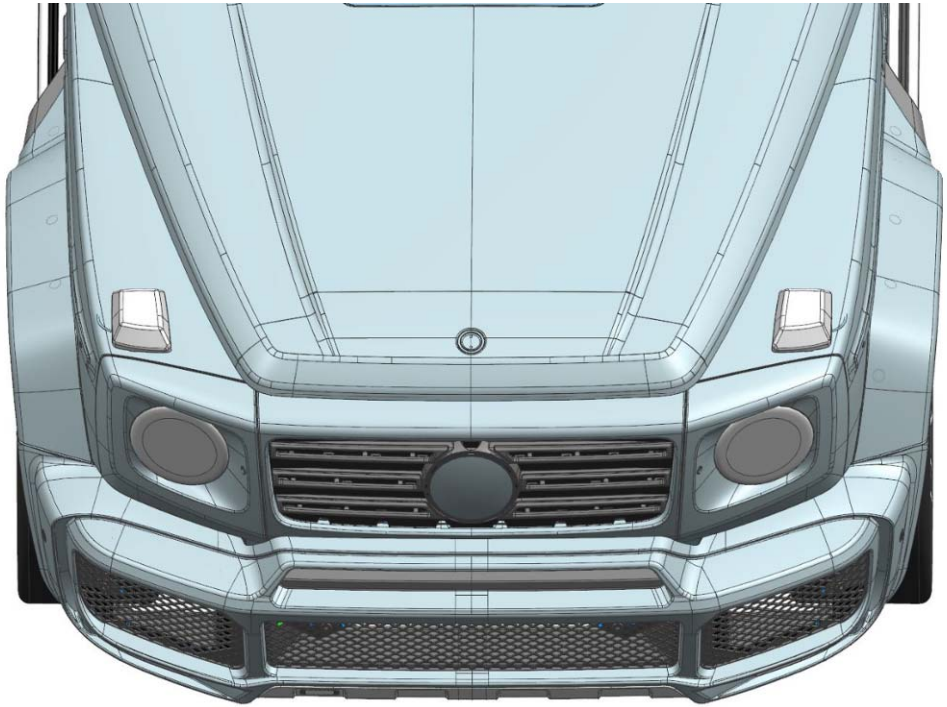


Establish the plug connections of the cable harness to the PDC sensors and number plate lights like in the standard model.

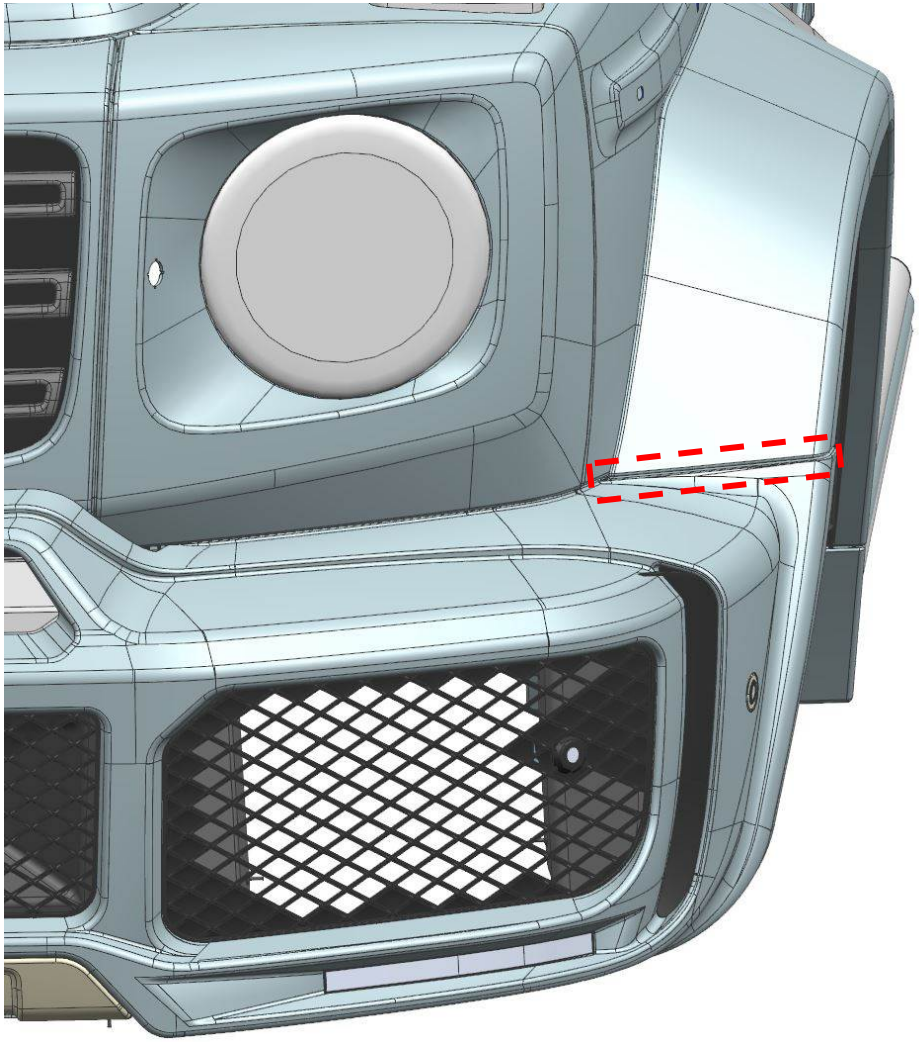
Fasten the cable harness to the positions marked red using the delivered adhesive pads/cable ties. Clean the adhesive surfaces in the front bumper using silicone remover in two stages.



