BRABUS®

Anpassungsmaßnahmen
Adaptation measures

Widestar-Bodykit

Teile-Nr./ *Part-no*: 463-234_236-XX

W463

Die in diesem Dokument beschriebenen Anpassungsmaßnahmen sollten vor dem Lackieren der Bauteile des BRABUS Widestar-Bodykits durchgeführt werden.
Herstellungsbedingte Toleranzen, die nach Fertigstellung des Umbaus etwaige Reklamationen nach sich ziehen könnten, werden durch die Durchführung dieser Maßnahmen vermieden.
Weiterhin sind die beschriebenen Maßnahmen notwendig,
um die Bauteile an das jeweilige Fahrzeug anzupassen, da die Fahrzeuge selbst Fertigungstoleranzen aufweisen.
The adaptation modifications described within this document should be performed prior to painting the components of the BRABUS Widestar-bodykit.
The modifications are necessary to avoid reclamations after completion of the modification caused by manufacturing tolerances. Furthermore the described modifications are necessary to adapt the components to the several vehicles which also show manufacturing tolerances.

Demontieren Sie vor Beginn der Anpassungsarbeiten die folgenden Serienkomponenten des Fahrzeuges gemäß Mercedes-Benz Werkstattinformationssystem.
Prior to adaptation remove the below listed standard components from the vehicle according to Mercedes-Benz workshop information system.

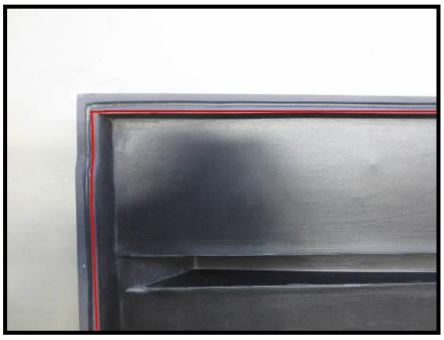
- **Frontstoßfänger/** ***Frontbumper***
- **Heckstoßfänger/** ***Rearbumper***
- **Kühlergrill/** ***radiator grille***
- **Scheinwerferrahmen/** ***headlamp frames***
- **Vordere und hintere Kotflügelansätze/**
  Front and rear fender wings
- **Obere und untere Zierleisten/** ***upper and lower side trims***
- **Vordere und hintere Trittbrettecken/**
  Front and rear running board caps
- **Türverkleidung der Fahrertür, Zentralverriegelungssensor**
  Door panel of driver's door, central locking system-sensor
- **Innere Verkleidungen der hinteren Seitenteile**
  Left and right inner sidewall trims
- **Tankdeckel/** **fuel filler cap**

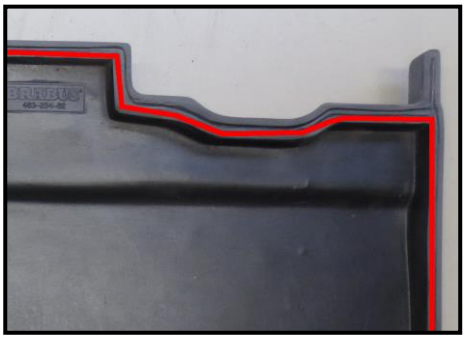


- Entnehmen Sie der Verpackung die Widestar - Komponenten und überprüfen Sie diese auf Beschädigungen.
  Unbox the Brabus Widestar - components and check these for damages.

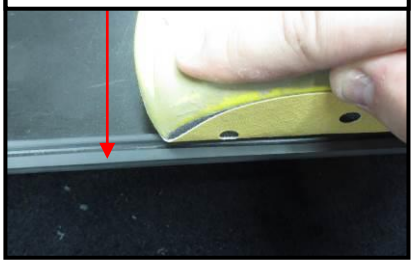
Durchzuführende Nacharbeiten/ ***post-treatments to be performed:***

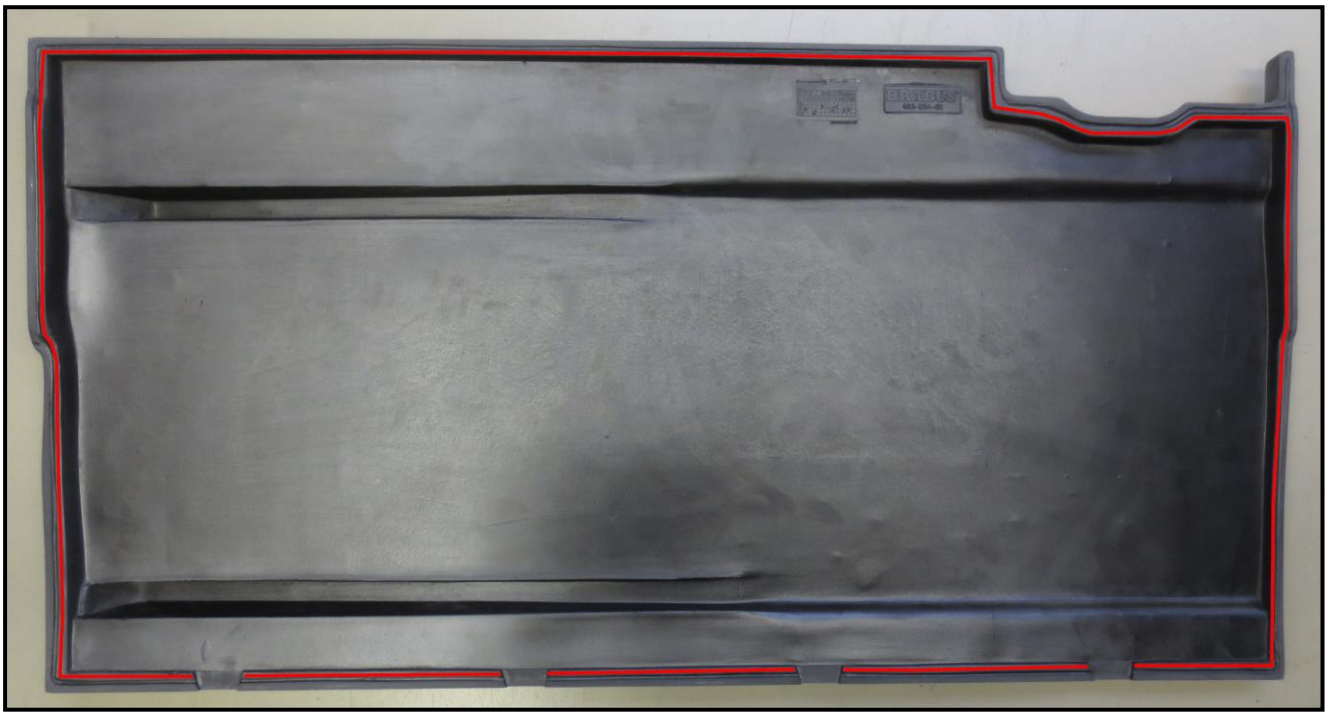
- Um eine möglichst hohe und dauerhafte Klebekraft zu erreichen, empfehlen wir, die inneren Klebekanten der vorderen und hinteren Türverkleidungen mit einem geeigneten Werkzeug (z.B. Schleifklotz), gemäß den Abbildungen unten auf das Niveau der mittigen Rille herunter zu schleifen. **Bearbeiten Sie nicht die äußeren Kanten der Bauteile!**
  To reach a bonding connection with maximum and long-lasting strength we recommend to sand the inner bonding edges of the front and rear door attachments down to the level of the center bonding edge grooves using a suitable tool (e.g. sanding block), according to images below.
  Do not re-work the outer edges of the components!





Äußere Kanten nicht bearbeiten!
Do not re-work outer edges!

