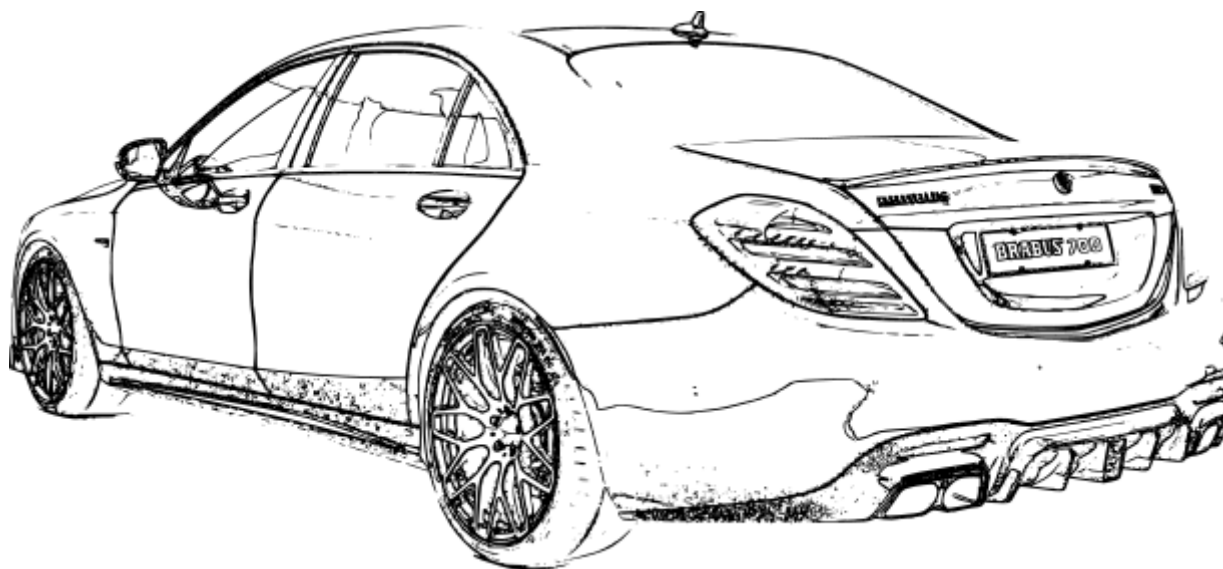




BRABUS®

222-678-63-2 & 222-470-00_10

Valve controlled sports exhaust and carbon fibre rear diffusor for type W222 - S63S AMG - 4 Matic



Installation guide

Official technology-partners



Member of



Deutsch



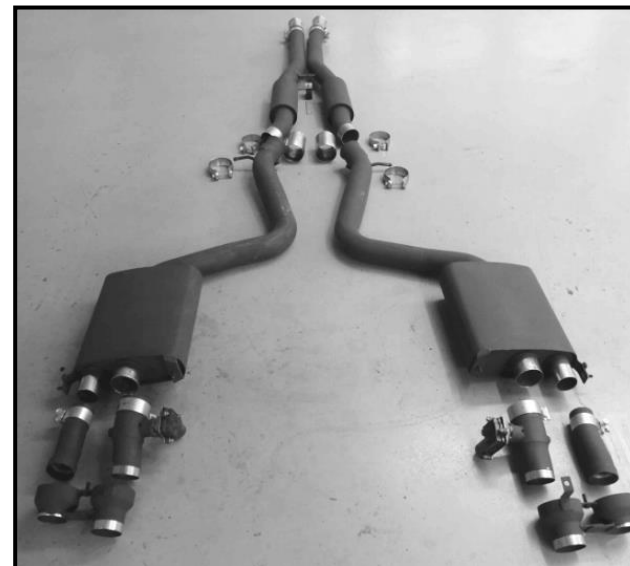
The product described in the instructions was developed, produced and checked considering the necessary safety requirements. In order to ensure a proper and safe function and to rule out danger for persons and objects, this product must be installed appropriately. Only trained, qualified staff, having 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. 222-470-00_10).

