



Installation instructions

Trim panels on model 124

88.03

The trim panels in the ET scope of supply are primed and can be painted before installation to match the vehicle color in accordance with the brochure "Painting vehicle components".

The installation instructions are divided up into the following sections:

1. Front spoiler/bumper
2. Side sills/sedan, T-sedan
3. Side sills/coupé, cabriolet
4. Rear apron
5. 3-piece rear spoiler/sedan
6. 3-piece rear spoiler/coupé, cabriolet
7. Information on painting
8. Information for ordering replacement parts

Note

In the Federal Republic of Germany the conversion must be accepted by a technical testing station for motor vehicles and be entered into the vehicle documents.

The sections of the operating instructions are divided up as follows:

1. Front spoiler/bumper/sedan, T-sedan, coupé

- A. Preparation
- B. Assembly
- C. Matching, final assembly
- D. Special notes

2. Side sills/sedan, T-sedan

- A. Preparation
- B. Final assembly

3. Rear apron/coupé, cabriolet

- A. Preparation
- B. Final assembly

4. Rear spoiler/sedan, T-sedan, coupé, cabriolet

- A. Preparation
- B. Assembly
- C. Matching, final assembly

5. 3-piece rear spoiler/sedan

- A. Preparation
- B. Matching
- C. Final assembly
- D. Special notes

6. 3-piece rear spoiler/coupé, cabriolet

- A. Preparation
- B. Matching
- C. Final assembly
- D. Special notes

7. Information on painting

8. Parts ordering note

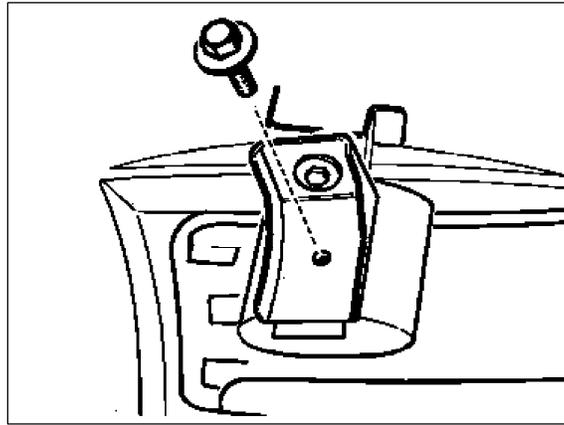
- A. Front spoiler/bumper
- B. Side sills/sedan, T-sedan
- C. Side sills/coupé, cabriolet
- D. Rear apron/sedan, T-sedan, coupé, cabriolet
- E. 3-piece rear spoiler/sedan
- F. 3-piece rear spoiler/coupé, cabriolet

1. Front spoiler/bumper for sedan/T-sedan/coupé, cabriolet

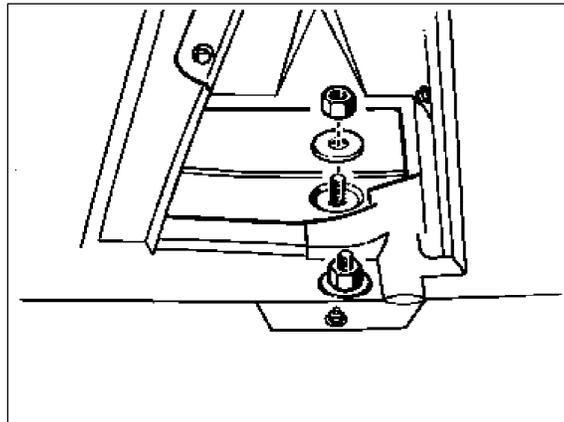
A. Preparation

1. Unscrewing the production bumper.

1.1 Unscrew bolt in the left and right side brackets.

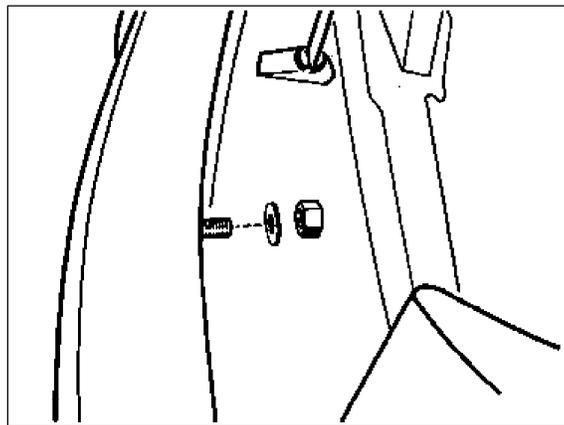


1.2 Unscrew both fixing nuts on the left and right of the side member and remove plain washers.



1.3 Unscrew fixing nut in the center of the bumper and remove plain washer.

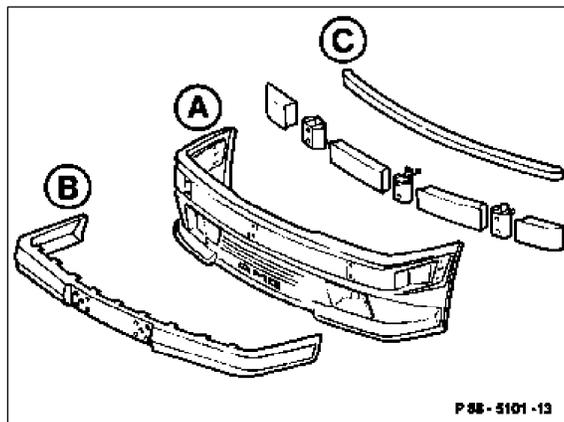
1.4 Remove bumper from the front.