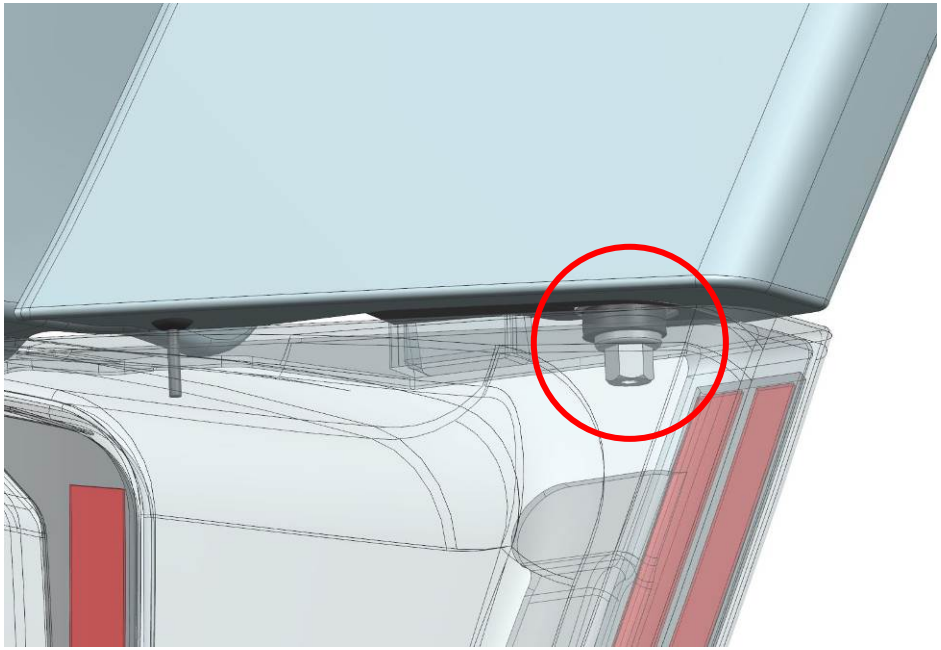
Establish the plug connection of the front bumper cable harness to the vehicle cable harness. Insert the completed front bumper into the brackets at the vehicle front and lock it in place like the standard component.



