



BRABUS®

213-678-63 & 213-463-00_10

Valve controlled sports exhaust and carbon fibre rear diffuser for type W213 - E63S AMG – 4 Matic



Installation guide

Official technology-partners



Member of



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 used in combination with the Brabus carbon-fibre rear diffuser (article-no. 213-470-00_10).

Included in delivery of Brabus valve controlled sports exhaust:

1x	Rear silencer left/ right	213-678-63-ESD
1x	Connection pipe W213 E63	213-678-63-VBR
1x	Stainless steel silencer exit pipe package	213-678-63-ARP-L
1x	Left tailpipe	166-678-63-ERLB
1x	Right tailpipe	166-678-63-ERRB
1x	Assembly material	

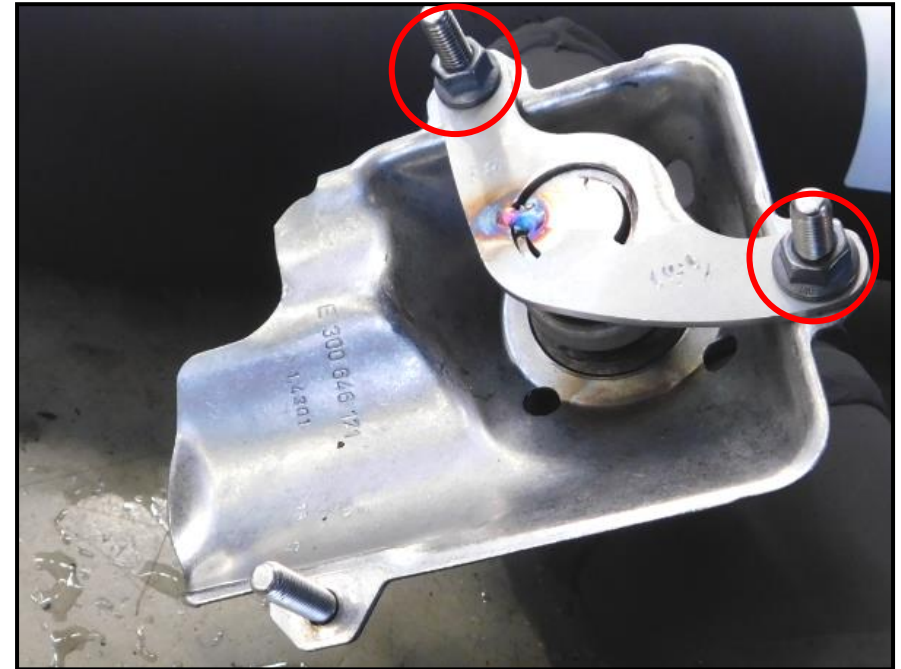
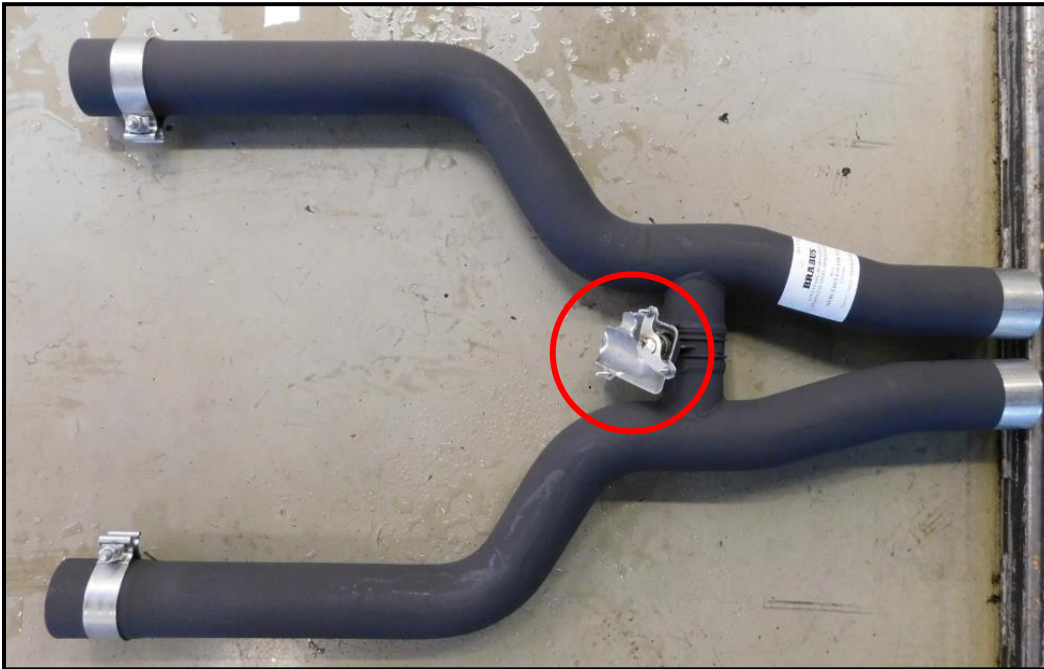
Preparation:

- Lift the car on the Mercedes-Benz prescribed lifting positions according to Mercedes-Benz Workshop instructions (WIS-document AR00.60-P-1002LWG).
- Remove the rearbumper according to Mercedes-Benz Workshop instructions (WIS-document AR88.20-P-2200LW).
- Remove the spare wheel moulding trim and the right side trim within the boot compartment according to Mercedes-Benz Workshop instructions (WIS-document AR68.30-P-4800LWE).
- Remove the standard exhaust system according to Mercedes-Benz workshop instructions (WIS-document AR49.10-P-7142MNE).
- Remove the left right and center (if equipped with) exhaust valve actuators.
- **Mark the positions of the actuators to the actuators. They may not be interchanged and have to be fitted to the same positions they have been assembled from the factory when completing the Brabus valve controlled exhaust system.**

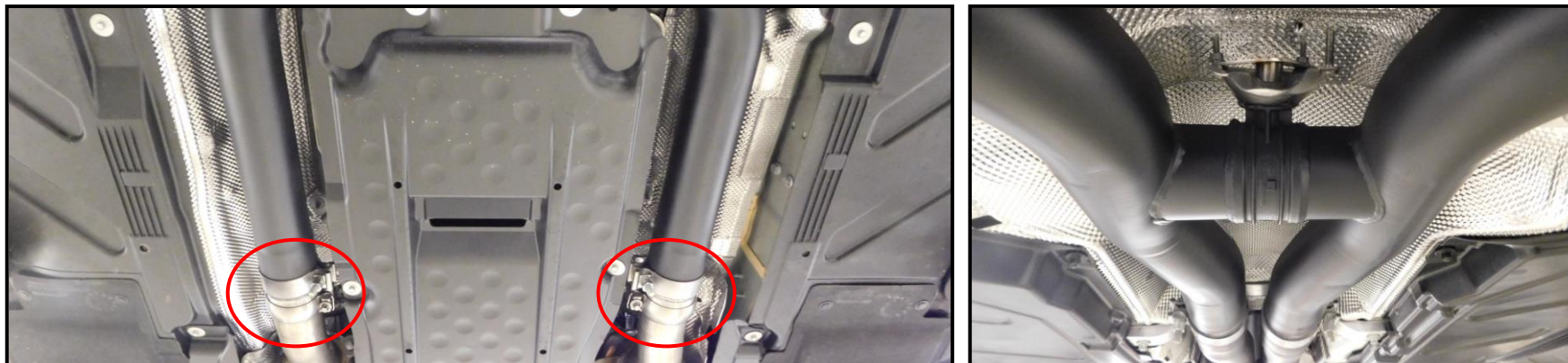


Assembly of exhaust system:

