

P64.20-4824-09

1 Rear fender

4 Rear longitudinal member section

6 Spare tire well













2 Bottom rear center section

5 Rear end plate




7 Locking lug above rear axle

3 Rear crossmember

	Removing		
Danger!	Risk of explosion caused by fuel igniting, risk of poisoning caused by inhaling and swallowing fuel and risk of injury to eyes and skin caused by contact with fuel	No fire, sparks, open flames or smoking. Pour fuels only into suitable and appropriately marked containers. Wear protective clothing when handling fuel.	AS47.00-Z-0001-01A
Danger!	Risk of death caused by high voltage used for electric welding. Risk of explosion caused by welding in the area of highly inflammable materials. Risk of injury caused by welding spatter and UV light while welding. Risk of poisoning caused by inhaling welding fumes.	Use insulating mats. Wear protective clothing, safety glasses and protective mask. Remove highly inflammable materials from the hazard area. Use air extractor system.	AS00.00-Z-0007-01A
Danger!	Risk of death caused by vehicle slipping or toppling off of the lifting platform.	Align vehicle between the columns of the lifting platform and position the four support plates at the lifting platform support points specified by the vehicle manufacturer.	AS00.00-Z-0010-01A
Danger!	Risk of injury caused by scraping or cutting body parts on sharp vehicle parts	Always wear protective gloves when working on or near sharp and non-deburred vehicle parts. Deburr repair panels.	AS00.00-Z-0017-01A
Danger!	Risk of explosion from aluminum grinding dust, risk of injury to respiratory system from inhaling dust	Wear protective respiratory mask, protective gloves and safety glasses. Use suitable, grounded vacuum cleaner	AS60.00-Z-0007-01N
	General information on repairs to body		AH60.00-N-0001-01A
	Pretreatment of bonding surfaces		AH60.00-P-0008-01SX
	Notes on paintwork repairs		AH98.00-P-9408-02A
	General information on riveting		AH60.00-P-0003-01N
	Notes on various body materials		AH60.00-P-0011-01SX
	General information on dent removal and straightening aluminum parts		AH60.00-P-0012-01N
	General information on body connection techniques		AH60.00-P-0015-01SX
	General information on MB materials		AH98.00-P-9409-03A
1	Remove rear door sill molding	Vehicles without code (Z07) Top protection Vehicles with code (Z07) Top protection	AR68.30-P-4100SX AR68.30-P-4100SXS
2	Remove rear wall window	Vehicles without code (Z07) Top protection Vehicles with code (Z07) Top protection	AR67.20-P-2000SX AR67.20-P-2000SXS
3	Remove taillamp		AR82.10-P-4905SX

