



Rearbumper 463-410-00 for cars after 11/ 2012



BRABUS®

*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.
Check the content of the parts supplied prior to assembly.*


Check the content of the parts supplied prior to assembly and carefully read these instructions and the additional hints!

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 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 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 )

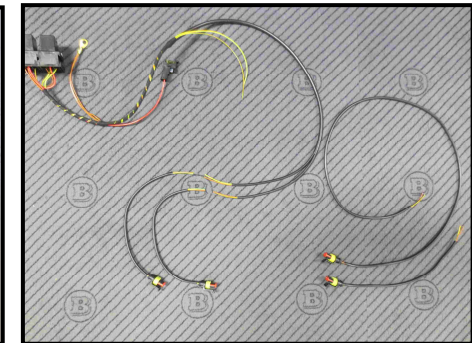
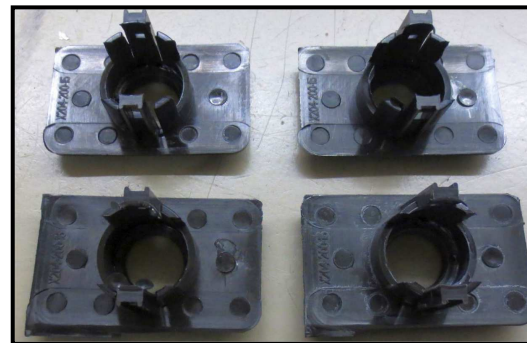
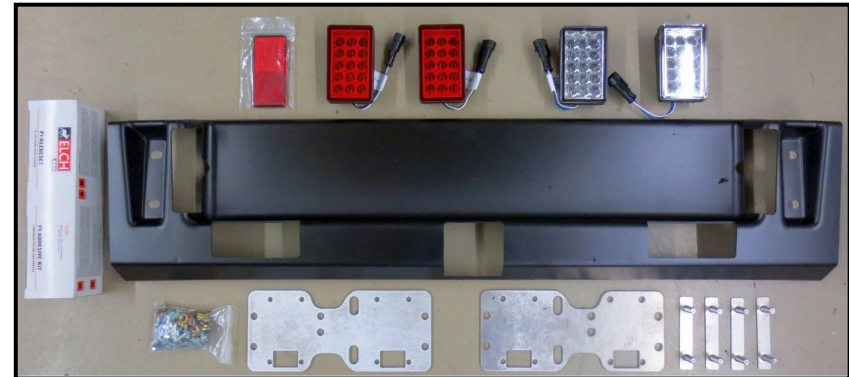
Remove paint fog prior to painting!

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.

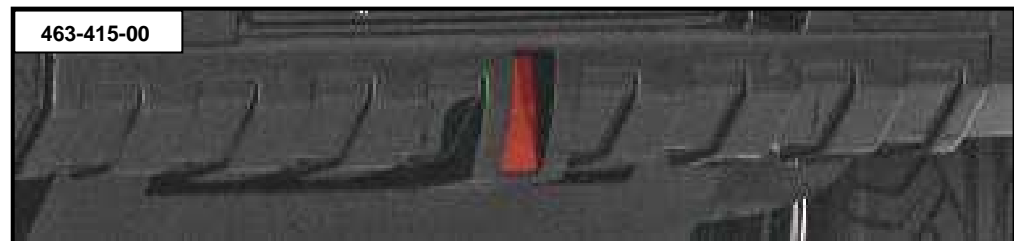
Included in delivery:

- | | | |
|----|----------------------------------|-------------|
| 1x | Rearbumper | 463-410-01 |
| 2x | Bracket for blind spot assistant | 463-430-03 |
| 2x | Foglamp | 000-NSL-01 |
| 2x | Reverse lamp | 000-RFS-01 |
| 4x | PDC-Adapter | X204-270-15 |
| 2x | Retaining plate | 463-410-05 |
| 4x | Bracket with threaded rods | 463-410-06 |
| 1x | Center bracket | 463-410-07 |
| 1x | Screw set | |
| 1x | PU-Kleber „Elch“ | 163-351-92 |



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Optionally available: Rearbumper attachment 463-415-00, prior to assembly the rearbumper is to be modified according to measurements within illustration next page.