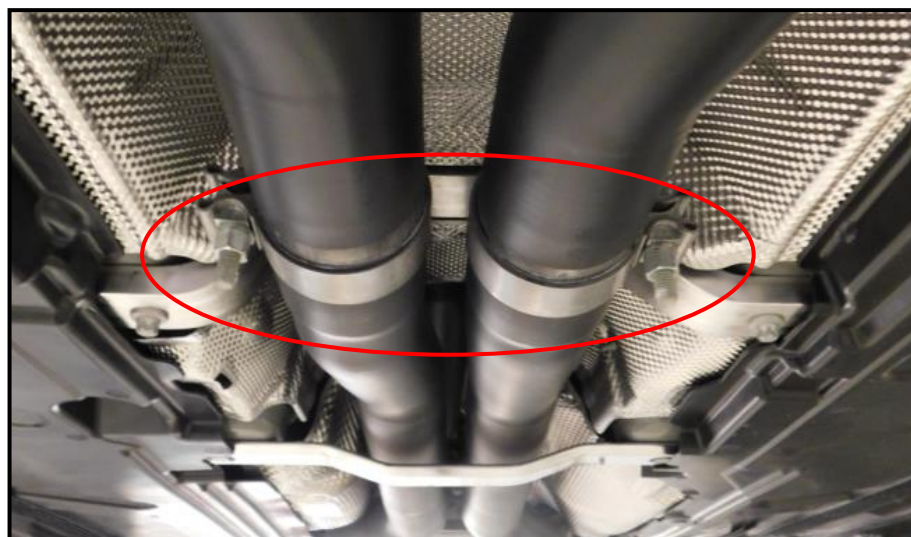
- If the vehicle from the factory is equipped with a center exhaust actuator please remove the lock plate shown below by unfastening the nuts marked red. Assemble the center exhaust actuator to the Brabus adapter pipe.
Just bolt the actuator to the seating, the spring automatically finds the correct position when being activated.
There is no need to adjust the actuator or it's spring!
- If the vehicle from the factory is not equipped with a center exhaust actuator just leave the lock plate fixe das out from the box. The adapter pipe then is to be assembled with the lock plate.



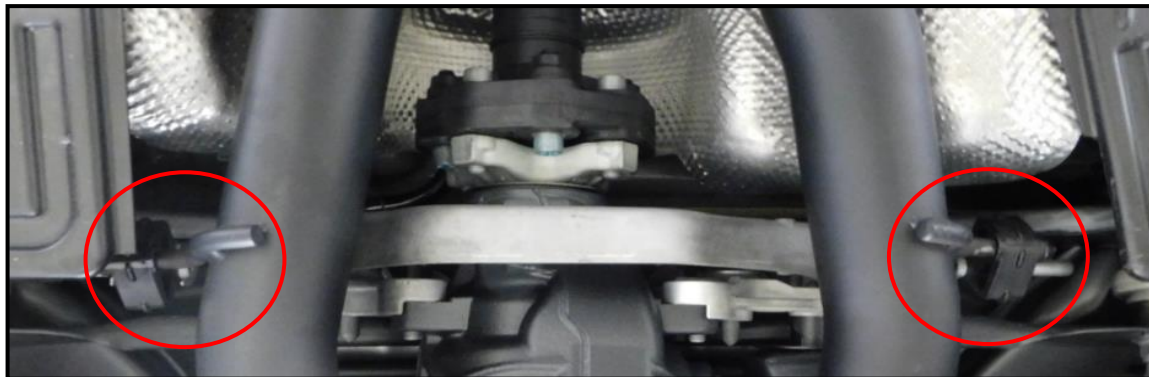
- Assemble the adapter pipe to the standard pipes behind the catalysts by using the standard clamps. Just pre-tighten the clamps to be able to align the exhaust system after assembly.



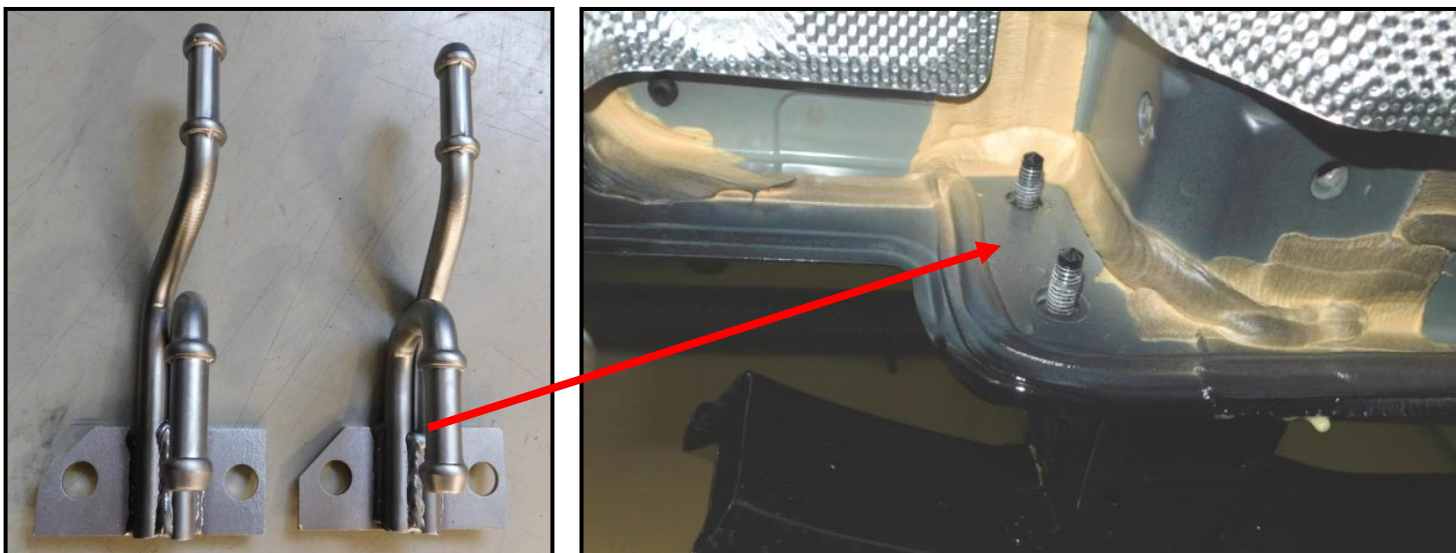
- Assemble the rear silencer connecting pipes to the Brabus adapter pipe using clamps supplied.