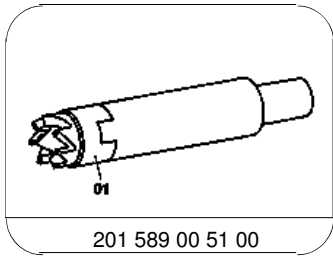
4	Remove rear bumper	Vehicles without code (Z07) Top protection Vehicles with code (Z07) Top protection	AR88.20-P-2200SX AR88.20-P-2200SXS AR88.30-P-1000SX
5	Remove spare tire well (6)		
6	Cover all detachable parts remaining in vehicle with tarp		
7	Equip straightening bench with module members, cross members and straightening bracket set.	 Observe body plans provided. Celette straightening bench Set of Celette module members 955.940, Celette auxiliary member 955.908, Car-Bench straightening bench BT 17, Car-Bench universal crossmember set A 296, Car-Bench straightening bench BT 43/1, Multi-Z straightening set system MZ 450.000, Car-Bench straightening bench BT 140, Car-Bench universal crossmember set 296/19, Celette straightening bracket set 7221.300, Car-Bench straightening bracket set 82456, see GOTIS ht.://GOTIS.aftersales.Mercedes-Benz.COM	
8	Lift vehicle with two-post lift	Two-post lift, see GOTIS ht.://GOTIS.aftersales.Mercedes-Benz.COM	
9	Set vehicle onto straightening bench		
10	Fasten vehicle to straightening bench		
11	Separate rear fender (1)	Drill, angle grinder, body saw, dry vacuum cleaner, see GOTIS ht.://GOTIS.aftersales.Mercedes-Benz.COM  Spot weld milling cutter  Spot weld milling cutter  Set of cutting templates Zinc dust paint suitable for spot welding	AR63.50-P-1400-02SX *201589005100 *215589005100 *221589032300 *BR00.45-Z-1001-07A WF58.50-P-6350-01Y
	 WF  OS	Sheet metal crimping pliers for areas not easily accessible Recycle aluminum parts	OS60.00-P-0001-01N
12	Separate bottom rear center section (2) with rear crossmember (3)	Drill, angle grinder, body saw, dry vacuum cleaner, see GOTIS ht.://GOTIS.aftersales.Mercedes-Benz.COM  Spot weld milling cutter  Spot weld cutter	AR64.20-P-1060-01SX *201589005100 *215589005100 OS60.00-P-0001-01N
	 OS	Recycle aluminum parts	
13	Partially remove rear longitudinal member (4), rear locking lug (5) and locking lug above rear axle (7)	Drill, angle grinder, dry vacuum cleaner, see GOTIS ht.://GOTIS.aftersales.Mercedes-Benz.COM  Spot weld milling cutter	AR64.20-P-1260-01SX *201589005100
14	Prepare new rear fender (1)	Drill, angle grinder, body saw, see GOTIS ht.://GOTIS.aftersales.Mercedes-Benz.COM  Set of cutting templates Zinc dust paint suitable for spot welding	AR63.50-P-1400-03SX *221589032300 *BR00.45-Z-1001-07A
15	Prepare bottom rear center section (2) for installation	Drill, see GOTIS ht.://GOTIS.aftersales.Mercedes-Benz.COM	AR64.20-P-1000-07SX
16	Prepare rear crossmember (3) for installation	Drill, see GOTIS ht.://GOTIS.aftersales.Mercedes-Benz.COM	AR64.20-P-1100-02SX
17	Prepare part of rear longitudinal member (4) and locking lug above rear axle (7)	Drill, angle grinder, see GOTIS ht.://GOTIS.aftersales.Mercedes-Benz.COM Zinc dust paint suitable for spot welding	AR64.20-P-1260-02SX *BR00.45-Z-1001-07A
18	Prepare rear locking lug (5)	Drill, angle grinder, see GOTIS ht.://GOTIS.aftersales.Mercedes-Benz.COM Zinc dust paint suitable for spot welding	AR64.20-P-1240-02SX *BR00.45-Z-1001-07A
	Install		

