

# Recall Campaign Bulletin



Mercedes-Benz

Campaign No. 2024120001, December 2024

Revision A 5/5/2025

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 33,447 vehicles are affected.

Order No. P-RC-2024120001

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## Check Sliding Sunroof Bonding

Models: 203, 209, 211, 219 with code 414 (GLASS ELECTRIC SLIDING ROOF)

### Revision Notes:

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

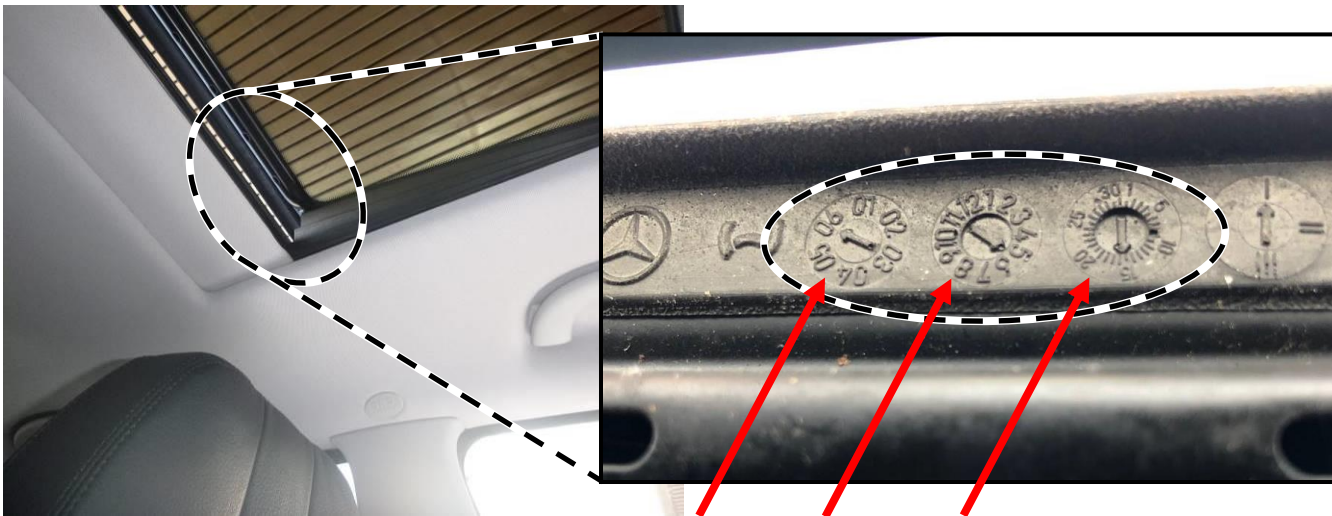
**i** If it is not possible to perform the work as described in these instructions, the further repair procedure must be clarified via **TIPS case**, specifying the codeword **24P7891012**.

### Check/Test Procedure A

- Move sliding sunroof to tilt position and check production date (**Figure 1**).

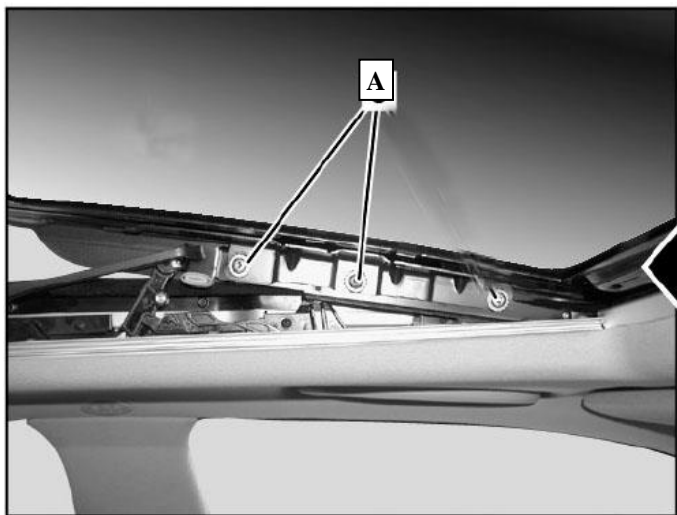
**i** The production date **must** be on or after 11/25/2005 or on or before 10/31/2007.

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



**Figure 1** (The production date in the sample picture is (06<sup>th</sup> year / 5<sup>th</sup> month / 15<sup>th</sup> day); **05/15/2006**)

**i** If the sliding sunroof is **not** functioning, loosen the two rear sliding sunroof panel screws (**Figure 2, A**), lift the sliding sunroof manually and then read off the production date.



