

<p>To: Mercedes-Benz Dealers, General Managers, Sales Managers, Service Managers, Parts Managers</p>	<p>From: Anthony Washington, Senior Manager, Regulations and Certifications</p>
<p>Re: Service Campaign Notification Model: Metris Model Year: 2021 Replace Longitudinal Member Weld Nuts</p>	<p>Date: February 2025</p>

IMPORTANT SERVICE CAMPAIGN INFORMATION



Mercedes-Benz

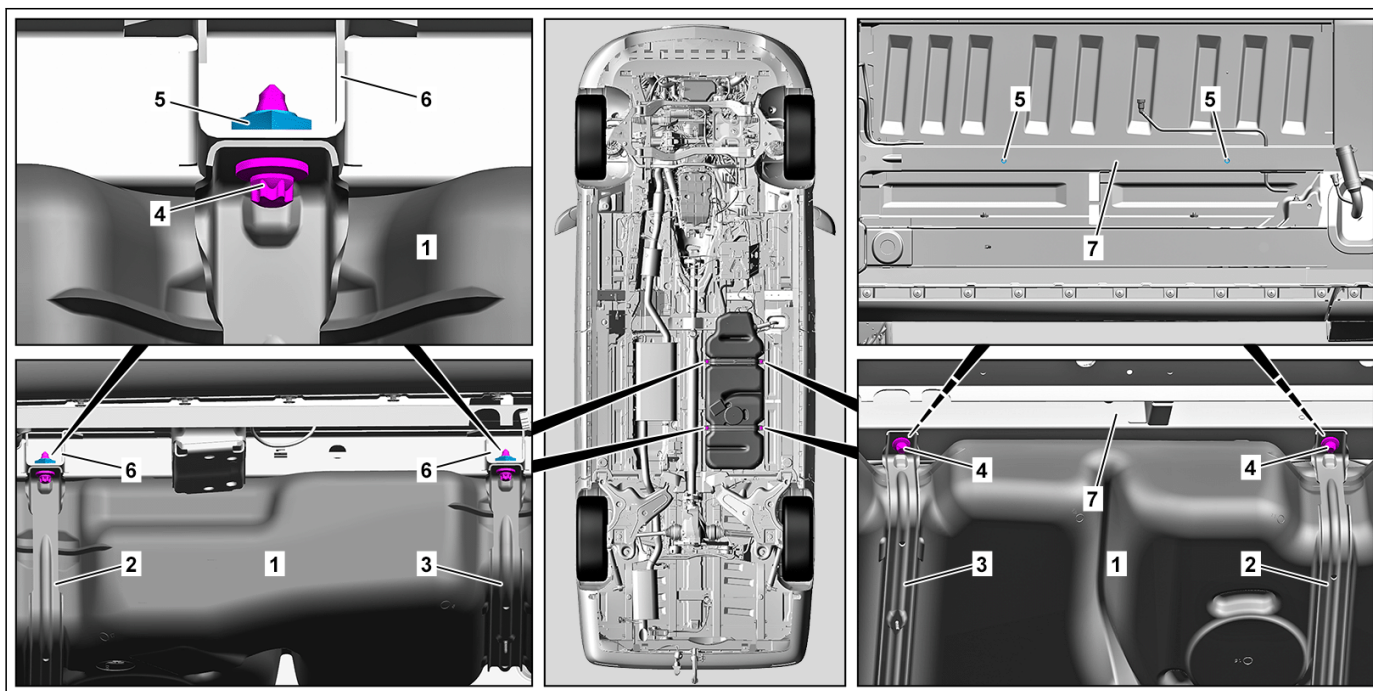


Campaign No.:	Campaign Desc.:	NHTSA ID:	Replace Longitudinal Member Weld Nuts
2025020011	VS2SPANBA	N/A	
This is to notify you of a Service Campaign to replace weld nuts on the longitudinal member on 1 MY 2021 Metris Van. All affected VINs will be flagged as "OPEN" in VMI			
Background			
Issue	Mercedes-Benz AG, the manufacturer of Mercedes-Benz Metris Vans, has determined that the weld nuts on the longitudinal member were not installed according to current production specifications.		
What We're Doing	MBUSA is conducting a service campaign. An authorized Mercedes-Benz dealer will replace and install new weld nuts on the longitudinal member.		
Parts	Part is available.		
Vehicles Affected			
Model Year(s)	2021		
Vehicle Model	Metris		
Vehicle Populations			
Total Vehicles	1		
Dealer Inventory	0		
Next Steps/Notes			
AOMS/SOMS	Please ensure your dealers have read and understand this notice		
While we regret any inconvenience this may cause, MBUSA are determined to maintain a high level of vehicle quality and customer satisfaction.			