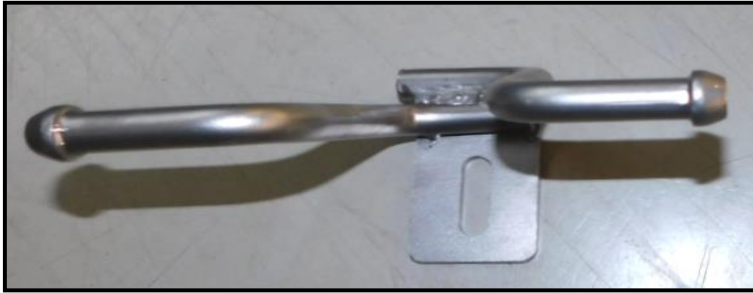
- Attach the exhaust brackets of the Brabus connecting pipes to the rubber supports of the standard exhaust system.



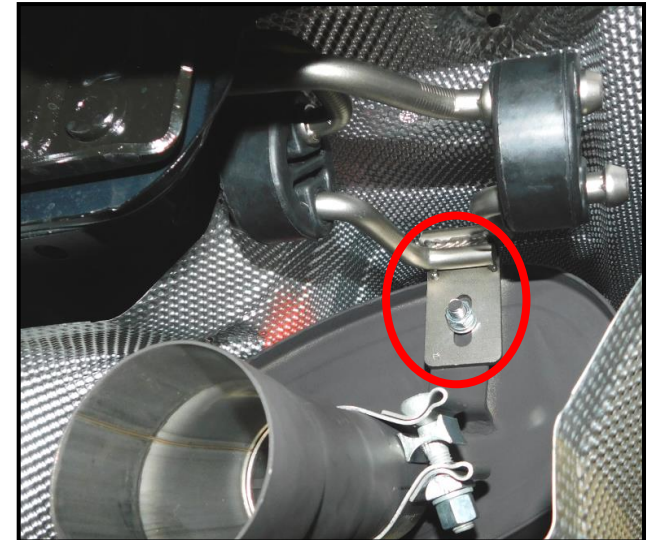
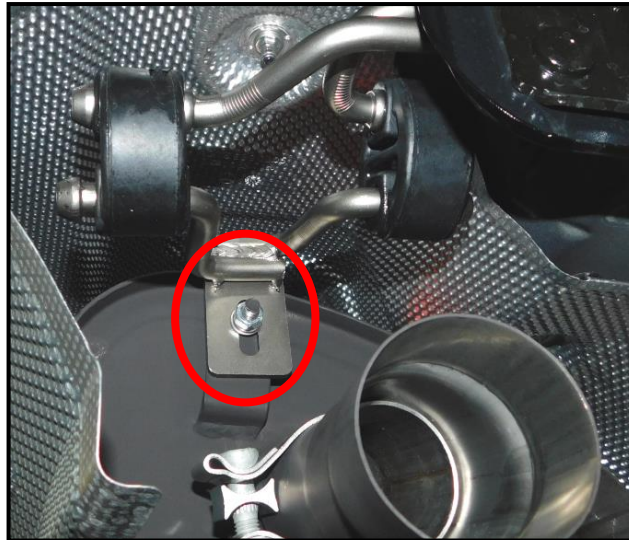
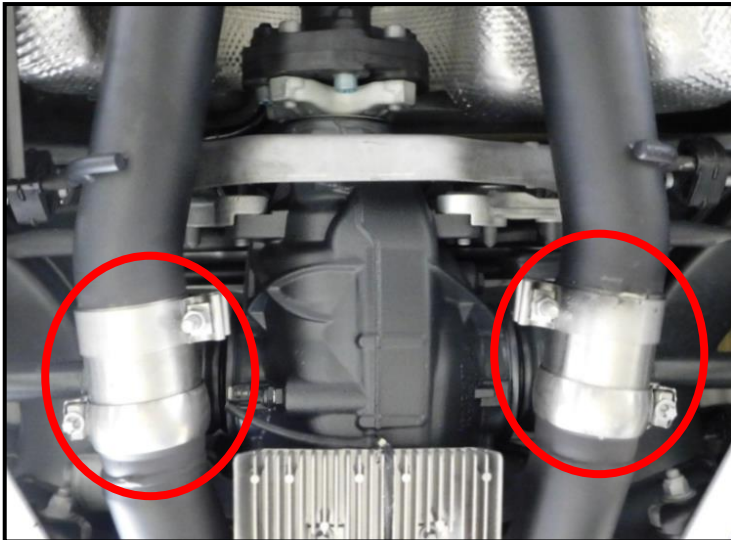
- Replace the standard exhaust brackets against the brackets supplied. Attach the standard rubber supports to the Brabus exhaust brackets.



- Attach the Brabus rear silencer brackets to the exhaust rubber supports.
Attention: The right side bracket according to red circle within image below is marked „R“.



- Connect the left and right rear silencers to the left and right connection pipes using clamps supplied. Attach the silencers to the rear exhaust brackets and fixate them using nuts supplied. Just pre-tighten the clamps to be able to align the exhaust system later on.

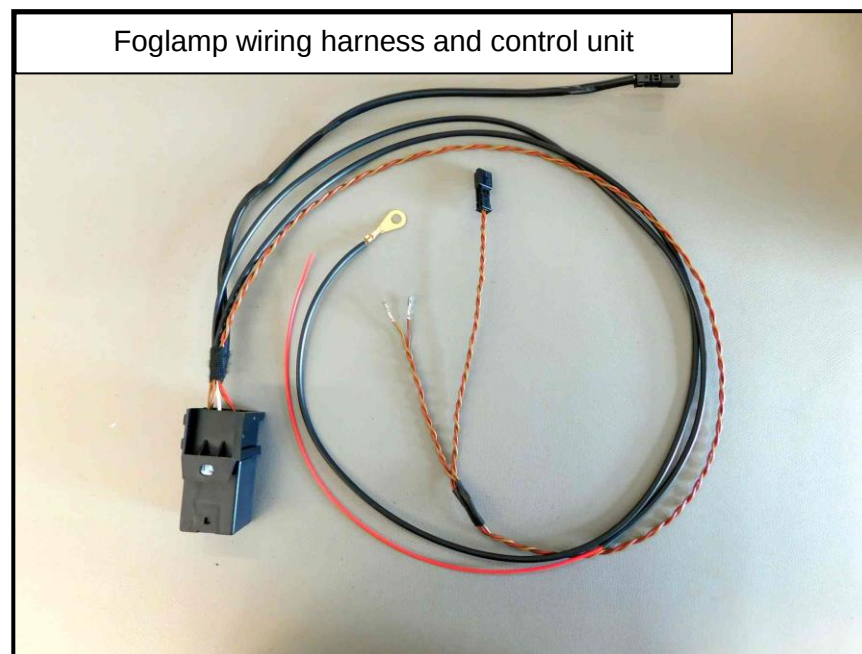


The further assembly of the exhaust system is described from page 15 as now at first the carbon fibre rear diffusor and the rearbumper are to be assembled.

