

ATTENTION: Mercedes-Benz Dealer Principals, General Managers, Sales Managers, Service Managers & Parts Managers

Service Campaign Notification

July 25, 2025

Campaign #	Description	Check Mounting Bracket on Vehicle Underbody
2025070004	25P6190215	

Campaign Details

Total Population	2,844	Model(s)/Platform(s)	GLE/GLS (167 platform)
Model Year(s)	2024		
Issue	Mercedes-Benz AG, the manufacturer of Mercedes-Benz vehicles, has determined that on certain subject vehicles, a bracket on the underbody of the vehicle might not meet current production specifications. Consequently, moisture might collect in the area due to a crack in the bracket.		
Remedy	MBUSA will conduct a service campaign. An authorized Mercedes-Benz dealer will inspect the mounting bracket and rework it if necessary.		
Launch Date	Affected VINs will be flagged as "OPEN" in VMI on Friday, July 25, 2025.		
Warranty Claim Notice	Please note the campaign will close after the warranty claim has been submitted. This change can take at least one-day to reflect in NetStar VMI.		

While we regret any inconvenience this may cause, MBUSA is determined to maintain a high level of vehicle quality and customer satisfaction. Please refer all customer inquiries to the Customer Care Center at 1-800-FOR-MERCEDES.



Service Campaign Bulletin



Mercedes-Benz

July 2025

TO: ALL MERCEDES-BENZ CENTERS

CAMPAIGN NO.	2025070004
CAMPAIGN DESC.	25P6190215
SUBJECT	Check Mounting Bracket on Vehicle Underbody
MODEL(S)	GLE and GLS (167 platform)
MODEL YEAR(S)	2024
CAMPAIGN POPULATION	2,844

Campaign Technical Instructions

Prior to performing this Campaign:

Check the Vehicle Master Inquiry (VMI) to verify this campaign applies to the specific vehicle.

Always check for other open campaigns and perform them accordingly!

Review the entire campaign bulletin first, and perform the procedures exactly as described.

Order No. P-SC-2025070004

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Primary Parts Information

Qty.	Part Name	Part Number
1*	Preservation agent*	A 000 986 72 70 10

* One bottle can be utilized for 25+ vehicles

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.

Additional Repair Information

Operation Step	Document Number
Step 1 – Check Procedure	AR00.60-P-1006A
Step 2 – Work Procedure	AR49.10-P-7283MNO or AR49.10-P-7283MSC
Step 3 – Work Procedure	AR68.80-P-0008ME

Check/Test Procedure

- Lift vehicle on vehicle lift (**AR00.60-P-1006A**).
- Check affected area (**Figure 1a or 1b**, depending on vehicle as-built configuration) for cracking (**Figure 1, A**).
i If the as-built configuration is **Figure 1b**, use a commercially available endoscope to check for cracks.