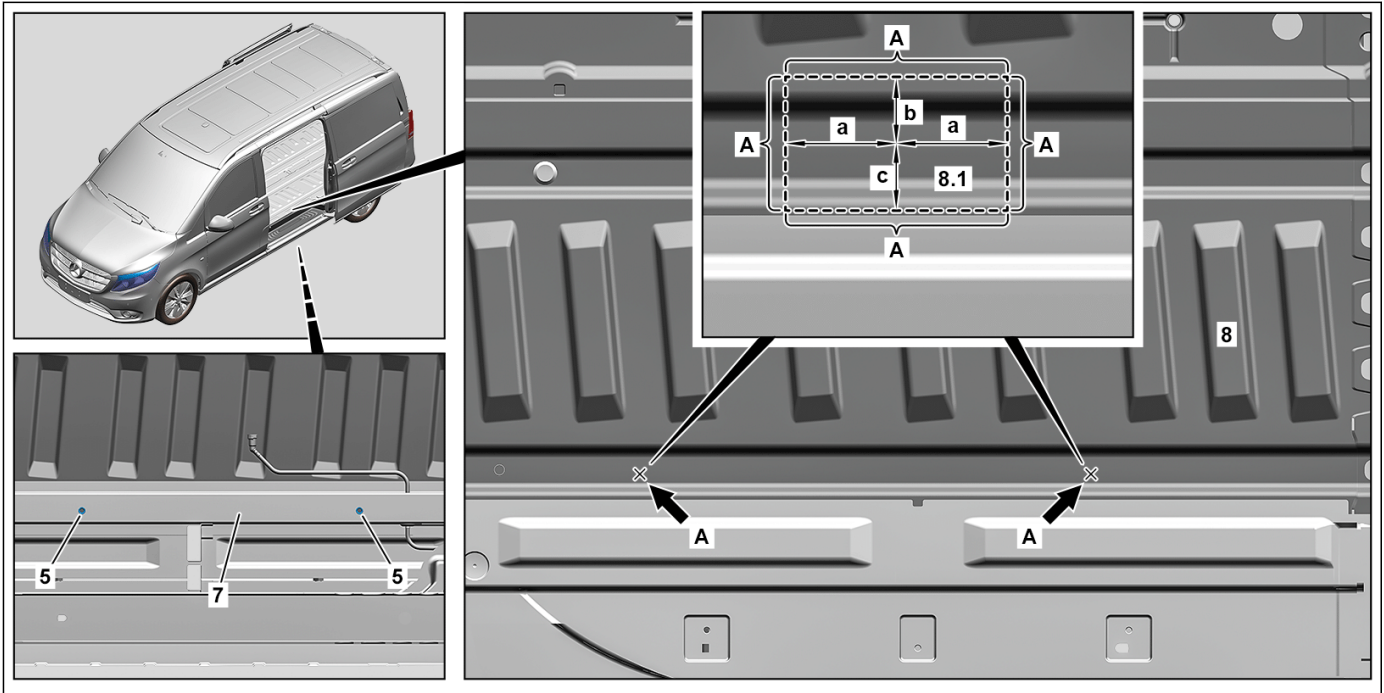
Operation no. of the operation texts or standard texts and flat rates

Category	Op. no.	Operation text	Time	Damage Code	Codeword
P	02 0032	Operations: Check weld nuts on longitudinal member for attachment of fuel tank retaining bracket	0.6 hr	47 901 05	VS2SPANBA
P	02 0033	Operations: Replace weld nut in longitudinal member (after check)	6.6 hr	47 901 05	VS2SPANBA
P	02 0034	Operations: Replace weld nut in holder at longitudinal member (after check)	2.3 hr	47 901 05	VS2SPANBA
P	02 0035	Operations: Replace weld nuts in longitudinal member and in longitudinal member holders (after check)	9.0 hr	47 901 05	VS2SPANBA