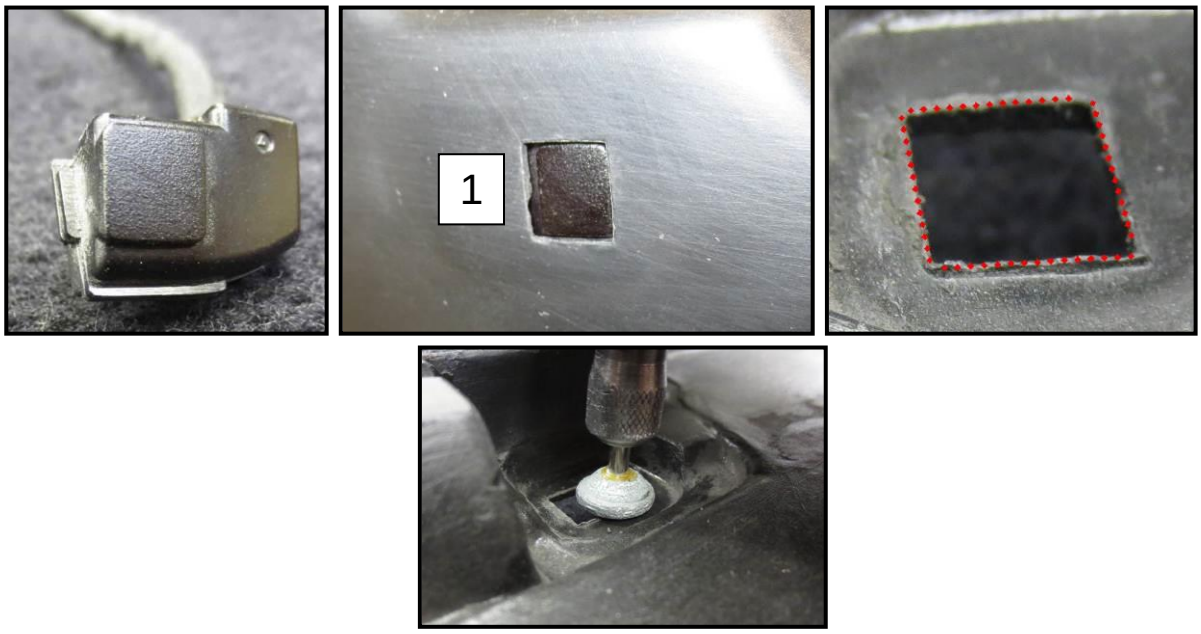




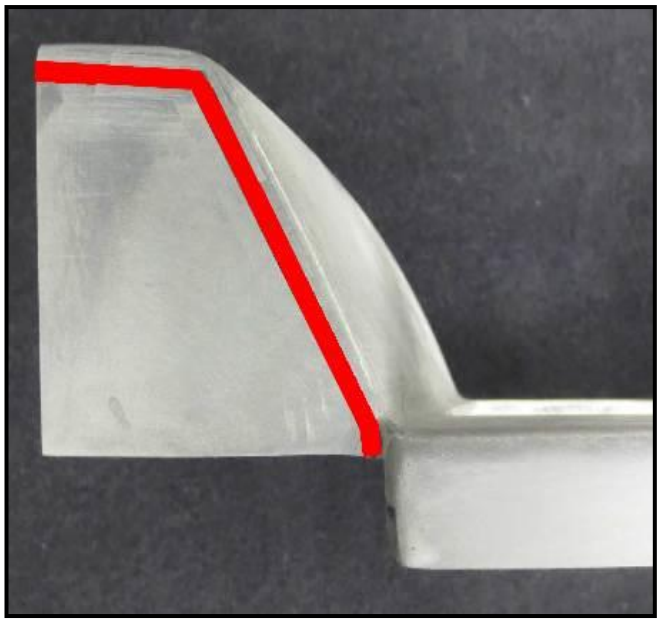
- Vertiefen Sie die unten gezeigten Klebstoffrillen der Türverkleidungen, sollten diese an den Türaufsatzteilen zu flach ausgeführt sein (wie **1**), mit einem geeigneten Werkzeug.
  *If accomplished too flat (as **1**), deepen the adhesive grooves shown of the door attachment parts using a suitable tool.*

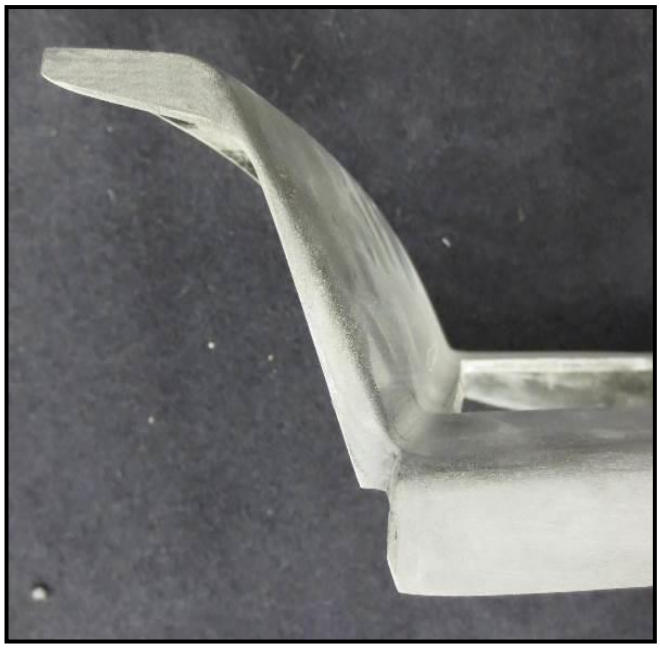


- Halten Sie den Sensor für die Zentralverriegelung in das Türaufsatzteil der Fahrertür und prüfen Sie die Passform. Sollte der Sensor sich nicht gleichmäßig in die Öffnung einstecken lassen (**1**), schleifen Sie die in der Abbildung (**2**) gezeigten Kanten mit einem geeigneten Werkzeug vorsichtig ab.
  Achtung, dünnwandiges Material, äußerst vorsichtig schleifen!
  *Hold the central locking system sensor to the opening of the driver's door attachment and check for proper seating. If the sensor does not properly suit the opening of the door attachment (**1**), sand the plastic edges (**2**) shown within image below down using a suitable tool. **Attention: Thin-walled material, sand carefully!***



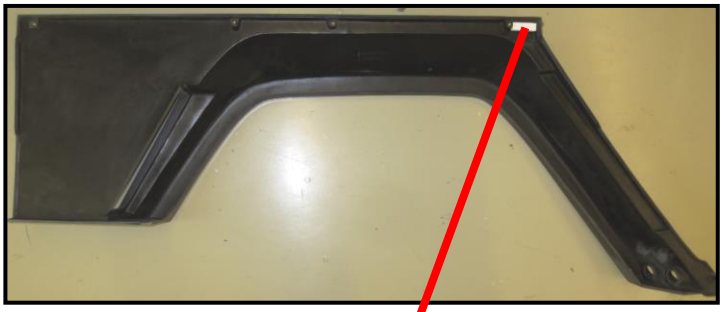
- Schneiden Sie die in der Abbildung ersichtlichen, rot markierten Bereiche aus den Ecken der Heckschürze aus, um bei der späteren Montage die Schrauben setzen zu können, die als Verbindungen zu den Aufsatzteilen der hinteren Seitenteile dienen.
  Cut the areas marked red within image below out of the BRABUS rearbumper to be able to, while completing the vehicle, set the bolt connection which serves the connection between the rearbumper and the rear fender attachments.



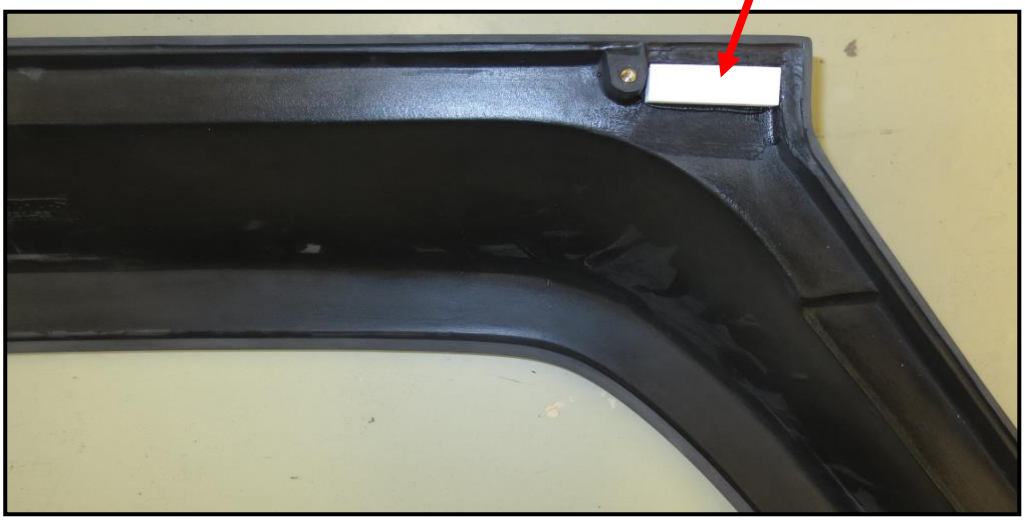


- Verkleben Sie, gemäß den Abbildungen und unter Beachtung der Klebehinweise, die mitgelieferten PVC-Blöcke an gezeigten Positionen der vorderen-und hinteren Kotflügelaufsatzteile. Auf diese wird beim Verkleben der Bauteile Klebstoff aufgetragen und durch die vergrößerte Klebefläche die Klebekraft erhöht.
  Bond the PVC blocks supplied to the front and rear fender attachments according to images below and bonding hints last page. When bonding the parts to the vehicle adhesive is applied also to these blocks, this raises the bonding strength.



