

Recall Campaign Bulletin



Campaign No. 2023010006, January 2023

Revision A 4/30/2025

TO: ALL MERCEDES-BENZ CENTERS

SUBJECT: **Model C-Class, CLK-Class, E-Class, CLS-Class (203, 209, 211, and 219 platform)
Model Year 2001-2011**

Check Sliding Roof Bonding

Mercedes-Benz AG ("MBAG"), the manufacturer of Mercedes-Benz vehicles, has determined that on certain Model Year ("MY") 2001 – 2011 C-Class (203 platform), CLK-Class (209 platform), E-Class (211 platform) and CLS-Class (219 platform) vehicles, the bonding between the glass sunroof panel and the sliding roof frame might not meet specifications. In this case, the adhesion of the bond might deteriorate gradually over time. Therefore, the specified durability requirements of the bond would not be guaranteed. As a consequence, a separation of the glass panel from the vehicle cannot be ruled out. This could increase the risk of a potential accident and/or injury for other road users. When the adhesion begins to deteriorate, the customer might observe a partially detached panel or excessive wind noises in the area of the sunroof while driving.

Prior to performing this Campaign:

- VMI must always be checked before performing campaigns to verify that the campaign is required on a specific vehicle. Always check for any other open campaigns and perform accordingly.
- Please review the entire Campaign bulletin and follow the repair procedure exactly as described.

Approximately 99,967 vehicles are affected.

Order No. P-RC-2023010006

This bulletin has been created and maintained in accordance with MBUSA-SLP S423QH001, Document and Data Control, and MBUSA-SLP S424HH001, Control of Quality Records.

Recall Campaign Bulletin

Check sliding sunroof, replace if necessary

Revision Notes:

- Information about **TIPS case** creation added.

i If it is not possible to perform the work as described in these instructions, the further repair procedure must be clarified via **TIPS case**, specifying the codeword **22P7891009**.

i Code 414 corresponds to GLASS ELECTRIC SLIDING ROOF.

Check/Test Procedure A

1. Move sliding sunroof to tilt position and check production date (figure 1).

i The production date **must** be on or after **11/25/2005** or on or before **10/31/2007**.

i Vehicles with a registration date that does **not** match with the production date of the sliding sunroof can also be affected.

i If the production date is **not** at the location shown (figure 1), this vehicle is **not** affected.

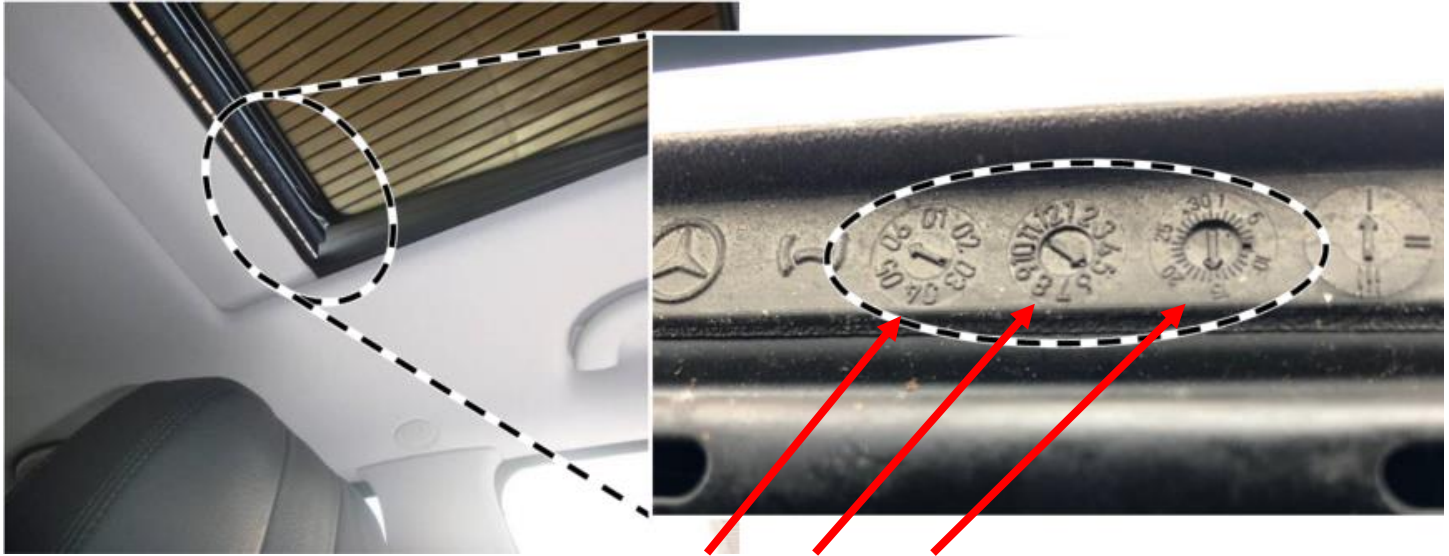


Figure 1 (The production date in the sample picture is (06 year / 5 month / 15 day) **5/15/2006**)

- a. Production date between **11/25/2005** and **10/31/2007**: Perform **check/test procedure B**.
- b. Production date **not** between **11/25/2005** and **10/31/2007**: **End measure**.
- c. **No** production date present at location shown (figure 1): **End measure**.

i The **findings** from the check/test procedure must be noted **in writing on the workshop order** and then stored **in a tamperproof manner**.