S61.10-A098-79

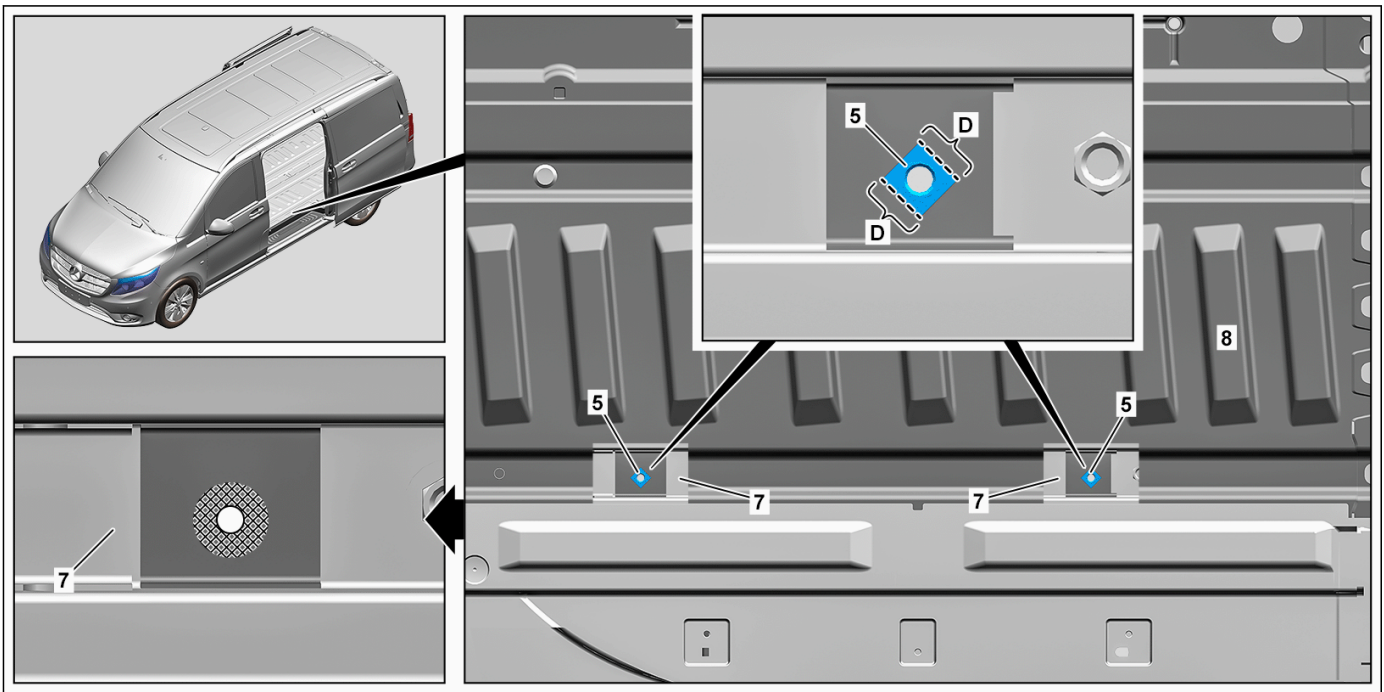
- | | | |
|---------------------------|------------|--------------------------------|
| 1 Fuel tank | 4 Screw | 6 Holder for retaining bracket |
| 2 Rear retaining bracket | 5 Weld nut | 7 Longitudinal member |
| 3 Front retaining bracket | | |



S61.10-A100-79

Shown on model 447 with code T19 (Left sliding door)

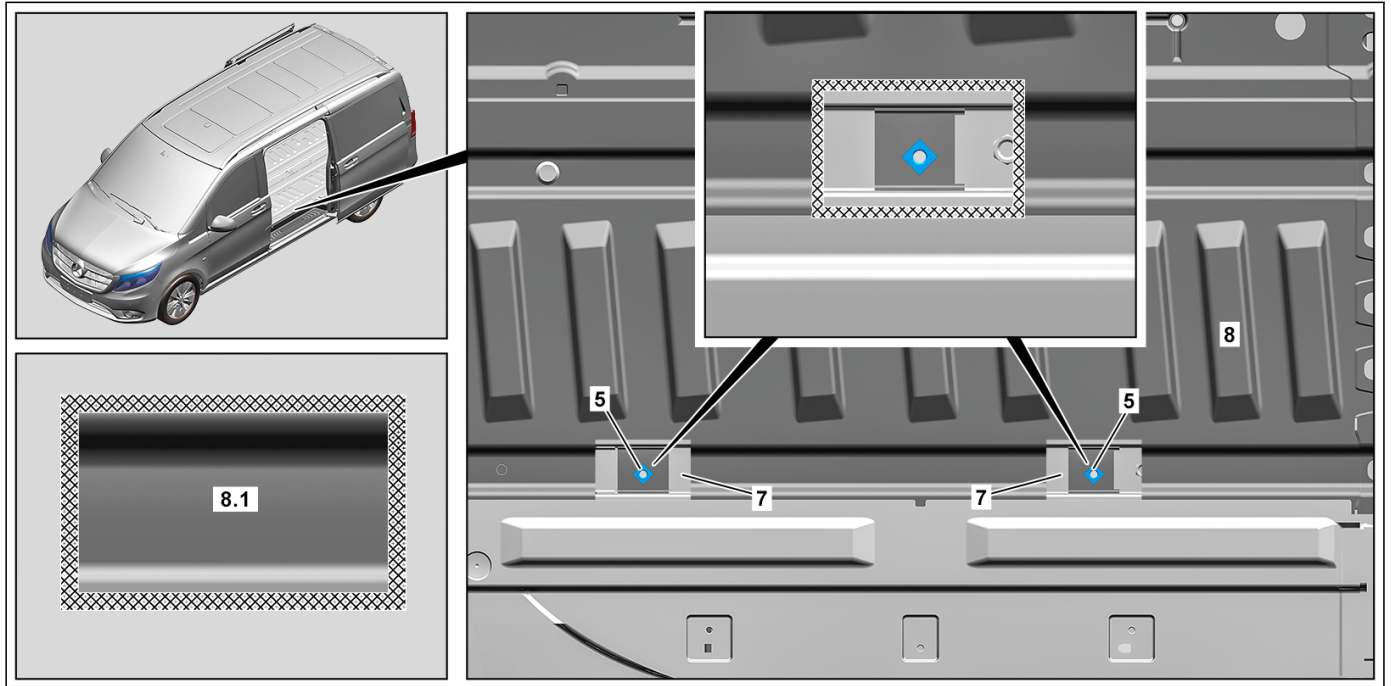
- | | | | | | |
|---|---------------------|-----|---------------------------|---|---------------------------|
| 5 | Weld nut | 8.1 | Center floor section | b | Dimension (approx. 45 mm) |
| 7 | Longitudinal member | a | Dimension (approx. 75 mm) | c | Dimension (approx. 25 mm) |
| 8 | Center floor | | | | |