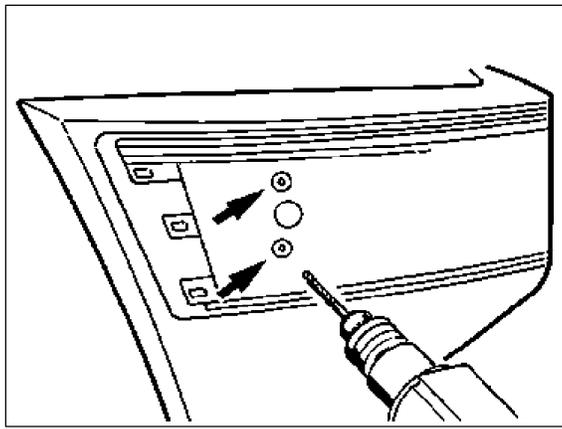
2. Dismantling the bumper.

2.1 Remove metallic impact absorbers.

2.2 Detaching the outer protective strip (B);
Unscrew 3 recessed-head screws on the left and right. Press back retaining strips in pairs using a screwdriver, starting from the outside in each case. Remove protective strip.



2.3 Detaching the bracket:
Drill out rivets (arrows) in the side-mounted bracket.
Unscrew the front three brackets.

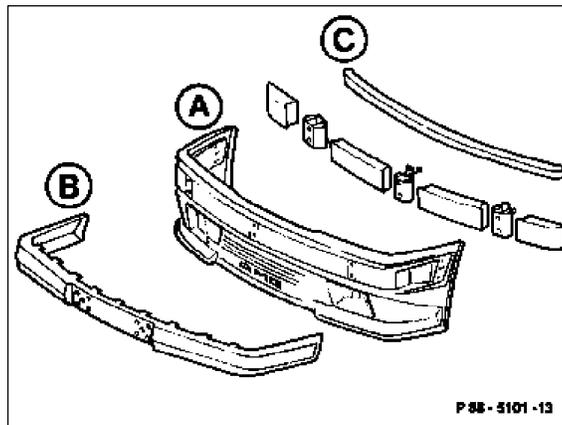


3. Remove metallic impact absorbers over a width of 10 mm.

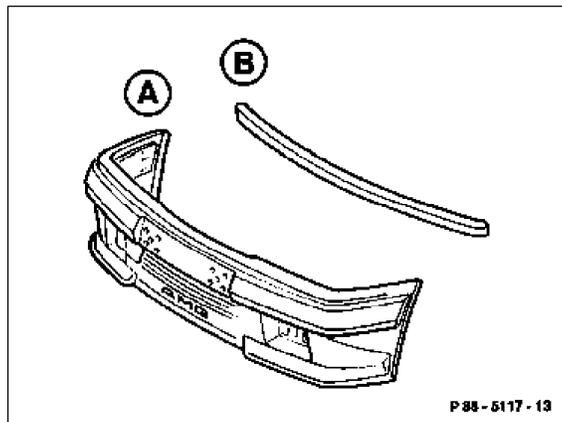
B. Assembly

1. Attaching the brackets: Screw on the front three brackets. Screw on the side brackets using hexagon bolts, U-washers and hexagon nuts supplied.

2. Attaching the outer protective strip: Press protective strip into the retaining slots. Screw in three bolts on the left and right.



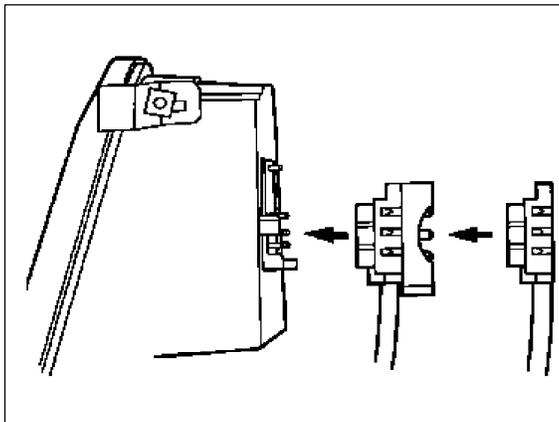
3. Installing the metallic impact absorbers. Slide reinforcement supplied between the production core and upper edge of front spoiler/bumper.



4. Assembling the headlamps:

4.1 Install headlamps supplied in the front spoiler/bumper lamp recesses. The center recess is for the attachment of the headlamp. Route cable through the outer recess. Note installation instructions for headlamps.

4.2 The headlamps are connected using the cables supplied. Detach the cables at the center cable plug connector. The end with the two blade terminals is connected to the headlamps. The end of the cables with the 6-pin plug-socket combination is installed between the 6-pin socket on the headlamp and the 6-pin plug.