Assembly of carbon fibre rear diffuser:

Included in delivery of Brabus carbon fibre rear diffuser:

1x	Carbon fibre rear rear diffuser, matte or glossy	213-463-01_11
1x	Foglamp bracket	213-463-08
1x	Foglamp	000-NSL-LED
1x	Foglamp wiring harness	213-463-50
1x	Foglamp control unit	213-463-51
12x	Clip Speedfix	Q0007371V000000000

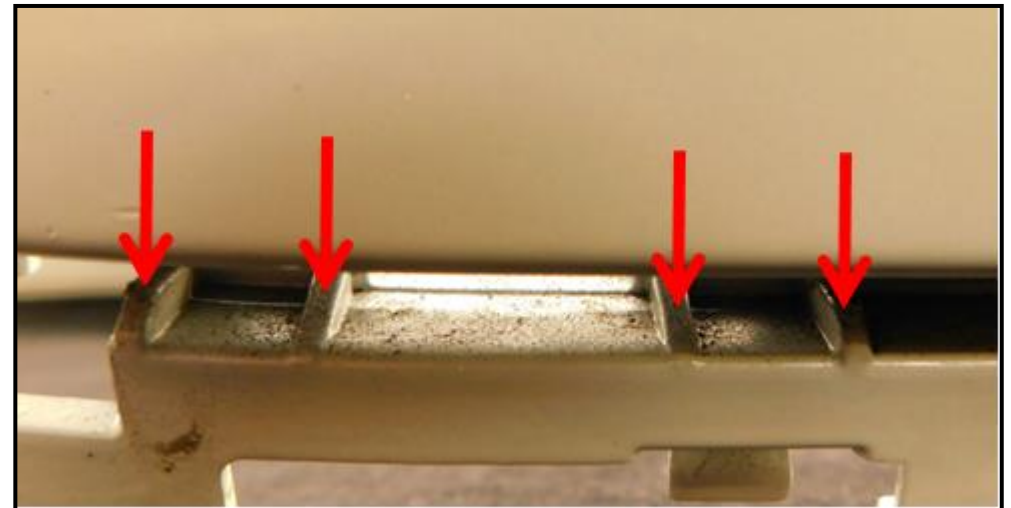
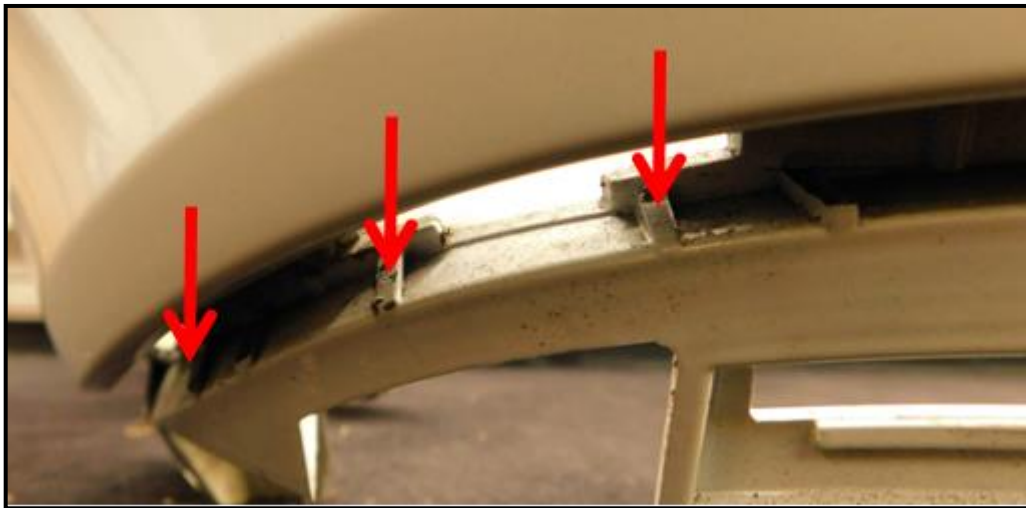


- Remove the standard rear diffuser and its inlay, disconnect the electrical connections of the rear bumper.
- Cover the lower rear bumper edge using adhesive tape to protect against damages.
- Attach the Brabus carbon fibre rear diffuser to the rear bumper notches.

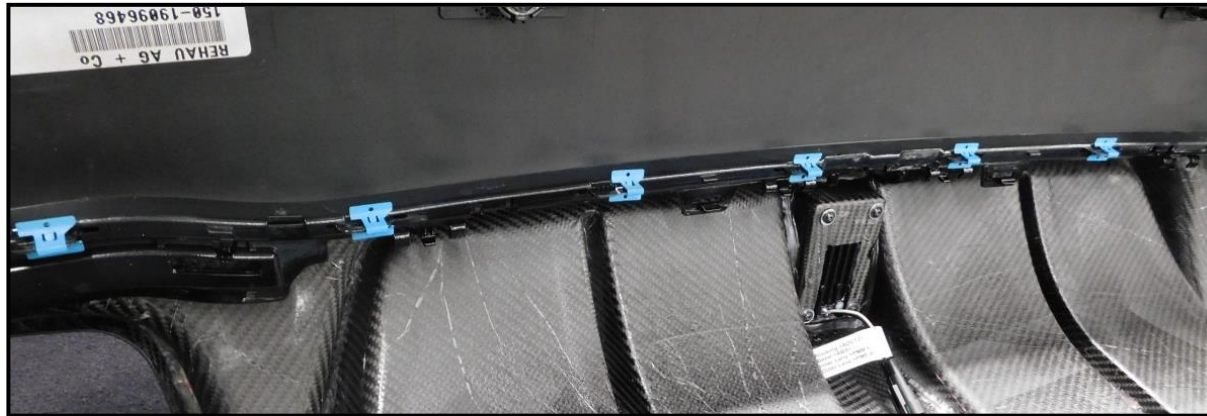
Attention:

Due to manufacturer depending tolerances in regard to the material thickness of the carbon fibre rear diffuser it can become necessary having to shorten the areas marked red below using a suitable tool.

Prior to shorten these areas please sufficiently protect the painted and visible areas by using appropriate adhesive tape.



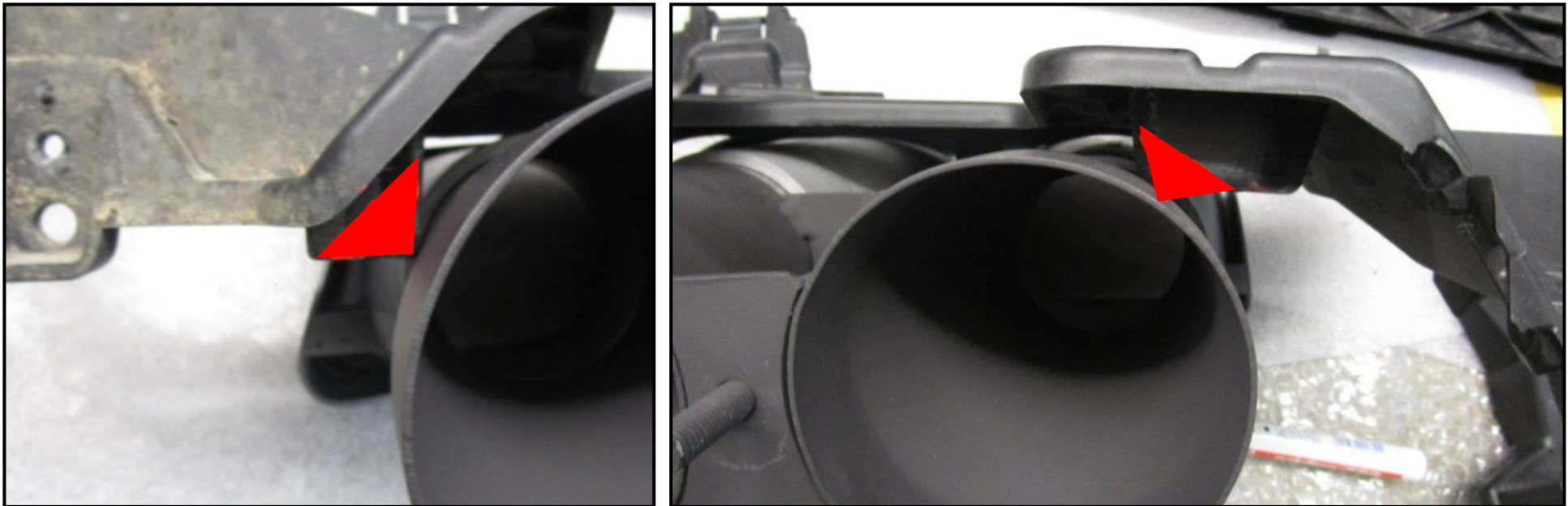
- Fixate the rear diffuser using Speedfix-clips supplied (according to image). Bolt the foglamp to the rear diffuser using assembly material supplied.