S61.10-A105-79

Shown on model 447 with code T19 (Left sliding door)

- | | | | | | |
|---|----------|---|---------------------|---|--------------|
| 5 | Weld nut | 7 | Longitudinal member | 8 | Center floor |
|---|----------|---|---------------------|---|--------------|



S61.10-A102-79

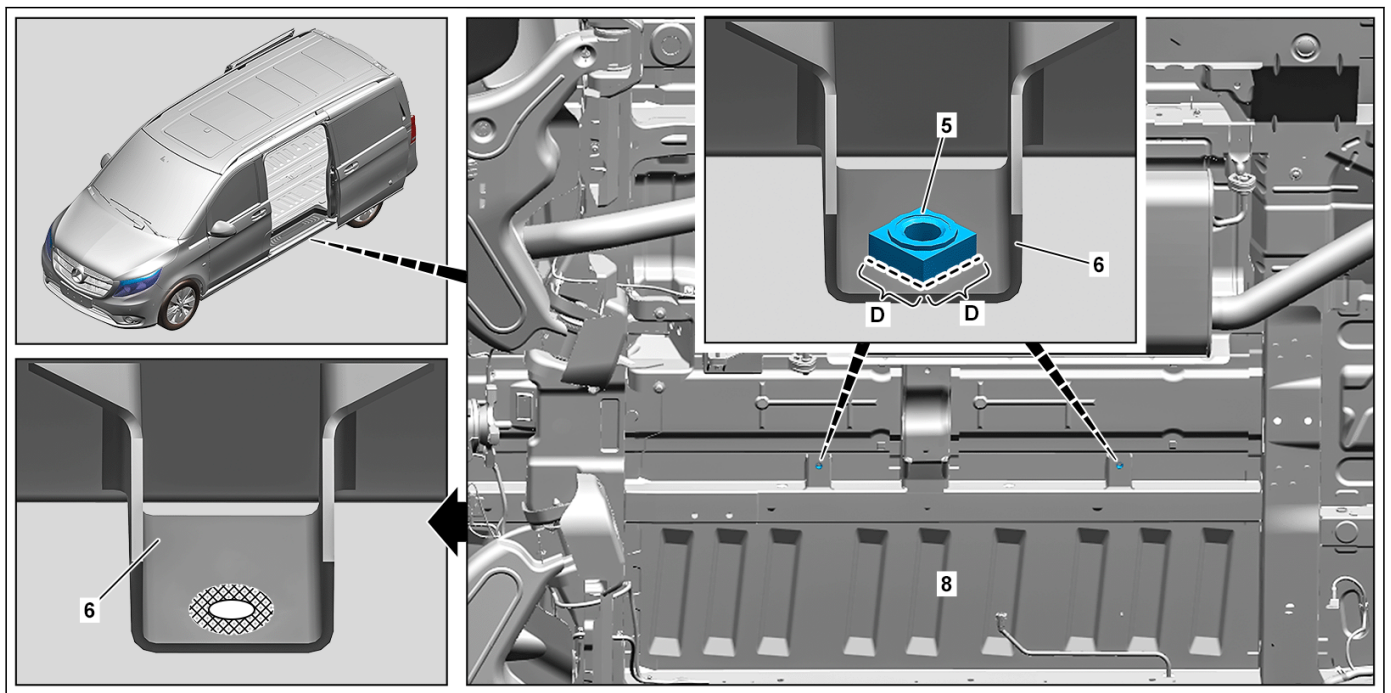
Shown on model 447 with code T19 (Left sliding door)