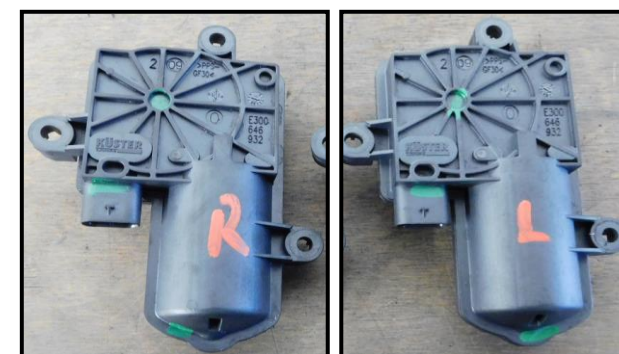
Included in delivery of Brabus valve controlled sports exhaust:

1x	Rear silencer left/ right	222-678-63-2-ESD
1x	Pre-silencers V222	222-678-63-2-VSD
1x	Stainless steel silencer exit pipe package	222-678-63-2-ARP
1x	Left tailpipe	166-678-63-ERLB
1x	Right tailpipe	166-678-63-ERRB
1x	Assembly material	



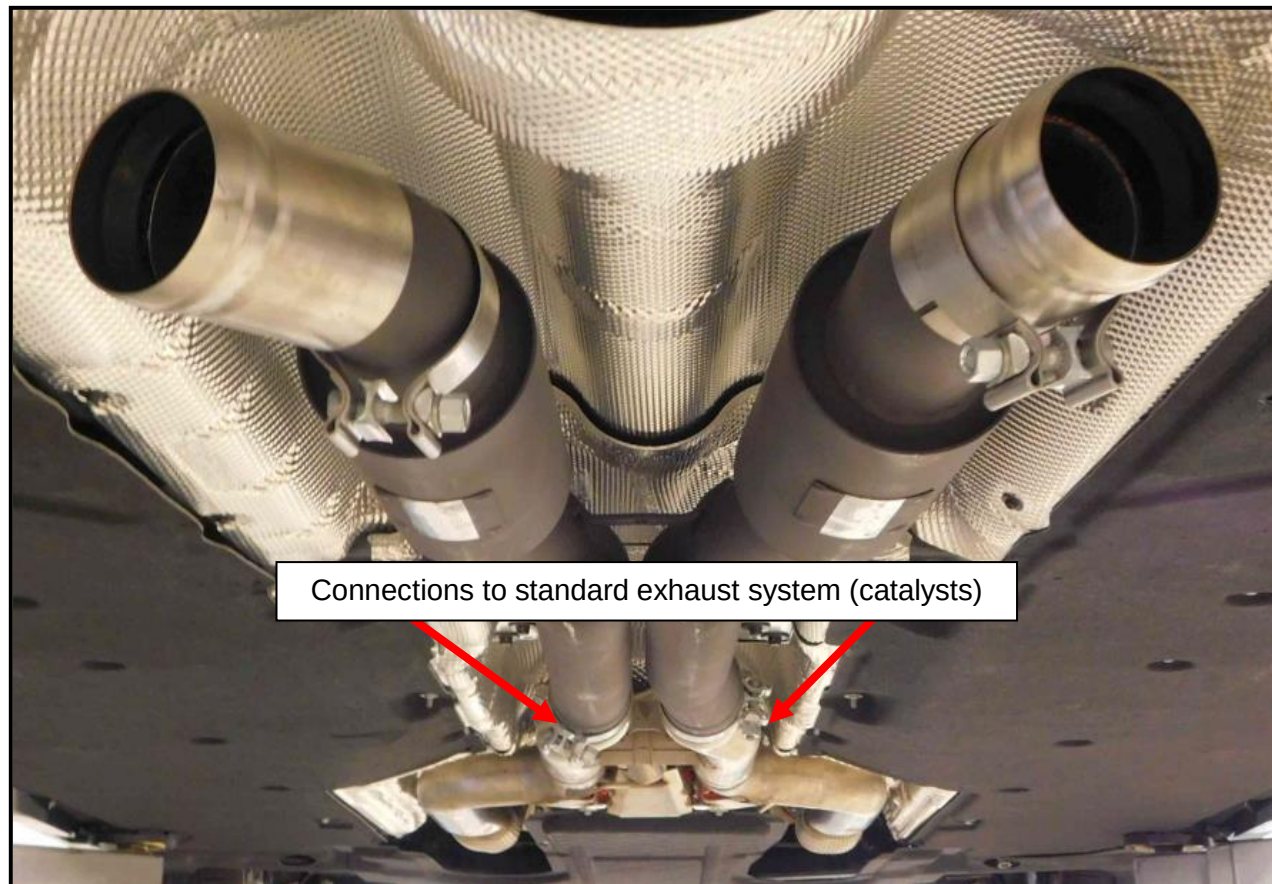
Preparation:

- Lift the car on the Mercedes-Benz prescribed lifting positions according to Mercedes-Benz Workshop instructions (according to WIS-document AR00.60-P-1000LF).
- Remove the rear bumper according to Mercedes-Benz Workshop instructions (AR88.20-P-2200LF).
- Remove the standard exhaust system according to Mercedes-Benz workshop instructions (AR49.10-P-7142MNM).
- Remove the left and right 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!**

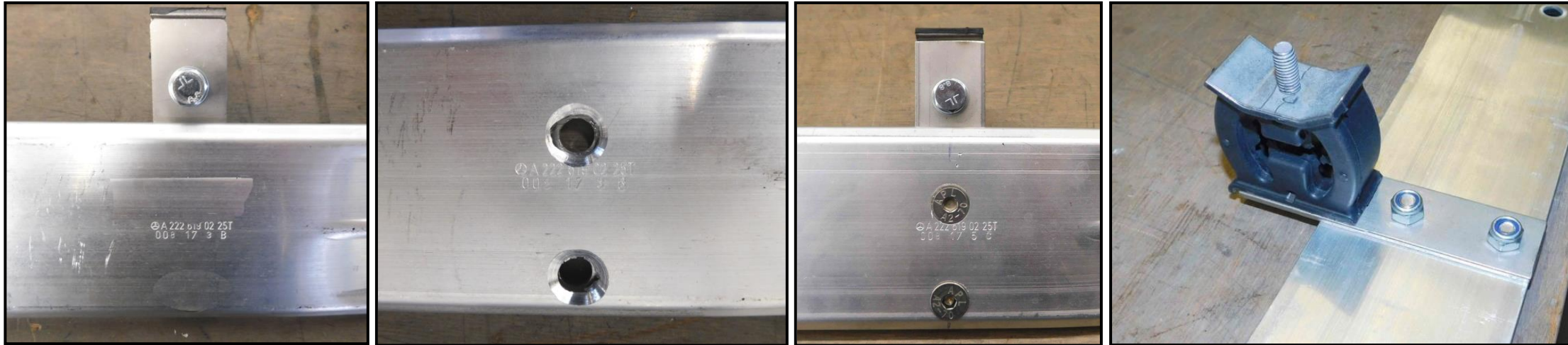


Assembly of exhaust system:

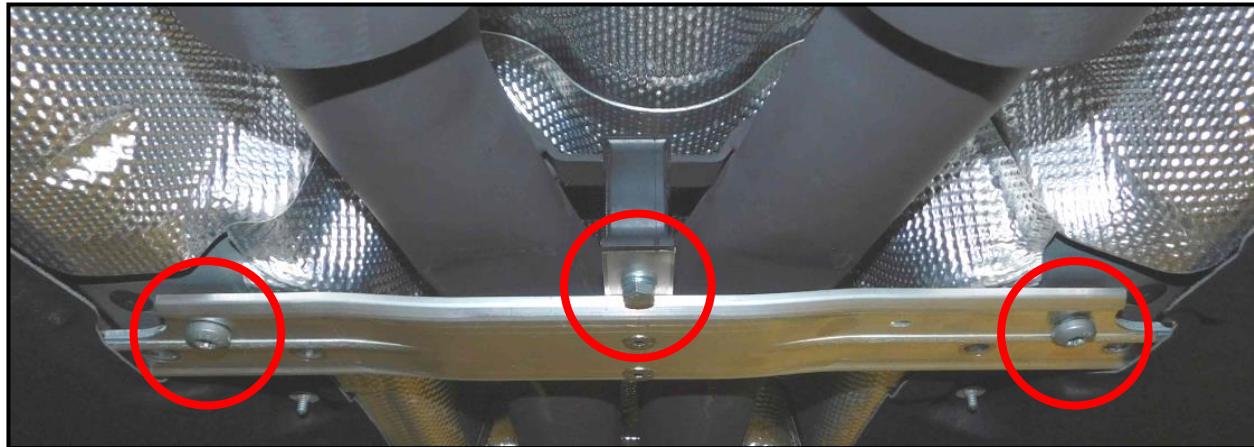
- Bolt the exhaust support to the pre-silencer unit. Assemble the pre-silencer unit pipe to the standard catalysts using assembly material supplied. Only pre-tighten the clamps to be able to align the exhaust system later.



