

FILE: SERVICE: GROUP 00 OF SERVICE INFORMATION BINDER
PARTS: GROUP 01 OF SERVICE INFORMATION - PARTS & ACCESSORIES BINDER

Campaign no. 2008050004, January 2009

TO: ALL MERCEDES-BENZ CENTERS

Revision	Date	Purpose
B	01/23/09	Revision to Warranty information for accessory installed trailer hitch and accessory intalled trailer hitch Customer Letter
A	09/26/08	Revision to Warranty information, Repair Procedure, Parts information, and Quality Assurance Certificate
-	06/03/08	Initial release

SUBJECT: **Models 164 and 164.8, Model Years 2006 - 2008**
Rework Trailer Hitch

This Recall Campaign has been initiated because Daimler AG (DAG) has determined that due to modification in the welding process at the supplier's manufacturing plant, some of the weld seams connecting the trailer hitch receiver to the attachment bar used to secure the trailer hitch to the body frame do not meet DAG performance specifications. This may result in the trailer hitch receiver separating from the attachment bar, creating a road hazard which may lead to a vehicle crash. The trailer hitch must not be used for any purpose until it has been repaired at an authorized Mercedes-Benz dealer. Mercedes-Benz USA, LLC (MBUSA) therefore has initiated a recall of these vehicles to repair all potentially affected trailer hitches.

Attached is a sample copy of a letter which owners of the affected vehicle will receive.

Prior to performing this Recall Campaign:

- Please check VMI to determine if the vehicle is involved in the Campaign and if it has been previously repaired.
- Please review the entire Recall Campaign bulletin and follow the repair procedure exactly as described.

Please note that Recall and Service Campaigns **do not expire** and may also be performed on a vehicle with a vehicle status indicator.

Approximately 52,740 vehicles are affected.

Order No. T-RC-2008050004

This bulletin has been created and maintained in accordance with MBUSA-SLP S423Q001, Document and Data Control, and MBUSA-SLP S424HH001, Control of Quality Records

Note: This vehicle repair requires welding to be performed. Welding is to be performed by a **CERTIFIED WELDER** certified for GMAW (Gas Metal Arc Welding) also known as MIG welding or Shielded Metal Arc Welding (SMAW) also known as stick welding; WHO HAS BEEN CERTIFIED BY ANY **ACCREDITED WELDER CERTIFICATION PROGRAM** (e.g., American Welding Society [AWS], National Registry for Certified Welders, I-Car etc. [other **accredited** welding certification programs are also acceptable]). Submitting a claim for reimbursement for this work constitutes dealer's representation that the work was performed by a certified welder as indicated above.

A. Prepare vehicle for welding

1. Disconnect negative battery cable, refer to WIS: AR54.10-P-0003GZ.

Note (regarding above WIS document):
Do **not** perform step 8.

2. Thoroughly cover area around trailer hitch with welding blankets (A, Figure 1).

Note:

Welding blankets can be purchased locally or by contacting: Reliable Automotive Equipment, Inc.
@ (732) 747-1770.