5 Weld nut

8 Center floor

8.1 Center floor section

7 Longitudinal member



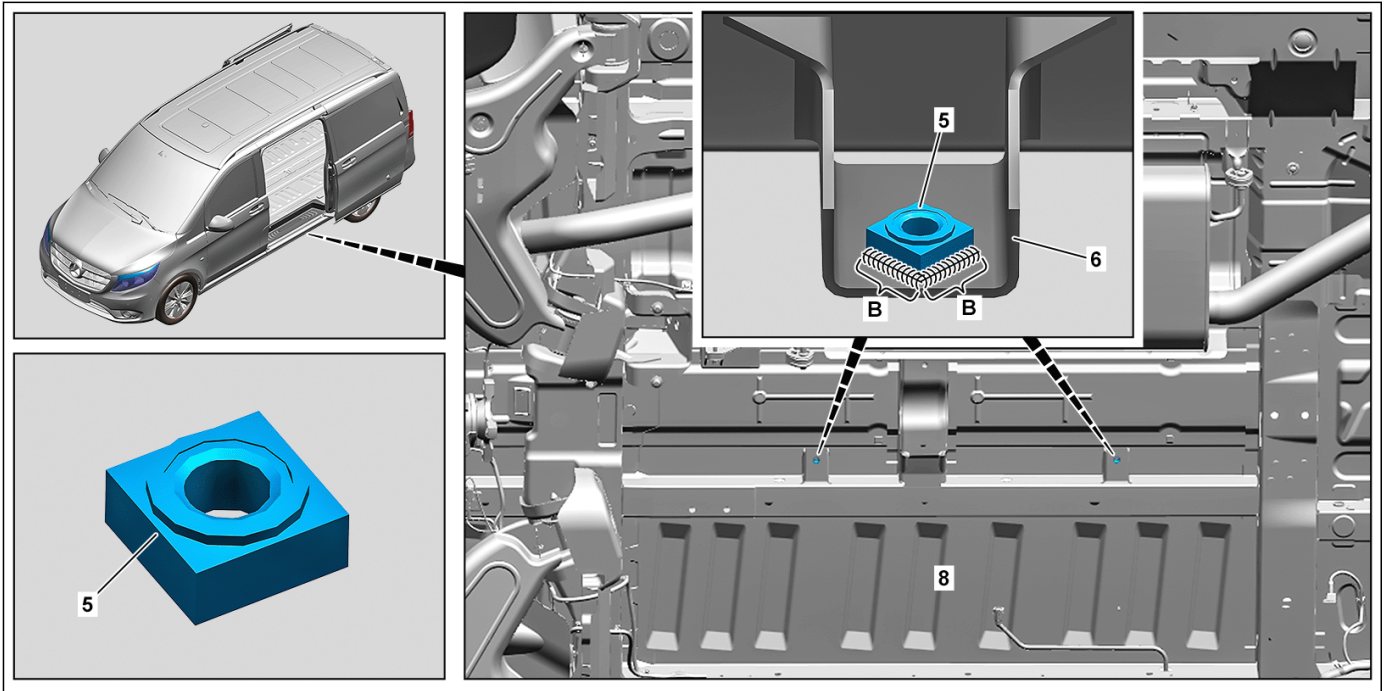
S61.10-A104-79

Shown on model 447 with code T19 (Left sliding door)