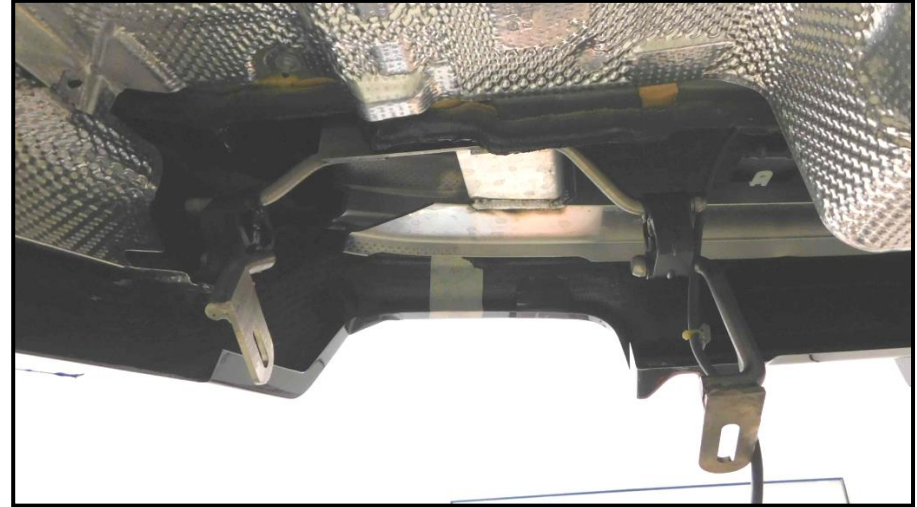
- Hold the exhaust carrier supplied centered to the vehicle underbody strut according to images. Mark the positions for the bores using a spike and drill the assembly holes using a suitable 10mm-drill. Countersink the bores using a suitable tool to reach the countersink bolts are flush to the underbody strut after assembly.



- Connect the carrier to the pre-silencers using assembly material supplied and re-attach the strut to the vehicle underbody.



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



- Connect the left and right rear silencer to the adapter pipe using adapters and clamps supplied, connect the rear silencers to the rear silencer carriers using nuts and washers supplied. Only pre-tighten the bolts and clamp connections to be able to align the exhaust system after assembly.



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

Assembly of carbon fibre rear diffusor:

Included in delivery of Brabus carbon fibre rear diffusor:

1x	Carbon fibre rear rear diffusor, matte or glossy	222-470-01
1x	Foglamp bracket	213-463-08
1x	Foglamp	000-NSL-LED
24x	Clip Speedfix	Q0007371V0000000000
1x	Foglamp adapter wire for standard foglamp connector	222-463-09
1x	Rear bumper bracket	222-470-02
1x	Adhesive kit 80ml	B28/000-8

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).

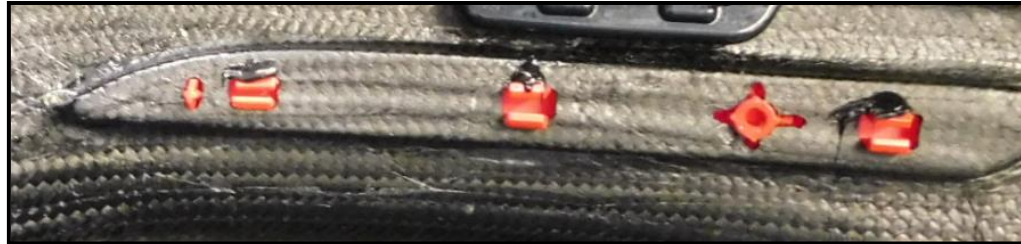
For fixation of the parts until the adhesive is completely hardened, we recommend to use assembly brackets, (e.g. Würth, article-no.: WU069155210 )

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.

- Take the rear bumper insert out of the rear bumper according to Mercedes-Benz workshop instructions.
- Take the parts listed below out of the rear bumper insert:
 - Center plastic inlay (disconnect the electrical connections)
 - Left and right outer inlay (by drilling the factory rivet connections)
 - Left and right reflector
- Attach the reflectors to the carbon fibre rear diffusor and additionally secure them using adhesive supplied.