3. Cover remaining exposed area with masking tape (arrows, Figure 1).

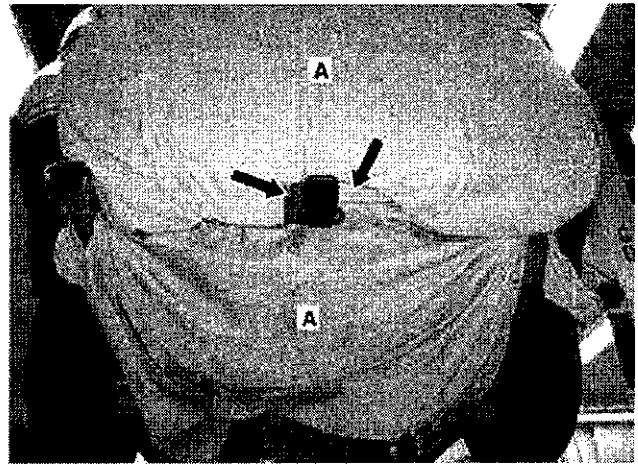


Figure 1

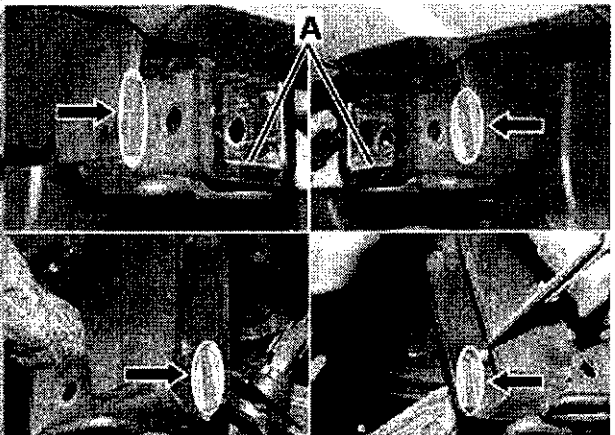
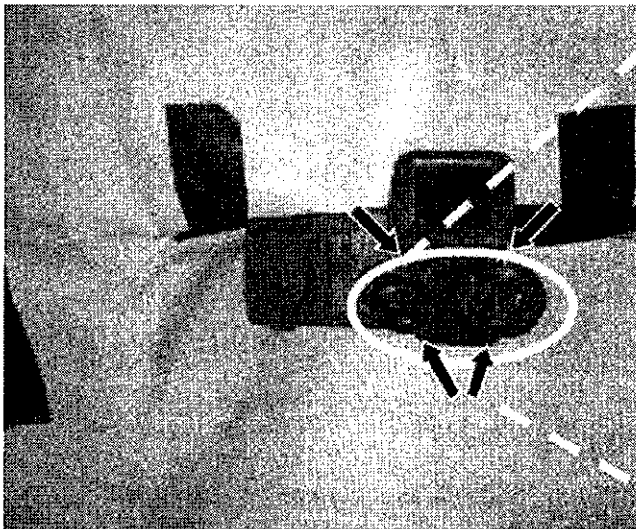


Figure 2

4. Thoroughly grind 4 weld point surfaces (arrows, Figure 2) and welder's ground point (A) down to bare metal using a die grinder with a burr bit (refer also to Figure 3 for view of weld points ground down).

WARNING!

Wear eye protection (safety glasses, face shield etc.) to prevent injury to eyes.