5 Weld nut

6 Holder for retaining bracket

8 Center floor



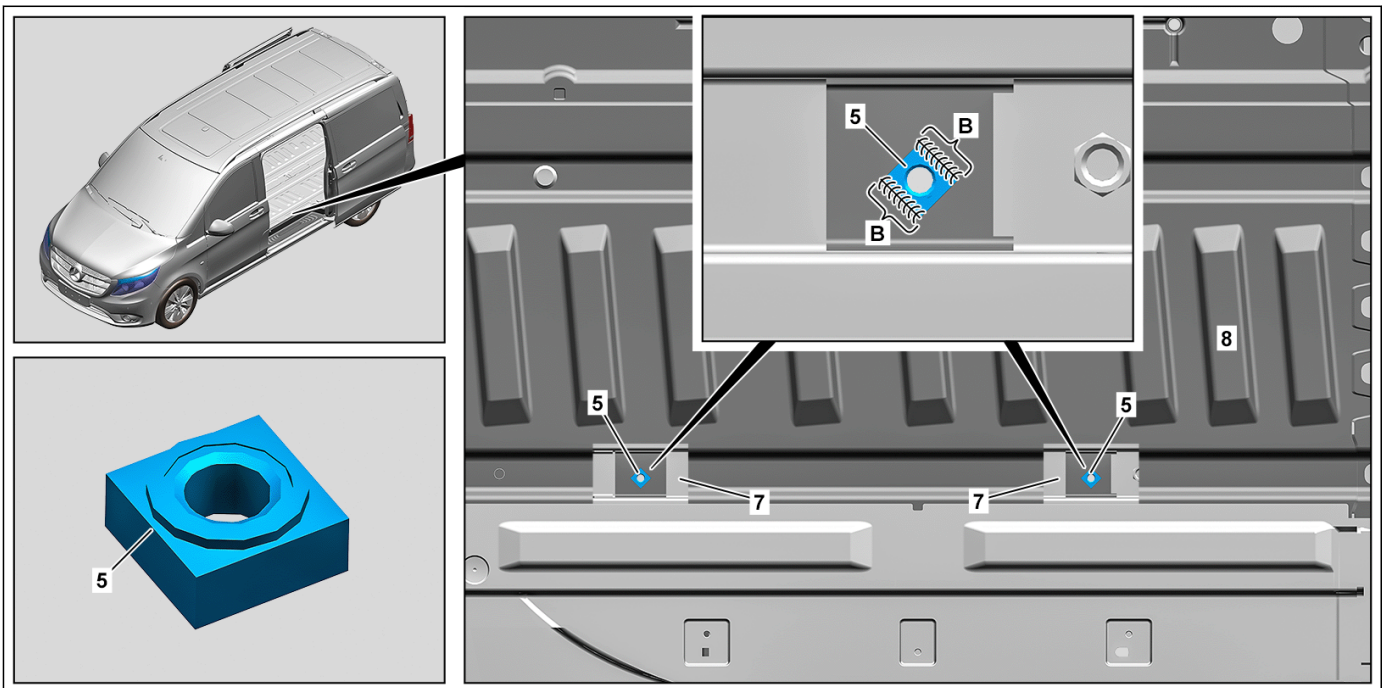
S61.10-A099-79

Shown on model 447 with code T19 (Left sliding door)

5 Weld nut

6 Holder for retaining bracket

8 Center floor



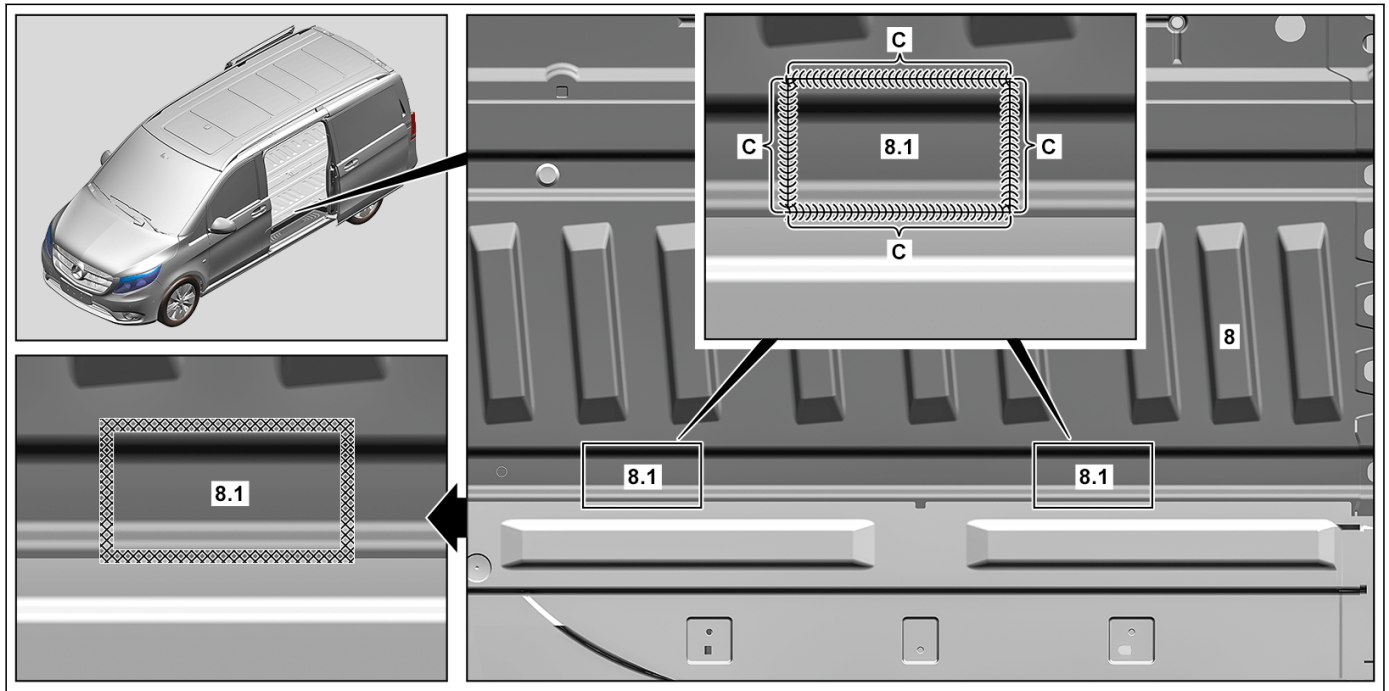
S61.10-A101-79

Shown on model 447 with code T19 (Left sliding door)

5 Weld nut

7 Longitudinal member

8 Center floor








S61.10-A103-79

Shown on model 447 with code T19 (Left sliding door)

