

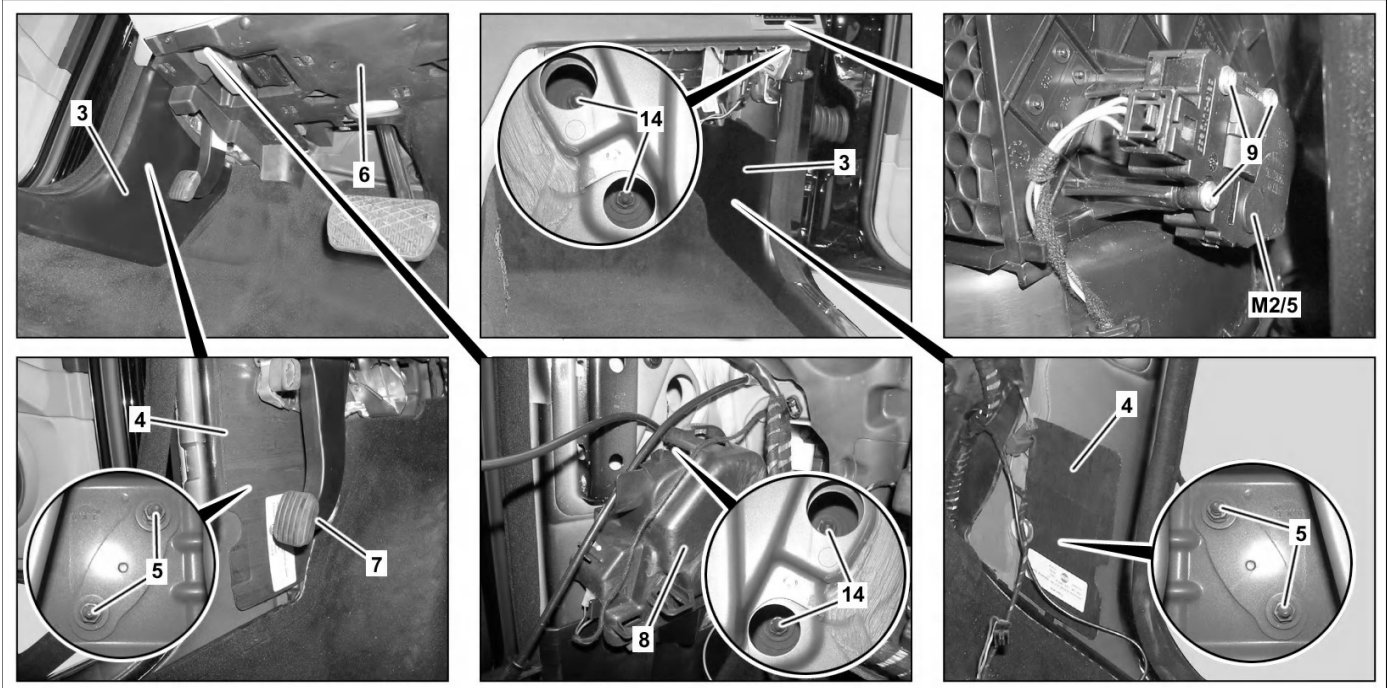
Model 166
 except code Z04 (Light armoring)
 except code Z05 (B5 armoring on special protection version)