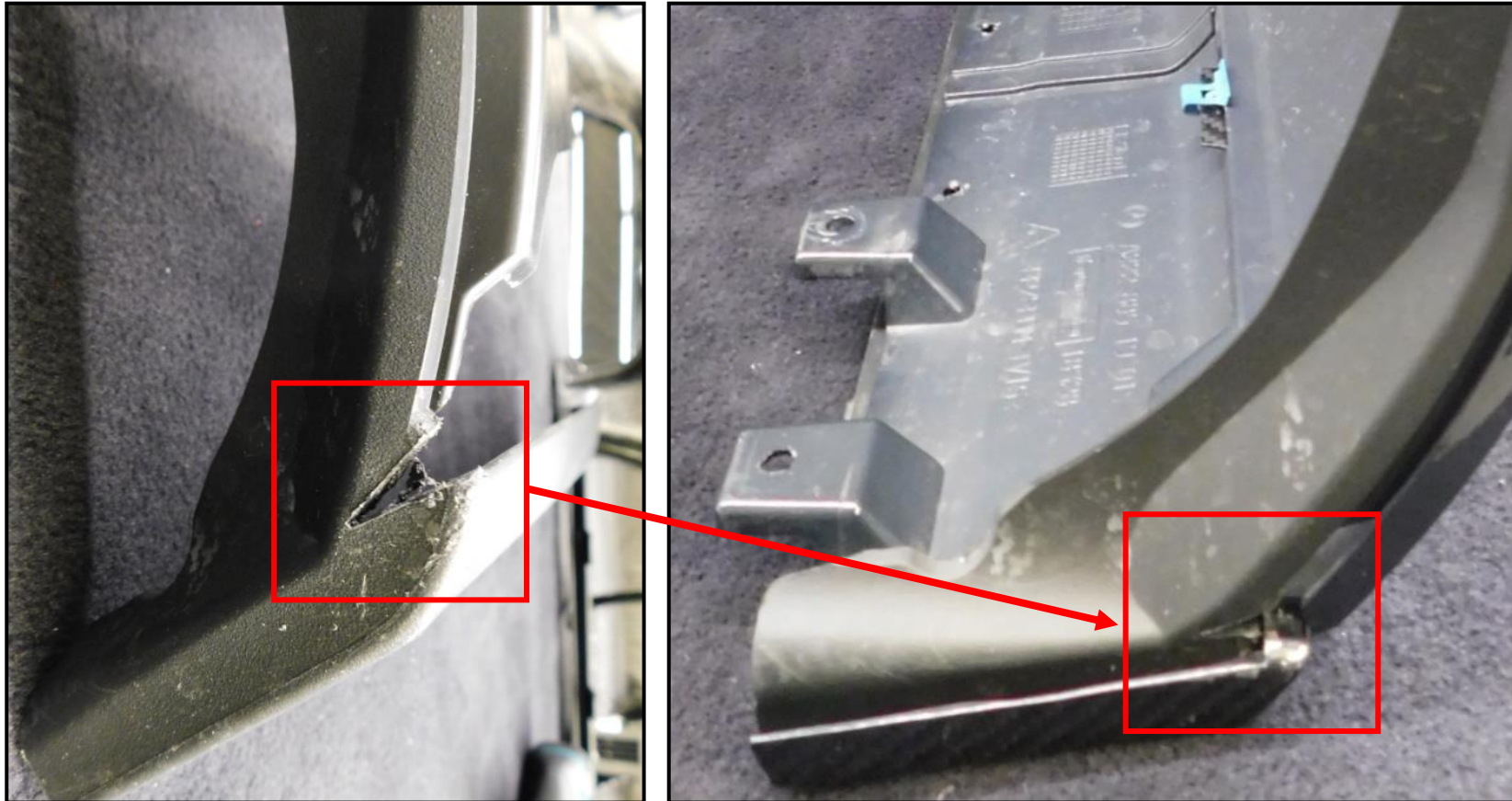
- Attach the Brabus carbon fibre rear diffusor to the fixation notches of the rear bumper and secure it using Speedfix clips supplied. Bolt the foglamp supplied to the carbon fibre rear diffusor.



- Divide the fixation lugs from the outer inlays using a suitable tool.



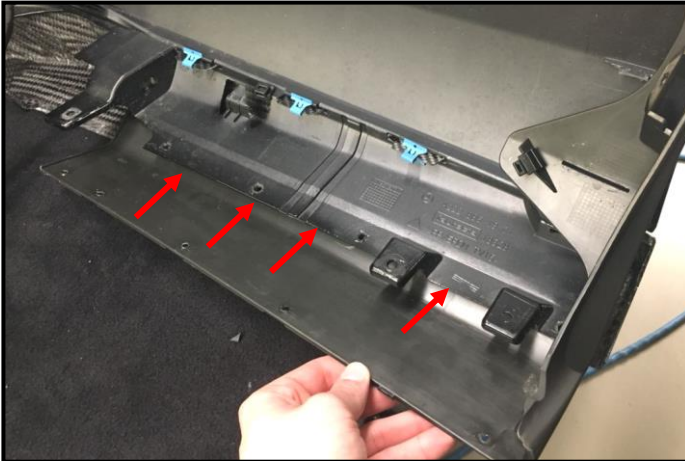
- Cut small openings into the edges of the outer inlays according to images below to reach the inlays will fit flush between the carbon fibre rear diffusor and the rear bumper. Check the seatings of the inlays and re-work the openings, if necessary.