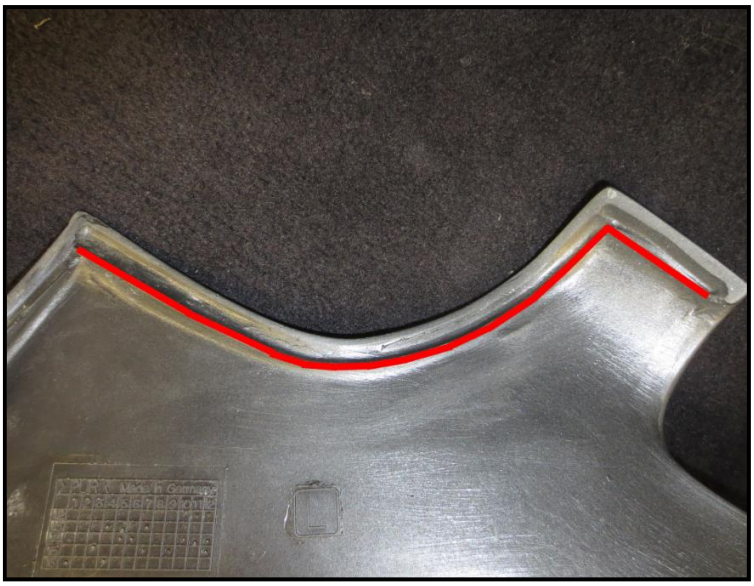






- Glätten Sie, unter Verwendung eines geeigneten Werkzeuges, die in der Abbildung rot markierte Klebekante der vorderen Ansatzteile des Widestar-Bodykits, um den Klebebereich zu erweitern. Bearbeiten Sie nicht die äußere Kante!
  Smoothen the bonding edge marked red within image below using a suitable tool in order to enlarge the bonding area. Do not re-work the outer edge!



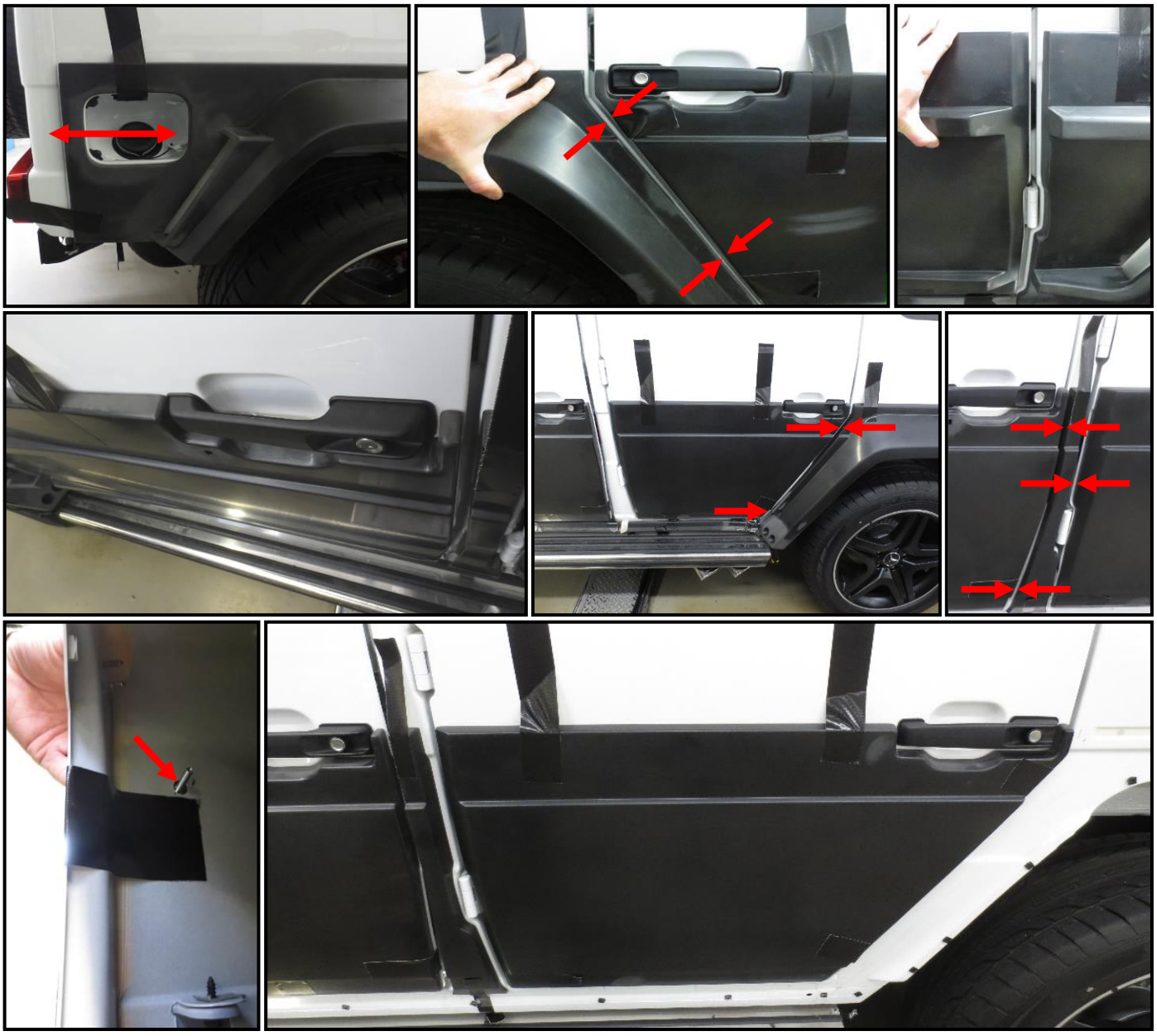


- Halten Sie, gemäß den Abbildungen, die Aufsatzteile für die vorderen Kotflügel, die Türen, die hinteren Seitenteile, sowie die Aufsatzteile zwischen und unter den Türen ans Fahrzeug an. Richten Sie alle Aufsatzteile zueinander aus.
  Fixieren Sie die Aufsatzteile mittels Gewebeband, sichern Sie sie zusätzlich an den zugänglichen Stellen von innen mit den mitgelieferten Muttern. Achten Sie auf gleichmäßige Spaltmaße und markieren Sie die Positionen der Bauteile mit einem abwaschbaren Marker an der Fahrzeugkarosse. Verschrauben Sie die Frontschürze am Fahrzeug, um die Übergänge der Widestar-Komponenten zum Frontstoßfänger auf Gleichmäßigkeit überprüfen und ausrichten zu können.
  Hold the body attachment parts for the front and rear fenders and the doors, same as the bodyparts, below and between the doors, to the vehicle. Align them to each other and fixate the parts using velcro tape and, at accessible areas, additionally fixate them by using nuts supplied. Make sure for even gaps and mark the outer shapes of the bodyparts to the vehicle body using a washable marker. Assemble the frontbumper to the vehicle to be able to check the gaps between the Widestar-components and the frontbumper for evenness and align the parts.



Widestar-Bodykit

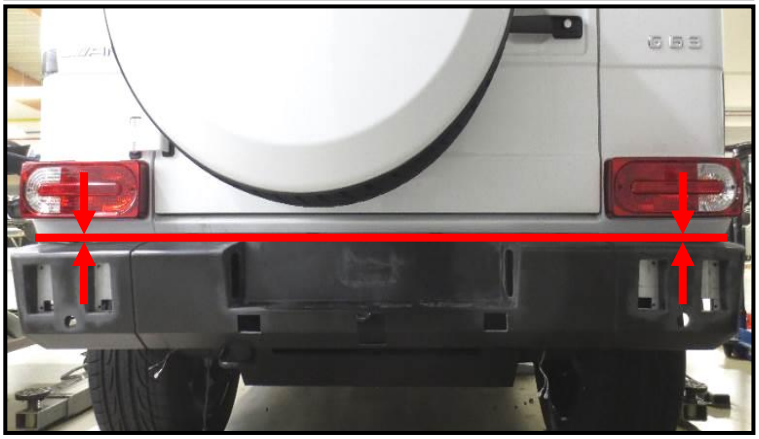
Teile-Nr./ *Part-no*: 463-234_236-XX



- Verschrauben Sie den Heckstoßfänger mit dem mitgelieferten Montagematerial, gemäß der Montageanleitung und den Abbildungen, am Fahrzeug. Richten Sie diesen zu den Widestar-Komponenten und zur Karosserie spannungsfrei aus.
  Assemble the rearbumper to the vehicle using assembly material supplied, according to the installation guide and pictures below. Align it to the Widestar-components and to the vehicle tension-free.







- Halten Sie die äußeren Ansatzteile des Widestar-Bodykits gemäß den Abbildungen an den Heckstoßfänger an. Richten Sie diese zur Heckschürze und den Widestar-Seitenteilaufsätzen aus. Markieren Sie die Positionen der Bauteile und verkleben Sie sie am Heckstoßfänger (Hinweise zur Verklebung auf letzter Seite beachten!
  Hold the outer Widestar rearbumper-attachments to the rearbumper. Align the parts to the rearbumper and the rear fender attachments. Mark the positions to the rearbumper and adhere the parts. Regard to bonding hints last page!