Hints regarding modifications when the vehicle is also equipped with rearbumper attachment 463-015-00:

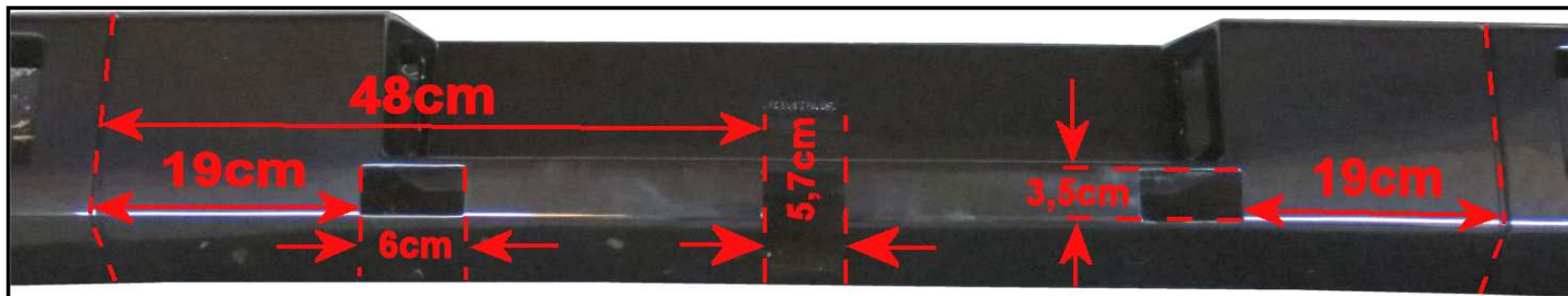


If the rearbumper add on-part gets painted in different colour than the car- colour, cut the necessary notches for the PDC sensors and the reflector out of the rearbumper after painting in order to avoid heat deformation of the rearbumper when painting!

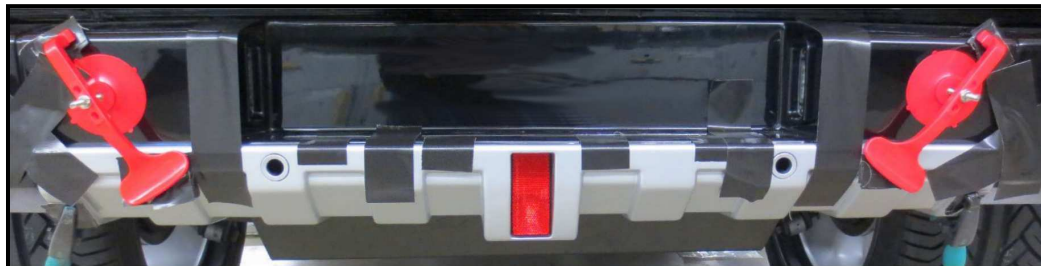
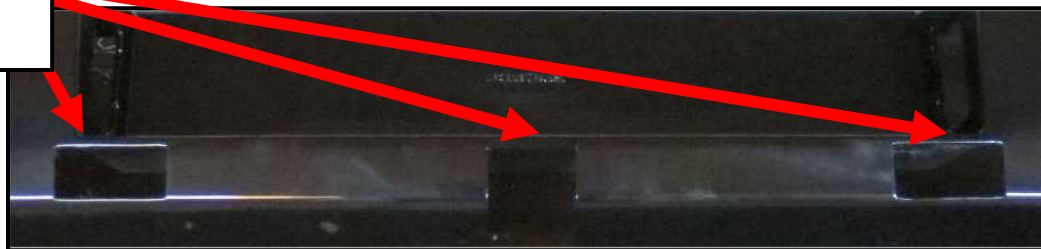
This is the reason why the parts are not delivered already cut, but why they have to be cut by the workshop that modifies the car.

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!