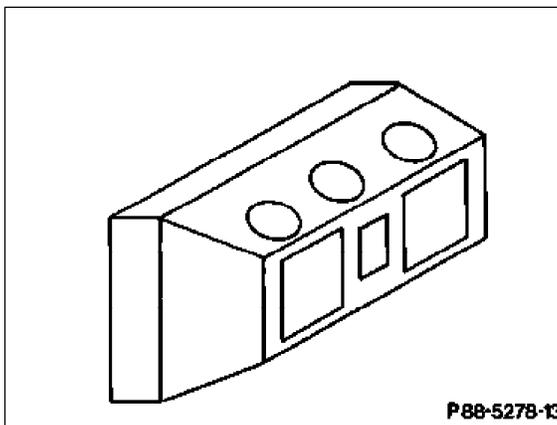
C. Matching and final assembly

1. Screw the assembled front spoiler/bumper loosely onto the original fixing points.
2. Carry out a visual inspection and align front spoiler/bumper, if required.
3. Tighten fixing bolts.
4. Route all cables to avoid any chafing (secure cable using clips and cable ties supplied).
Re-connect the center cable plug connections.
5. Fasten spoiler flange to the engine encapsulation on underside of vehicle using the three spoiler bolts supplied.
6. Carry out a functional check and adjust headlamps (note installation instructions for headlamps).

D. Special notes

1. If an outside temperature sensor is fitted, this must be detached from the protective strip before dismantling the production bumper and be refitted after assembling the front spoiler/bumper.
2. The center mounting bracket can be omitted on Turbo-Diesel versions, if appropriate.

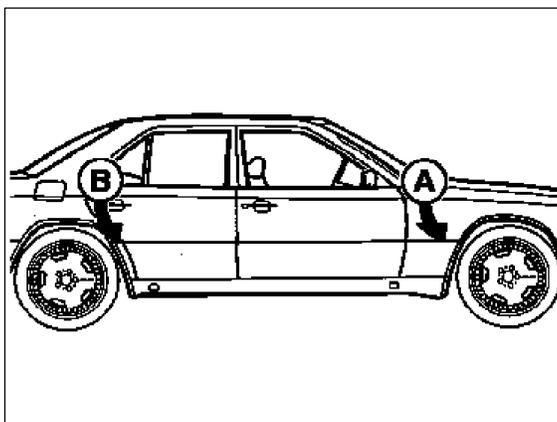
3. On vehicles with an oil cooler on the left-hand side of the vehicle (Model 300E/CE/TE-24 and 300D) three holes are to be made in the lamp recess (top and bottom), with a diameter $d = 15\text{-}20\text{ mm}$ in order to increase the air flow.



2. Side sills/sedan, T-sedan

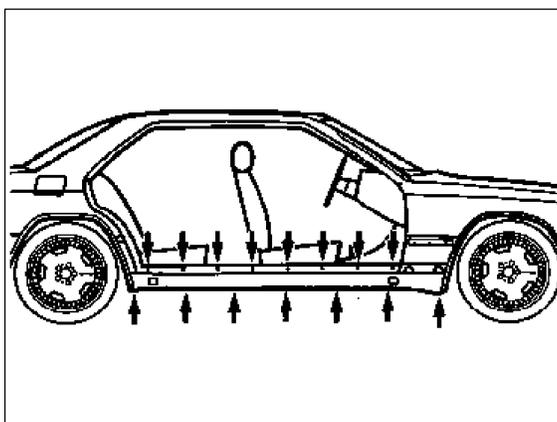
A. Preparation

1. Carefully raise the protective side molding on front fender (A) and rear wheelhouse (B) using a suitable blunt tool and tug gently to detach it from the fixings.



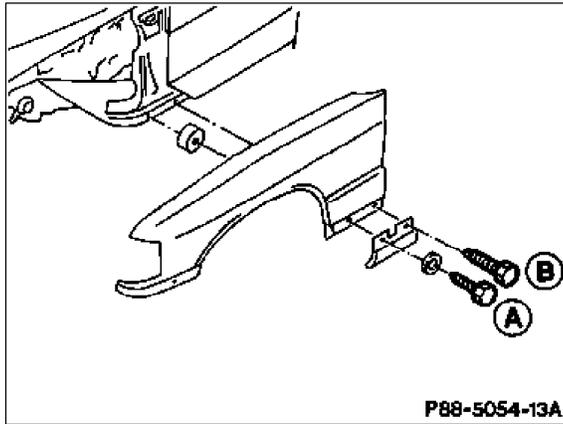
2. Remove sealing rubber from original side sill.

3. Unscrew fixing screws on the top and bottom of the production sill. Remove production sill.

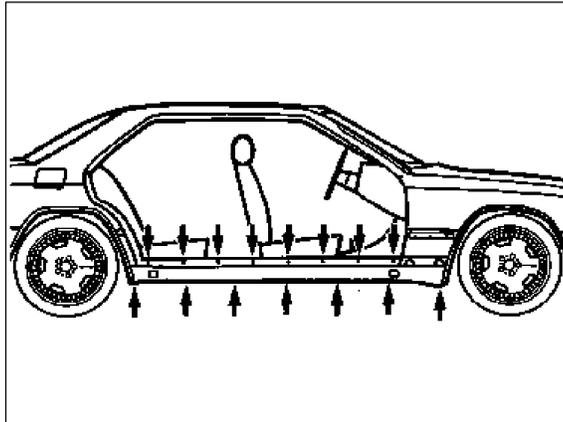


B. Final assembly

1. Adjust fender in the front sill area using expanding block supplied.



2. Attach AMG side sill to original fixing points.



3. Press sealing rubber into the AMG side sill.
4. Re-attach front and rear protective side moldings in the fixings.
5. Attach cover in rear wheelhouse to the side sill.