8 Center floor

8.1 Center floor section

Danger	Risk of death caused by vehicle slipping or toppling off of the lifting platform.	Align vehicle between vehicle lift columns and position the four support plates at the vehicle lift support points specified by the vehicle manufacturer.	AS00.00-Z-0010-01A
Danger	Risk of explosion caused by fuel igniting, risk of poisoning caused by inhaling and swallowing fuel as well as risk of injury to eyes and skin caused by contact with fuel.	No fires, sparks, open flames or smoking. Pour fuels into suitable and appropriately marked containers only. Wear protective clothing when handling fuel.	AS47.00-Z-0001-01A
Warning	Risk of injury. Skin or eye injuries may result when handling hot or glowing objects.	Wear protective gloves, protective clothing and safety glasses, if necessary.	AS00.00-Z-0002-01A
Caution	Risk of injury caused by scraping or cutting body parts on sharp vehicle parts	Always wear protective gloves when working on or near sharp and non-deburred vehicle parts. Deburr repair panels.	AS00.00-Z-0017-01A
Notice	General information on body repair		AH60.00-P-0001-01KOA
Notice	Information on preventing damage to electronic components due to electrostatic discharge		AH54.00-P-0001-01A
	General information on MB materials		AH98.00-P-9409-03A
	Check		
1	Check if vehicle is affected by measure.		
2	Raise vehicle.		
AR			AR00.60-S-1000E
3 WS WS	Support fuel tank (1). 000 588 10 62 00 Support plate 000 588 11 62 00 Major assembly mount	Secure the fuel tank(1) against falling down.	WS26.00-P-3309B WS01.00-P-0092B

4	Check whether thread of respective weld nut (5) and screw (4) on rear retaining bracket (2) and front retaining bracket (3) is damaged.	<p>ⓘ When checking the respective weld nut (5), it must not be possible to unscrew the screws (4) sluggishly and there must not be any visible damage to the thread. If one of the screws (4) unscrews sluggishly or if there is visible damage to the thread, replace respective weld nut (5) and screw (4). Otherwise, the correct torque of the respective screws (4) cannot be guaranteed.</p> <p>ⓘ At least one of the four following weld nuts (5) is damaged and must be replaced. Otherwise, correct mounting of the rear retaining bracket (2) or front retaining bracket (3) cannot be guaranteed.</p> <p>ⓘ To do so, unscrew screws (4) from rear retaining bracket (2) and front retaining bracket (3). If the screw (4) can be unscrewed sluggishly or if there is visible damage to the thread,</p> <p style="text-align: center;">↓</p> <p>replace respective damaged weld nut (5) with corresponding screw (4); to do so, continue with operation step 5.</p> <p>If it is not possible to determine whether the screw (4) can be unscrewed sluggishly or if there is any damage to the thread without error,</p> <p style="text-align: center;">↓</p> <p>replace all weld nuts (5) with corresponding screws (4); to do so, continue with operation step 5.</p>	
	Replace respective weld nut (5)		
 Danger	The high voltage used for electric welding presents a lethal hazard. Risk of explosion from welding in areas close to highly inflammable materials. Risk of injury from weld splatter and UV-light when welding. Risk of poisoning from inhaling welding gases	Use insulating mats. Wear protective clothing, safety glasses and a protective mask. Remove highly inflammable materials from the hazard area. Use air extraction system.	AS00.00-Z-0007-01A
 Notice	Measures for preventing damage to components when performing electric welding and soldering work		AH60.00-P-0001-02A
5  AR	Remove fuel tank.	Model 447.603 ## as of 862470 up to 862471 with engine 274.920 with code ZU8 (National version for USA) except code ZL3 (National version for Latin America)	AR47.10-S-4100EG
6  AR	Remove propeller shaft.	If respective weld nut (5) on holder for retaining bracket (6) has to be replaced.	AR41.10-S-0050E
7  AR	Remove floor covering in load compartment.	If respective weld nut (5) in longitudinal member (7) has to be replaced. Model 447.603 ## as of 862470 up to 862471 with engine 274.920 with code V43 (Wood flooring) with code ZU8 (National version for USA)	AR68.30-S-0004E
8	Cover all detachable parts remaining in vehicle with spark protection blanket.	If respective weld nut (5) in longitudinal member (7) has to be replaced.	