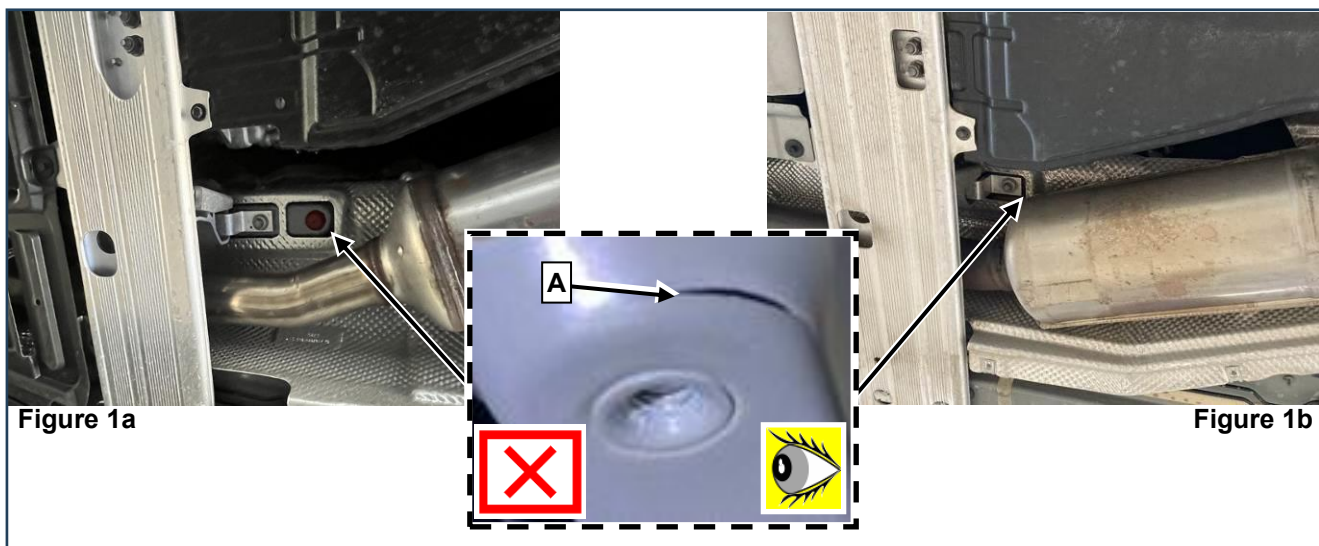


Figure 1

- If crack (**Figure 1, A**) is present: Carry out **Work Procedure**.
- If crack (**Figure 1, A**) is *not* present: **End measure**.

i The crack in the mounting console will be sealed by welding.

NOTE: This repair requires welding to be performed. Welding must be performed by a **CERTIFIED WELDER** certified for Gas Metal Arc Welding (GMAW) also known as MIG welding or Shielded Metal Arc Welding (SMAW) also known as stick welding; **WELDER MUST BE CERTIFIED BY ANY ACCREDITED WELDER CERTIFICATION PROGRAM** (e.g., American Welding Society [AWS], National Registry for Certified Welders, I-Car etc. [other accredited welding certification programs are also acceptable]). Submitting a claim for reimbursement for this work constitutes the dealer's acknowledgement that the work was performed by a certified welder as indicated above.

Prepare vehicle for welding:

1. Disconnect negative battery cable.
2. Thoroughly cover the interior working area (**Figure 4, C**) with welding blankets.
NOTE: Welding blankets can be purchased locally or by contacting:
Reliable Automotive Equipment, Inc. (732) 747-1770.

Work Procedure

1. Expose working area (**Figure 2**).

i Remove exhaust system and heat shielding until the working area is accessible.

2. Remove complete exhaust system (in one piece).
For M177 and M176, reference **AR49.10-P-7283MNO**
For M254.9 and M256, reference **AR49.10-P-7283MSC**.

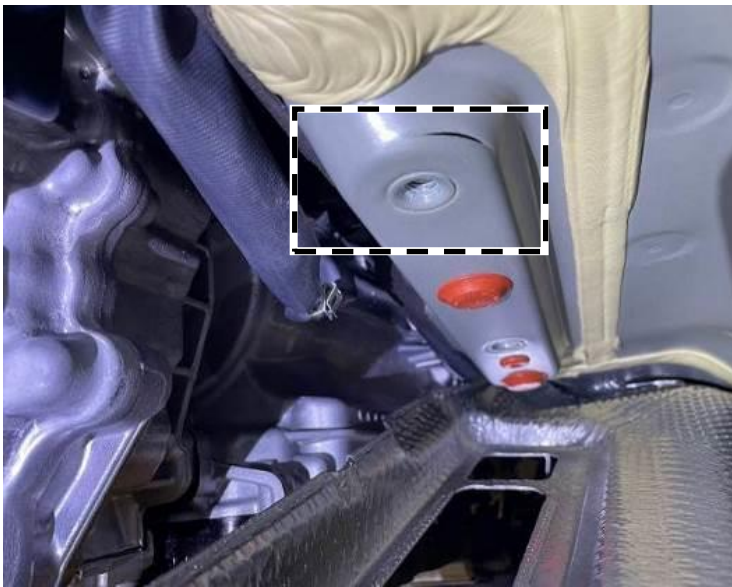


Figure 2

3. Remove floor covering on front passenger side (**AR68.80-P-0008ME**).

4. Remove plastic cover (**Figure 3, B**) on top electronic component parts in passenger footwell.



Figure 3

5. Take measures to protect against thermal damage in the area of the electrical lines (**Figure 4, C**).

i Protect electrical lines from heat introduced during welding by utilizing a welders blanket.