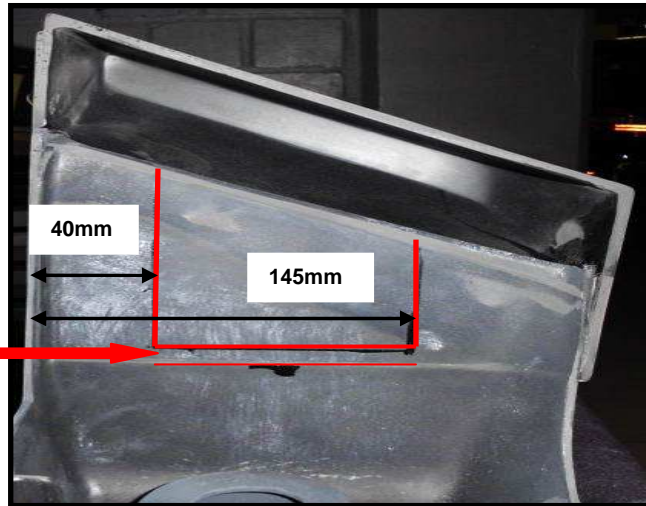




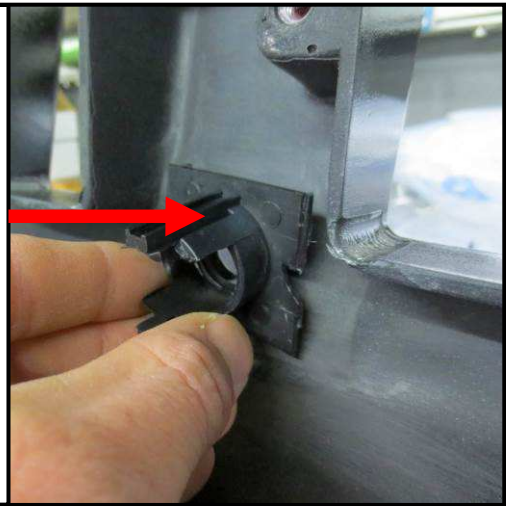
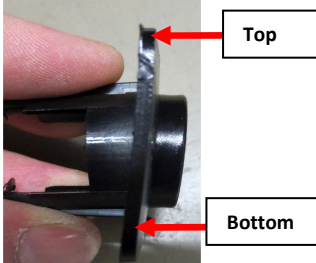
Attention:

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.



Electrical connections of fog-and reverse lamps:



463-410-00

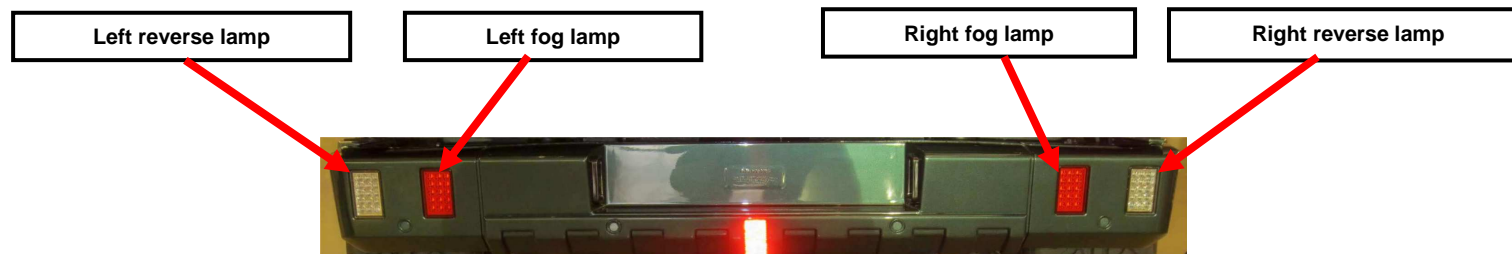


- Cut off the plug of the standard fog lamp.
- Crimp the pins supplied to the wires of the standard fog lamp and attach the pins to the plug supplied (brown to slot 1, yellow/ black to slot 2).
- Connect the plug to the Brabus harness.
- Route the long wire of the Brabus fog lamps to the right side and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