Hinweise zur Verklebung

Die Bauteile können sowohl mit dem mitgelieferten Kleber, als auch mit PU-Scheibenkleber in Verbindung mit entsprechendem Primer verklebt werden. Bei Verwendung des mitgelieferten Klebers müssen alle Klebeflächen, sowohl die am Fahrzeug, als auch die am Aufsatzteil, mit Sandpapier angerauht und hinterher entsprechend gereinigt und entfettet werden.
Wir empfehlen die Verwendung von Scheibenkleber (z.B. Würth, Scheibenkleber „Classic“ oder „Pro“, Artikelnr.: WU89002310, WU89002330) in Verbindung mit Aceton (z.B. Würth, Art.-Nr.: WU893460) und Primer (z.B. Würth, Art.-Nr.: WU890024101). Der Primer wird nach dem Reinigen mit Aceton mithilfe entsprechender Primerpinsel (z.B. Würth, Art.-Nr.: WU891650) auf den Klebeflächen am Fahrzeug und am Bauteil aufgebracht (nur in eine Richtung auftragen, danach ablüften lassen!). Tragen Sie gleichmäßige Kleberaupen auf die Klebekanten auf und verkleben Sie die Teile am Fahrzeug.
Zum Entfernen von überschüssigem Kleber empfehlen wir beispielsweise K+D Reiniger (z.B Würth, Art.-Nr.: WU89010063). Zum Fixieren der Bauteile bis zum Aushärten des Klebers empfehlen wir Klemmsauger (z.B. Würth, Art.-Nr.: WU069155210)
Es ist zu beachten, dass man die Klebeflächen nicht in dem Bereich mit Primer behandelt, den man nach dem Verkleben des entsprechenden Teils noch sehen kann! Primer nur bis zu einem Abstand von ca. 5mm zur Markierung auftragen!
Beachten Sie die Klebehinweise, achten Sie stets darauf, dass sämtliche Klebeflächen vor dem Verkleben sauber und fettfrei sind! Befreien Sie Klebeflächen vor dem Verkleben von Lacknebel!

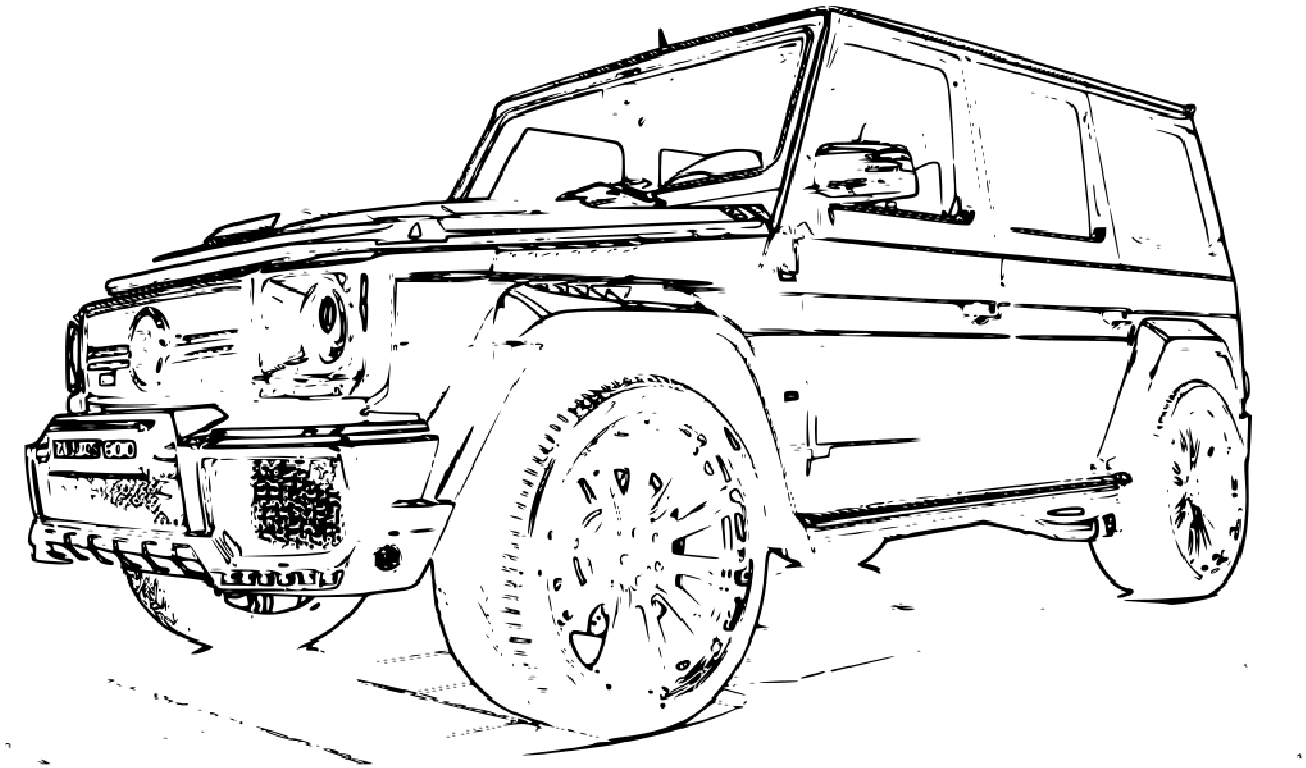
Bonding hints

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 degreased.
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 even lines of adhesive and bond the parts to the vehicle. 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.

BRABUS®

Widestar-Bodykit G63/ G65 AMG



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 make the installation.
Therefore you have to read and completely understand these instructions.

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.

Official technology-partners PIRELLI BILSTEIN Continental MOTUL YOKOHAMA ADVAN Member of VDA

Included in delivery:

1x	Base-bodykit G63/ G65	463-236-00B
1x	Electric kit for ill. running boards	463-351-14
2x	Typing „Brabus“	216-000-22
1x	Filler cap attachment	463-234-56ZB
8x	LED-unit	166-351-05
1x	Ill. fender brace left	463-550-01
1x	Ill. fender brace right Widestar-	463-550-02
1x	rearbumper	463-410-00W
3x	PU-adhesive„Classic Plus“	WU890023701
1x	Assembly kit	463-234-90
1x	Set of fender trim grilles	463-550-55
1x	Set of fender cover plates	463-550-56
1x	Front left fender attachment G63	463-234-21
1x	Front right fender attachment G63	463-234-22

Consisting of:

1x	Wiring loom	463-351-14B
1x	Control unit	463-353-00

Consisting of:

1x	Stiffener	A1247570510
1x	Buffer support	A0009980644
1x	Brace	A0009949645
1x	Filler cap	463-234-56
1x	Carrier	463-234-57
1x	Bracket	463-234-57-1
1x	Bracket	463-234-57-2

Consisting of:

1x	Rearbumper	463-410-01
1x	Assembly kit	463-415-00
2x	Sensor support	463-430-03
2x	Reverse lamp	000-RFS-01
2x	Foglamp	000-NSL-01
4x	PTS-Adapter	X204-270-15
2x	Carrying plate	463-410-05
4x	Carrying plate	463-410-06
1x	Center carrier	463-410-07
1x	Wiring loom	463-410-19
1x	Center attachment	463-41500
1x	Left attachment	463-235-41
1x	Right attachment	463-235-41
1x	PU-Adhesive-kit	B28/000-8

Consisting of:

10x	Screw	N914031004223
1x	Washer	Z000-000-99

Consisting of:

1x	Rr left fender attachment	463-234-53
1x	Rr right fender attachment	463-234-54
1x	Fr. left fender attachment	463-234-51
1x	Fr. Right fender attachment	463-234-52
1x	Blind spot sensor bracket	463-400-03
1x	Blind spot sensor bracket	463-400-04
1x	Fr. left running board cap	463-236-31
1x	Fr. right running board cap	463-236-32
1x	Rr. left running board cap	463-236-33
1x	RR right running board cap	463-236-34
1x	Left side attachment	463-234-31L
1x	Right side attachment	463-234-31R
1x	Fr. left door attachment	463-234-61
1x	Fr. right door attachment	463-234-62
1x	Rr. Left door attachment	463-234-65
1x	Rr. Right door attachment	463-234-66
1x	Inter-door attachment left	463-234-63
1x	Inter-door attachment right	463-234-64
1x	Set of trim grilles	463-234-26
2x	Buffer	A1409880311
2x	Cover	463-234-27
4x	Nut M6	

Cosnisting of:

1x	Left ABS part “3”
1x	Right ABS part ”3”
1x	Left ABS part “ 4”
1x	Right ABS part “4”

Consisting of:

1x	Trim grille left “3“
1x	Trim grille right “3“
1x	Trim grille left “4“
1x	Trim grille right “4“

Official technology-partners PIRELLI BILSTEIN Continental MOTUL YOKOHAMA ADVAN Member of VDA

Hints for adherence of single components:

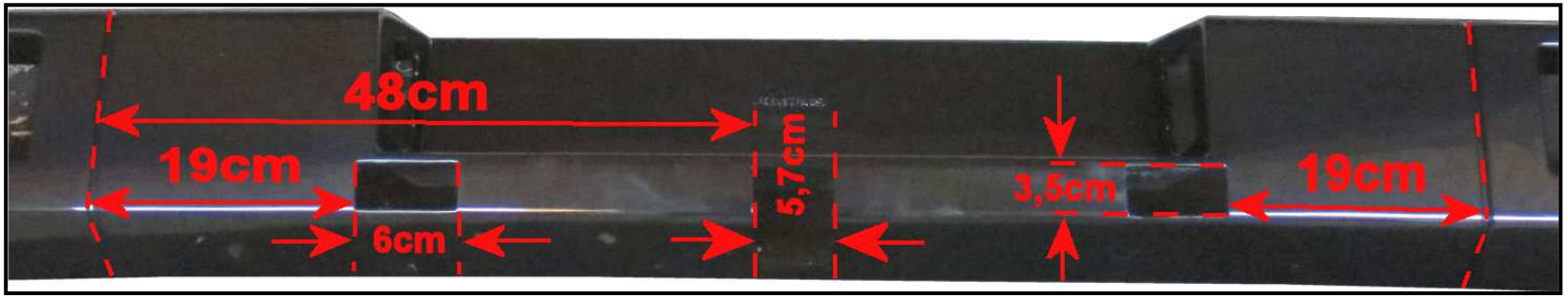
- **The front and rear bumper attachments should be bonded to the bumpers prior to painting in order to avoid deforming whilst painting!**

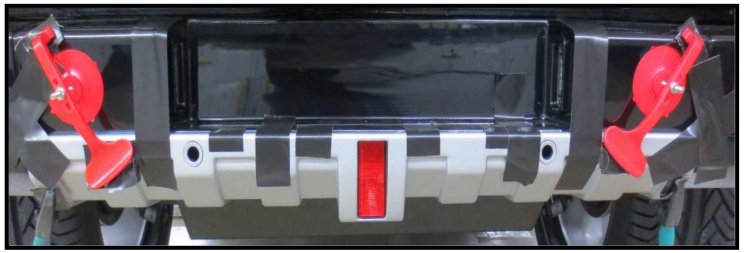
If the rearbumper add on-part gets painted in different colour than the car- colour, cut the necessary notches for the PDC sensors and the reflector out of the rearbumper after painting in order to avoid heat deformation of the rearbumper when painting!

Wichtig:

If the rearbumper add on-part gets painted in different colour than the car- colour, cut the necessary notches for the PDC sensors and the reflector out of the rearbumper after painting in order to avoid heat deformation of the rearbumper when painting!
This is the reason why the parts are not delivered already cut, but why they have to be cut by the workshop that modifies the car.
Take care for the rear middle PDC sensors to be painted in the same colour as the rear add on-part!

For the cutouts of the rearbumper please regard to image below including the measurements: Mark the cutting lines to the bumpers using a suitable, washable marker and cut the areas along the markings using a suitable tool. Deburr the cutting edges.







Attention!
Leave approx 10mm of edge!

Official technology-partners PIRELLI BILSTEIN Continental MOTUL YOKOHAMA ADVAN Member of VDA

Preparation:

Remove the following components:

- Frontbumper
- Standard fender edges front
- Headlamp covers
- Rearbumper
- Side trim mouldings (Remove adhesive residues!)
- Trim mouldings below doors (Remove adhesive residues!)
- Running board panels
- Fender enlargements
- Foglamps
- Wheelarch-liners front and rear
- Receiver of central locking system driver’s door
- Luggage compartment interior trims left and right

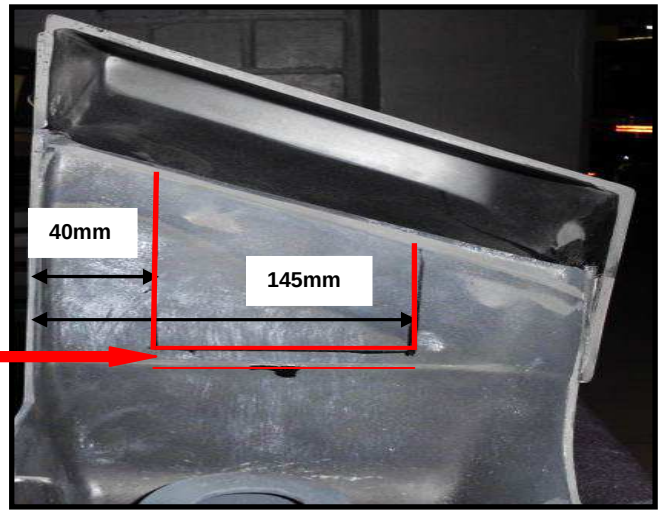
Official technology-partners PIRELLI BILSTEIN Continental MOTUL YOKOHAMA ADVAN Member of VDA

Important:

At cars equipped with Blind Spot assistant the rearbumper must be cut out as per left image below.

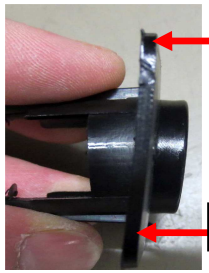
Bond the PDC sensor brackets to the rearbumper attachment prior to painting and, on cars which also do receive a Widestar modification, also bond the outer edges out of the Widestar-bodykit to the rearbumper attachment. Please regard to bonding hints on page 2.

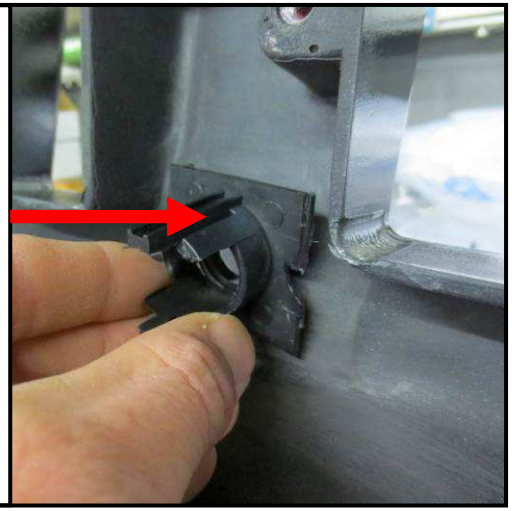
Attention!
Cut approx. 10mm away from edge shown by red ,thin line!



Adherence of PDC sensor brackets

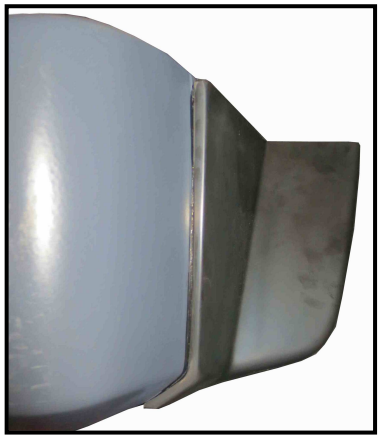
When bonding the PDC sensor brackets please make sure these are aligned flush to the bumper.











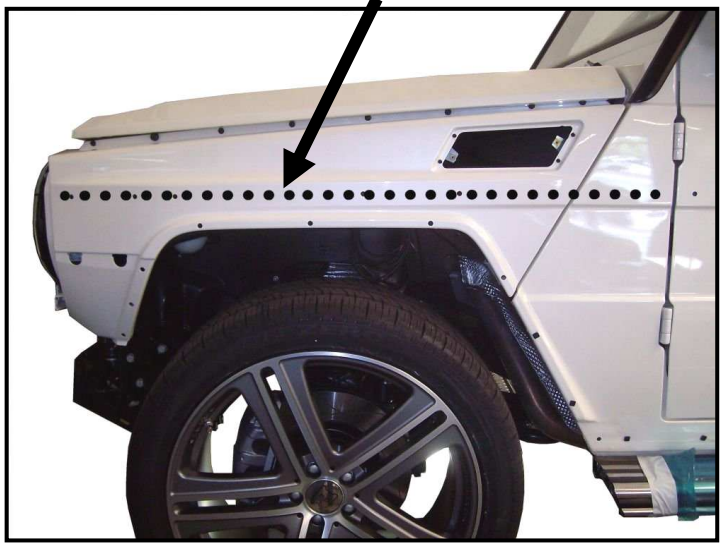
Official technology-partners PIRELLI BILSTEIN Continental MOTUL YOKOHAMA ADVAN Member of VDA

Assembly of front fender attachments:

- Hold the front fender enlargements to their positions and align them. Mark the outer lines of the parts to the front fenders using a washable marker.
- Prepare the fender enlargements for bonding according to bonding hints on page 2. Please be advised that the upper edges of the parts are not bonded but fixed by using the delivered screws / washers. You get access to the backsides of the mounting holes inside the wheelhouses.
- Remove the paint fog from the bonding areas, prepare the bonding areas according to hints on page 2. Hold the trim grilles and the cover plates to the notches of the fender parts, align and fixate the trim grilles / cover plates by using fast hardening 2 component adhesive (e.g. Würth, article-no.: WU8935003). After the 2 component adhesive is completely hardened, fixate the trim grilles and the coverplates by using the delivered adhesive / PU window-adhesive.
- Attach en even line of adhesive to the bonding areas of the front fender enlargement parts and bond the parts flush to the car. Align them according to previously made marks and fixate them by using strong adhesive tape until the adhesive is finally hardened. Remove excessive adhesive immediately!
- Bolt the fender parts to the fenders within the upper area using the delivered screws / washers.