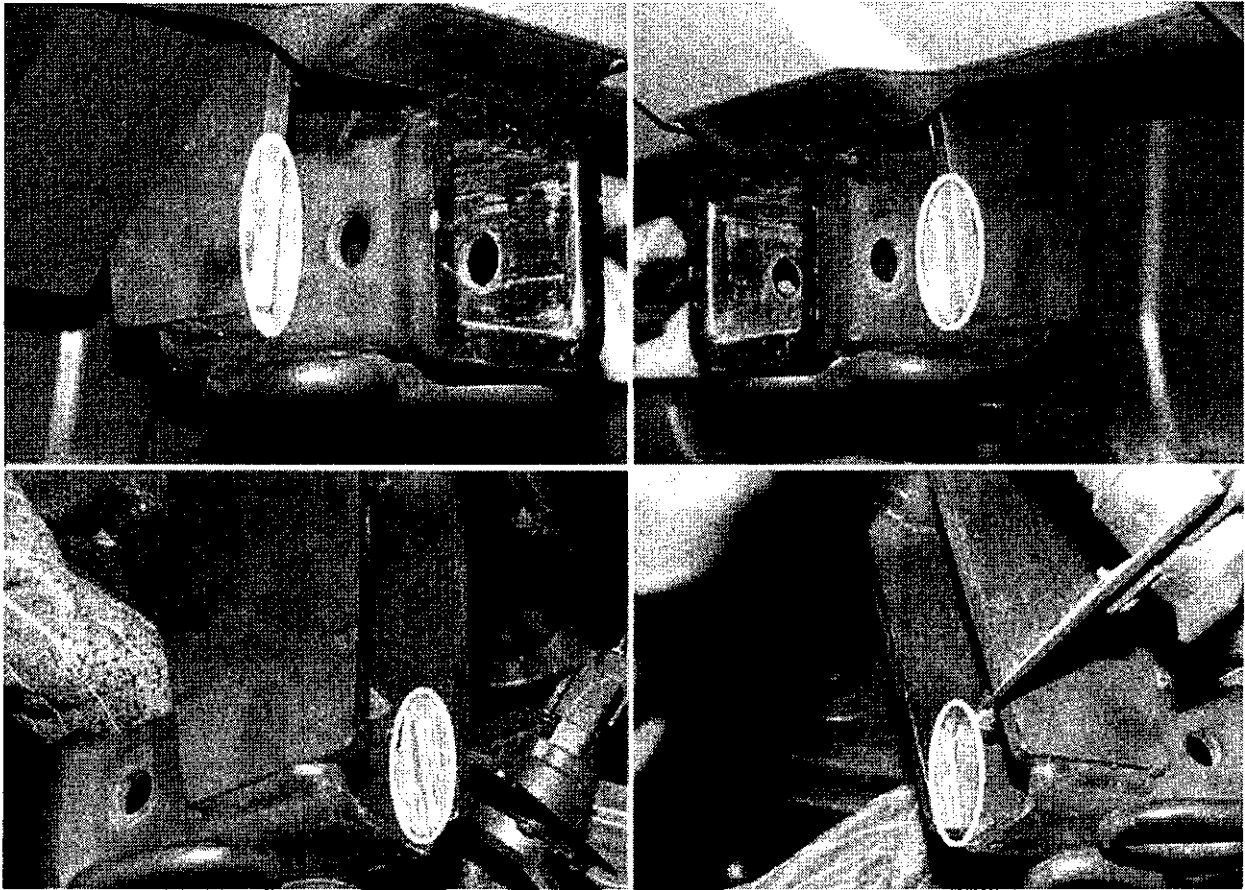


Figure 3

5. Attach welder's ground cable (arrow, Figure 4) to trailer hitch (A).

CAUTION!:

Ensure ground cable (arrow) connection is inside square tube (A) or damage may result to SRS control module and/or air bags and emergency tensioning devices may deploy.

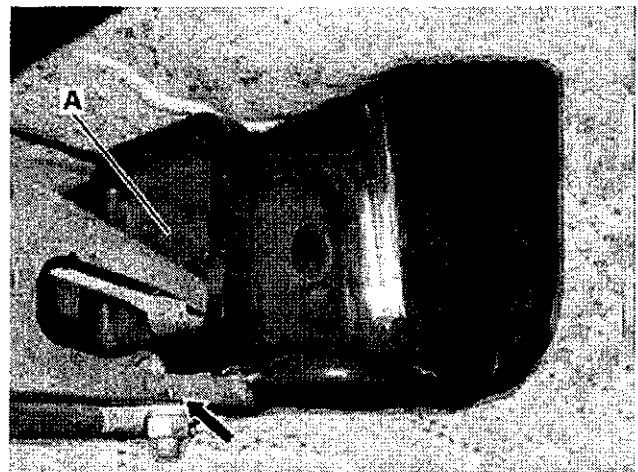


Figure 4

B Weld trailer hitch

CAUTION!

This vehicle repair requires welding to be performed. Welding is to be performed by a **CERTIFIED WELDER** certified for GMAW (Gas Metal Arc Welding) also known as MIG welding or SMAW (Shielded Metal Arc Welding) also known as stick welding; WHO HAS BEEN CERTIFIED BY ANY **ACCREDITED WELDER CERTIFICATION PROGRAM** (e.g., American Welding Society [AWS], National Registry for Certified Welders, I-Car etc. [other **accredited** welding certification programs are also acceptable]). Submitting a claim for reimbursement for this work constitutes dealer's representation that the work was performed by a certified welder as indicated above.

WARNING!

- Risk of bodily injury. Ensure no one is inside vehicle during welding. Risk of air bags and/or emergency tensioning devices deploying during welding.
 - Protective welding clothing (gloves, jackets etc.), eye/face protective masks (welder's mask) must be worn or bodily injuries may result (burns to skin and eyes, impaired vision).
1. Adjust settings as per welding machine's operating instructions (voltage, amperage, etc.) for a material thickness of 8 - 10 mm (5/16" - 25/64").

Note:

Recommended **GMAW (Gas Metal Arc Welding)** machines:

- 505-285 made by Tecna
- 521-332001 made by Wielander and Schill
- 521-ATLW made by Wielander and Schill

All **GMAW** machines can be purchased and questions pertaining to them can be answered by calling the Mercedes-Benz Standard Service Equipment Program at (888) 458-4040.