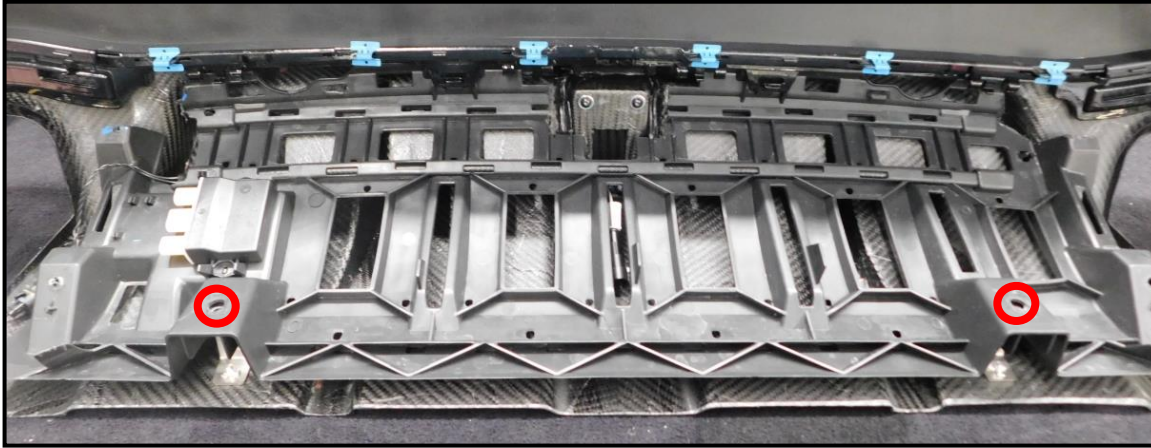
- Re-work the standard rearbumper inlay using a suitable tool (oscillating saw, body saw). Prior to cutting the inlay remove the upper Hands Free Access sensor from the rearbumper inlay in order not to damage it while cutting.



- Attach the sensor back into the rearbumper inlay, fixate it (upper edge behind lower edge of upper bumper inlay). Make sure the front fixation holes are flush to the holes of the alloy brackets (according to red marks).
- Remove the areas marked red within images below of the exhaust bezel brackets using a suitable tool.



- Fixate the outer exhaust bezel brackets to the rearbumper and connect them to the center inlay and to the upper rearbumper inlay.

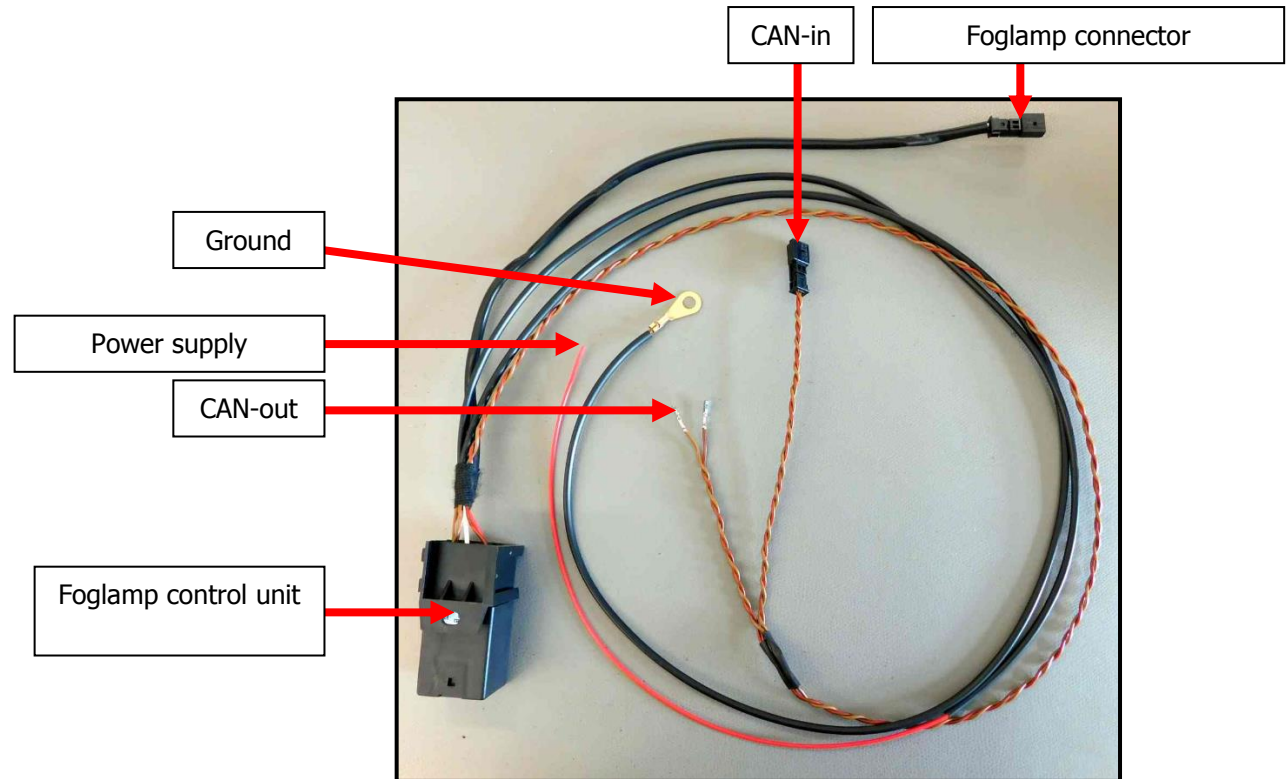
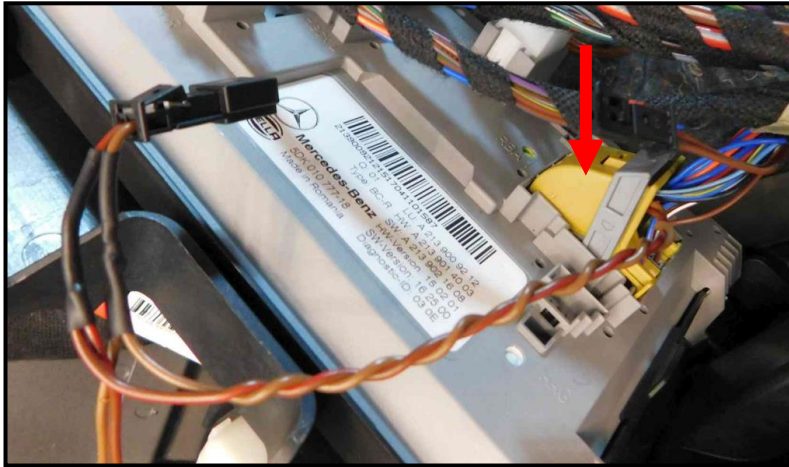


