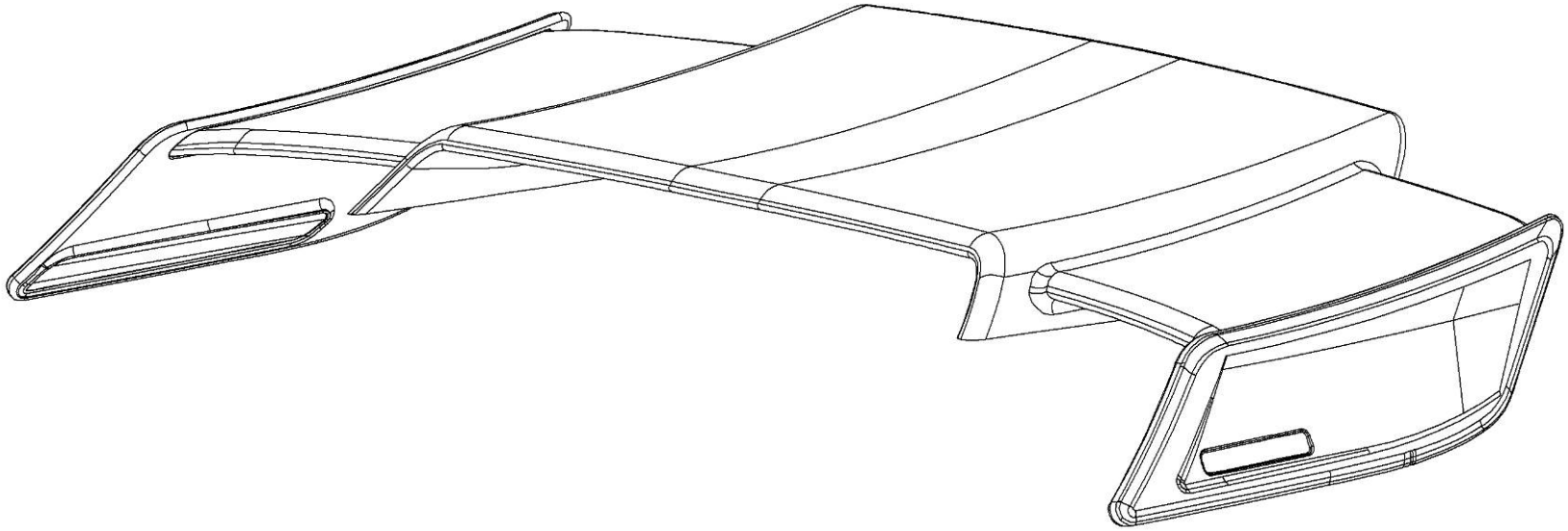
BRABUS®

BRABUS roof spoiler for G-Class, from MY2019
Article-no. 464-450-00



Please read these instructions carefully and check the content of the parts supplied prior to assembly. Wear protective clothes.
For disassembly/ assembly of standard components please regard to Mercedes-Benz Workshop information system.
The assembly takes about 3 hours of labour.
Make sure for sufficient cleanliness while assembly and regard to bonding hints on page 3.
Check the content of the parts supplied prior to delivery.

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 assembly suckers, (e.g. Würth, article-no.: WU069155210 )

Remove paint fog prior to painting!

