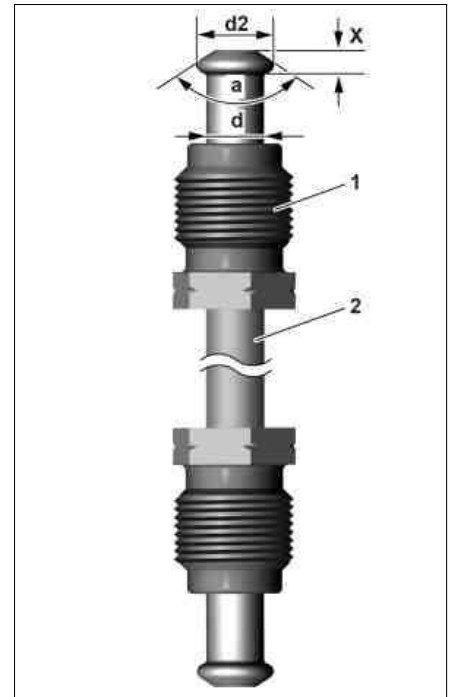




Model 163, 164, 168, 169, 170, 171, 202, 203, 208, 209, 210, 211, 215, 219, 220, 230, 245
 Model 463
 up to model year 2013
 except code 979 (Special protection MB Guard)

- 1 Union nut
 2 Brake line
 a F-flange (115°)
 d Line diameter \varnothing 4.75 mm
 d2 Flange diameter ($\varnothing = 7.1$ F 0.18 mm)
 X Flange height (Height= 2.3 F 0.3 mm)



P42.10-2899-03

 Caution	Risk of poisoning from swallowing brake fluid. Risk of injury from skin and eye contact with brake fluid	Only pour brake fluid into suitable and appropriately marked containers. Wear protective clothing and eye protection when handling brake fluid.	AS42.50-Z-0001-01A
	Brake fluid notes		AH42.50-P-0001-01A
	Notes on repairs to brake system		AH42.00-P-0003-01A
1	Remove each brake line (2)	 Installation: Install brake line (2) free of tension and with correct torque on threaded connection.	

		<p>Nm Model 163.113 #A as of 289565 Model 163.113 #A up to 289564 Model 163.113 #X as of 754620 Model 163.113 #X up to 754619 Model 163.128/172/174/175 Model 163.136 Model 163.154 #A as of 289565 except USA Model 163.154 #A up to 289564 Model 163.157 except USA Model 163.157 USA Model 170 Model 171 Model 202 Model 203 Model 208 Model 209 Model 210 Model 211 ABR Model 211 SBC Model 215 Model 220 Model 230 except code P99 (Special model "AMG Black Series") Model 230 with code P99 (Special model "AMG Black Series") Brake line to brake hose</p> <p>Nm Model 168 Brake line to brake hose</p> <p>Nm Model 219 ABR Union nut, brake line to brake hose</p> <p>Nm Model 169 Model 245 Brake line to brake hose</p> <p>Nm Model 164 Brake line to brake hose</p> <p>Nm Model 463 (except 463.270/271/272/273) up to model year 2013 except code 979 (Special protection MB Guard) Model 463.270/271 up to model year 2013 except code 979 (Special protection MB Guard) Model 463.272/273 up to model year 2013 except code 979 (Special protection MB Guard) Brake line to brake hose</p>	<p>*BA42.10-P-1001-04A</p> <p>*BA42.10-P-1002-04C</p> <p>*BA42.10-P-1001-04I</p> <p>*BA42.10-P-1003-04H</p> <p>*BA42.10-P-1002-04J</p> <p>*BA42.10-P-1001-04B</p>
2	Define length of new brake line (2) to match the old brake line (2)	<p>i Two additional connecting points per brake line (2) are permissible for part replacement of a brake line (2): ● Only part replacement for brake lines (2) with line diameter of Ø 4.75 mm (wheel line)</p> <p>i Heater lines (master brake cylinder to hydraulic unit), SBC return lines, plastic-coated lines and lines with flexible part are excluded from the repair.</p>	
3	Cut brake line (2) using pipe cutter	<p>i The constellation of the connecting point must be correct and there must be no soiling.</p> <p>i Use specified cable connectors for installation only.</p>	
4	Make flange on brake line (2)	<p>i Before making the flange, fit the union nut (1) to the respective brake line (2).</p> <p>i On Mercedes-Benz cars only brake lines (2) with an F-flange (a) as per DIN 74234 may be used.</p> <p>i When making a flange for the brake line (2), the tool manufacturer specifications must be complied with.</p> <p>Brake line flaring tool gotis://B 42/43.2 04.0</p>	
5	Adapt new brake line (2)	<p>i Adapt brake line (2) using bending tool to old configuration.</p> <p>A bending radius of 13 mm must not be exceeded here. When routing the brake line (2) make sure there is sufficient distance to other components. There must be no kinking and no line narrowing on the brake line (2).</p>	