**Figure 2**

- Production date on or between **11/25/2005** and **10/31/2007**:  
Perform **Check/Test Procedure B**.
- Production date **not** on or between **11/25/2005** and **10/31/2007**: **End measure**.
- No** production date present at location shown (**Figure 1**):  
**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 sliding sunroof.

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 sliding sunroof 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  $\pm 10$  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 5 positions in the sequence **1, 2, 3, 4, 5: (Figure 4)**.

**i** The specified force must be monitored during the first minute and adjusted if necessary (tolerance  $\pm 10$  N). The specified force must not be exceeded. Pull as vertically as possible (tolerance  $\pm 10$  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  $\pm 10$  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 x 10 min).

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

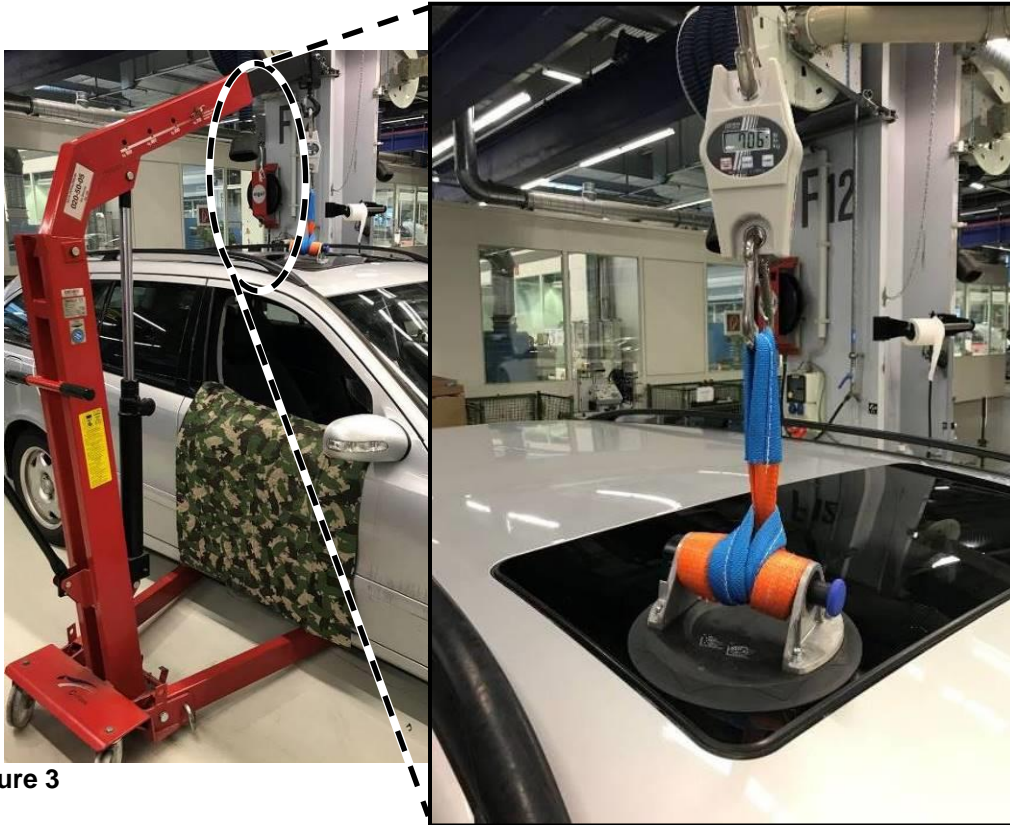


Figure 3

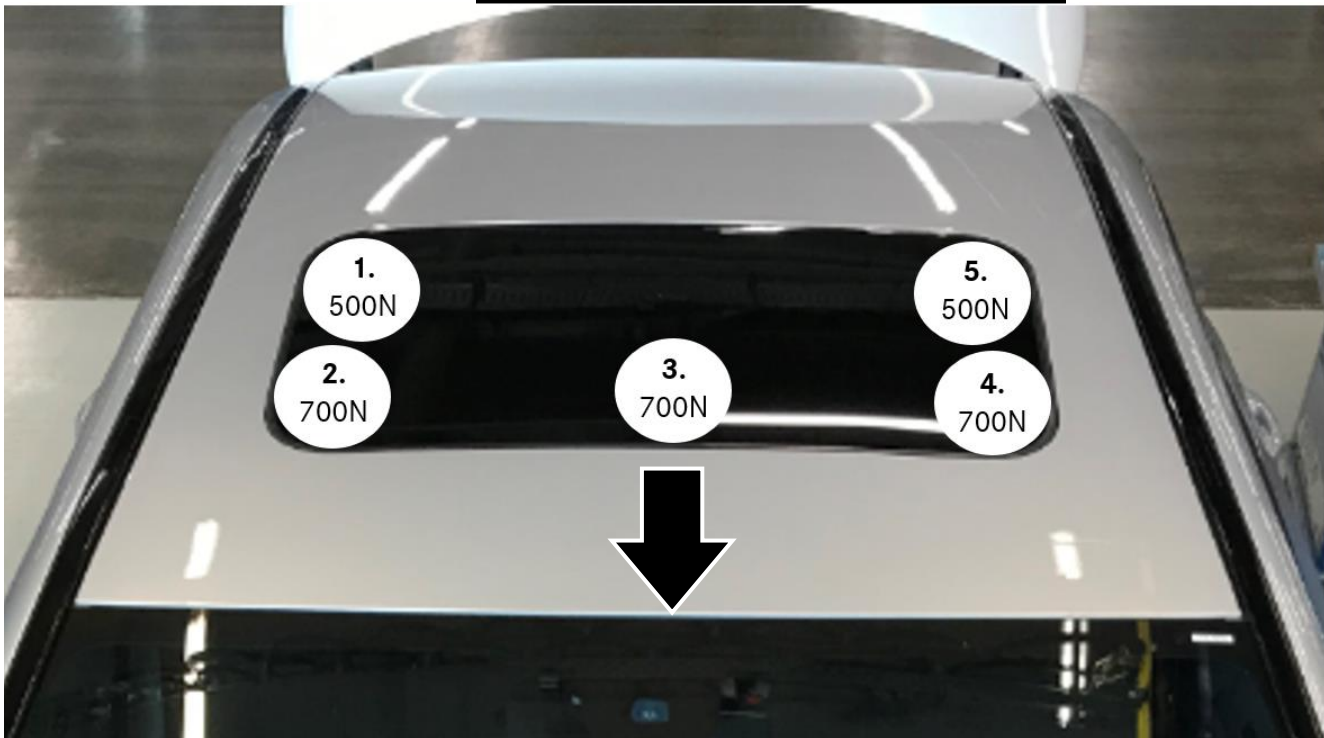
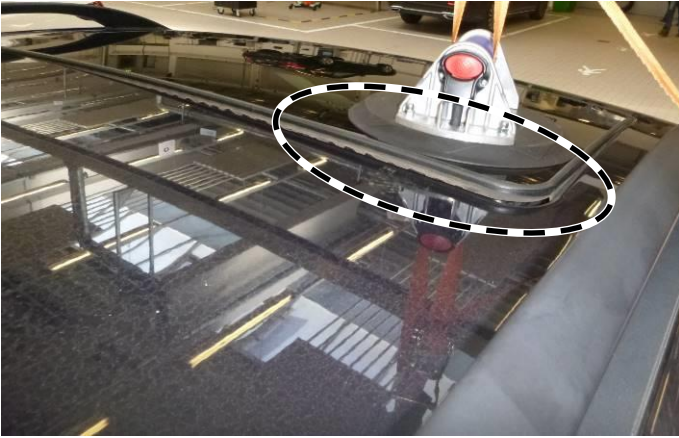


Figure 4 (test sequence 1, 2, 3, 4, 5 – arrow indicates front of vehicle)

**i** The sliding sunroof panel is lifted out of the roof frame noticeably at the rear test positions 1 and 5 (Figure 5).

**i** If the sliding sunroof panel detaches from the padding of the tilting/sliding sunroof frame at one of the test positions (see example Figure 6), the sliding sunroof panel must be replaced.



**Figure 5** (Sliding panel is lifted out of the frame at rear test position 1 and 5 – OK)



**Figure 6** (*not* OK)

- a. If the sliding roof panel detaches from the padding: Carry out **Work Procedure**.
- b. If the sliding roof panel does **not** detach from the padding: **End measure**.

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

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 **does not need to be removed** completely. It is sufficient to slide it back (**Figure 7**).

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 7**

2. Connect XENTRY Diagnosis.
3. Perform teach-in run for automatic reversing function on sliding sunroof.  
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".  
Then follow the user guidance in XENTRY Diagnosis.
4. Disconnect XENTRY Diagnosis.

**Special Tools Information**

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

**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 12	02-1632	Check manufacturing date of sliding sunroof (Check/Test Procedure A)	0.1
	02-1638	Check vertical force of sliding sunroof bonding (Check/Test Procedure B)	0.8
	02-1639	Replace sliding sunroof (after check) Models 203; 209; 211; 219 <b>Includes:</b> Perform teach-in run for automatic reversing function on sliding sunroof (XENTRY connected)	1.0

**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.