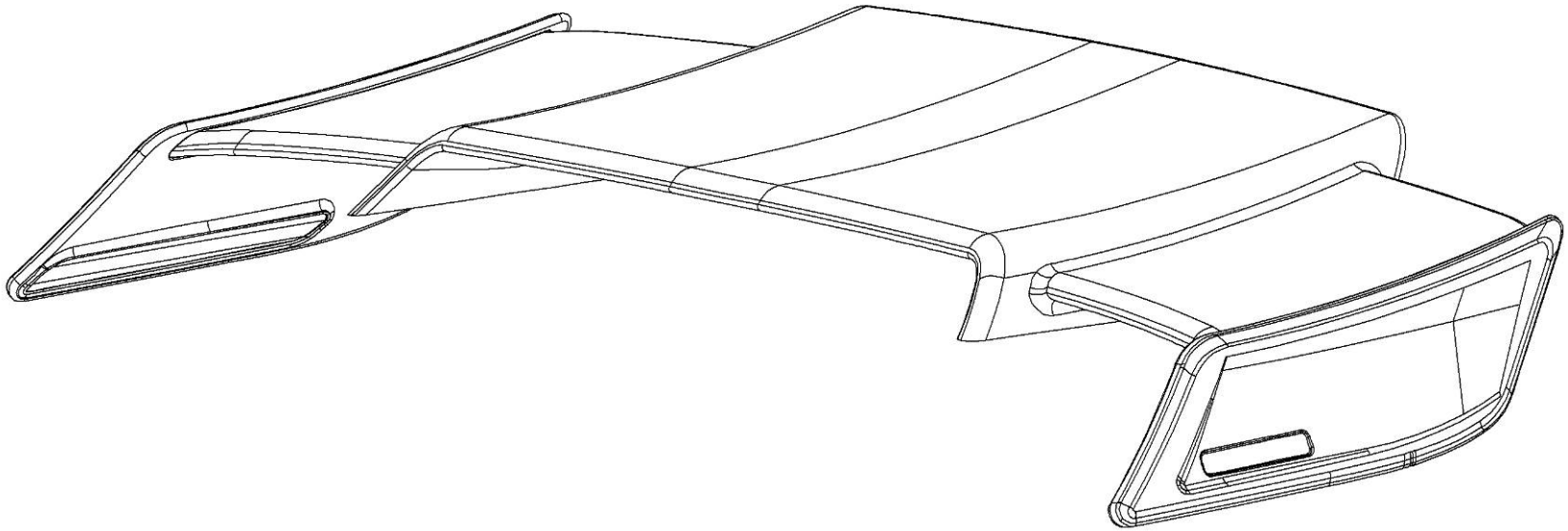
Take care not to apply the primer to areas which are still visible after bonding, apply up to 5mm away from the markings!

Regard to bonding hints and make sure the bonding areas are clean, free of grease and free of paint.

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Included in delivery BRABUS:

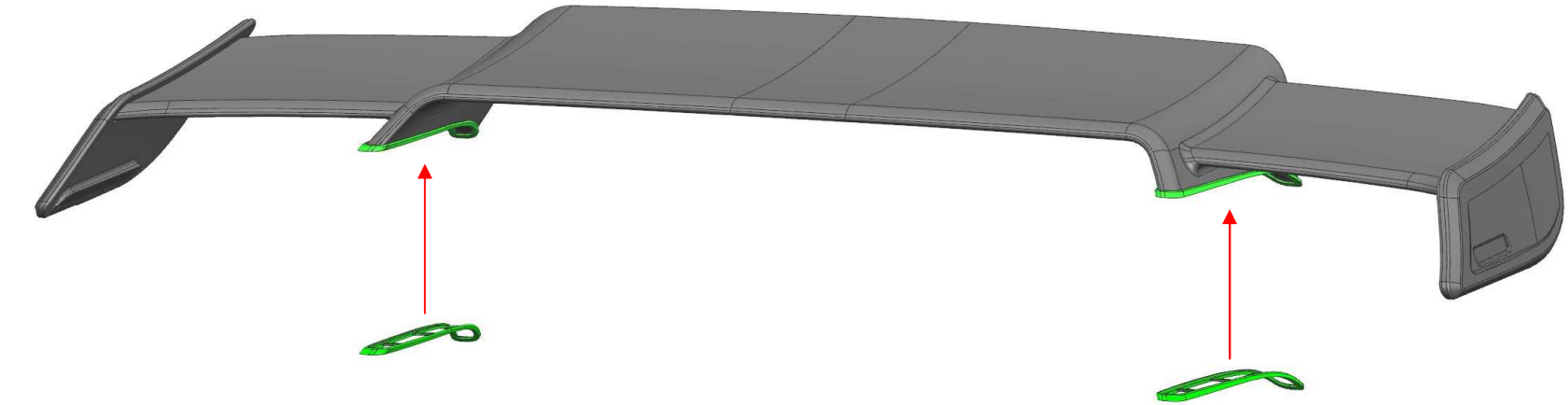
1x	Roof spoiler center part	464-450-00B
1x	Roof spoiler left outer part	464-450-01
1x	Roof spoiler right outer part	464-450-02
2x	Brabus-Typing	453-000-21
1x	Adhesive kit	B28/000-8
1x	Adapter left	463-450-23
1x	Adapter right	463-450-24



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Preparation:

- Fix both adapters to the center section of the roof spoiler while using superglue just for handling the assembly group. Use the orange sections as glued surface.