19	Install part of rear longitudinal member (4), rear locking lug (5) and locking lug above rear axle (7)	Taurus 3 blind rivet tool with 100 mm long extension unit Celette straightening bench Set of Celette module members 955.940, Celette auxiliary member 955.908, Car-Bench straightening bench BT 17, Car-Bench universal crossmember set A 296, Car-Bench straightening bench BT 43/1, Multi-Z straightening set system MZ 450.000, Car-Bench straightening bench BT 140, Car-Bench universal crossmember set 296/19, Celette straightening bracket set 7221.300, Car-Bench straightening bracket set 82456, inert gas welder, spot welder, drill, dry vacuum cleaner, see GOTIS ht.://GOTIS.aftersales.Mercedes-Benz.COM Polygrip flat round head rivet, 6.4 ×14	AR64.20-P-1260-03SX *BR00.45-Z-1001-13A
20	Install rear crossmember (3)	Drill, dry vacuum cleaner, see GOTIS ht.://GOTIS.aftersales.Mercedes-Benz.COM Polygrip flat round head rivet, 6.4 ×14 Polygrip countersunk head rivet, 6.4 ×14 Adhesive	AR64.20-P-1060-03SX *BR00.45-Z-1001-13A *BR00.45-Z-1002-13A *BR00.45-Z-1092-02A
21	Install bottom rear section (2)	Drill, dry vacuum cleaner, see GOTIS ht.://GOTIS.aftersales.Mercedes-Benz.COM ☒ Feeler gauge Polygrip flat round head rivet, 6.4 ×14 Adhesive Trunk lid to rear lamp unit Rear fender to rear lamp unit Trunk lid license plate panel to rear lamp unit	AR64.20-P-1000-08SX *129589032100 *BR00.45-Z-1001-13A *BR00.45-Z-1092-02A *BE60.00-P-1003-01R *BE60.00-P-1003-01R *BE60.00-P-1003-01R
22	Adjust gap dimensions on hoods, doors and lids	☒ Feeler gauge Trunk lid to rear lamp unit Rear fender to rear lamp unit Trunk lid license plate panel to rear lamp unit	AR60.00-P-0700-01SX *129589032100 *BE60.00-P-1003-01R *BE60.00-P-1003-01R *BE60.00-P-1003-01R
23	Unfasten vehicle from straightening bench		
24	Lift vehicle with two-post lift	Two-post lift, see GOTIS ht.://GOTIS.aftersales.Mercedes-Benz.COM	
25	Remove straightening bench.		
26	Install rear fender (1) and weld in	BTR-Usibor drill bit, dia. 6.7, Taurus 3 blind rivet tool with 100 mm extension unit, inert gas welder, spot welder, drill, dry vacuum cleaner, see GOTIS ht.://GOTIS.aftersales.Mercedes-Benz.COM Rear door to side section, bottom Trunk lid to rear lamp unit Rear fender to rear lamp unit Trunk lid license plate panel to rear lamp unit Fuel filler flap ☒ Feeler gauge ☒ Bending iron Zinc dust paint suitable for spot welding Polygrip flat round head rivet, 6.4 ×14 Polygrip countersunk head rivet, 6.4 ×14 Adhesive	AR63.50-P-1400-04SX *BE60.00-P-1002-01R *BE60.00-P-1003-01R *BE60.00-P-1003-01R *BE60.00-P-1003-01R *BE60.00-P-1004-01R *129589032100 *129589002700 *BR00.45-Z-1001-07A *BR00.45-Z-1001-13A *BR00.45-Z-1002-13A *BR00.45-Z-1092-02A
27	Adjust gap dimensions on hoods, doors and lids	☒ Feeler gauge Rear door to side section, bottom Trunk lid to rear lamp unit Rear fender to rear lamp unit Trunk lid license plate panel to rear lamp unit Fuel filler flap	AR60.00-P-0700-01SX *129589032100 *BE60.00-P-1002-01R *BE60.00-P-1003-01R *BE60.00-P-1003-01R *BE60.00-P-1003-01R *BE60.00-P-1004-01R
28	Clean weld joints and sheet metal flange with round wire brush	Drill, see GOTIS ht.://GOTIS.aftersales.Mercedes-Benz.COM	
29	Clean repair areas		
30	Prime area to be repaired using primer filler		

31	Carry out seam sealing after repairs	 Supplement standard sealants with MB body sealant. Sealant Seam sealant, sprayable 310 ml	AR97.10-P-4000SX *BR00.45-Z-1003-01A *BR00.45-Z-1041-01A
32	Paint repair areas and adjacent surfaces		
33	Cavity preservation following repair work	Cavity preservation gun HRS no. 11072, see GOTIS ht.://GOTIS.aftersales.Mercedes-Benz.COM Preservation agent	AR97.20-P-1500SX *BR00.45-Z-1003-05A AH97.20-P-0001-01B
	Notes on cavity preservation		
34	Remove tarp	 On all covered parts remaining in vehicle.	
35	Install rear wall window	Vehicles without code (Z07) Top protection Vehicles with code (Z07) Top protection	AR67.20-P-2000SX AR67.20-P-2000SXS
36	Install spare tire well (6)		AR88.30-P-1000SX
37	Install taillamp		AR82.10-P-4905SX
38	Install rear bumper	Vehicles without code (Z07) Top protection Vehicles with code (Z07) Top protection	AR88.20-P-2200SX AR88.20-P-2200SXS
39	Install rear door sill molding	Vehicles without code (Z07) Top protection Vehicles with code (Z07) Top protection	AR68.30-P-4100SX AR68.30-P-4100SXS