Check/Test Procedure B

- i** A suitable lifting tool (engine crane) is required for the check.
If the lifting tool (engine crane) does not fit under the vehicle because the ground clearance is too low, move the vehicle so that its front axle is on a suitable object (e.g. wooden beam).
1. Perform function test for sliding sunroof.

i For this purpose, fully open and close sliding sunroof. The sliding sunroof must function correctly. This check serves as a comparison; it ensures that the customer cannot claim compensation for any preexisting noticeable problems (e.g. reversing, sluggishness, etc.) after the check performed with the suction cup tool. Notify the customer if any preexisting problems exists concerning their sliding sunroof.

i The sliding sunroof must be closed.
 2. Clean the sliding sunroof panel and suction cup tool.

i Special caution must be exercised during the check. The suction cup tool may be used for this check.
 3. Position suction cup tool (figure 2) and pull as **vertically** as possible (tolerance of ± 10 degrees) using lifting tool.

i The hanging scale **must** be adjusted as per the operating instructions before use.

i Specified force 500 N/700 N (figure 3).

i Before the start of the measurement, the "(auto) hold function" of the hanging scale (see operating instructions) **must** be deactivated.
No "hold function" may be activated so that the current tractive force is always displayed.

i Position suction cup tool at 5 positions in the sequence **1, 2, 3, 4, 5**: (Figure 3).

i The specified force must be monitored during the first minute and adjusted if necessary (tolerance ± 10 N). The specified force must not be exceeded. Pull as vertically as possible (tolerance ± 10 degrees) with the specified force. No person should be inside the vehicle during the check, and the vehicle must not be touched if possible.

i The holding time per position must be exactly **10 min**!
After the first minute, the holding force per position must be further monitored and readjusted if necessary (tolerance ± 10 N).

i The technician can leave after the first minute if the holding force remains within the tolerance. The test **does not have to be** monitored during the entire period (5 x 10 min). The technician can perform a different task during the test.

Attention, danger: Wear safety glasses and stay clear of the area above the cup suction tool (head/face) during the check.



Figure 2

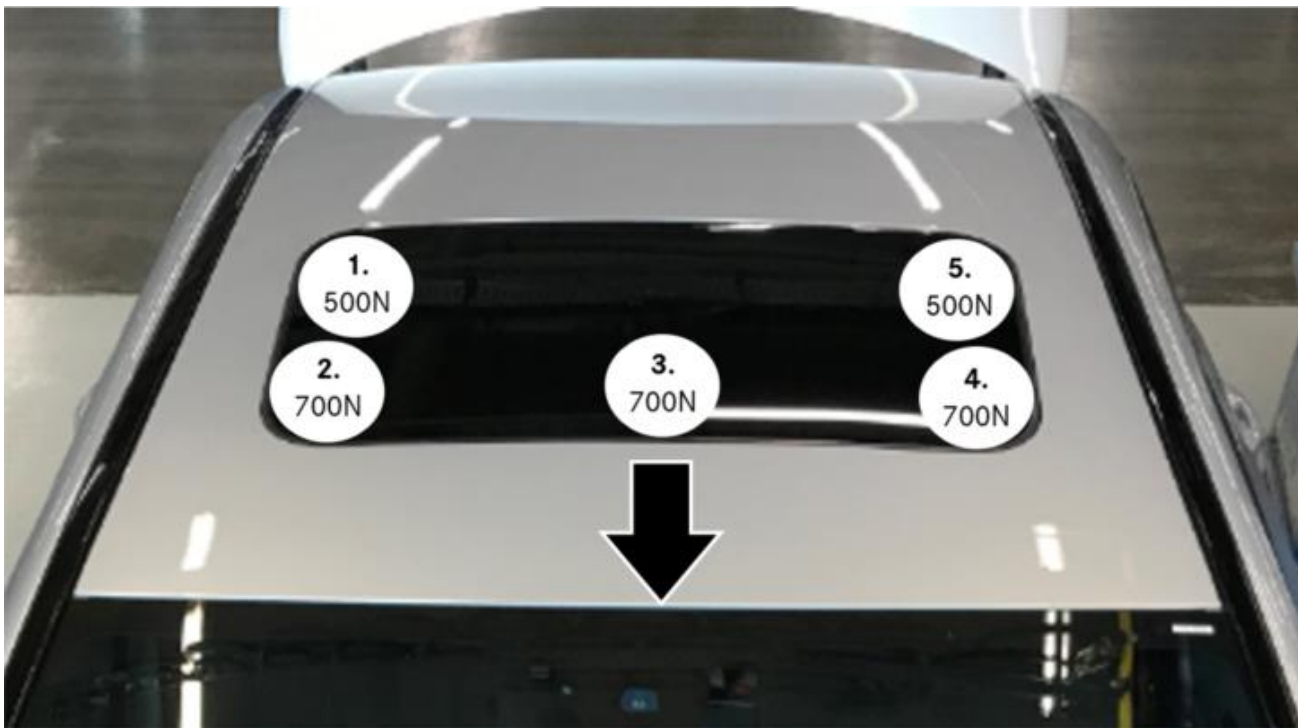


Figure 3 (test sequence 1, 2, 3, 4, 5 – arrow specifies direction of travel)

- i** The sliding sunroof panel is lifted out of the roof frame noticeably at the rear test positions 1 and 5 (figure 4).
- i** If the sliding sunroof panel detaches from the padding of the tilting/sliding sunroof frame at one of the test positions (see figure 5), the sliding sunroof panel must be replaced.

