

Recall Campaign Bulletin



Mercedes-Benz

Campaign No. 2024120003, December 2024

TO: ALL MERCEDES-BENZ CENTERS

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

Check Sliding Roof Bonding

Mercedes-Benz AG, the manufacturer of Mercedes-Benz vehicles, has determined that on certain 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. An authorized Mercedes-Benz dealer will check the glass panel bonding on the affected vehicles and replace the sliding roof, if necessary.

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 10,334 vehicles are affected.

Order No. P-RC-2024120003

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Check Sliding Sunroof Bonding

Models: 203, 209, 211, 219 with code 413 (PANORAMIC SLIDING SUNROOF – GLASS ROOF)

Check/Test Procedure A

1. **Open** panoramic sliding sunroof **approx. 3 cm** and check manufacturing date (**Figure 1**).

- i** Carry out check with a mirror as shown in Figure 2.
- i** To position the mirror, the wind deflector must be pushed downward by hand.
- i** Vehicles with a registration date that does **not** match with the manufacturing date of the panoramic sliding sunroof can also be affected.

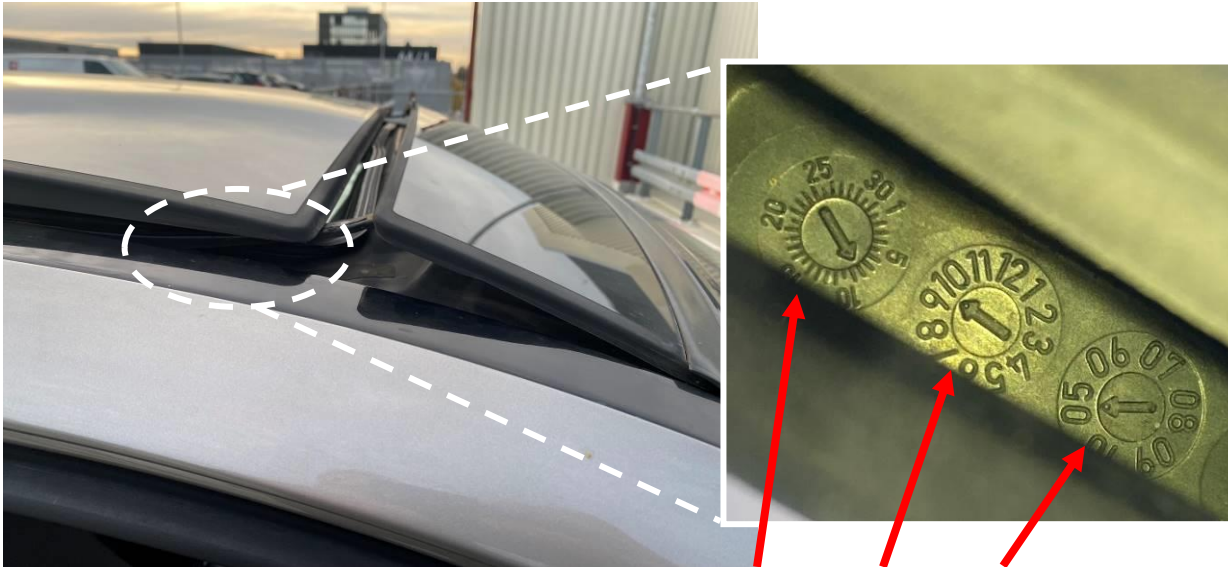


Figure 1 (The manufacturing date in the sample picture is (8th day / 10th month / 05th year) 10/08/2005)



Figure 2

- a. Manufacturing date is **on or after 06/30/2005**: Carry out **Check/Test Procedure B**.
- b. Manufacturing date is **on or before 06/29/2005**: **End measure**.

- i** The **findings** from the **Check/Test Procedure A** must be documented **in writing on the workshop order**.