Bolt upper edge to fender from behind



Attention!
Remove excessive adhesive immediately!

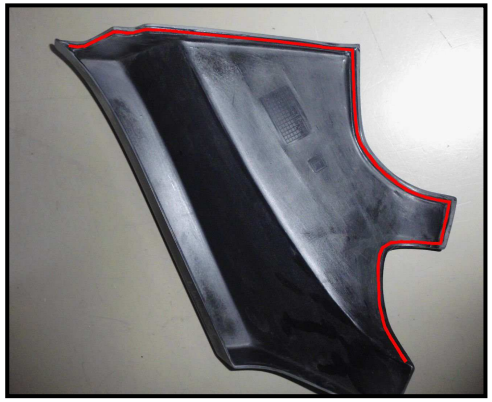
Assembly of front fender edges:

- Remove the standard parts according to Mercedes-Benz workshop instructions.
- Remove the frontbumper.



- Hold the front fender edges to the fenders and align them. Mark the outer edges to the fender using a washable marker.
- Prepare the bonding areas of the fenders and those of the front fender edges according to hints on page 2.
- Attach a thin and even line of adhesive to the bonding edges of the front fender edges and attach these to the fenders according to previously made marks. The dender edges must fit flush to the shape of the fenders. Align these and fixate them until the adhesive is finally hardened.using appropriate adhesive tape.
  Remove excessive adhesive immediately! After bonding drill a 5mm hole according to right figure below and bolt the fender edges to the fenders (not before the adhesive is hardened!!!).







Attention!
Remove excessive adhesive immediately!

Official technology-partners PIRELLI BILSTEIN Continental MOTUL YOKOHAMA ADVAN Member of VDA

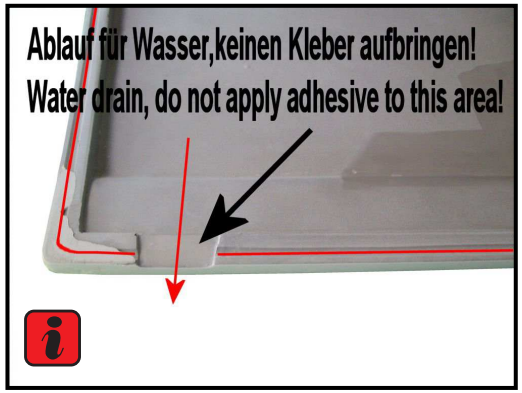
Assembly of front and rear door enlargement parts:

- Remove the comfort locking sensor of the front left door and bond it to the front left door enlargement part. Route the cable through the front left door before bonding!
- Hold the door enlargement parts to the doors, align them and mark the outer edges of the parts to the doors using a washable marker.
- Prepare the bonding areas of the enlargement parts and those of the doors for bonding according to hints on page 4.
- Attach en even line of adhesive to the bonding edges of the door enlargement parts. **Take care not to attach adhesive to the water drain notches at the bottoms of the parts!** Regard to images below.
- Attach the parts to the doors, align and fixate them until the adhesive is completely hardened. Remove excessive adhesive immediately!

Regard to following images:









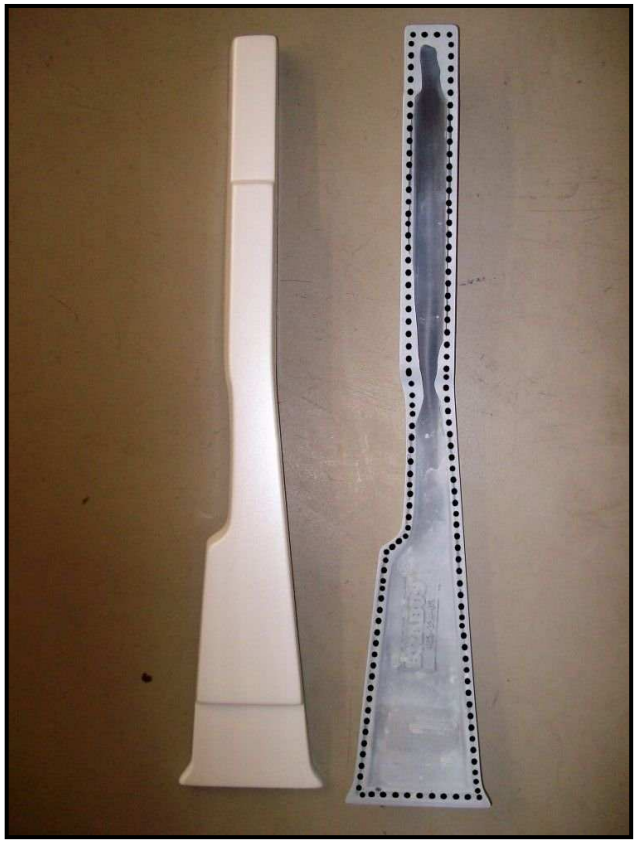
Attention!
Remove excessive adhesive immediately!

Official technology-partners PIRELLI BILSTEIN Continental MOTUL YOKOHAMA ADVAN Member of VDA

Assembly of inter-parts between doors:

- Hold the inter-parts between the front doors to the car and mark the outer lines to the car using a washable marker.
- Prepare the bonding areas of the car and those of the add on-parts according to bonding hints on page 4.
- Apply an even line of adhesive to the bonding edges of the add on-parts, attach them to the car and align them according to previously made marks. Fixate the add on-parts until the adhesive is finally hardened.

  Please regard to following images:





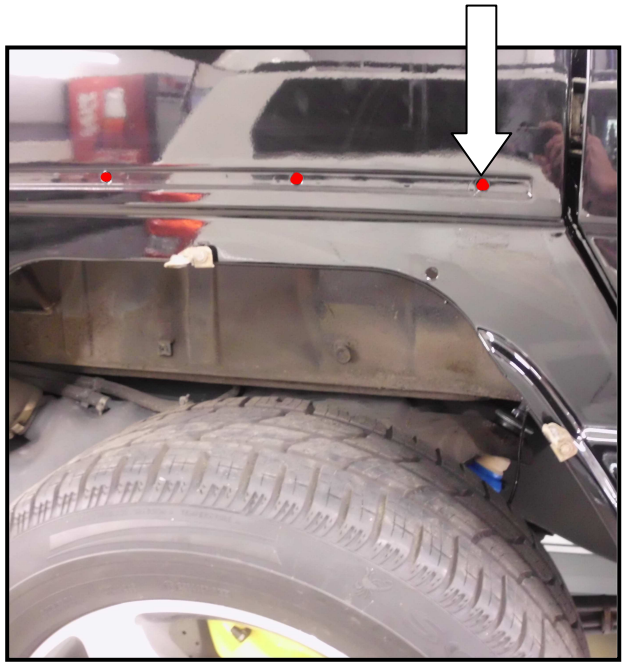
Attention!
Remove excessive adhesive immediately!

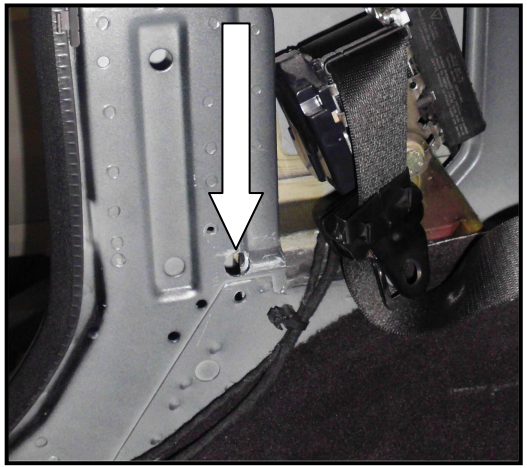
Official technology-partners PIRELLI BILSTEIN Continental MOTUL YOKOHAMA ADVAN Member of VDAT

Assembly of rear fender enlargements:

- Hold the rear fender enlargement parts to the car, align them and mark the outer edges to the car using a washable marker.