Model 204, 207, 212, 218

Model 292

Modification notes

24.08.2015	"Calibrate 360° camera in left outside mirror or 360° camera in right outside mirror with diagnostic system" added.	Operation step 40	
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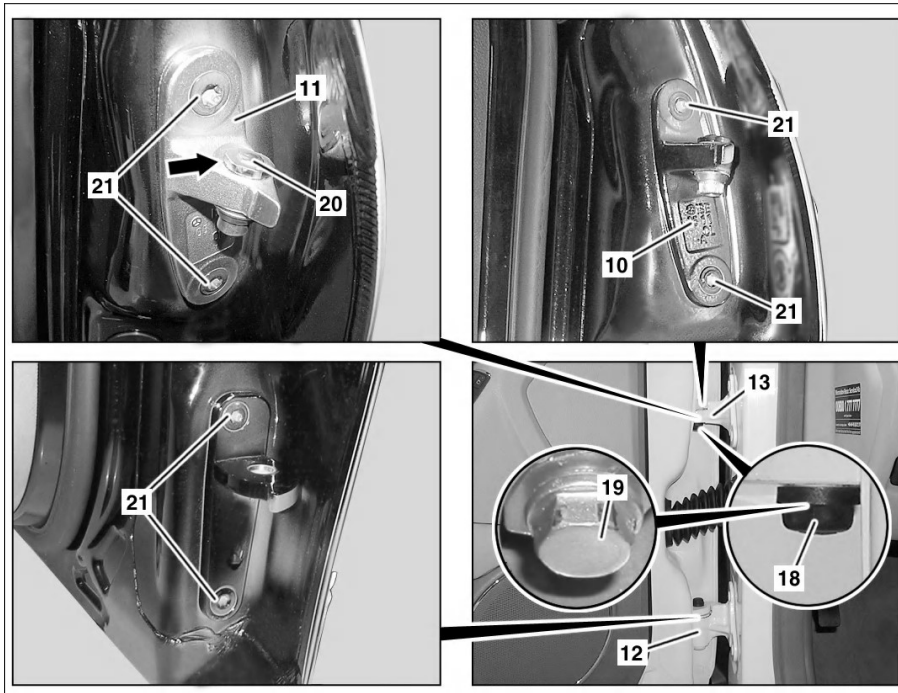
P72.10-3423-09

Shown on model 204.002

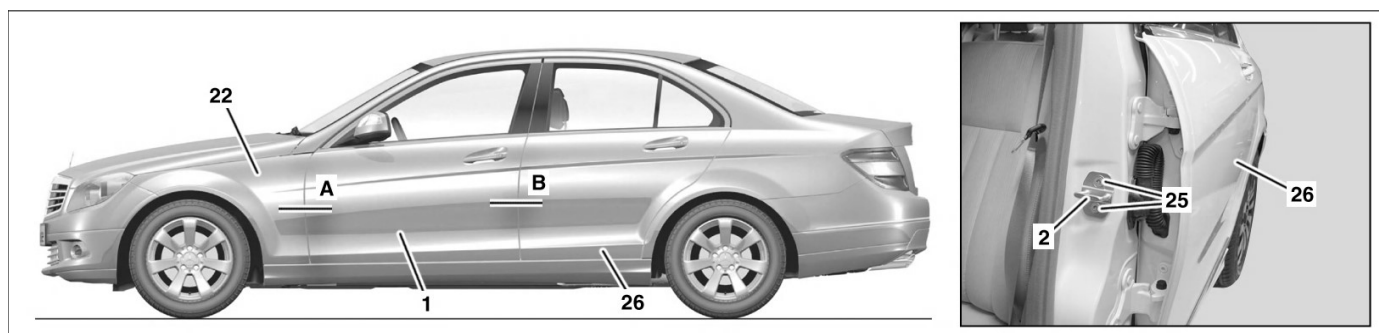
3	Cover	6	Dashboard cover	9	Bolts (model 204, 207, 212, 218)
4	Insulation mat (model 204, 207)	7	Parking brake pedal (model 204, 207, 212, 218)	14	Nuts
5	Nuts	8	Parking brake cover (model 204, 207, 212, 218)	M2/5	Fresh air/recirculated air flap (model 204, 207, 212, 218)

Shown on MODEL 204.0

- 10 Standard hinge leaf
- 11 Eccentric hinge leaf
- 12 Bottom hinge
- 13 Top hinge
- 18 Cap (on eccentric hinge leaf)
- 19 Bolt (on eccentric hinge leaf)
- 20 Eccentric disk (on eccentric hinge leaf)
- 21 Bolts