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 a function test by fully opening and closing the panoramic sliding sunroof and roller sunblind.
The sliding sunroof must function correctly before continuing!
i This check serves as a comparison to ensure that the customer cannot claim compensation for any preexisting problems (e.g. cosmetic damage, inadvertent reversing, sluggishness, etc.) after the **Check/Test Procedure B** is performed. If any preexisting problems for the sliding sunroof are found during this function test, inform the customer.
i The panoramic sliding sunroof and roller sunblind must be fully closed before continuing.
 2. The suction cup tool will be used for this check. Clean the sliding sunroof glass panel and suction cup tool.
i Special caution must be exercised during the check.
 3. Position suction cup tool (**Figure 3**) and pull as **vertically** as possible (tolerance of ± 10 degrees) using lifting tool.
i The hanging scale **must always** be adjusted per the Operator's Manual before use.
i Specified force **500N/700N (Figure 4)**.
NOTE: Do not convert the specified force! This **must** be measured in Newtons (N) or there is potential for damage.
i Before the start of the measurement, the "(auto) hold function" of the hanging scale **must** be deactivated, if applicable (see operating instructions).
The "hold function" must **not** be activated so that the current tractive force is always displayed!
i Position suction cup tool at 4 positions in the sequence **1, 2, 3, 4: (Figure 4)**.
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 for each location. There **must not** be a person inside the vehicle during the check, and the vehicle **must not** be touched when possible.
i The holding time per position must be exactly **10 minutes!**
During the first minute, the holding force must be further monitored at each position and readjusted if necessary (tolerance ± 10 N).
i The technician can leave and perform a different task **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 x10 min).