- Drill the hole for the first bolt connection (in driving direction) through. Due to the fact that there is no access from inside, the hole has to be drilled, using a long suitable drill and enlarged from inside up to a value of about 15mm. *Please regard to figures below.*



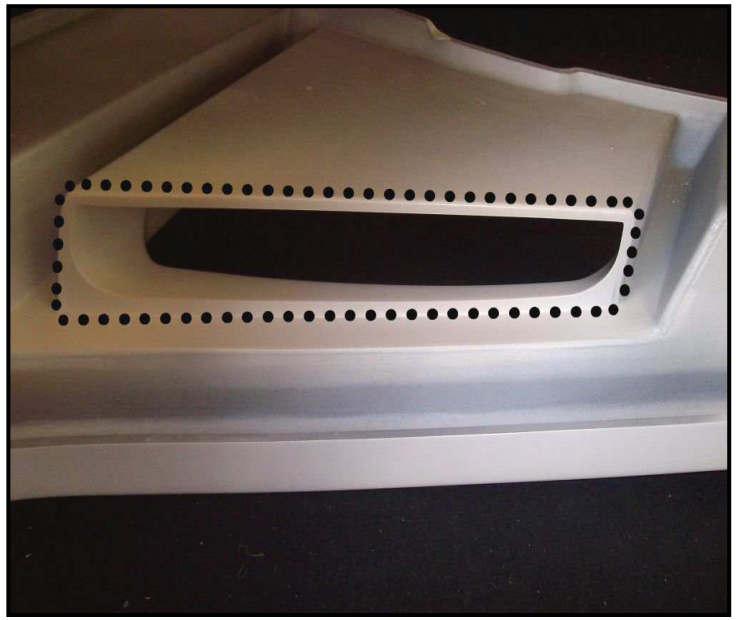


- Remove the paint fog from the bonding areas of the trim grilles and the cover plates, prepare the bonding areas according to hints on page 4. Hold the trim grilles and the cover plates to the notches of the fender parts, align and fixate the trim grilles / cover plates by using fast hardening 2 component adhesive (e.g. Würth, article-no.: WU8935003). Take care for correct and even alignment of the trim grilles on both sides! After the 2 component adhesive is completely hardened, bond the trim grilles and the coverplates by using the delivered adhesive / PU window-adhesive.

- Prepare the bonding areas of the rear fender enlargement parts and those of the car according to bonding instructions on page 4. Please be advised that the upper edges of the parts are not bonded but fixed by using the delivered screws / washers. You get access to the backsides of the mounting holes when the side trims within the boot compartment are removed.
  Take care not to attach adhesive to the water drain notches at the bottoms of the parts!

- Attach an even line of adhesive to the bonding edges of the rear fender enlargement parts (also to the bonding edge around the filler cap, take care to attach a thin line!). Bond the parts to the car, align them according to previously made marks and fixate the parts until the adhesive is finally hardened.
- Bolt the upper edges of the parts to the car using the delivered screws / washers.
- Bond the filler cap add on-part to the filler cap lid. Attach the completed filler cap lid and align it carefully. Make sure the lid and the enlargement part cannot come into contact to the car body when opening after alignment!
- Bolt the delivered spacers to the holes inside the filler cap area and align them.



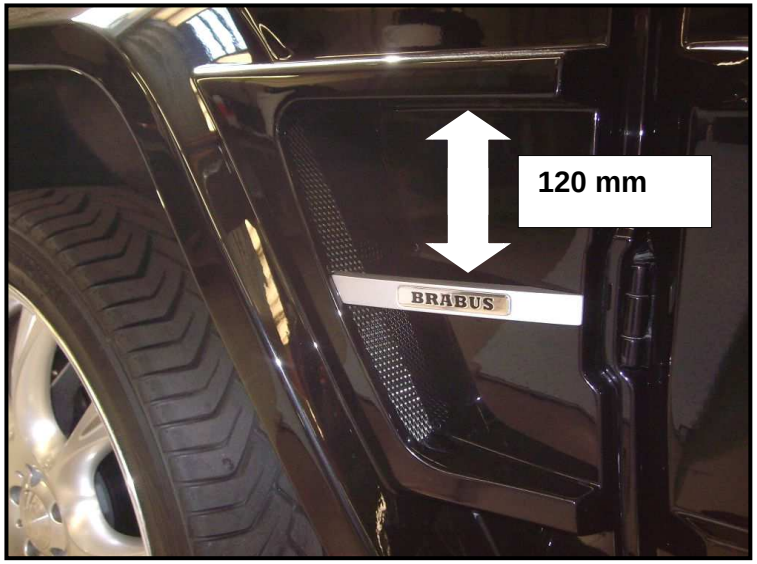


Attention!
Remove excessive adhesive immediately!

Official technology-partners PIRELLI BILSTEIN Continental MOTUL YOKOHAMA ADVAN Member of VDA

Assembly of fender braces:

- Hold the fender braces to the fender parts. Align them and mark the outer edges to the fenders using a washable marker.
- Prepare the bonding areas of the braces and those of the fender parts for bonding according to hints on page 2.
- Bond the fender braces to the fender enlargement parts, align and fixate them until the adhesive is finally hardened. The gap between the upper fender edge and the brace has to be adjusted according to image below.
- Route the cables of the illuminated braces through the trim grill into the wheelhouse and down to the running board illumination wires. Solder the cables parallel to the running board illumination cable and isolate the soldered areas!





Attention!
Remove excessive adhesive immediately!

Official technology-partners PIRELLI BILSTEIN Continental MOTUL YOKOHAMA ADVAN Member of VDAT

Assembly of running board caps:

- Remove the glovebox.
- Fixate the control unit behind the glovebox according to fig. below using velcro tape supplied.

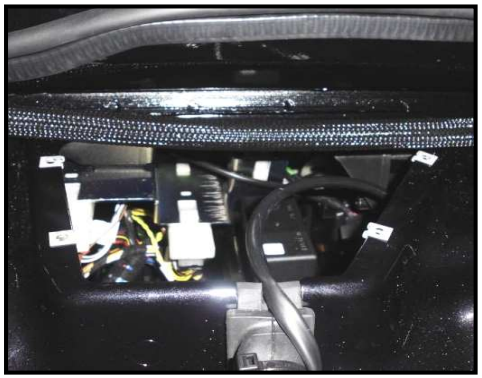


- Attach the wire with the brown, 2-pole plug to the CAN distributor shown.
- Bolt the ground ring lug to the ground terminal within the passenger footwell.
- Attach the fuse bracket to the fuse port shown (ignition power supply).
- Connect the wiring harness of the running board illumination to the wiring of the control unit and route the wires out according to explanations next page.



Official technology-partners PIRELLI BILSTEIN Continental MOTUL YOKOHAMA ADVAN Member of VDA

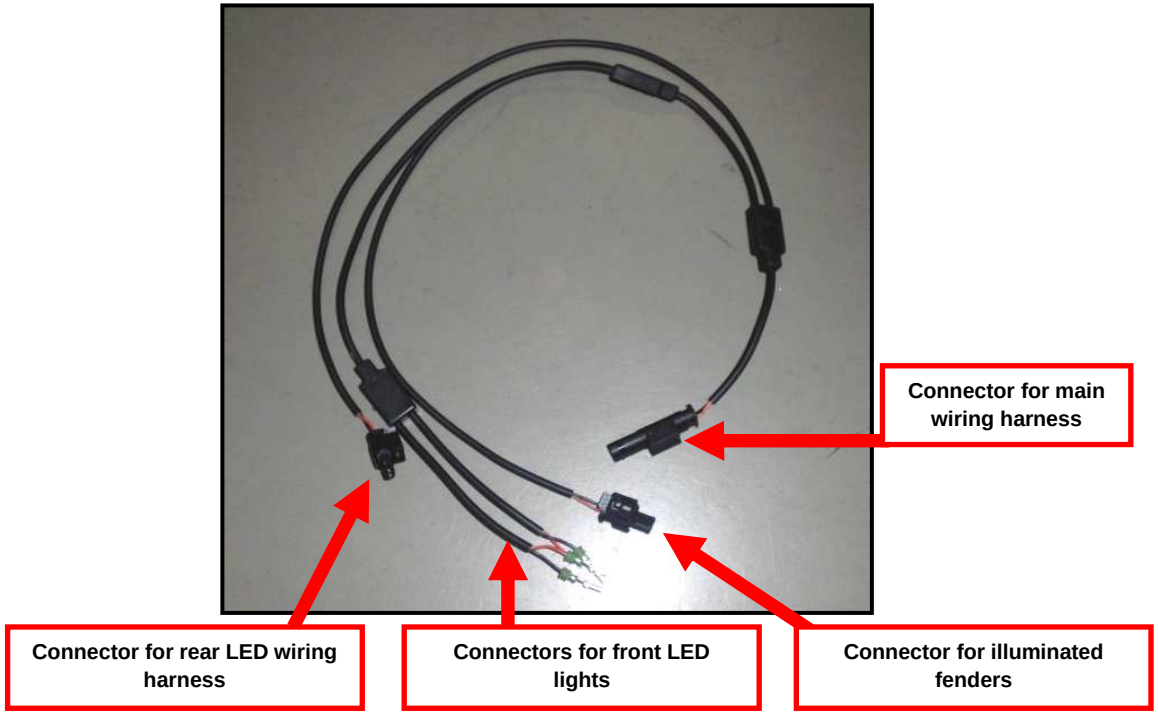
- Remove the metal cover shown within the engine bay in order to be able to route the wiring harness into the engine bay. Carefully cut the rubber grommet for the wiring harness to be led through.




- Route the longer end of the Brabus harness to the left side within the engine bay, the short end to the right side.

- Route the connectors of the wiring harness to the running board.