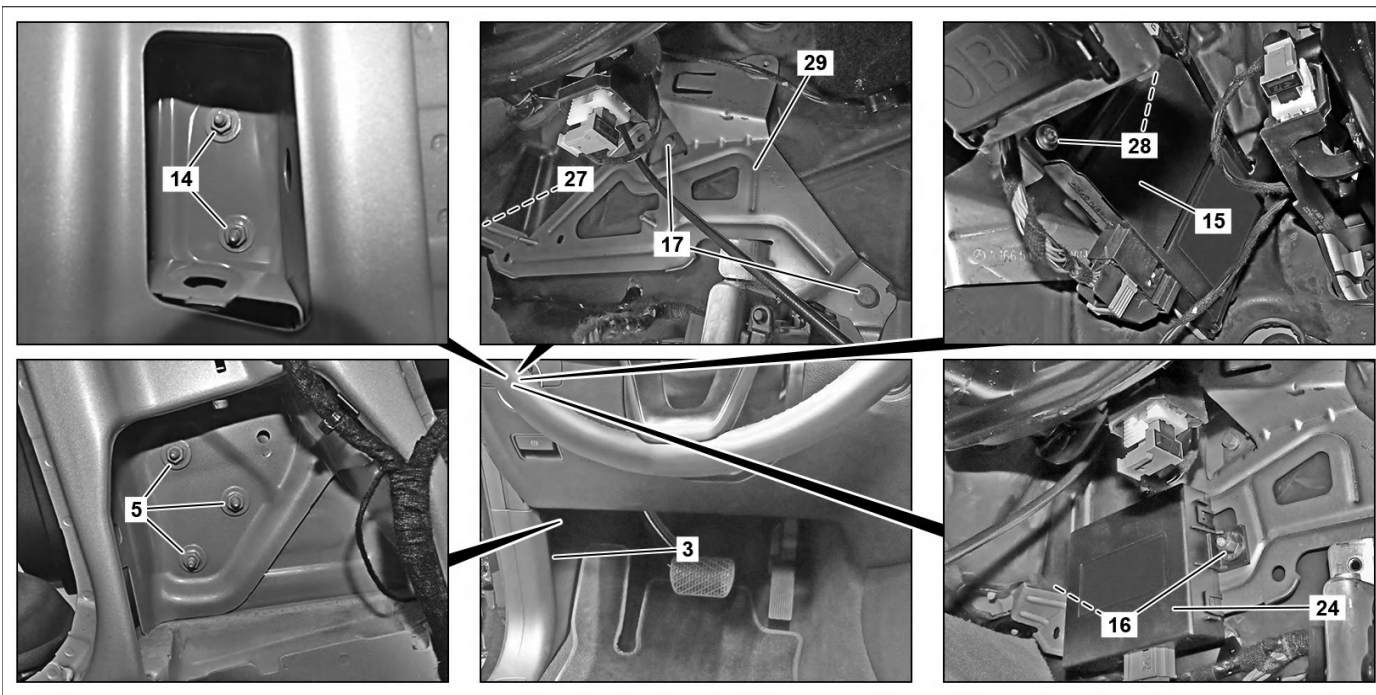
P72.10-4440-06



P72.10-3425-07

Shown on MODEL 204.0

- | | | |
|-------------------|--------------|--------------|
| 1 Front door | 25 Bolts | B Transition |
| 2 Locking striker | 26 Rear door | |
| 22 Fender | A Transition | |















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










Model 166, 292

- | | | | | | |
|----|--------------|----|--------------|----|---------|
| 3 | Cover | 16 | Nuts | 28 | Bolts |
| 5 | Nuts | 17 | Bolts | 29 | Bracket |
| 14 | Nuts | 24 | Control unit | | |
| 15 | Control unit | 27 | Nut | | |