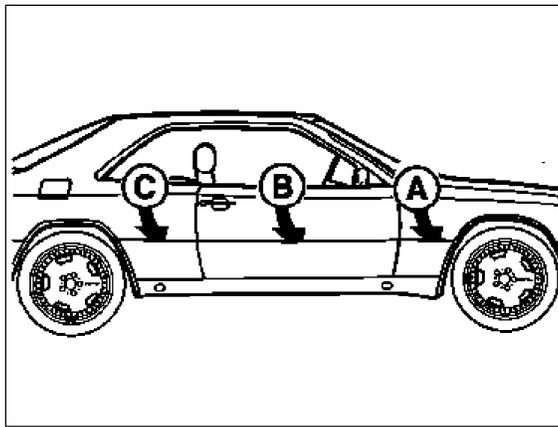
3. Side sills/coupé/cabriolet

A. Preparation

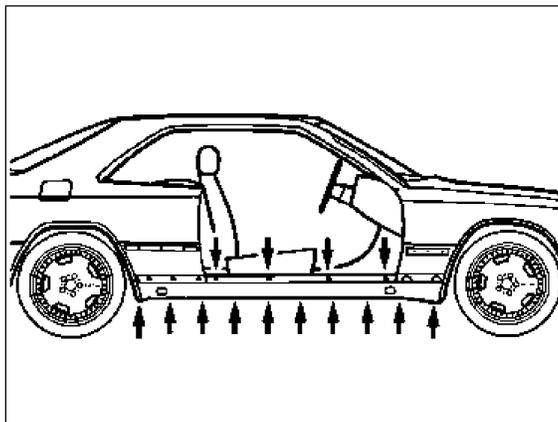
1. Carefully raise the protective side molding on front fender and rear wheelhouse (C) using a suitable blunt tool and tug gently to detach it from the fixings.

2. Remove protective side molding (B) on the doors. Open door. Unscrew fixing screw on protective side molding. Knock protective side molding gently backwards using blunt object to release it from the fixing. Remove protective side molding.

3. Lift off protective strip in the entry area.



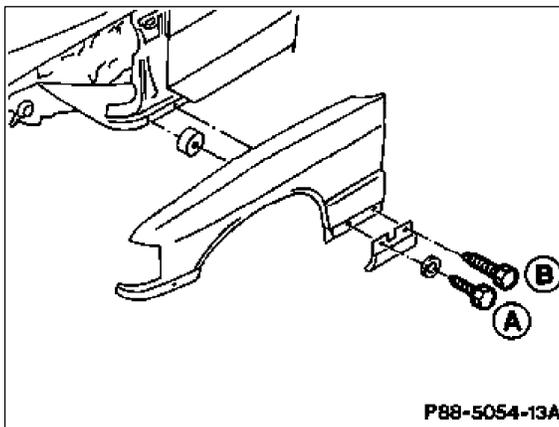
4. Unscrew fixing screws at the top and the bottom of the production sill. Withdraw production sill from the clips by tugging gently. Withdraw clips from the fixing sleeves.



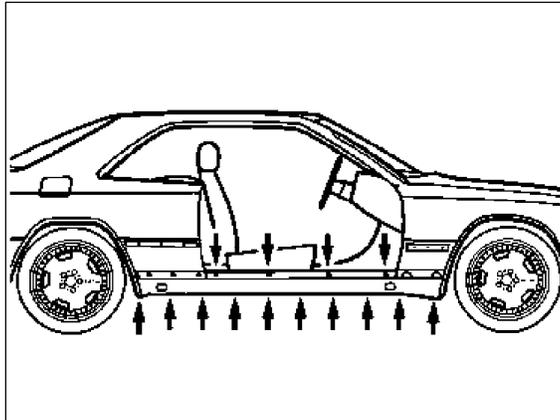
5. Press sealing rubber of production sill out of the retaining slots using a suitable tool.

B. Final assembly

1. Adjust fender in the front sill area using spacer supplied.
2. Attach sealing rubber and one snap fastener at the front and rear of the AMG side sill.



3. Screw AMG side sill onto original fixing points.

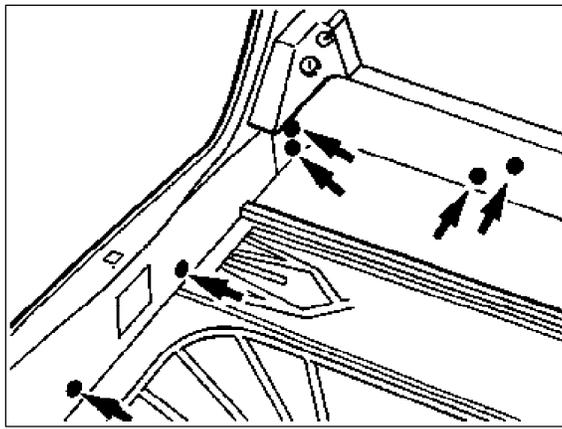


4. Re-attach protective strip and protective side molding in the fixings.
5. Attach cover in rear wheelhouse to the side sill.

