

P64.20-4485-09























Shown on model 221

1 Bottom rear center section

2 Mount below taillamp

3 Rear crossmember

☒	Removing		
⚠ Danger!	Risk of explosion from pressurized spray cans	Protect cans from direct sunlight and temperatures above 50 °C	AS00.00-Z-0015-01A
⚠ Danger!	Risk of poisoning caused by inhaling vapors or swallowing adhesive. Risk of injury caused by adhesive coming into contact with skin and eyes	Wear respiratory protection, protective gloves and safety glasses. Pour adhesive into suitable and appropriately marked containers only.	AS00.00-Z-0016-01A
⚠ Danger!	Risk of death caused by vehicle slipping or toppling off of the lifting platform.	Align vehicle between columns of vehicle lift and position four support plates at vehicle lift support points specified by 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 bumper	Model 216 Model 221 without code (Z07) Top protection Model 221 with code (Z07) Top protection	AR88.20-P-2200SC AR88.20-P-2200SX AR88.20-P-2200SXS
2	Remove taillamps		AR82.10-P-4905SX
3	Remove spare tire well		AR88.30-P-1000SX
4	Cover all detachable parts remaining in vehicle	Tarp (fire-resistant)	
5	Equip straightening bench with module members, cross members and straightening bracket set.	ⓘ Observe body plans provided. Celette straightening bench	

		<p>Set of Celette module members 955.940 Celette additional member 955.908 Car-Bench straightening bench BT 17 Car-Bench straightening bench BT 43/1 Car-Bench straightening bench BT 140 Car-Bench universal crossmember set A 296 Car-Bench universal crossmember set 296/19 Multi-Z straightening set system MZ 450.000 Celette straightening bracket set 7221.300 (for model 221) Celette 7216.309 supplementary straightening set for Celette straightening bracket set 7221.300 (for model 221) See also GOTIS: ht.://GOTIS.aftersales.Mercedes-Benz.COM Car-Bench straightening bracket set 82456 (for model 221)</p>	
6	Lift vehicle with two-post lift	Two-post lift	
7	Set vehicle onto straightening bench		
8	Fasten vehicle to straightening bench		
9	Separate bottom rear center section (1) with rear crossmember (3)	<p> Spot weld milling cutter  Spot weld milling cutter  Vario Drill WS 91 spot weld removing tool  Round wire brush, braided, dia. 70 mm  Abrasive disk, dia. 115 mm, 80 m/s (max. 13,250 rpm)  Hot-air gun - 3000 W  Aluminum workshop vehicle Drill (electric/pneumatic) Angle grinder (electric/pneumatic) Wet/dry vacuum cleaner</p>	<p>AR64.20-P-1060-01SX *201589005100 *215589005100</p>
	Recycle aluminum parts		OS60.00-P-0001-01N
10	Prepare bottom rear center section (1) for installation	<p> Round wire brush, braided, dia. 70 mm  Aluminum workshop vehicle Drill (electric/pneumatic)</p>	AR64.20-P-1000-07SX
11	Prepare rear crossmember (3) for installation	<p> Round wire brush, braided, dia. 70 mm  Aluminum workshop vehicle Drill (electric/pneumatic)</p>	AR64.20-P-1100-02SX
	Install		
12 	Install and weld in rear crossmember (3) General information on riveting	<p> Clamping pliers  Blind rivets with manual temporary fastener, 6.4 mm dia., clamping range 0 to 15 mm, identification color silver  Round wire brush, braided, dia. 70 mm  Taurus 3 blind rivet tool with 100 mm long extension unit  Aluminum workshop vehicle Drill (electric/pneumatic) Wet/dry vacuum cleaner Polygrip flat round head rivet, 6.4 x14 Polygrip countersunk head rivet, 6.4 x14 Adhesive</p>	<p>AR64.20-P-1060-03SX AH60.00-P-0003-01N *BR00.45-Z-1001-13A *BR00.45-Z-1002-13A *BR00.45-Z-1092-02A</p>
13 	Install bottom rear section (1) General information on riveting	<p>Trunk lid to rear lamp unit Rear fender to rear lamp unit Trunk lid to rear fender, top Trunk lid to rear lamp unit Rear fender to rear lamp unit  Feeler gauge  Clamping pliers</p>	<p>AR64.20-P-1000-08SX AH60.00-P-0003-01N *BE60.00-P-1003-01R *BE60.00-P-1003-01R *BE60.00-P-1003-01R *BE60.00-P-1003-01T *BE60.00-P-1003-01T *129589032100</p>