	Warning	Risk of injury caused by fingers being jammed or pinched when removing, installing or aligning hoods, doors, trunk lid/rear-end door or sliding roof.	No parts of the body or limbs should be within the operating area when the components are moving.	AS00.00-Z-0011-01A
	Check			
1	Check gap dimensions at front door (1)	Model 166 except code Z04 (Light armoring) except code Z05 (B5 armoring on special protection version) Model 292 Model 204.0/2/3 Model 204.9 Model 207 Model 212 Model 218.3 Model 218.9 Model 166 except code Z04 (Light armoring) except code Z05 (B5 armoring on special protection version) Model 292Gap dimension Model 204.0/2/9, 212.0/1/2Gap dimension Model 204.3, 207.3/4Gap dimension Model 218.3/9Gap dimension Feeler gauge	Model 204, 207, 212, 218	AR60.00-P-0700-01GQ AR60.00-P-0700-01CW AR60.00-P-0700-01WX AR60.00-P-0700-01EC AR60.00-P-0700-01EW AR60.00-P-0700-01EL *BE60.00-P-1001-01Z *BE60.00-P-1002-01U *BE60.00-P-1002-01W *BE60.00-P-1002-01O *129589032100
	Remove			
2	Completely press parking brake pedal (7) toward front			
3	Remove left or right trim (3)			
4.1	Detach insulation mat (4) in area of lower hinge (12)			

4.2	Remove cap in area of nuts (5)	Model 166 except code Z04 (Light armoring) except code Z05 (B5 armoring on special protection version) Model 212, 218 Model 292	
5	Remove dashboard cover (6)	When adjusting driver side front door (1), if a standard hinge leaf (10) is installed. Model 166 except code Z04 (Light armoring) except code Z05 (B5 armoring on special protection version) Model 292	AR68.10-P-1500GQ
6	Remove parking brake cover (8)	Model 204, 207, 212, 218 When adjusting driver side front door (1), if a standard hinge leaf (10) is installed.	
7	Unscrew bolts (28), remove control unit (15) with electrical line connected and lay down to side	Model 292 When adjusting driver side front door (1).	
8	Unscrew nuts (16), remove control unit (24) with electrical line connected and lay down to side	Model 292 When adjusting driver side front door (1).	
9	Unscrew bolts (17) and nuts (27) and remove bracket (29)	Model 166, 292 When adjusting driver side front door (1).	
10	Remove glove compartment	When adjusting passenger side front door (1), if a standard hinge leaf (10) is installed. Model 166 except code Z04 (Light armoring) except code Z05 (B5 armoring on special protection version) Model 292 Model 204.0/2/3 Model 204.9 Model 207 Model 212 Model 218	AR68.10-P-1400GQ AR68.10-P-1200CW AR68.10-P-1200CY AR68.10-P-1400EC AR68.10-P-1200EW AR68.10-P-1400EL
11	Remove SAM control unit together with bracket	Model 166 except code Z04 (Light armoring) except code Z05 (B5 armoring on special protection version) Model 292 When adjusting passenger side front door (1).	AR54.21-P-1254GQ
12	Unscrew bolts (9) and lay fresh/air recirculated air flap actuator motor (M2/5) down to side with electrical line connected	Model 204, 207, 212, 218 When adjusting passenger side front door (1), if a standard hinge leaf (10) is installed.	
13	Mark installation position of lock striker (2)		
14	Remove bolts (25)		
15	Remove locking striker (2)		
	Adjust		
16.1	Loosen bolts on lower hinge (12) on outside of A-pillar	Model 207	
16.2	Loosen nuts (5) on bottom hinge (12) from A-pillar	Model 166 except code Z04 (Light armoring) except code Z05 (B5 armoring on special protection version) Model 204, 212, 218 Model 292	
17.1	Loosen bolts on upper hinge (13) on outside of A-pillar	Model 207 If standard hinge leaf (10) is installed.	
17.2	Loosen nuts (14) on upper hinge leaf (13) on A-pillar	Model 166 except code Z04 (Light armoring) except code Z05 (B5 armoring on special protection version) Model 204, 212, 218 Model 292 If standard hinge leaf (10) is installed.	
18	Remove cap (18) and loosen bolt (19)	If eccentric hinge leaf (11) is installed.	
19	Adjust gap dimensions on front door (1)	Model 166 except code Z04 (Light armoring) except code Z05 (B5 armoring on special protection version) Model 292 Model 204.0/2/3 Model 204.9 Model 207 Model 212	AR60.00-P-0700-01GQ AR60.00-P-0700-01CW AR60.00-P-0700-01WX AR60.00-P-0700-01EC AR60.00-P-0700-01EW