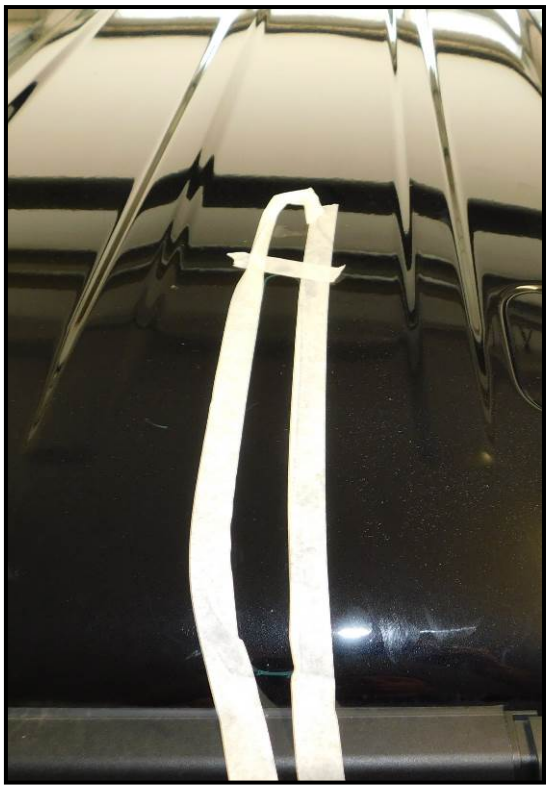




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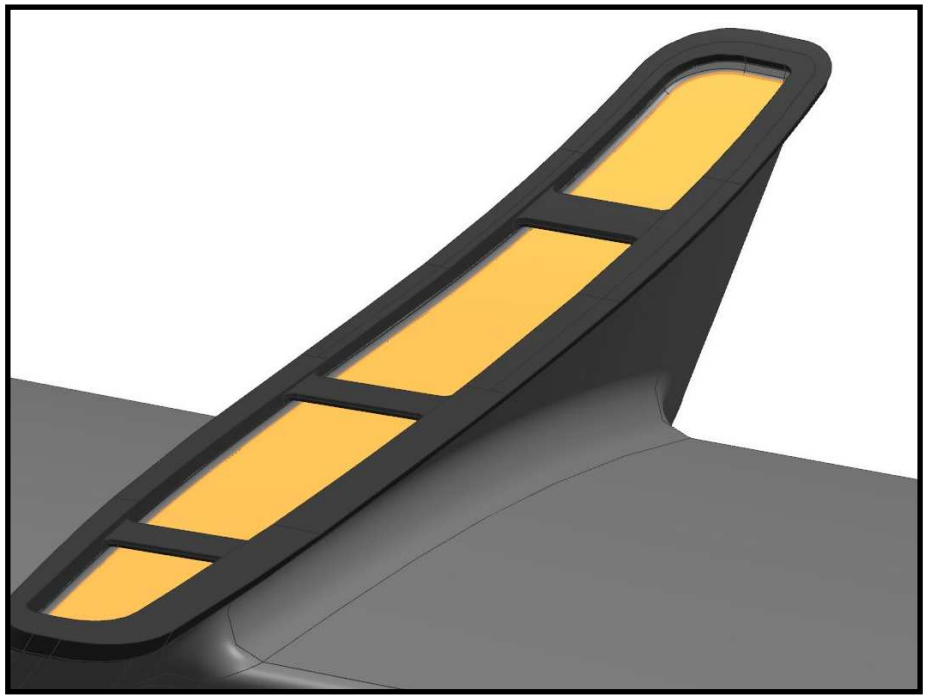
- Hold the center roof spoiler part to the vehicle roof. Align it flush and centered and mark the outer edges to the roof using a washable marker (2 persons required).