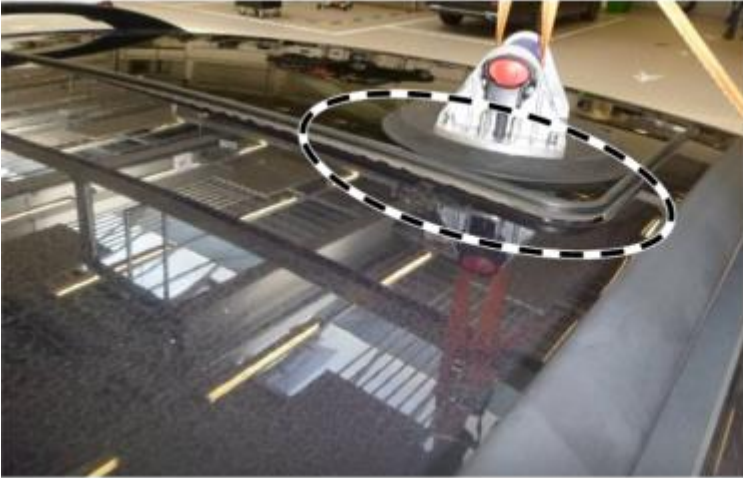


Figure 4

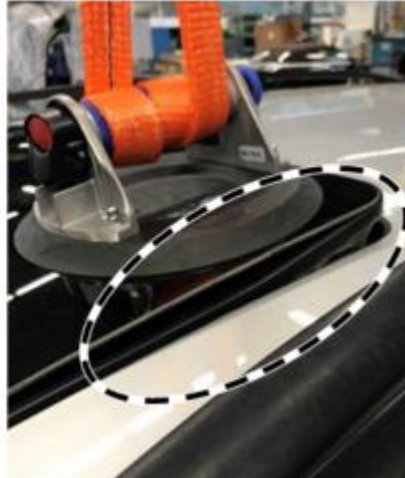


Figure 5 (not OK)

- d. If the sliding roof panel detaches from the padding: Carry out **work procedure**.
- e. If the sliding roof panel does **not** detach from the padding: **End measure**.

i The **findings** from the check/test procedure must be recorded **in writing in the workshop order** and then stored **in a tamperproof manner**.

4. Perform function test for sliding sunroof.

i To do this, open and close the sliding sunroof (tilt and slide positions).

Work Procedure

1. Replace sliding sunroof.

i The accordion boot **need** not be removed completely. It is sufficient to slide it back (figure 6).

i It is not necessary to prepare the strip of cardboard.

The WIS documentation is being adapted.

Model 203: AR77.20-P-1000P

Model 209: AR77.20-P-1000Q

Model 211: AR77.20-P-1000T

Model 219: AR77.20-P-1000TX



Figure 6

2. Connect XENTRY Diagnosis.
3. Perform teach-in run for automatic reversing function on sliding sunroof.
 - i** To do this, select menu item "Quick test view – Overhead control panel – Control unit adaptations – Sliding sunroof – Normalization of automatic reversing function for sliding sunroof".
 - i** Then follow the user guidance in XENTRY Diagnosis.
4. Disconnect XENTRY Diagnosis.

Primary Parts Information

Qty.	Part Name	Part Number
As required (1)*	Sliding sunroof panel (models 203, 211)	A 211 780 03 00
As required (1)*	Sliding sunroof panel (model 209)	A 209 780 02 00
As required (1)*	Sliding sunroof panel (model 219)	A 219 780 01 00

* Includes 6 screws. Screws must be replaced.

i Small parts such as screws, lock nuts, sealing rings, cable ties, fluids, sealant, etc. are not listed in the parts list. The required small parts are taken into account in the budgeting.

i **Note:** The following allowable labor operation should be used when submitting a warranty claim for this repair:

Warranty Information

Damage Code	Operation Number	Description	Labor Time (hrs.)
78 910 09	02-1632	Check manufacturing date of sliding sunroof	0.1
	02-1638	Check sliding sunroof	0.8
	02-1639	Replace sliding sunroof (after check) Models 203; 209; 211; 219 Includes: Perform teach-in run for automatic reversing function on sliding sunroof (XENTRY connected)	1.0

i **Note:** Always check ASRA for the current OP-Code times. Labor times are subject to change and updates may not be reflected in this document.

Special tools

Qty.	Part Name	Part Number
1	Tool kit	W 000 588 01 99 00