6	Install in the reverse order		
	Check		
7	Check surface of brake line (2)	 Check surface of brake line (2) for scratches and paint damage, if necessary touch up any paint damage. Zinc dust paint spray can	*BR00.45-Z-1055-07A
8	Thoroughly wax the brake line (2) after mounting it	Cavity preservation, solvent-free (1 l container)	*BR00.45-Z-1011-05A
9	Bleed brake system	Model 170, 202, 208, 210 Model 169.006/007/008/031/032/033/034/090/306/307/308/331/332/333/334 Model 245.207/208/231/232/233/234 Model WDB168.032, 168.006/007/008/009/031/033/035/109/131/132/133/135 Model 163.113/128/136/154/157/172/174/175 Model 164 Model 215 Model 220 except code 979 (Special protection MB Guard) except code Z07 (Top protection) Model 220 with code 979 (Special protection MB Guard) with code Z07 (Top protection) Model 203, 209 Model 211, 219 with Adaptive Brake (ABR)Model 230 with code P99 (Special model "AMG Black Series") Model 230 except code P99 (Special model "AMG Black Series") Model 171 Model 463 (except 463.270/271) up to model year 2013 except code 979 (Special protection MB Guard) Model 463.270/271 up to model year 2013 except code 979 (Special protection MB Guard)	AR42.10-P-0010A AR42.10-P-0010AK AR42.10-P-0010GC AR42.10-P-0010GH AR42.10-P-0010GZ AR42.10-P-0010I AR42.10-P-0010MB AR42.10-P-0010P AR42.10-P-0010T AR42.10-P-0012R AR42.10-P-0010V AR42.10-P-0010GG AR42.10-P-0010GX
10	Check brake system for leaktightness	Model 463.270/271 up to model year 2013 except code 979 (Special protection MB Guard) Model 463 (except 463.270/271) up to model year 2013 except code 979 (Special protection MB Guard)Disk brakes on front axle Model 170, 202, 203, 208, 209, 210 Model 169.006/007/008/031/032/033/034/090/306/307/308/331/332/333/334 Model 245.207/208/231/232/233/234 Model 168.006/007/008/009/031/032/033/035/109/131/132/133/135 Model 163.113/128/136/154/157/172/174/175 Model 215, 220 Model 211, 219with Adaptive Brake (ABR) Model 171 Model 164	AR42.10-P-0015GX AR42.10-P-0015GG AR42.10-P-0015A AR42.10-P-0015AK AR42.10-P-0015GC AR42.10-P-0015GH AR42.10-P-0015I AR42.10-P-0015T AR42.10-P-0015V AR42.10-P-0015GZ
11	Carry out brake test on the test stand	Model 163, 164, 168, 169, 170, 171, 202, 203, 208, 209, 210, 211, 215, 219, 220, 230, 245 (except 245.286) Model 463 up to model year 2013 except code 979 (Special protection MB Guard)	AP42.00-P-4290BA AP42.00-P-4290G

 **Brake lines, brake hoses**

Number	Designation		MODEL 163.113 #A as of 289565, MODEL 163.113 #X as of 754620, MODEL 163.154 #A as of 289565 except USA	MODEL 163.113 #A up to 289564, MODEL 163.113 #X up to 754619, MODEL 163.154 #A up to 289564
BA42.10-P-1001-04A	Brake line to brake hose	Nm	18	18

Nm Brake lines, brake hoses

Number	Designation		Model 163.128/172/174/175	Model 163.136
BA42.10-P-1001-04A	Brake line to brake hose	Nm	18	18

Nm Brake lines, brake hoses

Number	Designation		Model 163.157 USA	Model 163.157 except USA
BA42.10-P-1001-04A	Brake line to brake hose	Nm	18	18

Nm Brake lines, brake hoses

Number	Designation		Model 170	Model 171
BA42.10-P-1001-04A	Brake line to brake hose	Nm	14	16

Nm Brake lines, brake hoses

Number	Designation		Model 202	Model 203
BA42.10-P-1001-04A	Brake line to brake hose	Nm	14	14

Nm Brake lines, brake hoses

Number	Designation		Model 208	Model 209
BA42.10-P-1001-04A	Brake line to brake hose	Nm	14	14

Nm Brake lines, brake hoses

Number	Designation		Model 210	Model 211 with SBC
BA42.10-P-1001-04A	Brake line to brake hose	Nm	14	18

Nm Brake lines, brake hoses

Number	Designation		Model 211 ABR	Model 215
BA42.10-P-1001-04A	Brake line to brake hose	Nm	18	14

Nm Brake lines, brake hoses

Number	Designation		Model 220	Model 230 except code P99
BA42.10-P-1001-04A	Brake line to brake hose	Nm	14	14

Nm Brake lines, brake hoses

Number	Designation		MODEL 230 with Code P99
BA42.10-P-1001-04A	Brake line to brake hose	Nm	14

Nm Brake lines, brake hoses

Number	Designation		Model 463 (except 463.236/248/270/271/272/273) up to model year 2019, model 463.236/248 except code 979 up to model year 2019	Model 463.270/271 up to model year 2019
BA42.10-P-1001-04B	Brake line to brake hose	Nm	15	15

Nm Brake lines, brake hoses

Number	Designation		Model 463.272/273 up to model year 2019	Model 463 as of model year 2019
BA42.10-P-1001-04B	Brake line to brake hose	Nm	15	14

Nm Brake lines, brake hoses

Number	Designation		Model 219 with SBC	Model 219 with ABR
BA42.10-P-1001-04I	Union nut, brake line to brake hose	Nm	18	18

Nm Brake lines, brake hoses

Number	Designation		Model 168.007/008/031/033	Model 168.006/009/131
BA42.10-P-1002-04C	Brake line to brake hose	Nm	14	14

Nm Brake lines, brake hoses

Number	Designation		Model 168.032/035	Model 168.109/132/133/135
BA42.10-P-1002-04C	Brake line to brake hose	Nm	14	14

Nm Brake lines, brake hoses

Number	Designation		Model 164.1/8
BA42.10-P-1002-04J	Brake line to brake hose	Nm	15

Nm Brake lines, brake hoses

Number	Designation		Model 169	Model 245
BA42.10-P-1003-04H	Brake line to brake hose	Nm	18	18

Repair materials

Number	Designation	Order number
BR00.45-Z-1011-05A	Cavity preservation, solvent-free (1 l container)	A 000 986 72 70 10
BR00.45-Z-1055-07A	Zinc dust paint spray can	A 000 986 82 42 09