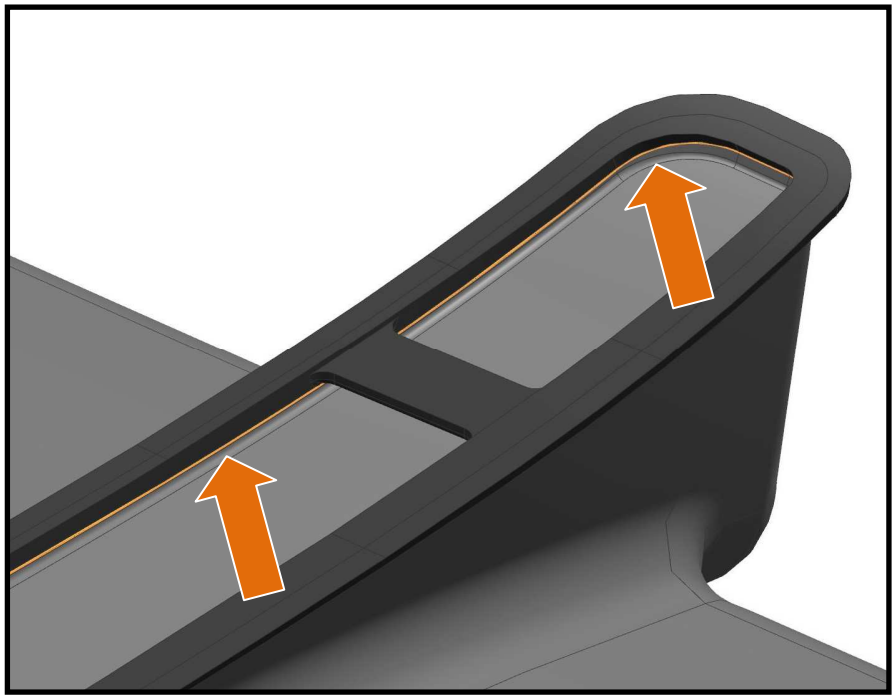




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- Fill up the space between the both components with PU-adhesive.
- Take care that both componets are connected with PU-adhesive

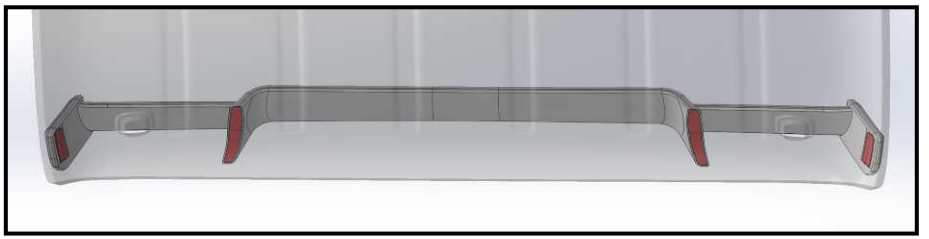




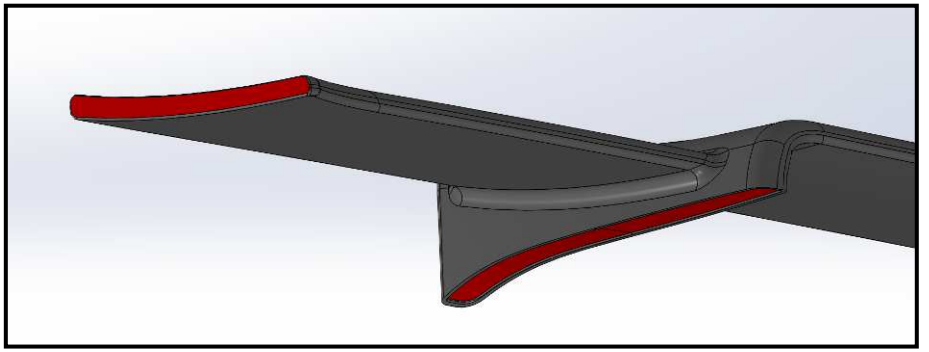
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- Clean and degrease the bonding surfaces of the outer and the center roof spoiler parts, same as the bonding areas on the vehicle roof according to bonding hints.

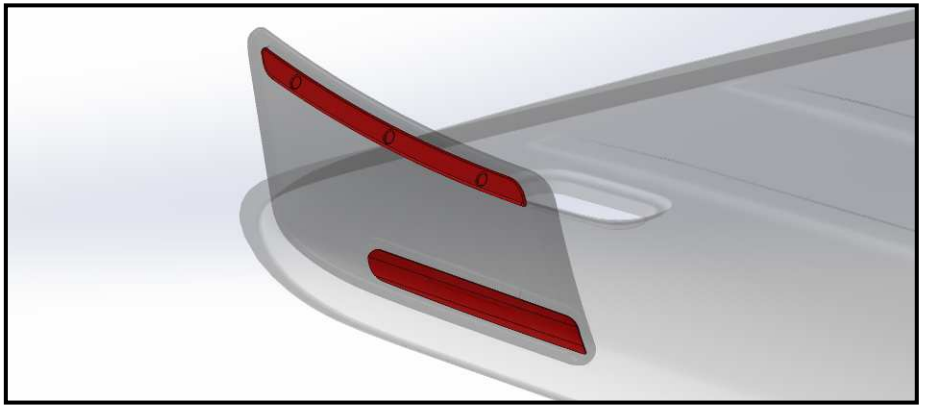
Roof bonding surfaces



Center part bonding surfaces (left side equal)