		<p>Model 218.3 Model 218.9</p> <p> On standard hinge leaf (10) by moving front door (1). On eccentric hinge leaf (11) by turning eccentric disk (20).</p> <p>Model 166 except code Z04 (Light armoring) except code Z05 (B5 armoring on special protection version)</p> <p>Model 292Gap dimension</p> <p>Model 204.0 Model 204.2 Model 204.9 Model 212.0/1 Model 212.2Gap dimension</p> <p>Model 204.3 Model 207.3 Model 207.4Gap dimension</p> <p>Model 218.3 Model 218.9Gap dimension</p>	<p>AR60.00-P-0700-01EL</p> <p>*BE60.00-P-1001-01Z</p> <p>*BE60.00-P-1002-01U</p> <p>*BE60.00-P-1002-01W</p> <p>*BE60.00-P-1002-01O</p>
20.1	Tighten bolts on upper hinge (13) on outside of A-pillar	<p>Model 207</p> <p>If standard hinge leaf (10) is installed.</p> <p> Nut/bolt for door hinge on A-pillar</p>	*BA72.10-P-1002-01S
20.2	Tighten nuts (14) on upper hinge (13) on A-pillar	<p>Model 166 except code Z04 (Light armoring) except code Z05 (B5 armoring on special protection version)</p> <p>Model 204, 212, 218, 292</p> <p>If standard hinge leaf (10) is installed.</p> <p> Model 166 except code Z04 (Light armoring) except code Z05 (B5 armoring on special protection version)</p> <p>Model 292Bolt/nut, hinge to A-pillar</p> <p> Model 204 (except 204.3)</p> <p>Model 212 except code Z04 (Light armoring)</p> <p>Model 212 with code Z04 (Light armoring)Nut/bolt for door hinge on A-pillar</p> <p> Model 218Bolt/nut, hinge to A-pillar</p>	<p>*BA72.10-P-1003-01O</p> <p>*BA72.10-P-1002-01S</p> <p>*BA72.10-P-1004-01M</p>
20.3	Tighten screw (19)	<p>If eccentric hinge leaf (11) is installed.</p> <p> Model 166 except code Z04 (Light armoring) except code Z05 (B5 armoring on special protection version)</p> <p>Model 292Bolt/nut, hinge to A-pillar</p> <p> Model 218Bolt/nut, hinge to A-pillar</p> <p> Model 204</p> <p>Model 207</p> <p>Model 212 except code Z04 (Light armoring)</p> <p>Model 212 with code Z04 (Light armoring)Nut/bolt for door hinge on A-pillar</p>	<p>*BA72.10-P-1003-01O</p> <p>*BA72.10-P-1004-01M</p> <p>*BA72.10-P-1002-01S</p>
21.1	Tighten bolts on lower hinge (12) on outside of A-pillar	<p>Model 207</p> <p> Model 207Nut/bolt for door hinge on A-pillar</p>	*BA72.10-P-1002-01S
21.2	Tighten nuts (5) on lower hinge (12) on A-pillar	<p>Model 166 except code Z04 (Light armoring) except code Z05 (B5 armoring on special protection version)</p> <p>Model 204, 212, 218, 292</p> <p> Model 166 except code Z04 (Light armoring) except code Z05 (B5 armoring on special protection version)</p> <p>Model 292Bolt/nut, hinge to A-pillar</p> <p> Model 204 (except 204.3)</p> <p>Model 212 except code Z04 (Light armoring)</p> <p>Model 212 with code Z04 (Light armoring)Nut/bolt for door hinge on A-pillar</p> <p> Model 218Bolt/nut, hinge to A-pillar</p>	<p>*BA72.10-P-1003-01O</p> <p>*BA72.10-P-1002-01S</p> <p>*BA72.10-P-1004-01M</p>