- Lay the wires to the rear diffuser.
- Divide the 2 pcs tow hook cover.
- Cut the lower area off from the tow hook base part according to image below using a suitable tool (oscillating saw, body saw).



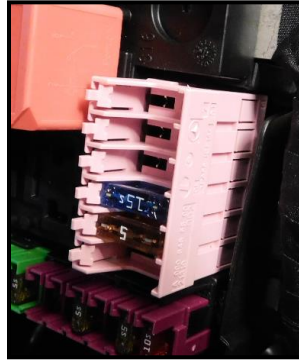
- Attach the painted tow hook cover trim to the base part, bond it to the base part using PU adhesive within area marked green within image above.
- Attach the completed tow hook cover to the rearbumper.

- Release the CAN high and low wires out of slots 48 & 49 of plug X33/30 of the rear SAM and attach the wires to the 2-pole plug supplied (make sure for correct allocation, bn to bn and bn-rd to bn-rd).
- Attach the wires out of the Brabus wiring harness to the free ports of plug X33/30 (bn to port 49, bn-rd to port 48).

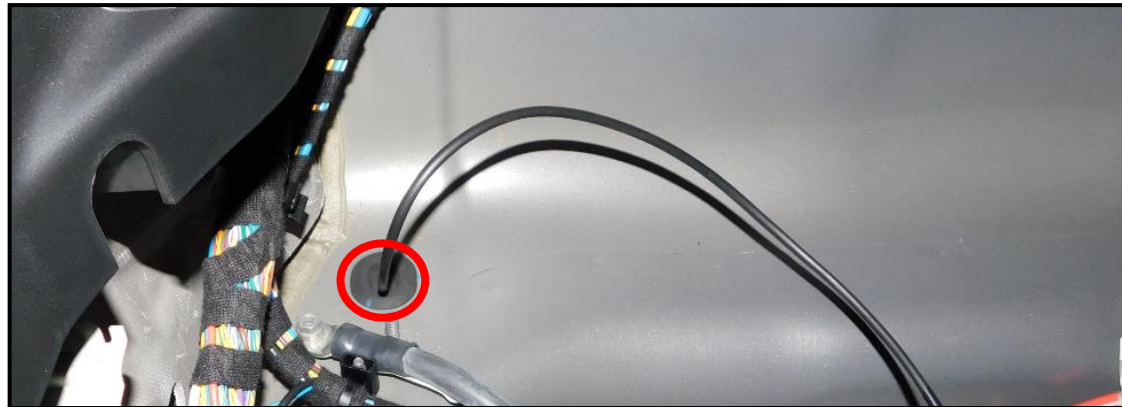


- Connect the plug to the Brabus wiring harness.

- Bolt the ground ring lug within the boot compartment.
- Attach the power supply wire of the Brabus wiring harness to port 455 of the rear fuse and relay box (K40/5). Attach the fuse supplied to the fuse port.

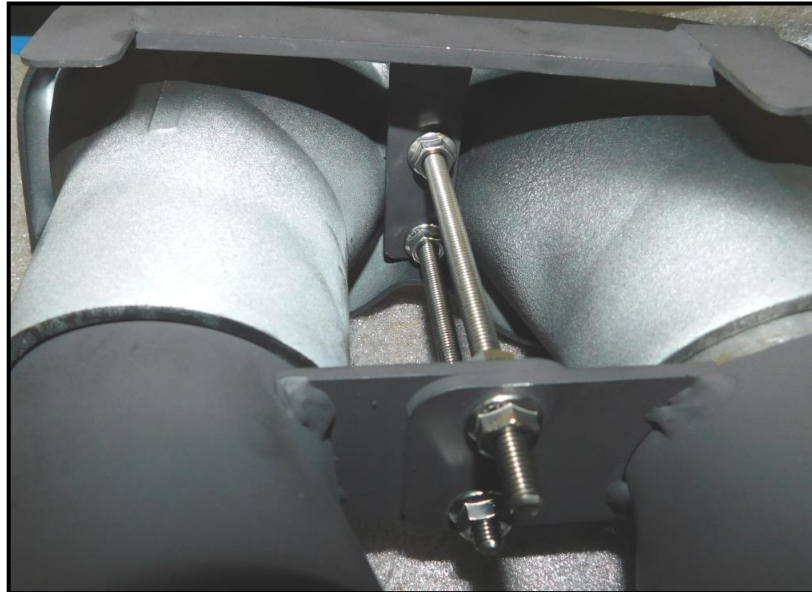
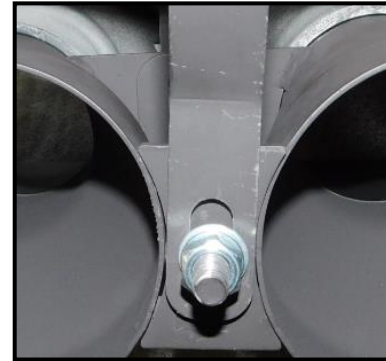


- Route the foglamp extension wire through rubber grommet shown into the boot compartment.



- Attach the wires color equal to the 2-pole plug supplied and connect it to the Brabus wiring harness. Fixate the control unit socket to an appropriate area within the boot compartment using Velcro tape supplied.