4. Rear apron sedan, T-sedan, coupé, cabriolet

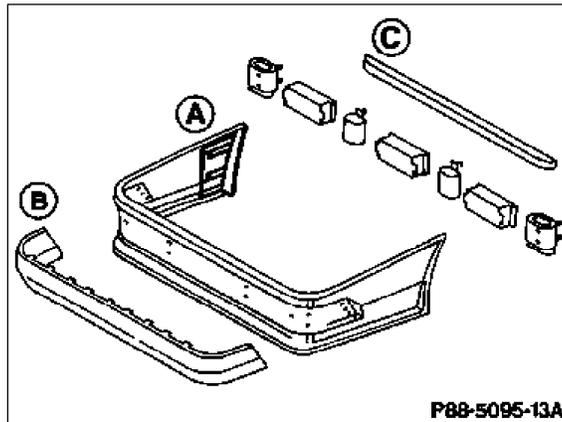
A. Preparation

1. Remove or open side trim.
2. Remove spare wheel (T-sedan).
3. Remove cover between bumper and wheelhouse.
4. Unscrew the production bumper, by unscrewing left and right fixing nuts on the protective side molding and on rear panel of the luggage compartment.



Two people are required to remove the bumper to avoid damaging the paint.

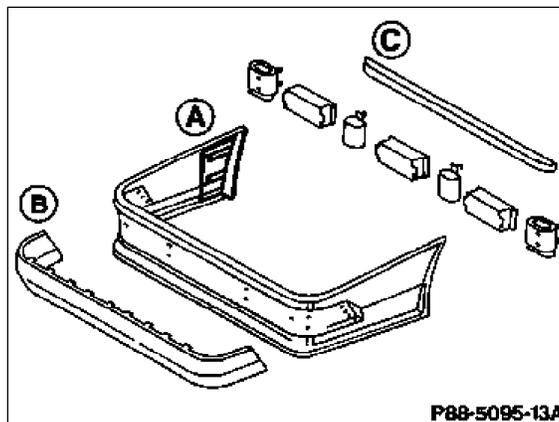
5. Dismantle bumper.
 - 5.1 Remove metallic impact absorber.
 - 5.2 Detaching outer protective strip. Unscrew 3 recessed-head screws on the left and right. Press back retaining strips in pairs using a screwdriver, starting from the outside. Remove protective strip.
 - 5.3 Detach bracket. Unscrew the center four brackets. Push out the two side brackets.



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B. Assembly

1. Attaching the brackets. Screw on the four brackets in correct position. Push the side brackets into the fixing.
2. Attaching the outer protective strip. Press protective strip into the retaining slots. Screw in three screws on the left and right.
3. Installing the metallic impact absorbers. Slide reinforcement supplied between the production core and upper edge of rear apron.



C. Matching and final assembly

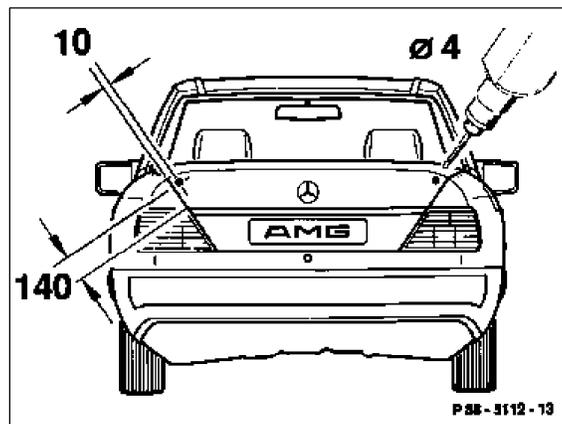
1. Loosely attach the assembled rear apron to the original fixing points.
2. Carry out visual inspection and align rear apron, if required.
3. Tighten fixing screws.
4. Re-install trim panels and spare wheel (T-sedan).

5. 3-piece rear spoiler/sedan

A. Preparation

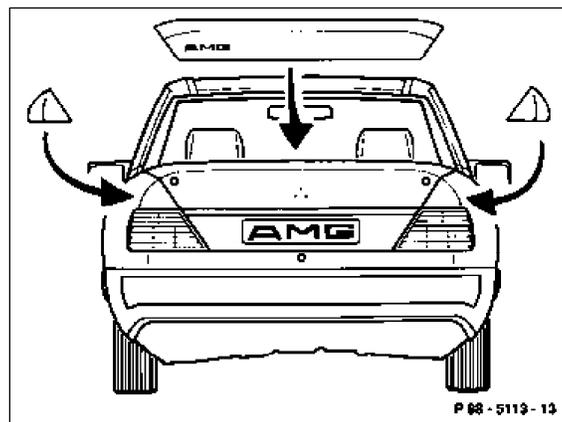
1. Remove maker's plate on trunk lid. The maker's plate is attached with adhesive. Lift off maker's plate using a suitable blunt tool.
2. Remove the MB emblem (star) on trunk lid. Prise the star out of the fixing sleeves using a suitable blunt tool.
3. Remove fixing sleeves on trunk lid from the inside.
4. Tape over holes for fixing sleeves with insulating tape.

5. Making the fixing holes for center section of rear spoiler. Drill two 4 mm dia. holes in the trunk lid.
6. Protect holes against corrosion using a suitable touch-up stick.