22	Loosen bolts (21) on inner door panel and adjust transition (A) to front fender (22) by moving front door(1)	 The contour of the fender (22) must align with the contour of the front door (1) or project by a maximum of 1 mm.	
23	Tighten bolts (21)	 Model 166 except code Z04 (Light armoring) except code Z05 (B5 armoring on special protection version) Model 292Screw/bolt, hinge to front door  Model 204, 207 Model 212 except code Z04 (Light armoring) Model 212 with code Z04 (Light armoring)Bolt, door hinge on front door  Model 218Bolt, hinge to front door	*BA72.10-P-1002-01O *BA72.10-P-1001-01S *BA72.10-P-1003-01M
24	Insert lock striker (2), align according to marking and screw in bolts (25) to stop	 It should still be possible to adjust the lock striker (2).	
25	Adjust transition (B) between front door (1) and rear door (26) by moving lock striker (2)	 The contour of the front door (1) should be flush with the contour of the rear door (26) and the rear fender and should project by a maximum of 1 mm.	
26	Tighten bolts (25)	 Model 166 except code Z04 (Light armoring) except code Z05 (B5 armoring on special protection version) Model 292Bolt, lock striker to B-pillar  Model 204, 207 Model 212 except code Z04 (Light armoring) Model 212 with code Z04 (Light armoring)Bolt, locking eye to B-pillar  Model 218Bolt, lock striker to B-pillar	*BA72.10-P-1004-01O *BA72.10-P-1004-01S *BA72.10-P-1009-01M
	Install		
27	Repair paint damage on screw heads (19, 21)	Repair screw heads (19) only if an eccentric hinge leaf (11) is installed. 	
28	Install cap (18)	If eccentric hinge leaf (11) is installed.	
29	Protect front door (1) and A-pillar in area of upper door hinge (13) and lower door hinge (12) against corrosion	Wax for engine compartment (400 ml spray can)	*BR00.45-Z-1018-05A
30	Insert fresh air/recirculated air flap actuator motor (M2/5) and tighten with bolts (9)	Model 204, 207, 212, 218 When adjusting passenger side front door (1), if a standard hinge leaf (10) is installed.	
31	Install SAM control unit with bracket	Model 166 except code Z04 (Light armoring) except code Z05 (B5 armoring on special protection version) Model 292 When adjusting passenger side front door (1), if a standard hinge leaf (10) is installed.	AR54.21-P-1254GQ
32	Install glove compartment	When adjusting passenger side front door (1), if a standard hinge leaf (10) is installed. Model 166 except code Z04 (Light armoring) except code Z05 (B5 armoring on special protection version) Model 292 Model 204.0/2/3 Model 204.9 Model 207 Model 212 Model 218	AR68.10-P-1400GQ AR68.10-P-1200CW AR68.10-P-1200CY AR68.10-P-1400EC AR68.10-P-1200EW AR68.10-P-1400EL
33	Install parking brake cover (8)	Model 204, 207, 212, 218 When adjusting driver side front door (1), if a standard hinge leaf (10) is installed.	
34	Tighten bracket (29) with nut (27) and bolts (17)	Model 166 except code Z04 (Light armoring) except code Z05 (B5 armoring on special protection version) Model 292 When adjusting driver side front door (1).	

35	Tighten control unit (24) with nuts (16)	Model 166 except code Z04 (Light armoring) except code Z05 (B5 armoring on special protection version) Model 292 When adjusting driver side front door (1).	
36	Tighten control unit (15) with bolts (28)	Model 166 except code Z04 (Light armoring) except code Z05 (B5 armoring on special protection version) Model 292 When adjusting driver side front door (1).	
37	Install dashboard cover (6)	When adjusting driver side front door (1), if a standard hinge leaf (10) is installed. Model 166 except code Z04 (Light armoring) except code Z05 (B5 armoring on special protection version) Model 292	AR68.10-P-1500GQ
38.1	Glue on damping mat (4)	Model 204, 207	
38.2	Install inner cap on lower A-pillar in area of nuts (5)	Model 166 except code Z04 (Light armoring) except code Z05 (B5 armoring on special protection version) Model 212, 218, 292	
39	Install left or right paneling (3)		
	Calibrate		
40.1	Calibrate 360° camera in left outside mirror or 360° camera in right outside mirror with diagnostic system	Model 207, 212, 218 with code 501 (360° camera) Model 292 with code 501 (360° camera) If the front door (1) has been adjusted on the driver and passenger side.	AD00.00-P-2000-04A
40.2	Calibrate all the cameras for the 360° camera system using the diagnostic system	Model 207, 212, 218 with code 501 (360° camera) Model 292 with code 501 (360° camera) If the front door (1) has been adjusted on the driver and passenger side.	AD00.00-P-2000-04A