- Prepare the bonding areas of the inlays and those of the carbon fibre rear diffuser according to bonding hints, carefully degrease the bonding areas.



- Bond the inlays to the areas between the rear diffuser and the rear bumper using adhesive supplied and fixate the parts until the adhesive is finally hardened (e.g. by using collets, according to images below). The upper lugs are connected to the rear bumper using standard assembly material.



- Attach the center plastic inlay to the rear diffuser and the rear bumper.

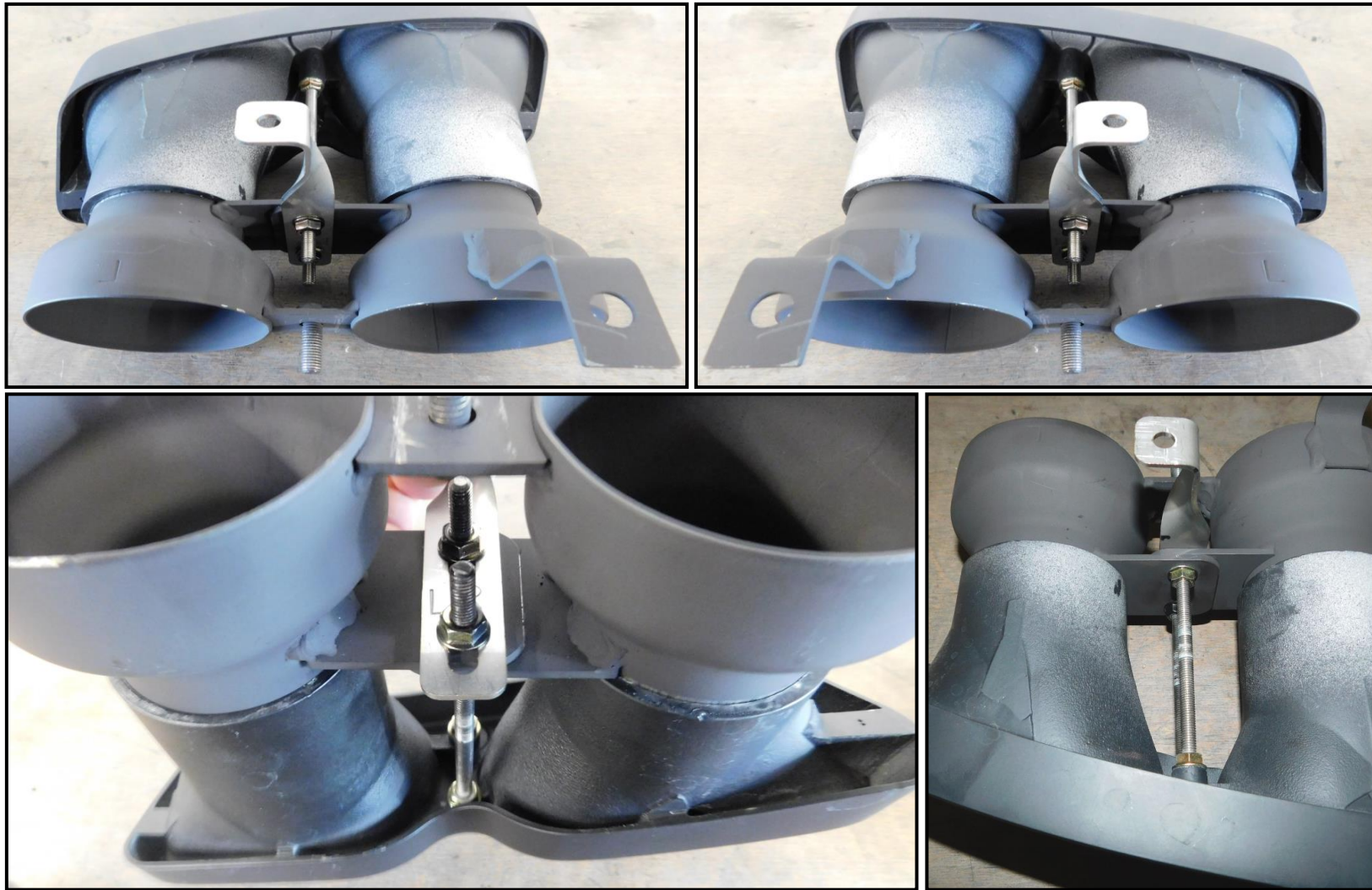


- Connect the adapter wire supplied to the foglamp.