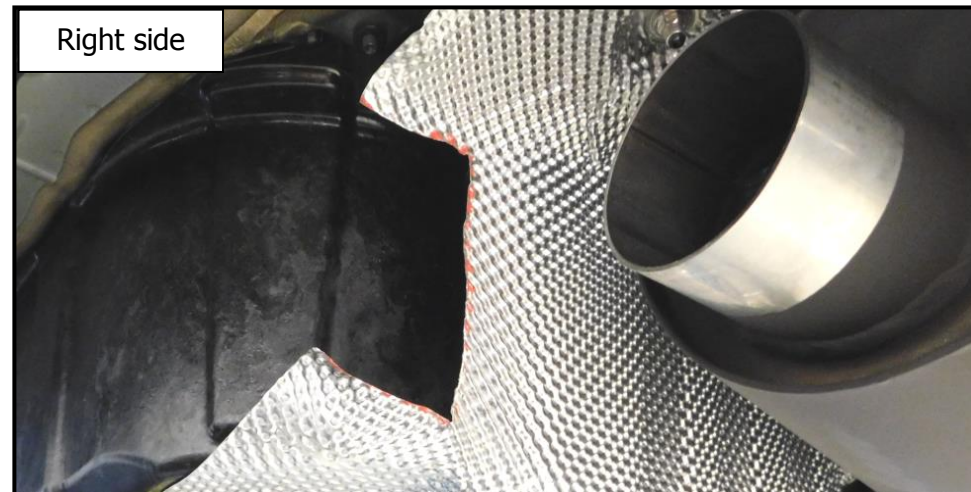
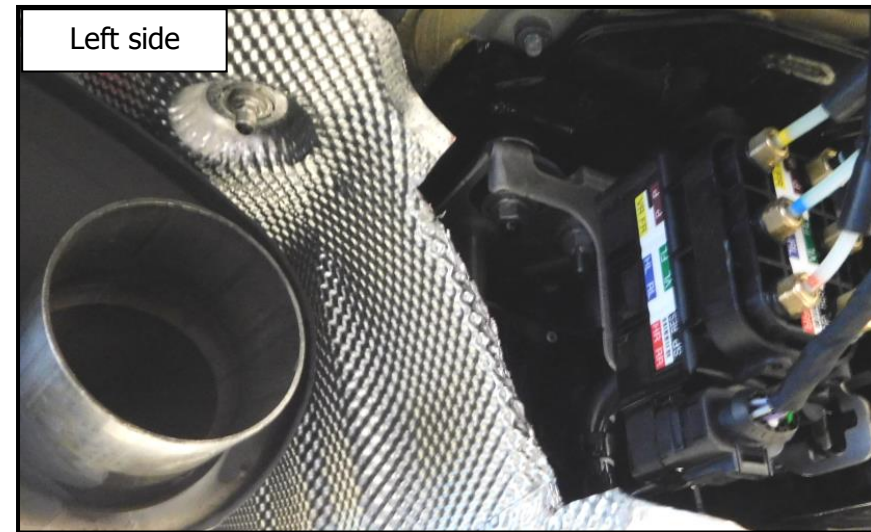
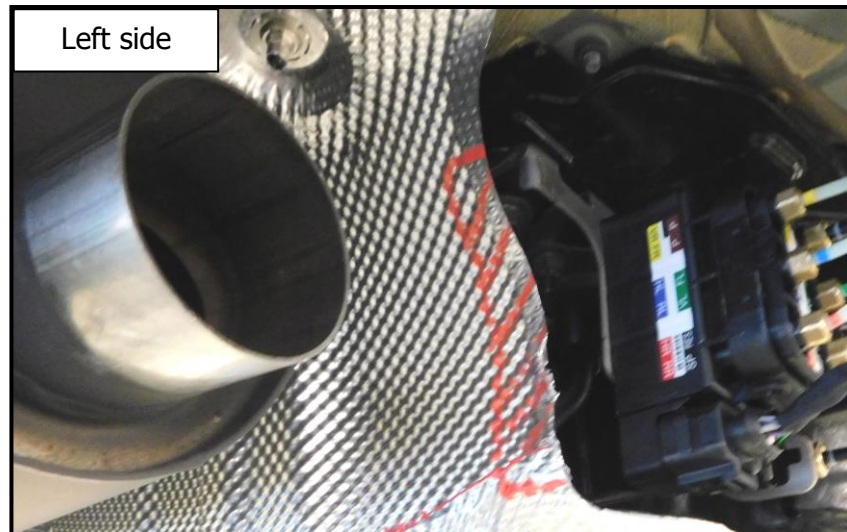
- Connect the electrical plugs of the rearbumper to the vehicle and attach the completed rearbumper to the vehicle.
- Assemble the exhaust tailpipe bezels according to images below using assembly material supplied. Make sure for correct allocations by paying attention to the markings on the brackets (L & R).



- Attach the left and right exhaust tailpipe to the left and right exhaust brackets within the rearbumper (to notches within brackets).
- Bolt the left and right exhaust bracket to the vehicle underbody. Align the exhaust tailpipes to the rearbumper.



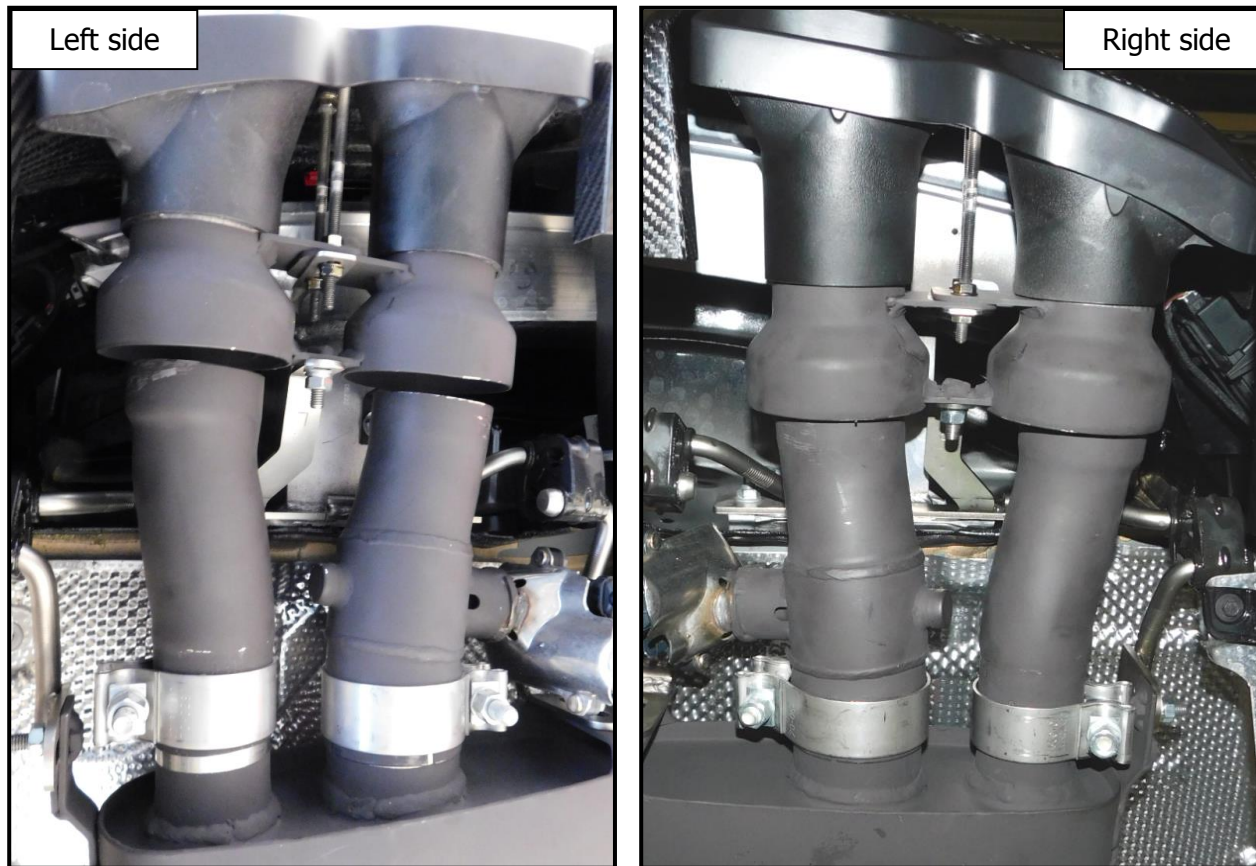
- Mark the areas to be cut out of the exhaust heat shields according to images and cut the marked areas out using a suitable tool.
Make sure for sufficient protection wear while cutting!