Note:

Minimum specifications for **GMAW** machines:

- | | |
|-------------------------------|------------------------------------|
| • Rated amperage: 200 - 250 A | • Wire diameter: .023" - .045" |
| • Duty cycle: 60% | • Wire feed: 2" per sec. (2 rolls) |
| • Rated voltage: 27 V | • Gas: 18% CO2 (Argon mixed gas) |

Note:

In addition, an **SMAW** (Shielded Metal Arc Welding) machine that meets the minimum specifications listed below, may be used for this procedure.

Minimum specifications for **SMAW** machines:

- | | |
|--------------------------------|---|
| • Rated amperage: 225 - 350 A | • Welding electrode: 3/32" 7018 electrode |
| • Amperage setting: 95 - 125 A | |

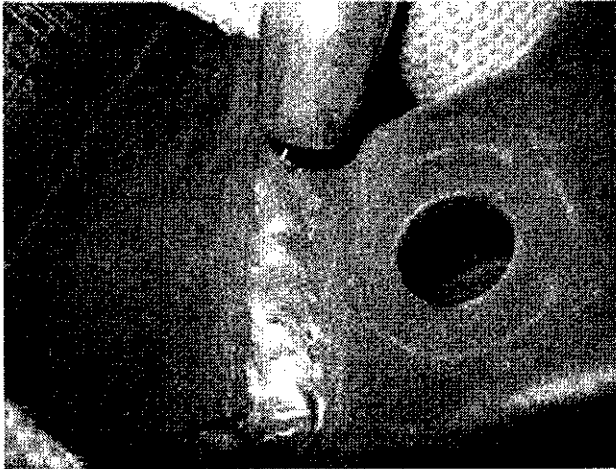


Figure 5

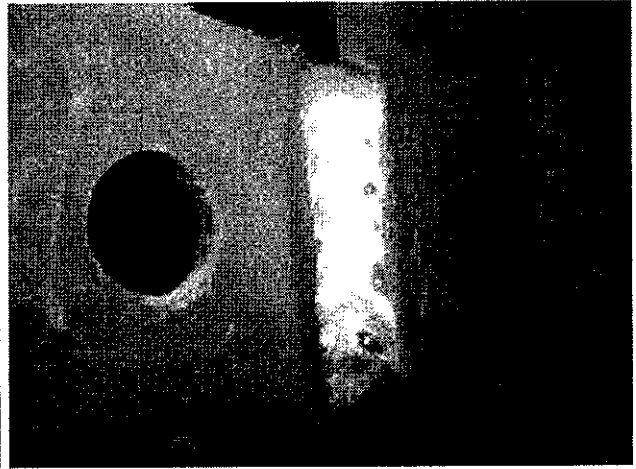


Figure 6

2. Weld front of trailer hitch (Figures 5 and 6).



Figure 7

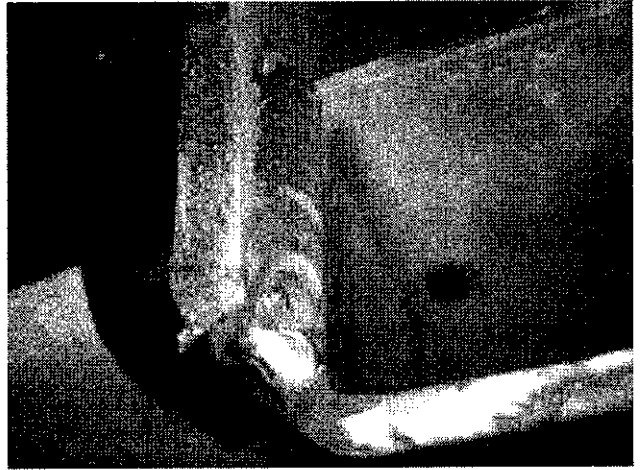


Figure 8

3. Weld rear of trailer hitch (Figures 7 and 8).
4. Clean new welding beads (at all 4 weld points) with a wire brush (Figure 9).