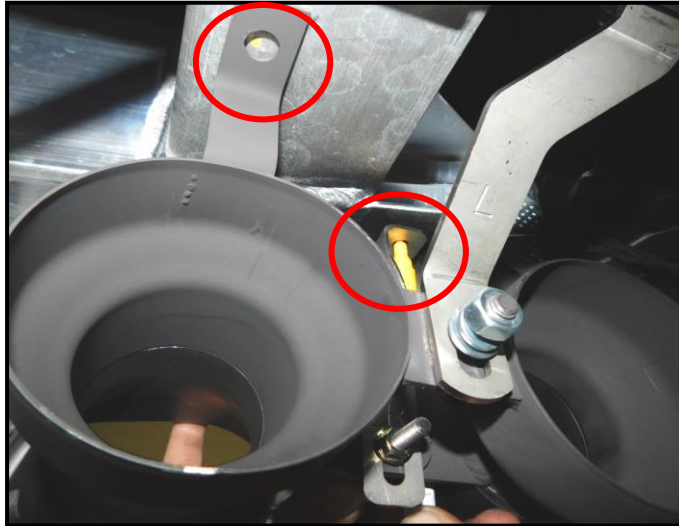
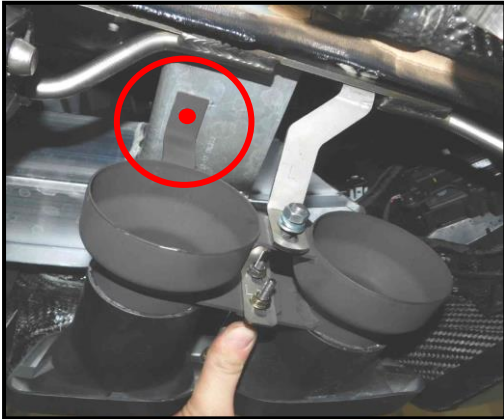


- Re-assemble the completed rear bumper to the vehicle according to standard workshop documentation.

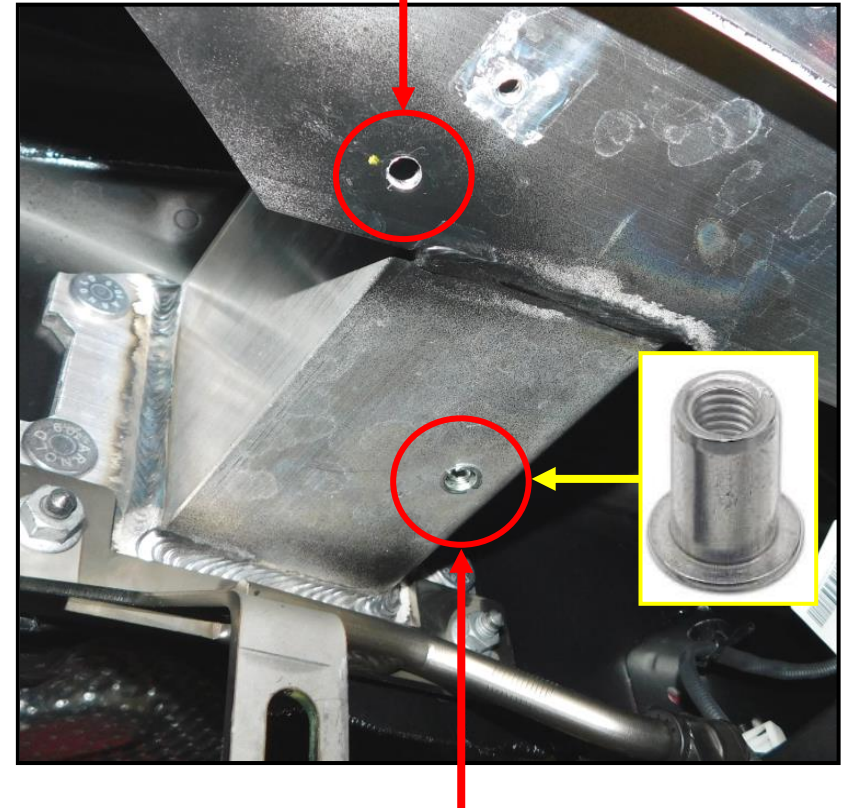
- Assemble the rear tailpipes according to images below, using assembly material supplied. Make sure for correct allocation (left & right markings on the tailpipe funnels).