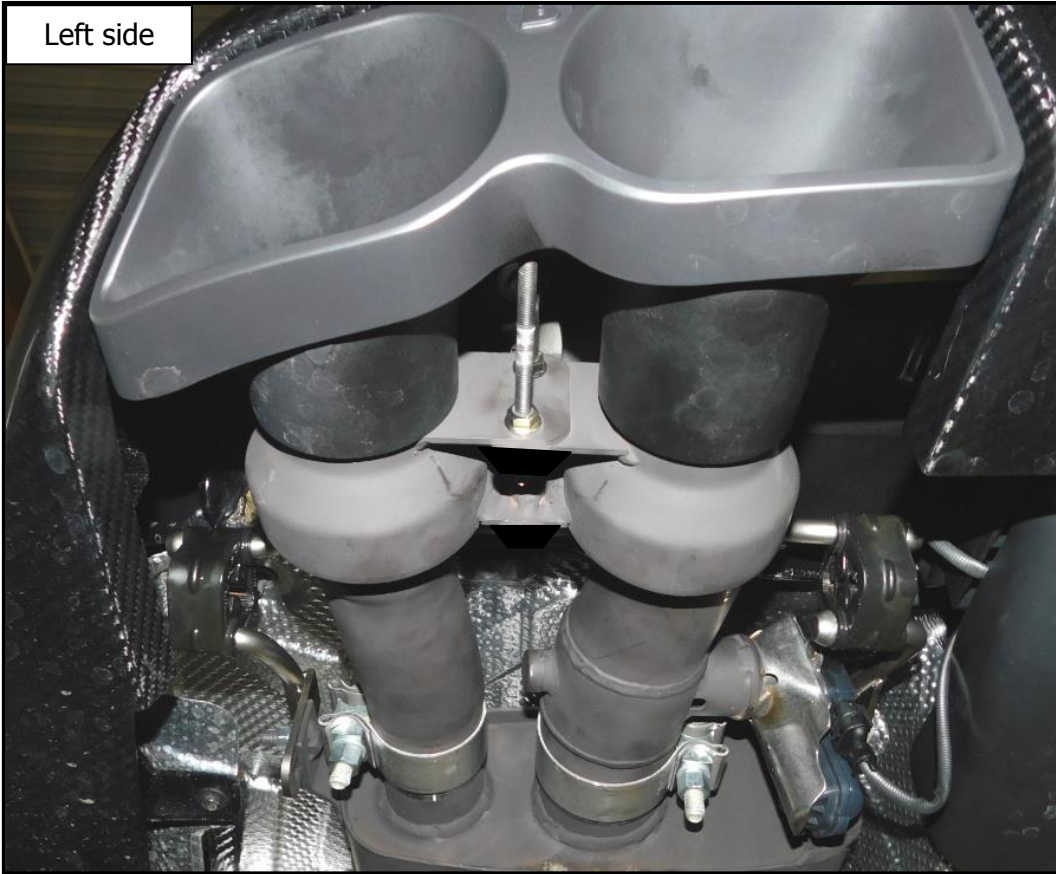
- Bolt the exhaust actuators to the exit pipes of the rear silencers (side markings on packages of exhaust pipes).

**Just bolt the actuators to their seatings, the springs automatically find the correct positions when being activated.
There is no need to adjust the actuators or their springs!**

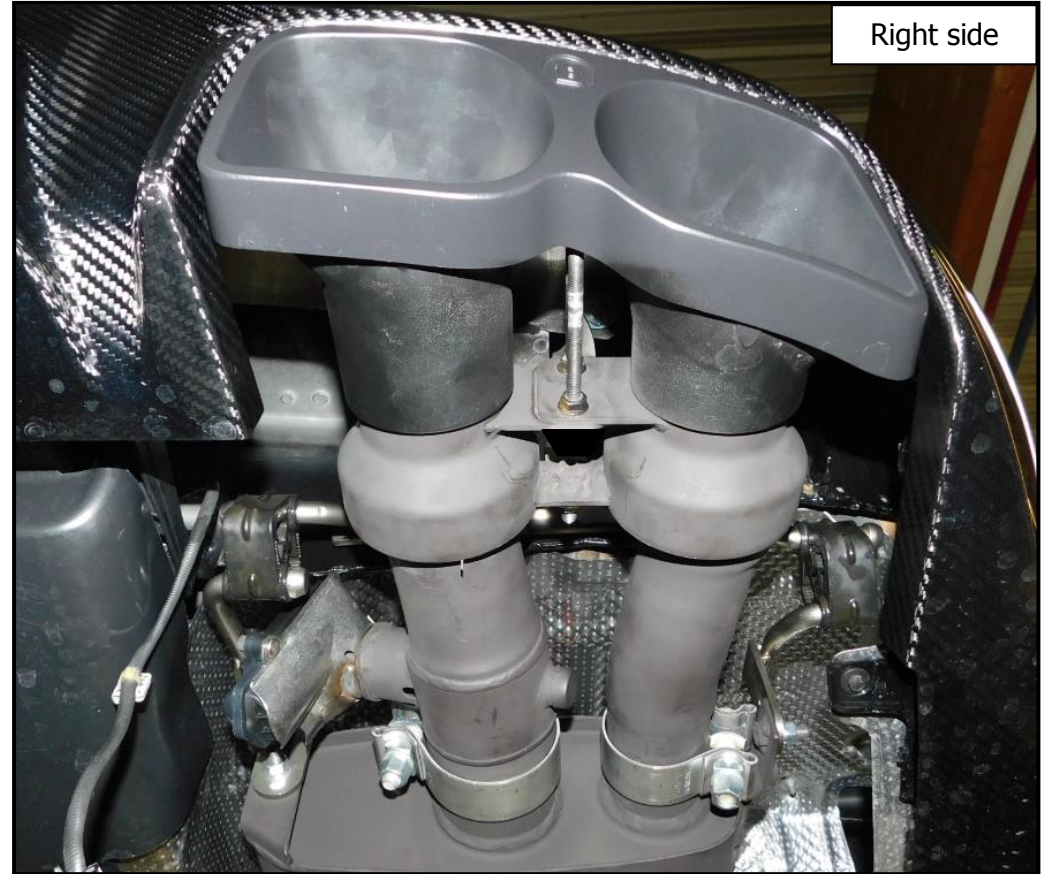
- Attach the exit pipes of the rear silencers to the rear silencers according to images. Align these centered within the ducts of the exhaust tailpipes. Tighten the clamps.



Left side



Right side



- Establish the electrical connections of the exhaust actuators.
- Make sure all bolts and clamps have been sufficiently tightened. Re-assemble all trim and cover parts.
- Perform a test-drive. Check the exhaust system alignment again after having performed the test-drive, re-align, if necessary. Re-check the tightness of all bolts and clamps.