9	Mark separating points on center floor (8) for respective center floor section (8.1) (areas A).	<p>If respective weld nut (5) in longitudinal member (7) has to be replaced.</p> <p>i To do so, mark center point (arrow A) of respective center floor section (8.1) through screw hole of weld nut (5) using a suitable tool from underside of longitudinal member (7).</p> <p>i Observe dimensions (a, b, c).</p>	
10	Separate separating points on center floor (8) for respective center floor section (8.1) (areas A).	<p>If respective weld nut (5) in longitudinal member (7) has to be replaced.</p> <p>!</p> <p>Only cut through one sheet thickness. Otherwise the components below can be damaged and weakened.</p> <p>i This enables access to the respective weld nut (5) in the longitudinal member (7).</p>	
11	Grind mating surfaces on respective center floor section (8.1) and center floor (8) down to bare metal in cross-hatched areas.	<p>If respective weld nut (5) in longitudinal member (7) has to be replaced.</p> <p>i Remove grinding dust and wood shavings.</p>	
12	Separate respective damaged weld nut (5) from holder for retaining bracket (6) (areas D).	<p>If respective weld nut (5) on holder for retaining bracket (6) has to be replaced.</p> <p>i To do so, release respective damaged weld nut (5) from holder for retaining bracket (6) on weld joints.</p> <p>i Dispose of removed weld nut (5) properly. To do so, observe the applicable legal requirements and specifications of the relevant country.</p>	
13	Separate respective damaged weld nut (5) in longitudinal member (7) (areas D).	<p>If respective weld nut (5) in longitudinal member (7) has to be replaced.</p> <p>i To do so, release respective damaged weld nut (5) from longitudinal member (7) at weld joints.</p> <p>i Dispose of removed weld nut (5) properly. To do so, observe the applicable legal requirements and specifications of the relevant country.</p>	
14	<p>Install and weld in respective new weld nut (5) at holder for retaining bracket (6) (areas B).</p> <p>WS 000 588 02 84 00 Welder</p>	<p>If respective weld nut (5) on holder for retaining bracket (6) has to be replaced.</p> <p>i Order required new weld nut (5) with "DIN 928-M10-ST" specification from free market.</p> <p>i To do so, fasten respective new weld nut (5) at holder for retaining bracket (6) using screw (4).</p>	WS60.00-P-0022K
15	<p>Install and weld in respective new weld nut (5) in longitudinal member (7) (areas B).</p> <p>WS 000 588 02 84 00 Welder</p>	<p>If respective weld nut (5) in longitudinal member (7) has to be replaced.</p> <p>i Order required new weld nut (5) with "DIN 928-M10-ST" specification from free market.</p> <p>i To do so, fasten respective new weld nut (5) at screw hole of longitudinal member (7) using screw (4).</p>	WS60.00-P-0022K

16 WS	Install and weld in respective center floor section (8.1) at center floor (8) (areas C). 000 588 02 84 00 Welder	If respective weld nut (5) in longitudinal member (7) was replaced. i Perform shielding gas welding at intervals and allow to cool down in between. This reduces heat distortion.	WS60.00-P-0022K
17	Grind inert gas weld joints flat on respective center floor section (8.1) (areas C).	If respective weld nut (5) in longitudinal member (7) was replaced.	
18	Clean weld joints and sheet metal flange.		
19	Remove spark protection blankets.	If respective weld nut (5) in longitudinal member (7) was replaced.	
20	Clean repair area.		
21 AR	Restore surfaces of repair areas on center floor (8).	If respective weld nut (5) in longitudinal member (7) was replaced. If two-component adhesive is not used to restore the surfaces, ↓ use basic body filler on body. Process filler on body Silicone remover Order No. 3295 Basic body filler Parts kit for 2-component adhesive for body	AR60.00-S-0031-01P BR00.45-Z-1052-04A BR00.45-Z-1057-07A BR00.45-Z-1162-02A
22 Notice	Prime repair areas with primer filler. Notes on paintwork repairs	i Use only primer fillers approved by manufacturer. See guidelines for paint technology in the workshop portal.	AH98.00-P-9408-02A
23 Notice	Repaint repair areas. Notes on paintwork repairs	i Only use paints approved by the manufacturer. See guidelines for paint technology in the workshop portal.	AH98.00-P-9408-02A
24 AR	Supplement cavity preservation.		AR97.20-S-1500E
	Install		
25 AR	Install propeller shaft.	If respective weld nut (5) on holder for retaining bracket (6) was replaced.	AR41.10-S-0050E
26 AR	Install floor covering in load compartment.	If respective weld nut (5) in longitudinal member (7) was replaced. Model 447.603 ## as of 862470 up to 862471 with engine 274.920 with code V43 (Wood flooring) with code ZU8 (National version for USA)	AR68.30-S-0004E
27 AR	Install fuel tank.	Model 447.603 ## as of 862470 up to 862471 with engine 274.920 with code ZU8 (National version for USA) except code ZL3 (National version for Latin America) i Use new screws (4). i Dispose of old screws (4) properly. To do so, observe the applicable legal requirements and specifications of the relevant country.	AR47.10-S-4100EG
28 AR	Lower vehicle.		AR00.60-S-1000E

Repair materials

Number	Designation	Order number
BR00.45-Z-1052-04A	Silicone remover Order No. 3295	Prosol Lacke + Farben GmbH Schneidmühlweg 12 63741 Aschaffenburg Germany Tel. +49 6021 3480-0 Fax +49 6021 3480-40 http://www.prosol-farben.de
BR00.45-Z-1057-07A	Basic body filler	A 012 989 29 71
BR00.45-Z-1162-02A	Parts kit for 2-component adhesive for body	A 012 989 17 71

Parts ordering note

Part no.	Designation	Quantity
N 910143 010011	Screw, tensioning strap to longitudinal member M10x20	4
	Weld nut M10 (order required new weld nut (5) with specification "DIN 928-M10-ST" from free market)	As Needed