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

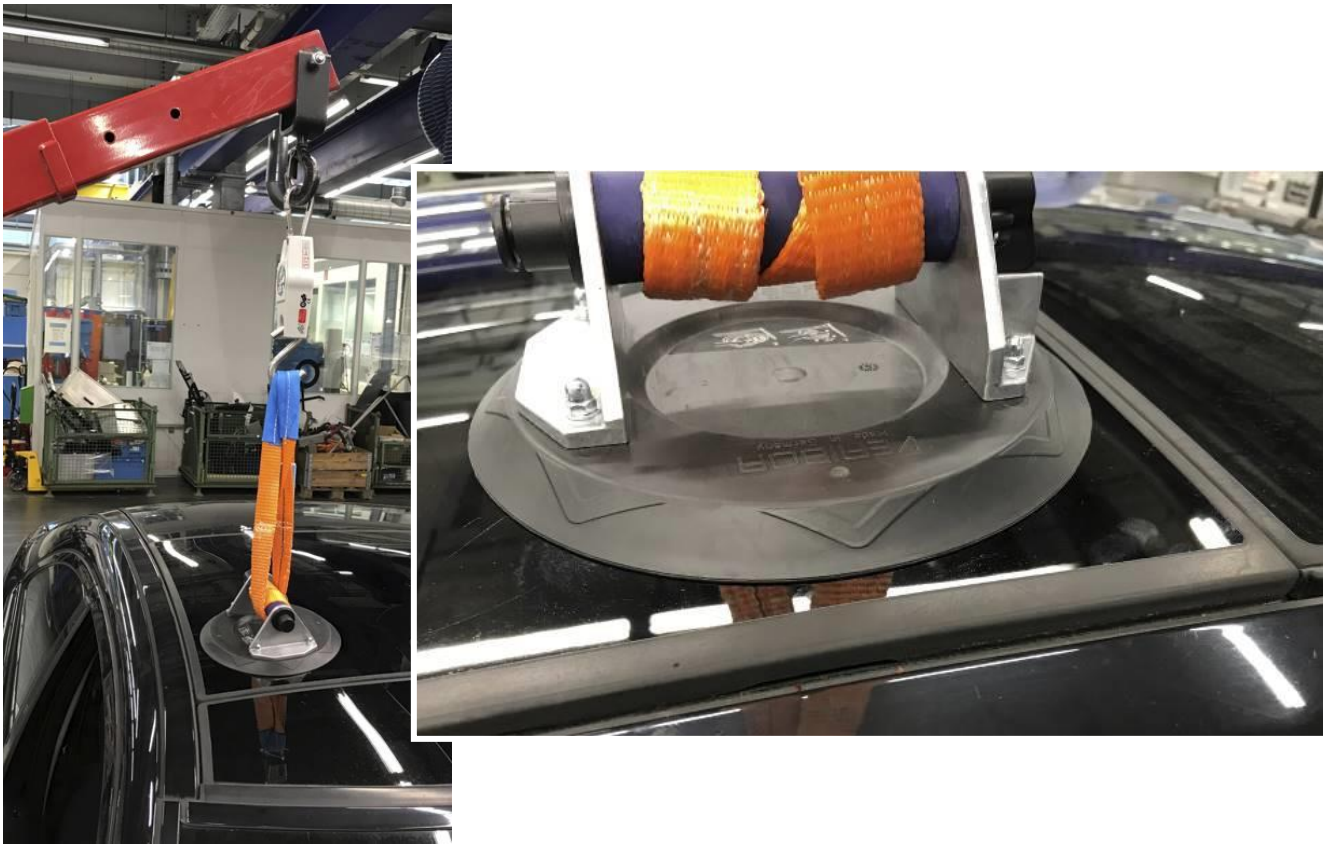


Figure 3

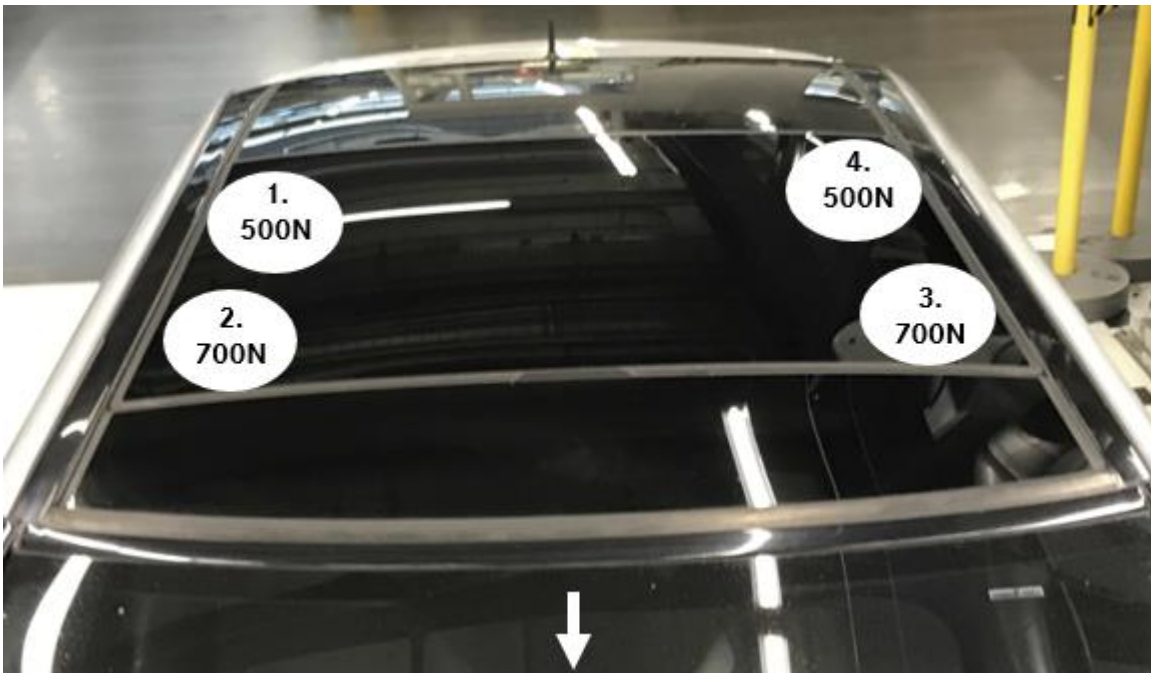


Figure 4 (Test sequence 1, 2, 3, 4 - arrow indicates direction of travel)

i If the panoramic sliding sunroof panel is detached from the padding of the sliding sunroof/ tilting roof frame at one of the test points (see Figure 5), replace the sliding sunroof panel.