B. Matching

1. Place center section of rear spoiler on the trunk lid, align and fix with adhesive tape.
2. Scribe the two fixing holes on center section of rear spoiler.
3. Drill the marked fixing holes to dia. = 3 mm on center section of rear spoiler (drilling depth - 10 mm).



C. Final assembly

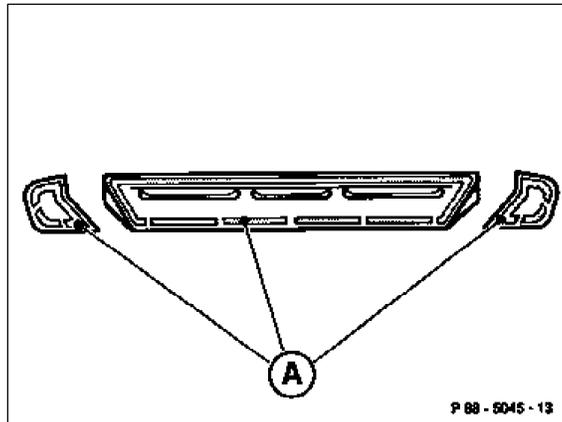
1. Use silicone remover to clean the trunk lid and protective side moldings in the area to be bonded.

2. Apply 1K adhesive to rear spoiler components in the area to be bonded (A).

3. Place center section of rear spoiler on the trunk lid, screw down, and fix with adhesive tape.

4. Place side sections of rear spoiler on the fender, align and fix with adhesive tape.

5. After 5 hours the 1K adhesive has hardened sufficiently for the vehicle to be driven and is fully cured after 24 hours.

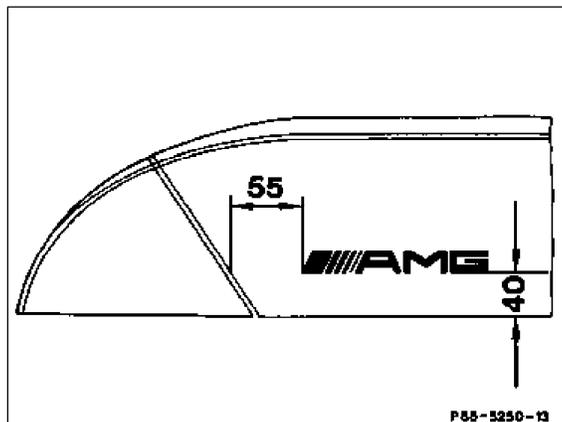


6. Press AMG star into the fixing bores. Note direction of arrow on the back (arrow pointing upwards).

Mount AMG emblem on rear opening hood or rear spoiler.

Heat up AMG emblem and adhesive area to approx. 40°C (radiant heater, hot air gun or similar).

Mount AMG emblem in accordance with the drawing and press on.

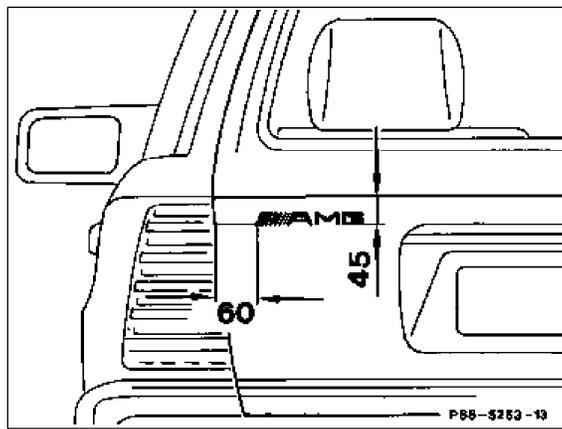


Sedan

Mount AMG emblem on rear opening hood.

Heat up AMG emblem and adhesive area to approx. 40°C (radiant heater, hot air gun or similar).

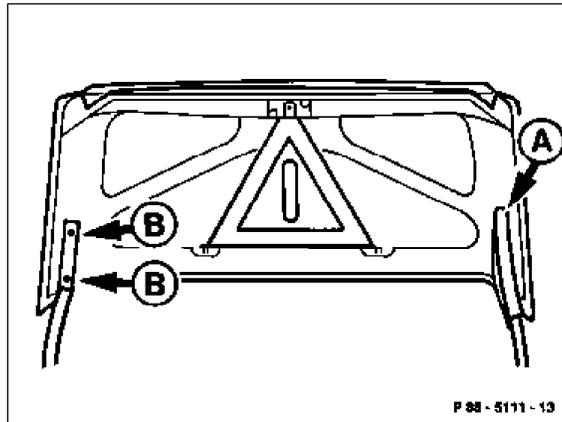
Mount AMG emblem in accordance with the drawing and press on.



T-sedan

D. Special notes

1. The maker's plate is easy to remove if it is heated up with a radiant heater, hot air gun or similar.
2. Work carefully to avoid damaging the paint.
3. Aligning the rear spoiler components by adjusting the trunk lid.
 - 3.1 Remove protective cap on the left and right.
 - 3.2 Detach both screws on the left and right.
4. Re-tension the tension spring on trunk lid.
 - 4.1 Hook in left and right tension spring in the last locking hole.