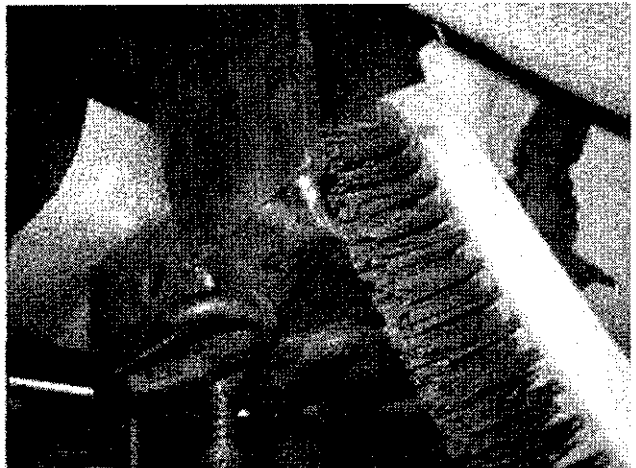


Figure 9

5. Thoroughly paint welding beads (Figure 10) and any metal exposed during grinding (in area of 4 weld points), and welder's ground point inside the square tube:
 - Apply black paint primer.
 - Paint with black paint.
6. Allow paint to dry then apply preservation agent to painted surfaces in area of welds.
7. Reassemble in reverse order.
8. Perform basic programming, refer to WIS: AR00.19-P-0200GZ.
9. Complete and sign quality assurance form (on page 8).

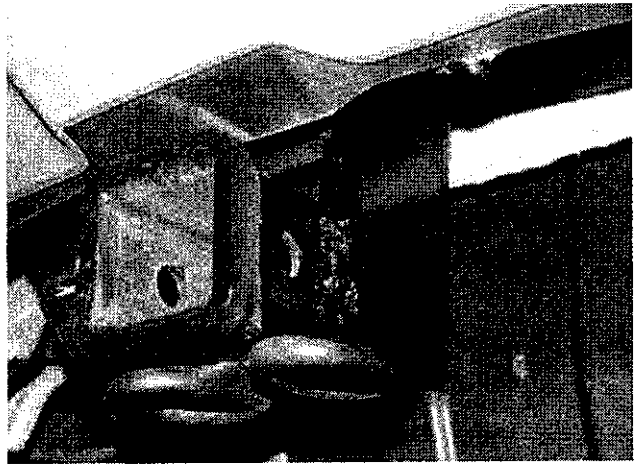


Figure 10

Parts information

Qty.	Part Name	Part number	Estimated Replacement Rate
1	Preservation agent	A 000 986 33 70 10 ¹⁾	100%
1	Aerosol primer	A 000 986 32 50 ²⁾	
1	Black aerosol paint	A 000 986 28 50 9040 ³⁾	
-	Welding wire	Wire dia.: .023" - .045"	
-	Welding electrode	Dia.: 3/32" 7018	

Note:

¹⁾ 1 container is to be used for 10 vehicles.

²⁾ 1 spray can of aerosol primer is to be used for 10 vehicles.

³⁾ 1 spray can of black aerosol paint is to be used for 10 vehicles.

All parts are to be submitted as one local purchase part, utilizing part number PTS01000, for a qty of 1, handling is included. Reimbursement will be \$10.00.

Note:

- Please be aware that only the part number(s) referenced in the Campaign Bulletin is/are approved for use to repair the vehicle. Repairs performed using any other part(s) will not have been performed in accordance with the campaign. Accordingly, warranty claims submitted with reference to an improper part number(s) will be denied.
- The following allowable labor operation should be used when submitting a warranty claim for this repair:

Warranty Information

Repair 1

Operation: Weld trailer hitch (02-6044)
Connect/disconnect battery ground cable (02-6046)

Damage code	Operation Number	Labor Time Est.	Model Indicator(s)
31 900 32 7	02-6044	1.0	Z1, Z2, Z3, Z4, Z5
	02-6046	0.2	EA, EB, EC

Repair 2

Operation: Repair required at facility other than dealership.
Connect/disconnect battery ground cable (02-6046)

Damage code	Operation Number	Labor Time Est.	Model Indicator(s)
31 900 32 8	Submit as a SUBLET utilizing sublet code of SUB with required amount.		
	02-6046	0.2	Z1, Z2, Z3, Z4, Z5 EA, EB, EC

Repair 3

Operation: Sublet repair performed at dealership, dealer claiming for parts.
Connect/disconnect battery ground cable (02-6046)