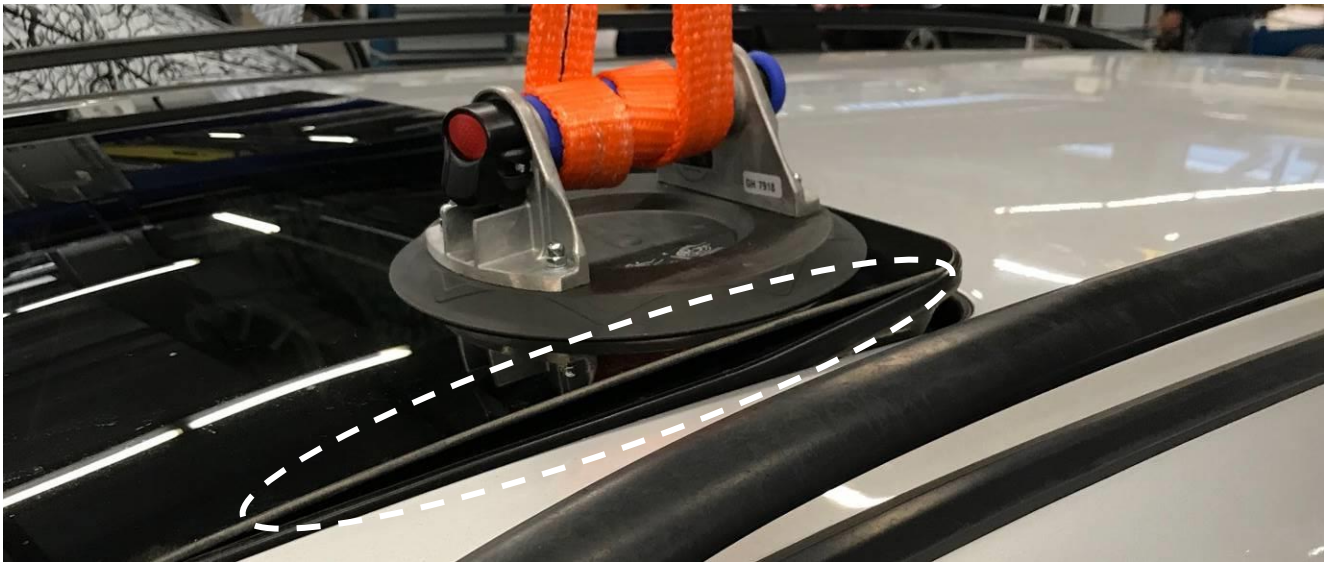


Figure 5, not OK (shown here at test sequence position 4)

- a. If the panoramic sliding sunroof panel is detached from the padding: Carry out **Work Procedure**.
- b. If the panoramic sliding sunroof panel is **not** detached from the padding: Perform **Operation Step 4** and **End Measure**.

4. Perform function test of panoramic sliding sunroof.

i To do so, fully open and close panoramic sliding sunroof (tilt and slide positions).

Work Procedure

1. Replace panoramic sliding sunroof panel (AR77.21-P-0500PB).

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.

Special Tools Information

Qty.	Part Name	Part Number
As required (1*)	Tool kit – suction cup tool & hanging scale	W 000 588 01 99 00

* Tool kit - cup suction tool **W 000 588 01 99 00** is identical for the campaigns 2020040011, 2021040012, 2023010005, and 2023010006. The special tool should therefore already be available in most dealers.

Primary Parts Information

Qty.	Part Name	Part Number
As required (1)	Panoramic sliding sunroof panel	A 203 780 01 21
As required (1)	Screws (repair kit)	A 203 780 02 16

 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.

 **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 14	12-1586	Check manufacturing date of panoramic sliding sunroof (Check/Test Procedure A)	0.1
	12-1587	Check vertical force of panoramic sliding sunroof (Check/Test Procedure B)	0.8
	12-1588	Replace panoramic sliding sunroof (after check) Includes: Perform teach-in run for automatic reversing function on panoramic sliding sunroof (XENTRY connected)	1.6

 **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.