		Blind rivets with manual temporary fastener, 6.4 mm dia., clamping range 0 to 15 mm, identification color silver Round wire brush, braided, dia. 70 mm Taurus 3 blind rivet tool with 100 mm long extension unit Aluminum workshop vehicle Drill (electric/pneumatic) Wet/dry vacuum cleaner Polygrip flat round head rivet, 6.4 x14 Adhesive	*BR00.45-Z-1001-13A *BR00.45-Z-1092-02A
14	Adjust gap dimensions on hoods, doors and lids	Model 221 gap dimensions Feeler gauge Trunk lid to rear lamp unit Rear fender to rear lamp unit Trunk lid to rear fender, top Model 216 gap dimensions Feeler gauge Trunk lid to rear lamp unit Rear fender 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 AR60.00-P-0700-01SC *129589032100 *BE60.00-P-1003-01T *BE60.00-P-1003-01T
15	Unfasten vehicle from straightening bench		
16	Lift vehicle with two-post lift	Two-post lift	
17	Remove straightening bench.		
18	Clean area to be repaired		
19	Prime area to be repaired with primer filler		
20	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
21	Paint repair areas and adjacent surfaces		
22	Apply additional cavity preservation	Model 221 Model 216 Cavity preservation gun Sata HRS no. 11072 Preservation agent	AR97.20-P-1500SX AR97.20-P-1500SC AH97.20-P-0001-01B *BR00.45-Z-1003-05A
⚠	Notes on cavity preservation		
23	Remove tarp	On all covered parts remaining in vehicle.	
24	Install spare tire well		AR88.30-P-1000SX
25	Install taillamps		AR82.10-P-4905SX
26	Install rear bumper	Model 216 Model 221 without code (Z07) Top protection Model 221 with code (Z07) Top protection	AR88.20-P-2200SC AR88.20-P-2200SX AR88.20-P-2200SXS

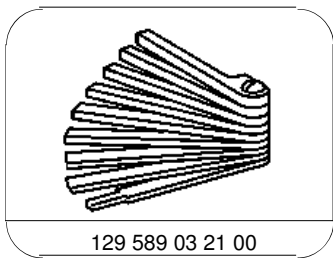
Check values for gaps

Number	Designation	Model 221
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

Check values for gaps

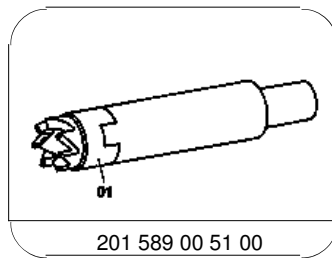
Number	Designation	Model 216

BE60.00-P-1003-01T	Gap dimension	Trunk lid to rear fender, top	Dimension "J"	mm	3.5 (±0.8)
		Trunk lid to rear lamp unit	Dimension "K"	mm	3.5 (±0.8)
		Trunk lid to bumper	Dimension "L"	mm	5.5 (±1.5)
		Rear fender to rear lamp unit	Dimension "M"	mm	2.5 (±0.5)
		See picture			



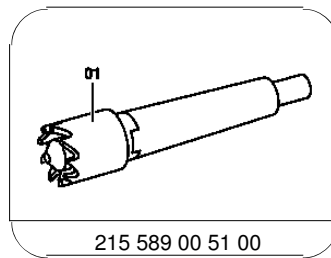
129 589 03 21 00

Feeler gauge



201 589 00 51 00

Spot weld milling cutter



215 589 00 51 00

Spot weld milling cutter

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-1002-13A	Polygrip countersunk head rivet, 6.4×14	A 003 990 86 97 05
BR00.45-Z-1001-13A	Blind rivet 6.4×14	A 003 990 35 97