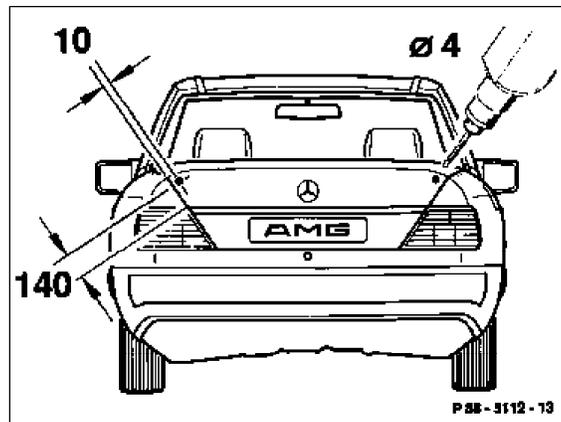


6. 3-piece rear spoiler/coupé/cabriolet

A. Preparation

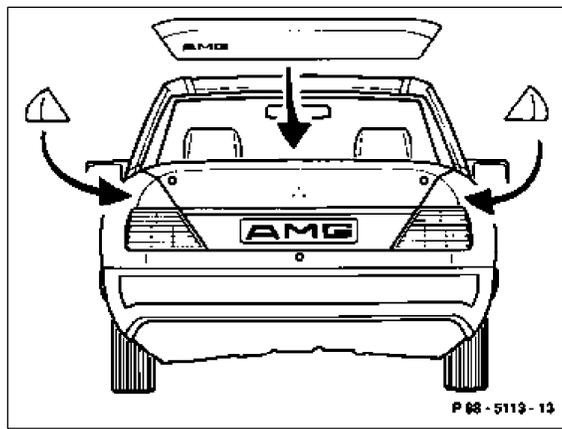
1. Remove maker's plate on trunk lid. The maker's plate is attached with adhesive. Lift off maker's plate using a suitable blunt tool.
2. Remove the MB emblem (star) on trunk lid. Prise the star out of the fixing sleeves using a suitable blunt tool.
3. Remove fixing sleeves on trunk lid from the inside.
4. Tape over holes for fixing sleeves with insulating tape.

5. Making the fixing holes for center section of rear spoiler. Drill two 4 mm dia. holes in the trunk lid.
6. Protect holes against corrosion using a suitable touch-up stick.



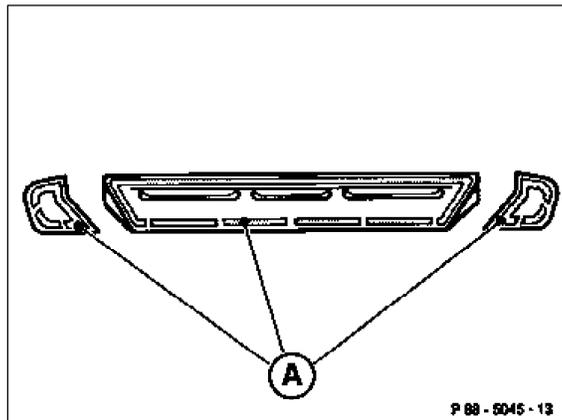
B. Matching

1. Place center section of rear spoiler on the trunk lid, align and fix with adhesive tape.
2. Scribe the two fixing holes on center section of rear spoiler.
3. Drill the marked fixing holes to dia. = 3 mm on center section of rear spoiler (drilling depth - 10 mm).



C. Final assembly

1. Use silicone remover to clean the trunk lid and protective side moldings in the area to be bonded.
2. Apply 1K adhesive to rear spoiler components in the area to be bonded (A).
3. Place center section of rear spoiler on the trunk lid, screw down and fix with adhesive tape.
4. Place side sections of rear spoiler on the fender, align and fix with adhesive tape.
5. After 5 hours the 1K adhesive has hardened sufficiently for the vehicle to be driven and is fully cured after 24 hours.

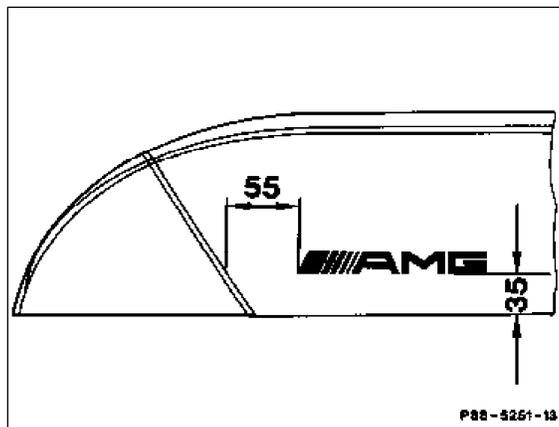


6. Press AMG star into the fixing bores. Note direction of arrow on the back (arrow pointing upwards).

Mount AMG emblem on rear opening hood or rear spoiler.

Heat up AMG emblem and adhesive area to approx. 40°C (radiant heater, hot air gun or similar).

Mount AMG emblem in accordance with the drawing and press on.