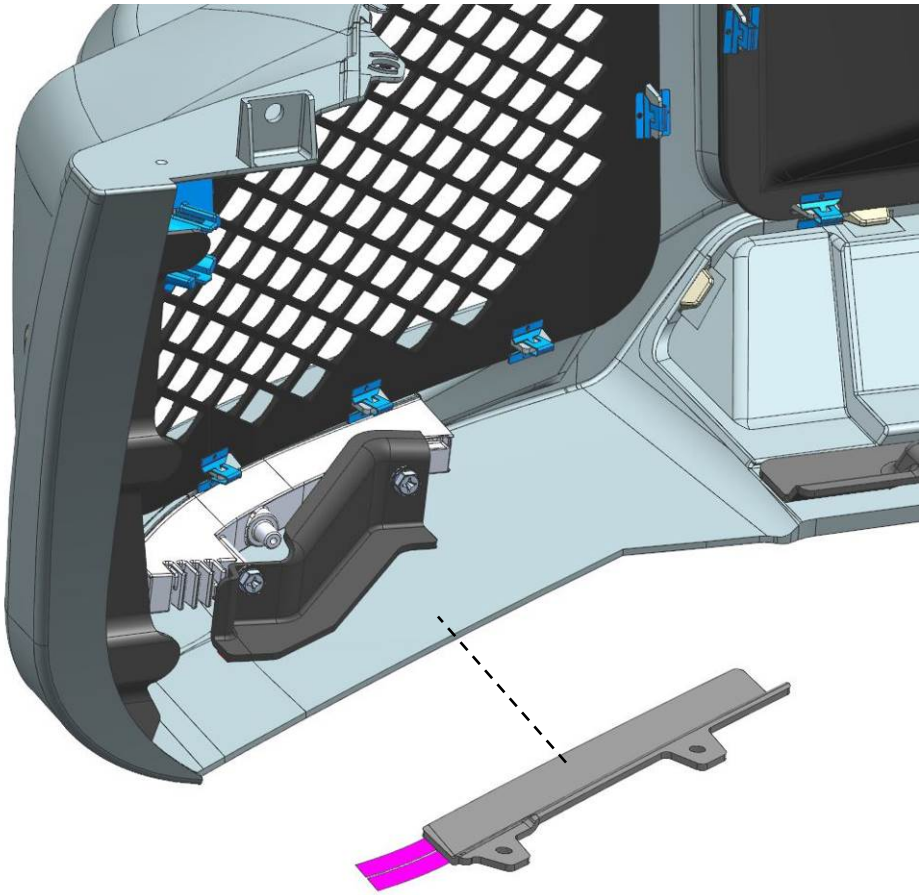
To compensate tolerances occurring at the vehicle, 4 spacers are delivered to align the gap between the bumper and the fender attachment.



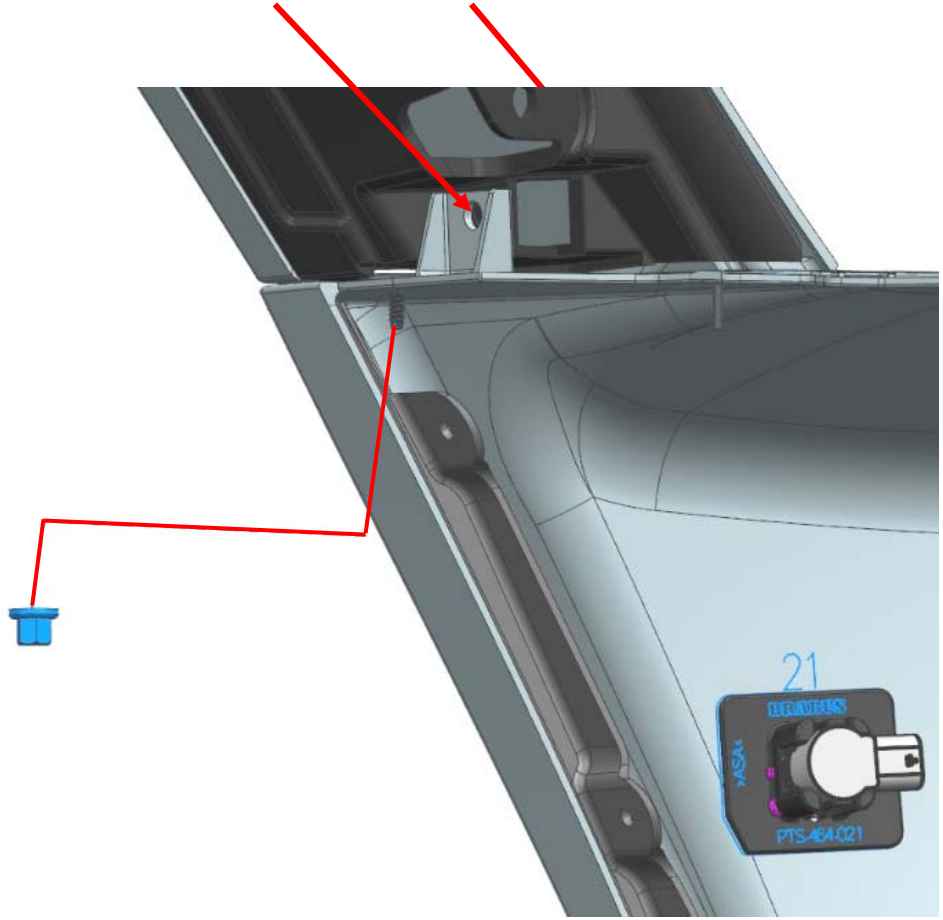
To adjust the distance between the fender attachment and the bumper, up to two spacer washers must be mounted as shown in the figure below depending on the respective situation.