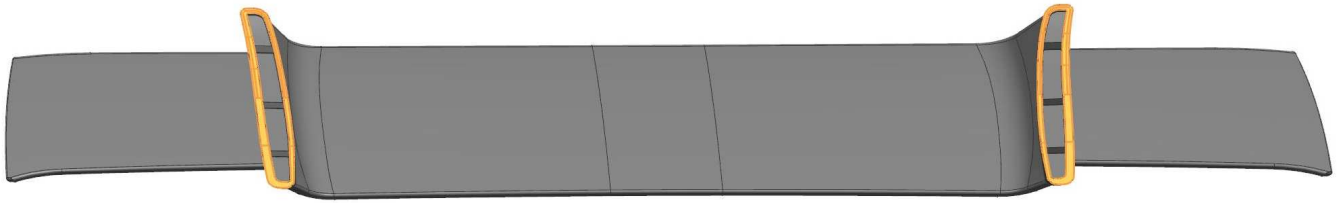


Outer part bonding areas (left side equal)



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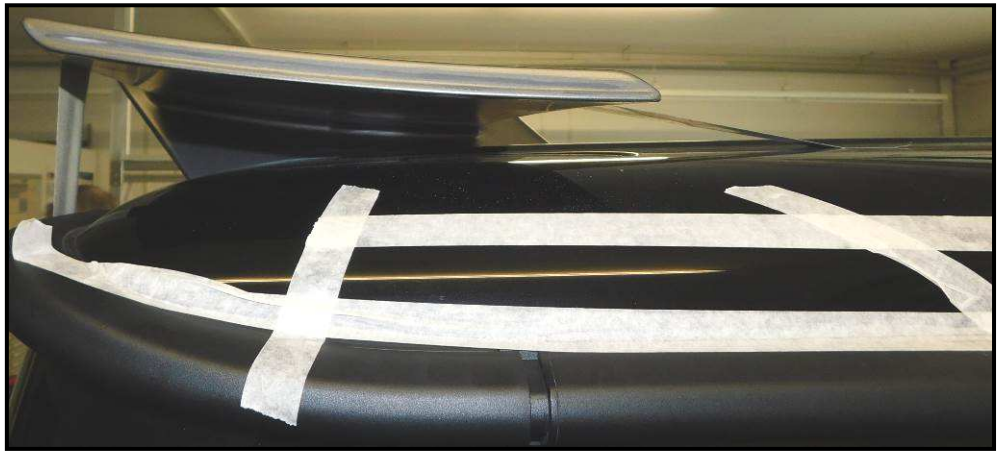
- Start the fixation of the center part.
- Apply even lines of adhesive to the bonding areas of the center part adapter and bond the center part to the vehicle roof.
- Align the roof spoiler according to the markings on the roof, remove excessive adhesive immediately.
- Fixate the roof spoiler center part using appropriate adhesive tape (e.g. duct tape) until the adhesive has finally hardened.



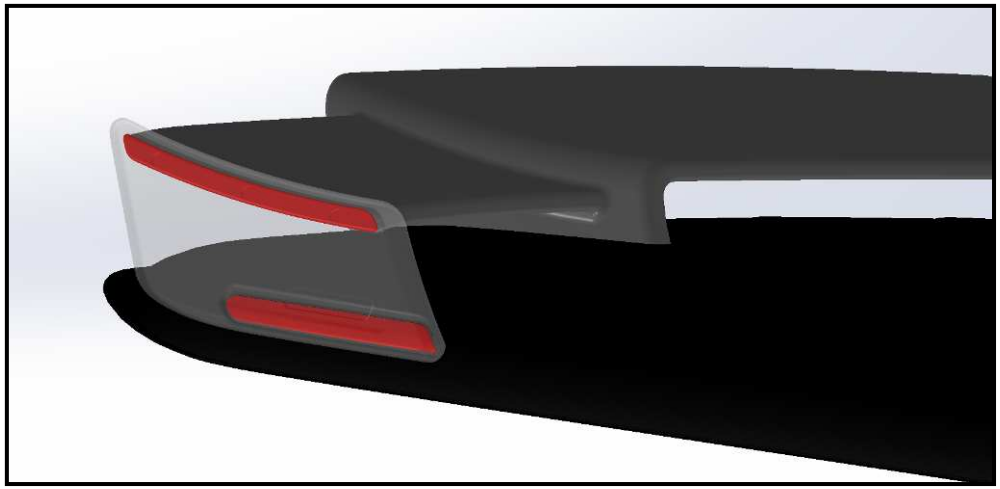


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- Apply even lines of adhesive to the outer roof spoiler parts. Bond the outer roof spoiler parts to the roof spoiler center part and the vehicle roof. Align the outer parts and fixate them using appropriate adhesive tape until the adhesive has finally hardened.









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- Bond the Brabus typings supplied to the outer roof spoiler parts. Carefully clean and degrease the bonding areas prior to bonding.

- Avoid to wash the vehicle in an automatic washing bay within 24 hours after assembly!





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