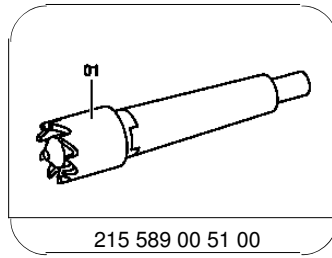
Check values for gaps

Number	Designation	Model 221
BE60.00-P-1002-01R	Gap dimension	Front door to A-pillar Dimension "D" mm 4.5 (±0.5)
		Front door to fender Dimension "E" mm 4 (±0.5)
		Front door to rear door Dimension "F" mm 4.5 (±0.5)
		Trim strip at front door to roof frame Dimension "G" mm 4.5 (±0.5)
		Trim strip at rear door to roof frame Dimension "H" mm 4.5 (±0.5)
		Rear door to side section, bottom Dimension "I" mm 4.5 (±0.5)
		Front door cover to rear door cover Dimension "S" mm 4.5 (±0.5)
	See picture	AR60.00-P-0700-01SX
BE60.00-P-1003-01R	Gap dimension	Trunk lid to rear fender, top Dimension "J" mm 4 (±0.5)
		Trunk lid to rear lamp unit Dimension "K" mm 4 (±0.5)
		Trunk lid to bumper Dimension "L" mm 5.5 (±1.5)
		Rear fender to rear lamp unit Dimension "M" mm 2.5 (±0.5)
		Trunk lid license plate panel to rear lamp unit Dimension "N" mm 4 (±0.5)
	See picture	AR60.00-P-0700-01SX
BE60.00-P-1004-01R	Gap dimension	Fuel filler flap Dimension "O" mm 3.5 (±0.5)
		See picture



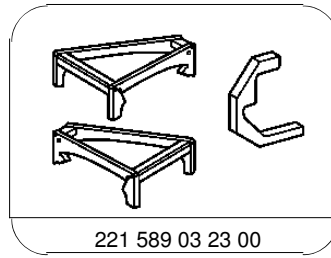
201 589 00 51 00

Spot weld milling cutter



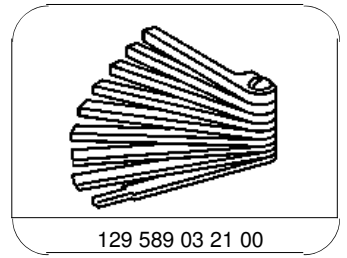
215 589 00 51 00

Spot weld milling cutter



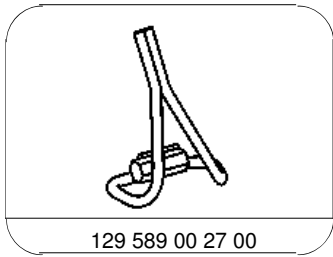
221 589 03 23 00

Set of cutting templates



129 589 03 21 00

Feeler gauge



129 589 00 27 00

Bending iron

Repair materials

Number	Designation	Order number
BR00.45-Z-1003-01A	Sealant, white, 310 ml, DB supply specification 6069.20	A 001 989 63 20
BR00.45-Z-1041-01A	Seam sealant, sprayable 310 ml	A 002 989 84 20
BR00.45-Z-1092-02A	Adhesive kit, body, 2-component adhesive	A 009 989 36 71
BR00.45-Z-1003-05A	Preservation agent, cavities and engine compartment 1 l	A 000 986 72 70 05
BR00.45-Z-1001-07A	Zinc dust paint suitable for spot welding	A 000 986 34 42
BR00.45-Z-1001-13A	Blind rivet 6.4×14	A 003 990 35 97
BR00.45-Z-1002-13A	Polygrip countersunk head rivet, 6.4×14	A 003 990 86 97 05