Damage code	Operation Number	Labor Time Est.	Model Indicator(s)
31 900 32 7	Submit as a SUBLET utilizing sublet code of SUB with required amount.		
	02-6046	0.2	Z1, Z2, Z3, Z4, Z5 EA, EB, EC

Repair 4 (Applies to accessory installed trailer hitch only)

Operation: Visual check of trailer hitch; weld trailer hitch if necessary (02-6190)
Weld trailer hitch (after check) (02-6191)
Connect/disconnect battery ground cable (02-6046)

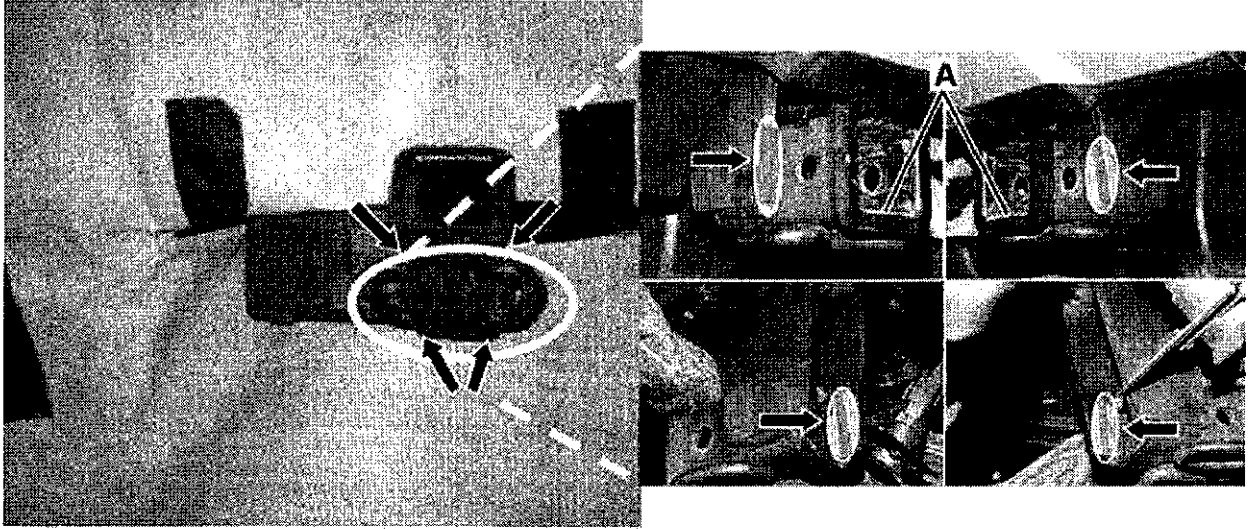
Damage code	Operation Number	Labor Time Est.	Model Indicator(s)
31 900 32 7	02-6190	0.1	Z1, Z2, Z3, Z4, Z5
	02-6191	1.0	EA, EB, EC
	02-6046	0.2	

Note:

- Operation number: 02-6190 includes visual check of trailer hitch, checking VMI for an open trailer hitch campaign, contacting CAC to add VIN to the campaign (if necessary).
- Refer to illustrations in customer letter to identify if trailer hitch is affected.

QUALITY ASSURANCE CERTIFICATE FOR RECALL CAMPAIGN T-RC-2008050004**Check and quality items:**

1. All four weld points (arrows, Figure1) and welder's ground point in square tube (A) ground down to metal ☐

**Figure 1**

2. All four welds properly welded (Figure 2) at all 4 weld points (arrows, Figure 1) ☐

**Figure 2**

3. Welding method:
- SMAW (Shielded Metal Arc Welding) ☐
- GMAW (Gas Metal Arc Welding) ☐
4. Trailer hitch painted in area of welds and square tube (inner) ☐
5. Preservation agent applied to trailer hitch in areas of welds ☐
6. Visual inspection performed by service manager ☐

I hereby confirm that the check and quality items were observed on the vehicle with
the VIN: 4JG
(Insert Vehicle VIN number)

Certified Welder

Date:

Name of Welder: Signature:

Accredited Welding Test Facility:

Welder's certification number (if applicable) from

Accredited Welder Test Facility:

Name of welding company (if applicable):

Service Manager

Date: Name: Signature:

Dealer number:

Place and maintain completed form in vehicle file.