- For assembly of the rear tailpipes two assembly holes are to be drilled into the rear cross strut, one each left and right side and one into each the longitudinal supports. Hold the completed exhaust tailpipes into the openings of the rear diffuser. Align them centered and equal within the openings and mark the holes which are to be drilled using a suitable marker. Drill 7mm holes into the rear cross strut and 10mm holes into each the longitudinal supports. Make sure for proper protection when drilling the holes (protective glasses).



Bore diameter 7mm, fixation by screw M6, nut M6 and lock washer



Bore diameter 10mm, fixation by press nut M6, screw M6 and lock washer M6

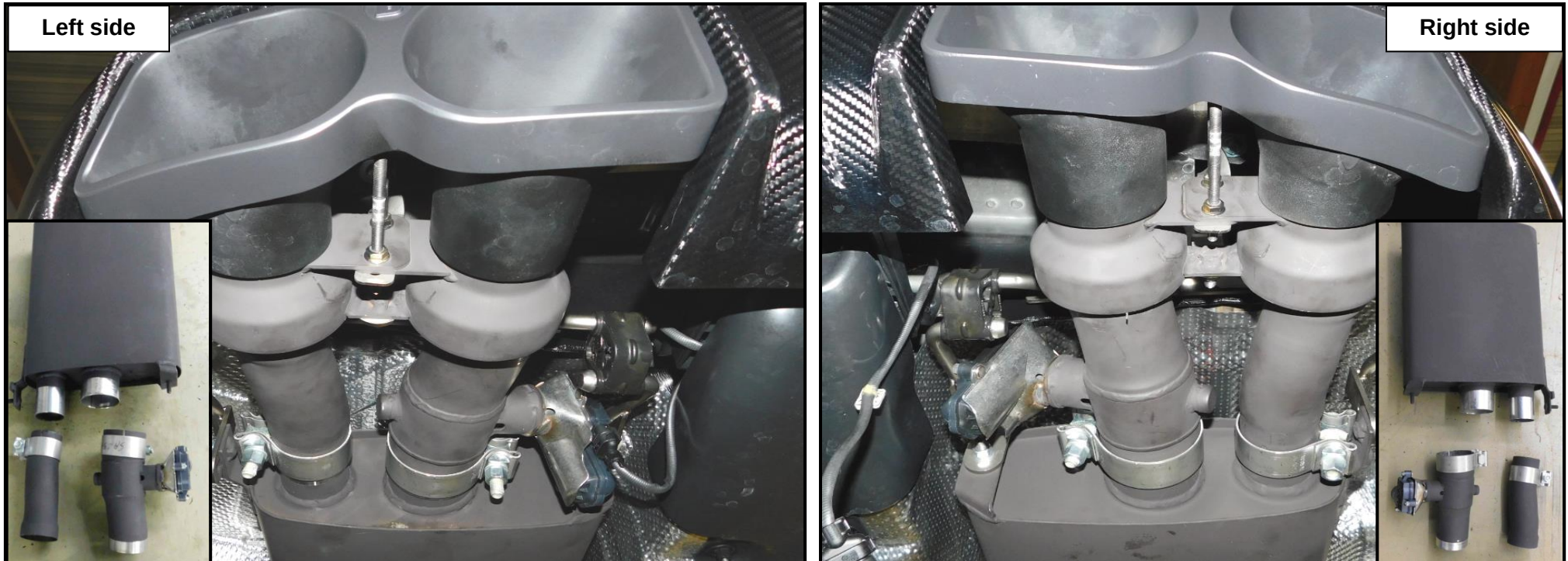
- Bolt the third fixation points of the rear exhaust tailpipes to the standard bolts of the exhaust brackets (at rear cross strut).



- Bolt the exhaust actuators to the exit pipes of the rear silencers (side markings on packages of exhaust pipes). Do not interchange the left and right actuator!

**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. Regard to the left/ right markings on the packages.



- Establish the electrical connections of the exhaust actuators.
- Finally align the exhaust system tension-free. 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.