Test and adjustment values for gap dimensions

Number	Designation	Model 166	Model 292		
BE60.00-P-1001-01Z	Gap dimension	Engine hood to fender	Dimension "A" mm	3,8 (± 1)	3,0 (± 0,5)
		Engine hood to headlamp	Dimension "B" mm	3,9 (± 1)	3,5 (± 1)
		Engine hood to bumper	Dimension "C" mm	5,4 (± 1,5)	4,5 (± 1,5)
		Fender to A-pillar	Dimension "D" mm	3,5 (± 1)	3,0 (± 0,5)
		Front door to fender	Dimension "E" mm	4,3 (± 0,7)	4,0 (+1/-0,5)
		Front door to rear door	Dimension "F" mm	4,8 (± 0,7)	4,5 (+1/-0,5)
		Rear door to rear fender	Dimension "I" mm	4,3 (± 0,7)	3,5 (+1/-0,5)
		For picture, see	AR60.00-P-0700-01 GQ	AR60.00-P-0700-01 GQ	

Test values for gap dimensions on hoods, doors and lids

Number	Designation	Model 218.9	Model 218.3		
BE60.00-P-1002-01O	Gap dimension	Fender to A-pillar	Dimension "D" mm	3,5 (± 1)	3,5 (± 1)
		Front door to fender	Dimension "E" mm	4,0 (-0,5/+1)	4,0 (-0,5/+1)
		Front door to rear door	Dimension "F" mm	5,0 (-0,5/+1)	5,0 (-0,5/+1)
		B-pillar cover to front window	Dimension "G" mm	10 (± 1)	10 (± 1)
		B-pillar cover to rear window	Dimension "H" mm	10 (± 1)	10 (± 1)
		Rear door to side piece, bottom	Dimension "I" mm	4,5 (± 1)	4,5 (± 1)
		Fixed window on rear door to fixed window on rear side window	Dimension "O" mm	7,5 (± 1)	–

		Picture	AR60.00-P-0700-01 L	AR60.00-P-0700-01 EL
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Check values for gap dimensions

Number	Designation				Model 204.0	Model 204.2
BE60.00-P-1002-01U	Gap dimension	Front door to fender	Dimension "G"	mm	4 (+1/-0,5)	4 (+1/-0,5)
		Front door to rear door	Dimension "H"	mm	4 (+1/-0,5)	4 (+1/-0,5)
		Front door to roof frame	Dimension "I"	mm	15 (+0,5/-1)	15 (+0,5/-1)
		Rear door to roof frame	Dimension "J"	mm	15,5 (+1/-0,5)	15,5 (+1/-0,5)
		Rear door to side piece, bottom	Dimension "K"	mm	4 (+1/-0,5)	4 (+1/-0,5)
		Driver door cover to rear door cover	Dimension "W"	mm	4 (+1,5)	4 (+1,5)
			Picture			AR60.00-P-0700-01 CW

Check values for gap dimensions

Number	Designation				Model 204.9	Model 212.0/1
BE60.00-P-1002-01U	Gap dimension	Front door to fender	Dimension "G"	mm	4,5 (± 1)	4 (+1/-0,5)
		Front door to rear door	Dimension "H"	mm	4,5 (± 1)	4,5 (+1/-0,5)
		Front door to roof frame	Dimension "I"	mm	10 (+2/-1)	14 (± 1,5)
		Rear door to roof frame	Dimension "J"	mm	9,5 (+2/-1)	13 (± 1,5)
		Rear door to side piece, bottom	Dimension "K"	mm	4 (± 1)	4 (+1/-0,5)
		Driver door cover to rear door cover	Dimension "W"	mm	4 (+1,5/-0,5)	4 (± 1)
			Picture			AR60.00-P-0700-01 WX