- The wiring harness does have 4 outlets: One 2-pole plug is used for the illuminated fender braces, the others for the running board LED lights (regard to overview above).
- Route the wiring harness through the running board (plugs for rear LED lights facing rearward.
- Connect the wiring harness of the rear LED lights to the 2-pole plug.

Assembly of lower attachments:

- Hold the lower attachments to the car and align them. Mark the positions of the parts to the car using a washable marker.
- Prepare the bonding areas of the braces and those of the fender parts for bonding according to hints on page 2.
- Apply an even line of adhesive to the bonding edges of the add on-parts, attach them to the car and align them according to previously made marks. Fixate the add on-parts until the adhesive is finally hardened.
- Do not apply the adhesive to the middle of the parts but only to the bonding edges!



Attention!
Remove excessive adhesive immediately!

Official technology-partners PIRELLI BILSTEIN Continental MOTUL YOKOHAMA ADVAN Member of VDA

Electrical connections of fog-and reverse lamps:

Connect to standard plug of fog lamp (left)



Connect to standard plug of reverse lamp (right)





- Cut off the plug of the standard fog lamp.
- Crimp the pins supplied to the wires of the standard fog lamp and attach the pins to the plug supplied (brown to slot 1, yellow/ black to slot 2)
- Connect the plug to the Brabus harness.
- Route the long wire of the Brabus fog lamps to the right side and the short wire to the left side.

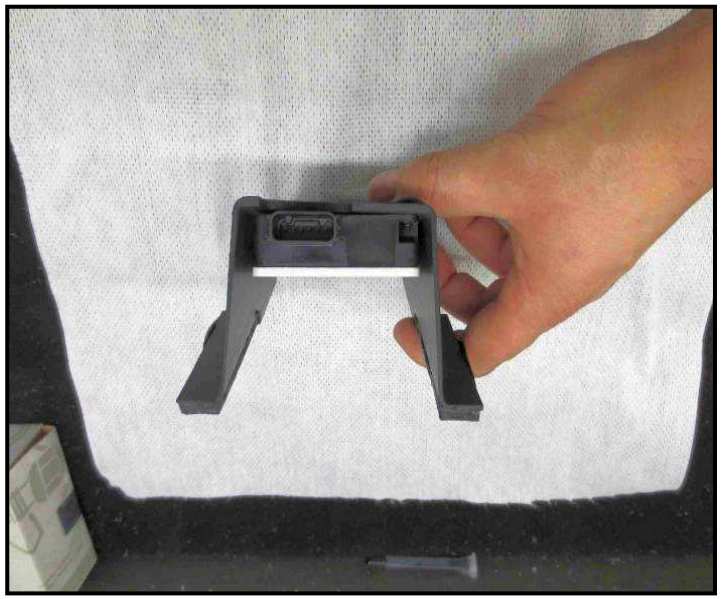
- Cut off the plug of the standard reverse lamp.
- Crimp the pins supplied to the wires of the standard reverse lamp and attach the pins to the plug supplied (brown to slot 1, green/ yellow to slot 2).
- Connect the plug to the Brabus harness.
- Route the long wire of the Brabus reverse lamps to the left side and the short wire to the right side.



Official technology-partners PIRELLI BILSTEIN Continental MOTUL YOKOHAMA ADVAN Member of VDA

Rearbumper assembly:

- Remove the no-plate illuminations and attach these to the Brabus rearbumper.
- Cut off the towing eye using an appropriate tool, seal the cutting edges.
- Attach the PDC sensors to the Brabus rearbumper using the rubbers ealings supplied. Take care for proper alignment.
- Bolt the sensors of the blind spot assistant to the brackets according to images below and bond the completed units to the rearbumper.

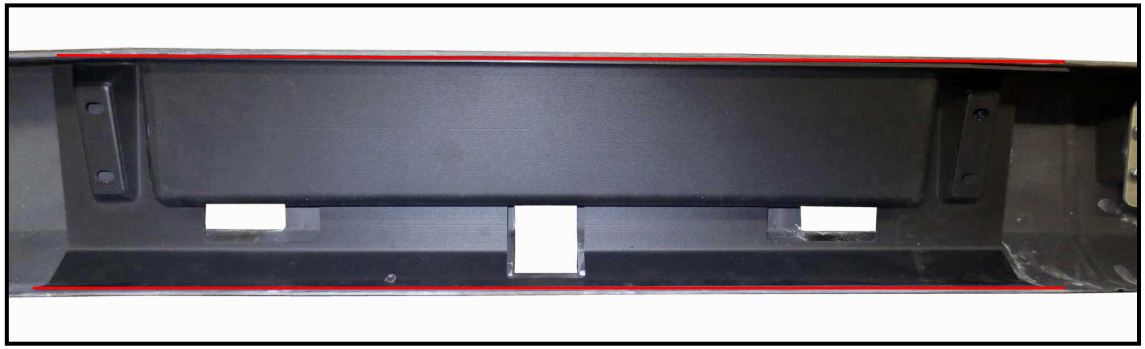




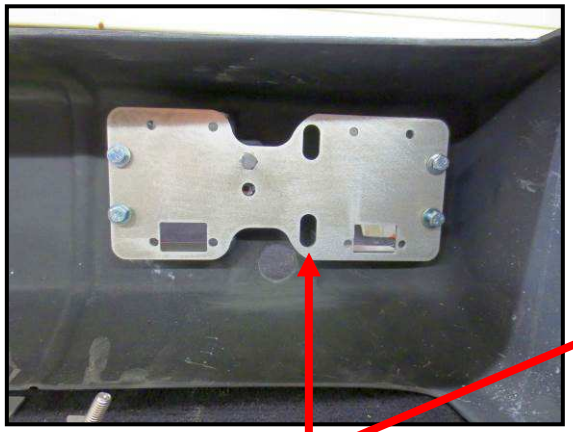


Official technology-partners PIRELLI BILSTEIN Continental MOTUL YOKOHAMA ADVAN Member of VDA

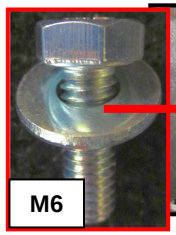
- Attach the plastic inlay of the rearbumper to the rearbumper according to image below using the adhesive tape on the top and the bottom. Clean the bonding areas according to bonding hints on page 2 and take care for proper alignment. Bolt the foglamps and the revers lamps to the rearbumper according to images. The reverse lamps are to be attached to the outer assembly areas. Also attach the brackets for the rearbumper assembly.

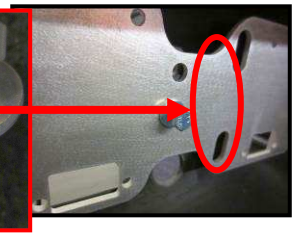


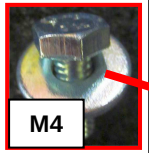


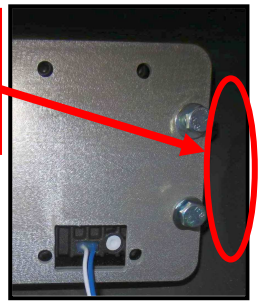








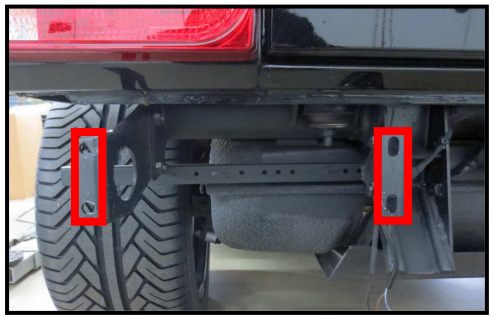






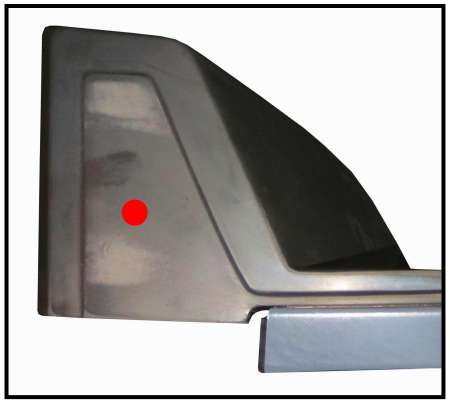
Official technology-partners PIRELLI BILSTEIN Continental MOTUL YOKOHAMA ADVAN Member of VDA

- Perform the electrical connections of the PDC sensors, the blind spot assistant-sensors and the number plate illumination and bolt the rearbumper to the standard brackets. Align it carefully.



- Drill the assembly holes (5mm)for the left and right rearbumper edges and the rear fender parts from bottom through the rearbumper edges up through the fender parts. Attach the delivered, black plastic spacers to the gaps between the parts before (only on cars with Widestar modification). Route the screws M5 from the bottom through the bumper edges, the plastic washers and the fender parts. Bolt the parts together using the delivered washers/ nuts M5.







- Reattach all previously removed cover parts.

- Perform a function check and make sure all screw connections were realized with sufficient strength and all adhesive connections were securely made.