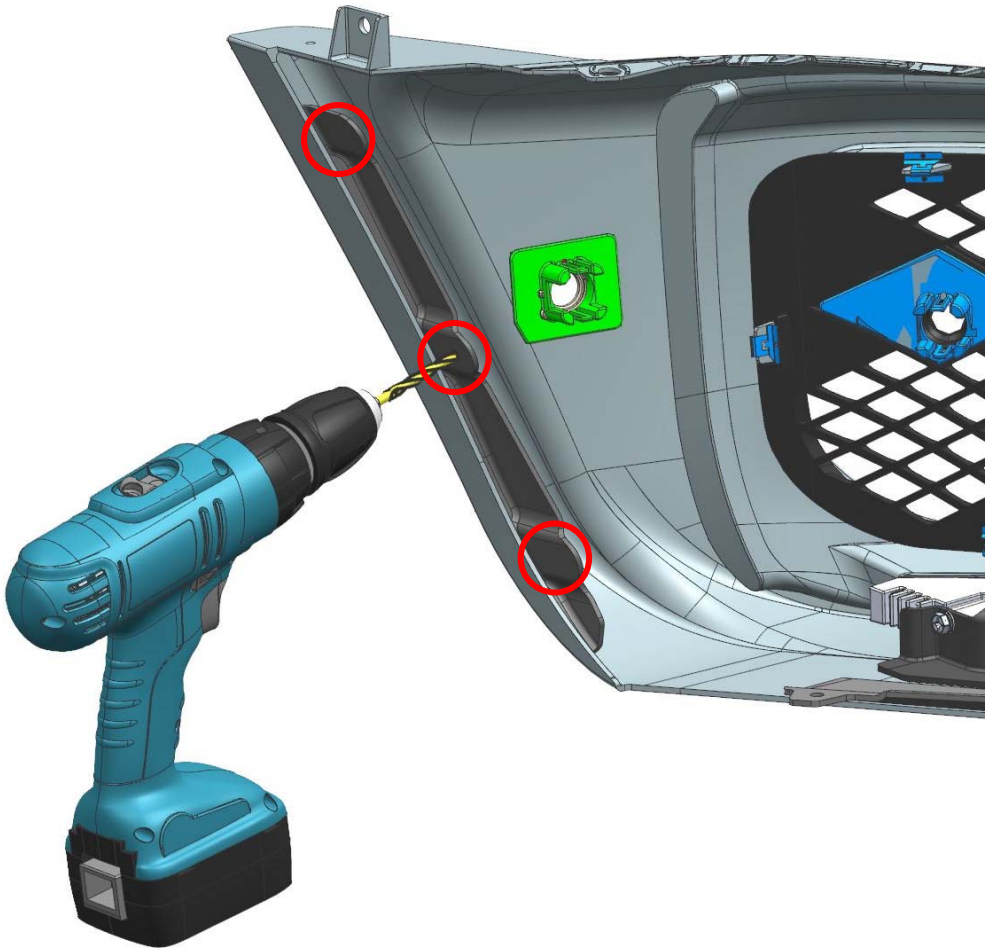
The lower bracket for the inner fender may be mounted to the vehicle only after the bumper has been installed. To do this, connect the bracket with the lower strut to the vehicle, position the bracket in the front bumper, remove the liner of the VHB adhesive tape and press on the bracket.



Align the front bumper to the front fender attachments and screw it to the fender attachments in the transition area using the standard screws/expanding rivets.



After the assembly, 3 holes matching the holes in the inner fenders must be drilled in the lateral bracket. Use a Ø 7 mm drill bit and a suitable drilling machine to drill the Ø 7 mm holes in the positions shown.



Fasten the wheel arch liners and drill the outer mounting openings for the assembly of the Ø 7mm plastic expanding rivets in the carriers of the rear fender attachments.

Fasten the wheel arch liners using the standard expanding rivets.



If you have any questions about the product itself or about the installation of the BRABUS Widestar body kit, please do not hesitate to contact

TECHNIK@BRABUS.COM