D. Special notes

1. The maker's plate is easy to remove if it is heated up with a radiant heater, hot air gun or similar.

2. Work carefully to avoid damaging the paint.

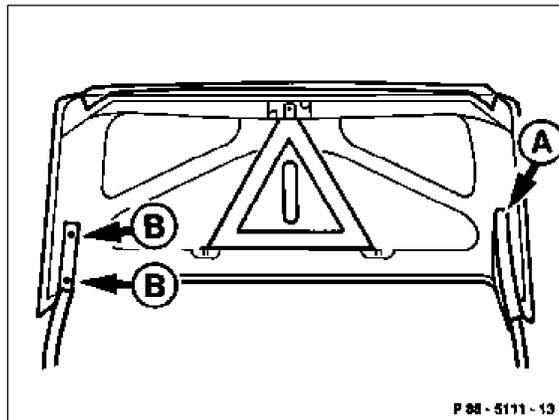
3. Aligning the components of the rear spoiler by adjusting the trunk lid:

3.1 Remove protective caps on the left and right.

3.2 Detach both screws on the left and right.

4. Re-tension the tension spring on trunk lid.

4.1 Hook in left and right tension spring in the last locking hole.



7. Information on painting

1. Only position the parts in the condition in which they are mounted on the vehicle. Do not bend them or allow them to sag and distort when painting and drying.

2. Thoroughly grind primer with wet grinding paper grain 240.

2.1 Clean parts with silicone remover.

2.2 Coat 2K filler with 10-15% 2K elasticity additive.

2.3 Grind 2K filler with wet grinding paper grain 800-1000.

3. Unless otherwise instructed by the paint manufacturer, proceed as follows.

3.1 2K acrylic paint is used as the top coat for solid color paintwork.

Mixture:

a) Mix 2K acrylic paint with 30% elasticity additive:

b) Combine this mixture with 2K hardener in a ratio of 2:1 (adding 2K thinners if required).

3.2 Two-coat metallic paint is used as the top coat for metallic paintwork.

Mixture:

a) Paint 1st coat with metallic paint;

b) Mix 2nd coat of 30% elasticity additive and 2k clear varnish;

c) Combine this mixture with 2K hardener in a ratio of 2:1 (adding 2K thinners if required).

Note

- The maker's plate must remain legible at all times.
- Never dry at a temperature above 40°C.
- It is absolutely essential to position the component without any stress when painting and drying.

8. Information for ordering replacement parts

The parts required for installation can be obtained under the following part numbers.:

A. Front spoiler/bumper

Quantity	Designation	Part no.
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1	Front spoiler/bumper without fixing material	H WA124 880 07 70
1	Reinforcement	H WA124 885 01 37
1	Towing hook cover	H WA140 880 01 05
4	Hexagon bolt M6×20	N000933 006121
4	Hexagon nut M6	N000934 006013
8	Body U-washer 6×20	N009021 006205
2	Headlamp	H WA201 820 01 56
2	Halogen bulb	N07261 012290
2	Headlamp cable harness	H WA201 540 01 08
3	Spoiler bolt	N914127 004213
1	Fixing strap	A 201 698 02 14

B. Side sills/sedan/T-sedan

Quantity	Designation	Part no.
1	Left side sill	H WA124 690 03 40
1	Right side sill	H WA124 690 04 40
4	Vehicle jack cover	H WA140 698 01 30
2	Spacer	H WA201 990 01 40
2	Sheet metal hexagon 6.3×32	N007981 006212
2	Body U-washer 6×20	N009021 006205
4	Fixing strap	A201 698 02 14
1	Cover	A124 698 08 30
1	Cover	A124 698 07 30

C. Side sills/coupé/cabriolet

Quantity	Designation	Part no.
1	Left side sill	H WA124 690 05 40
1	Right side sill	H WA124 690 06 40
4	Vehicle jack cover	H WA124 698 01 30
2	Spacer	H WA201 990 01 40
2	Sheet metal hexagon 6.8×32	N007981 006212
2	Body U-washer 6×20	N009021 006205
4	Fixing strap	A201 698 02 14

D. Rear apron/coupé/cabriolet

Quantity	Designation	Part no.
1	Rear apron without fixing material	H WA124 880 03 40
1	Reinforcement	H WA124 885 02 37

E. Rear apron/T-sedan

Quantity	Designation	Part no.
1	Rear apron without fixing material	H WA124 880 04 40

F. 3-piece rear spoiler/sedan

Quantity	Designation	Part no.
1	Center section of 3-piece rear spoiler without fixing material	H WA124 790 13 88
1	Left corner of rear spoiler without fixing material	H WA124 790 11 88
1	Right corner of rear spoiler without fixing material	H WA124 790 12 88
1	1K PUR adhesive	H WA201 989 01 71
2	Spoiler screw 4.2 × 12.5	N914127 004208
1	Sticker	H WA124 584 01 39
1	AMG plate	H WA201 817 03 15
1	AMG star	H WA201 758 03 58

G. 3-piece rear spoiler/coupé/cabriolet

Quantity	Designation	Part no.
1	Center section of 3-piece rear spoiler without fixing material	H WA124 790 17 88
1	Left corner of rear spoiler without fixing material	H WA124 790 15 88
1	Right corner of rear spoiler without fixing material	H WA124 790 16 88
1	1K PUR adhesive	H WA201 989 01 71
2	Spoiler screw 4.2 × 12.5	N914127 004208
1	Sticker	H WA124 584 02 39
1	AMG plate	H WA201 817 03 15
1	AMG star	H WA201 758 03 58