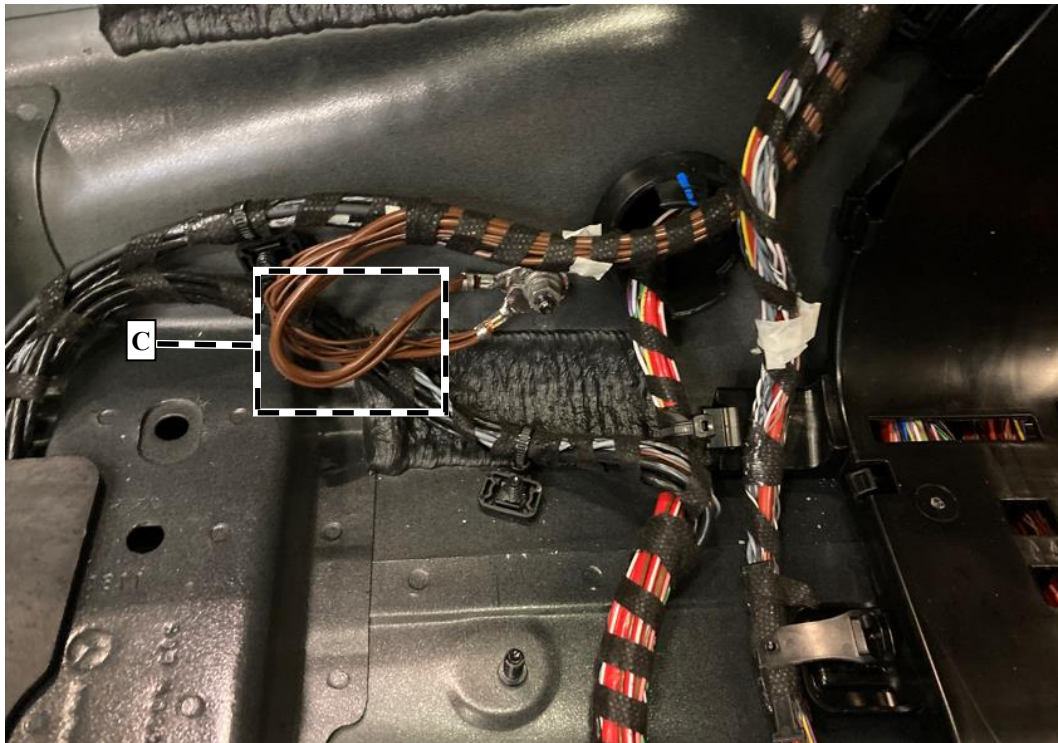


Figure 4

6. Repair crack found on underbody mounting. **Drill crack ends, then perform weld (Figures 5 and 6).**

i When working on vehicles with HV system, observe the applicable WIS documents!



Figure 5



Figure 6

7. Apply **primer/paint** (any available color spray/pen) and **corrosion protection** (preservation agent) in compliance with Mercedes-Benz guidelines.

NOTE: Guidelines are available from XENTRY Portal → Mercedes-Benz Retail Platform → Resources → Documents → Mercedes-Benz Paint Services → *MB Paint Services: Paint and corrosion protection guidelines.*

i In addition, **wax underbody in the welded repair area**, including the space of the mounting console (wax inner side of the welded area). Insert a round nozzle (<6mm) through the bolt hole and briefly spray behind the welded area.

8. Assemble in reverse order.

Warranty Information

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

Damage Code	Operation Number	Description	Labor Time (hrs.)
61 902 15	11-1519	Check crossmember mounting console on underbody for crack	0.2
	11-1520	Weld crack in crossmember mounting console on underbody (after check) Includes: Remove exhaust system; Remove heat shields; Remove right front seat; Remove floor covering in right front footwell; Take precautions against thermal damage in welding area (interior footwell), apply paint and wax underbody (inner and outer weld surface).	ZM

i **Per Warranty Policy 7.4.0 Sublet Repairs – It is the dealership’s responsibility to ensure that any sublet repairs which they commission are performed up to Mercedes-Benz standards and follow all Mercedes-Benz procedures and work instructions (including making available all MB products required for the repair). When submitting a warranty claim for a sublet repair where the parts are being supplied by the dealer to the third-party performing the repair, the dealer RO must reflect these parts listed separately on the claim. This not only pertains to the welding, but also any additional MB products required for installation. The sublet line should only include the labor and those materials (if applicable) not supplied by the dealer and not available from MBUSA.**

i **By submitting a claim for reimbursement for work completed by a third party, the dealer agrees to indemnify MBUSA for any issues that may arise from such third-party work that was not performed according to the WIS instructions with the required welding, priming and corrosion protection.**

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.*