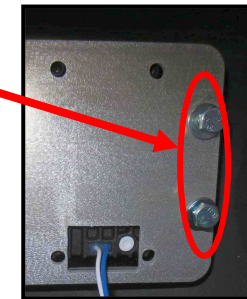
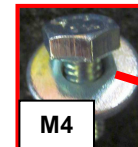
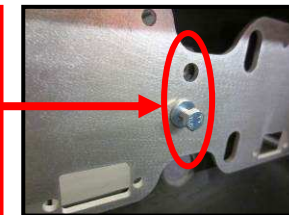
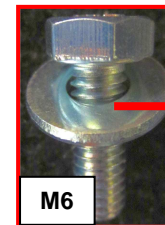
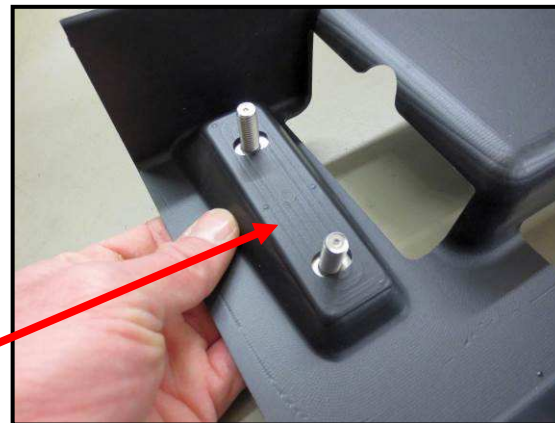
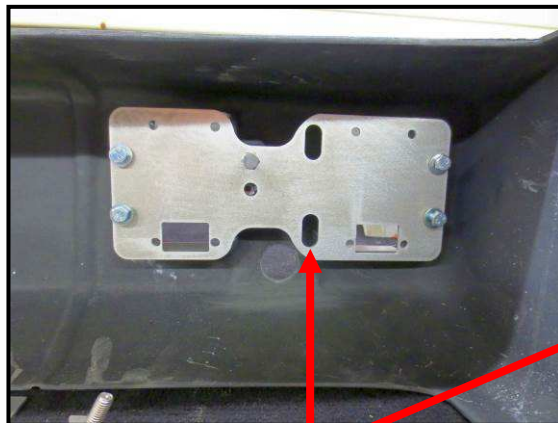
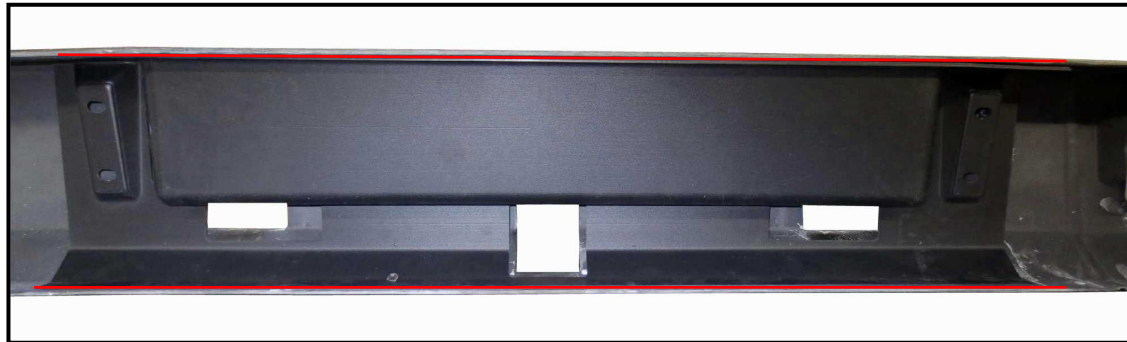
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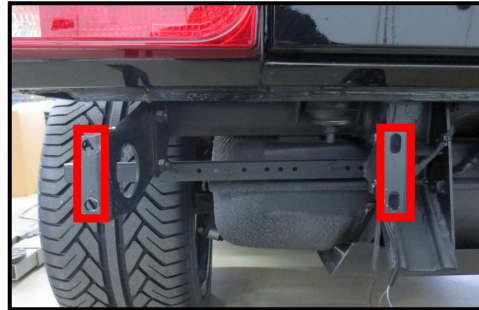
- Remove the no-plate illuminations and attach these to the Brabus rearbumper.
- Cut off the towing eye using an appropriate tool, seal the cutting edges.
- Attach the PDC sensors to the Brabus rearbumper using the rubbers ealings supplied. Take care for proper alignment.
- Bolt the sensors of the blind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



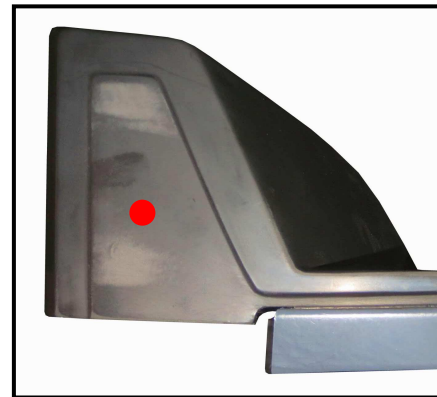
- Attach the plastic inlay of the rearbumper to the rearbumper according to image below using the adhesive tape on the top and the bottom. Clean the bonding areas according to bonding hints on page 2 and take care for proper alignment. Bolt the foglamps and the revers lamps to the rearbumper according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



- 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.