Check values for gap dimensions

Number	Designation				Model 212.2
BE60.00-P-1002-01U	Gap dimension	Front door to fender	Dimension "G"	mm	4 (+1/-0,5)
		Front door to rear door	Dimension "H"	mm	4,5 (+1/-0,5)
		Front door to roof frame	Dimension "I"	mm	14 (± 1,5)
		Rear door to roof frame	Dimension "J"	mm	13 (± 1,5)
		Rear door to side piece, bottom	Dimension "K"	mm	4 (+1/-0,5)
		Driver door cover to rear door cover	Dimension "W"	mm	4 (± 1)
			Picture		

Check values for gaps

Number	Designation				Model 204.3	Model 207.3
BE60.00-P-1002-01W	Gap dimension	Front door to fender	Dimension "F"	mm	4 (+1,5/-0,5)	4 (+1,5/-0,5)
		Front door to rear fender	Dimension "G"	mm	4 (+1/-0,5)	4 (+1/-0,5)
			Picture			AR60.00-P-0700-01 CW

Check values for gaps

Number	Designation				Model 207.4
BE60.00-P-1002-01W	Gap dimension	Front door to fender	Dimension "F"	mm	4 (+1,5/-0,5)
		Front door to rear fender	Dimension "G"	mm	4 (+1/-0,5)
			Picture		

Nm Front door

Number	Designation		Model 204	Model 207
BA72.10-P-1001-01S	Bolt, door hinge on front door	Nm	34	37

Nm Front door

Number	Designation		Model 212 except code Z04 (Light armoring)	Model 212 with code Z04 (Light armoring)
BA72.10-P-1001-01S	Bolt, door hinge on front door	Nm	34	34

Nm Front door

Number	Designation		MODEL 166 except CODE Z04/Z05	Model 292
BA72.10-P-1002-01O	Screw/bolt, hinge to front door	Nm	32	32

Nm Front door

Number	Designation		Model 204	Model 207
BA72.10-P-1002-01S	Nut/bolt for door hinge on A-pillar	Nm	34	37

Nm Front door

Number	Designation		Model 212 except code Z04 (Light armoring)	Model 212 with code Z04 (Light armoring)
BA72.10-P-1002-01S	Nut/bolt for door hinge on A-pillar	Nm	34	34

Nm Front door

Number	Designation		Model 218
BA72.10-P-1003-01M	Bolt, hinge to front door	Nm	34

Nm Front door

Number	Designation		MODEL 166 except CODE Z04/Z05	Model 292
BA72.10-P-1003-01O	Bolt/nut, hinge to A-pillar	Nm	32	32

Nm Front door

Number	Designation		Model 218
BA72.10-P-1004-01M	Bolt/nut, hinge to A-pillar	Nm	34

Nm Front door

Number	Designation		MODEL 166 except CODE Z04/Z05	Model 292
BA72.10-P-1004-01O	Bolt, lock striker to B-pillar	Nm	24	24

Nm Front door

Number	Designation		Model 204	Model 207
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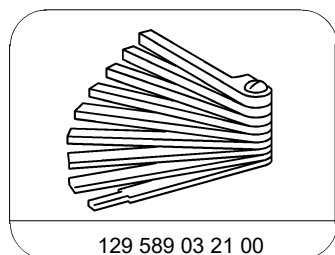
BA72.10-P-1004-01S	Bolt, locking eye to B-pillar	Nm	24	24
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Nm Front door

Number	Designation		Model 212 except code Z04 (Light armoring)	Model 212 with code Z04 (Light armoring)
BA72.10-P-1004-01S	Bolt, locking eye to B-pillar	Nm	24	24

Nm Front door

Number	Designation		Model 218
BA72.10-P-1009-01M	Bolt, lock striker to B-pillar	Nm	24



Feeler gauge

Repair materials

Number	Designation	Order number
BR00.45-Z-1018-05A	Wax for engine compartment (400 ml spray can)	A 000 986 33 70 10