



Mercedes-Benz

Campaign No. 2024090013, October 2024

TO: ALL MERCEDES-BENZ CENTERS

SUBJECT: **Model GLC (254 platform)**
Model Year 2024

Replace Front Axle Integral Carrier

Mercedes-Benz AG, the manufacturer of Mercedes-Benz vehicles, has determined that on certain MY 2024 GLC (254 platform) vehicles, the integral carrier welds might not meet current production specifications. In this case, the durability of the integral carrier might be affected over the vehicle's lifetime. As a result, the controllability of the vehicle might be affected, which could increase the risk of a crash. An authorized Mercedes-Benz dealer will replace the integral carrier on the potentially affected vehicles.

Prior to performing this Campaign:

- VMI must 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 4 vehicles are affected.




Order No. P-RC-2024090013

Replace Front Axle Integral Carrier







Model 254

Work Procedure

1. Replace front axle integral carrier (Figure 1, 1).

-  Basic data for model 254 with engine 139, see AR33.10-P-0100WTF.
-  Basic data for model 254 with engine 254.9, see AR33.10-P-0100WTF.
-  **Do not** use a pneumatic wrench to **release or screw-in** threaded connections (self-tapping) on front axle carrier. There is a risk of thread damage!

Installation Notes:

-  Clean threads on body-in-white with compressed air and inspect for any thread damage/chipping.
 -  Before threading in new bolts, check that the front axle carrier is in contact with the body-in-white and the hole patterns are aligned properly!
 -  Thread new screws **by hand** with 3 to 4 thread turns before using a **manual** tool (e.g. ratchet) for tightening.
 -  Tighten screws with the specified torque outlined in WIS.
2. Perform wheel alignment measurement.
 -  For basic data, see AR40.20-P-0200WTF.
 3. Apply cavity preservation wax at connections to body.
 -  For basic data, see AR62.30-P-0010WTF.

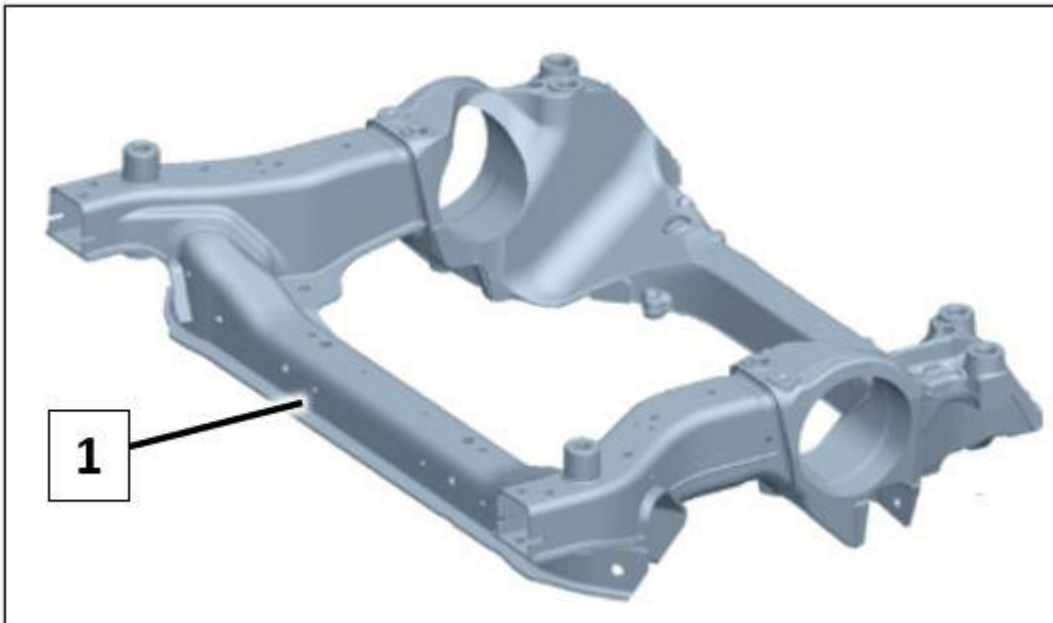


Figure 1

Primary Parts Information

Qty.	Part Name	Part Number
1	Integral carrier	A 254 620 00 00
2	Integral carrier screws	A 000 990 15 37
2	Integral carrier screws (M12X85)	A 000 990 76 18
1	Cavity preservation (1 Liter)	A 000 986 72 70

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.)
33 900 28	12-2262	Operations: Replace front axle integral carrier Includes: Remove/install front axle, disassemble/assemble front axle, apply cavity preservation	ZM
	12-1601*	Operations: Perform wheel alignment measurement, acc. no.:, code:	0.9

* Please enter the code and accounting number manually in the workshop order as per the work instructions.

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