



Mercedes-Benz

Campaign No. 2018060009, June 2018

TO: ALL MERCEDES-BENZ CENTERS

SUBJECT: **Model 906 (Sprinter), Model Year 2017**
Spot Welds on Front Side Wall Paneling

Daimler AG (DAG), the manufacturer of Mercedes-Benz Vans, has determined that on certain Mercedes-Benz and Freightliner Sprinter vehicles, spot welds might be missing on the front side wall on the driver and/or the passenger side. The affected spot welds connect the door portal with the underlying hinge reinforcements behind. If the missing welds affect body strength, there may be an increased risk of injury in the event of a crash. An authorized Mercedes-Benz or Freightliner Sprinter dealer will check if any of the welds on the A-pillar are missing. If necessary, the affected vehicles will be reworked by setting the missing weld spots at the front side wall panelling.

Prior to performing this Recall Campaign:

- Please check VMI to determine if the vehicle is involved in the Campaign and if it has been previously repaired.
- Please review the entire Recall Campaign bulletin and follow the repair procedure exactly as described.

Please note that Recall Campaigns **do not expire** and may also be performed on a vehicle with a vehicle status indicator.

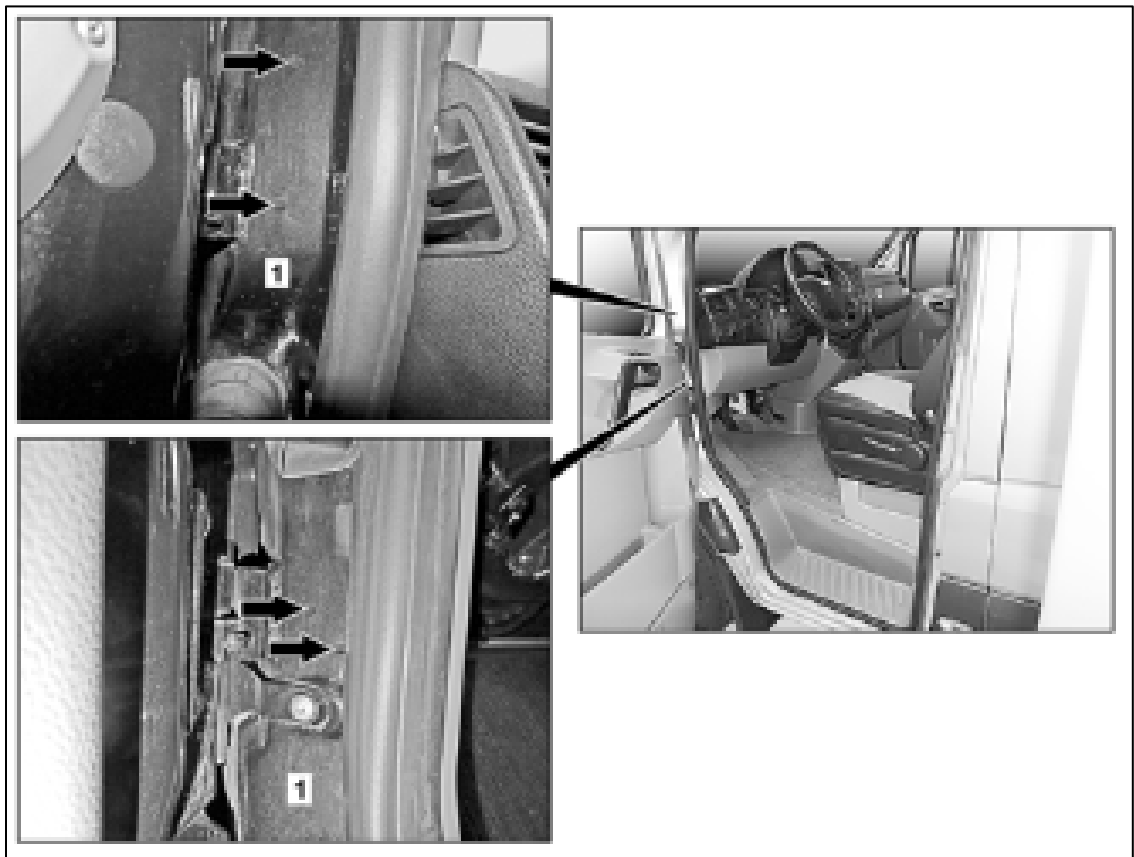
Approximately 153 vehicles are involved.

Order No. V-RC-2018060009

This bulletin has been created and maintained in accordance with MBUSA-SLP S423QH001, Document and Data Control, and MBUSA-SLP S424HH001, Control of Quality Records.





Op. no.	Operation text	Time	Damage Code	Code
02 2508	Operations: Check spot welds on A-pillars	---	63 910 61 7	NC3BEPLANK
02 2509	Operations: Weld A-pillar (after check)	---	63 910 61 7	NC3BEPLANK
02 2510	Operations: Weld 2 A-pillars (after check)	---	63 910 61 7	NC3BEPLANK
02 2594	Operations: Extra work for: Weld A-pillar on vehicle with mud flap	---	63 910 61 7	NC3BEPLANK
85 9800	Carry out spot repair, location:.....	---		
85 9802	Carry out spot repair (each remaining) on additional part, location:.....	---		

1 A-pillar



Check		
1	Check whether vehicle is affected by measure	<p>i</p> <p>For authorized Mercedes-Benz service partners, only the entry in the "Extended VEGA Application" (EVA) system, in the "Current" tab is decisive. An additional test of the affected vehicles in the workshop information system (WIS) or vehicle list is thereby not necessary.</p>
2	Check whether spot welds (arrows) are present on A-pillar (1).	<p>i</p> <p>Check A-pillars (1) on driver and front passenger side.</p> <p>i</p> <p>Clean A-pillars (1) before visual check with a rag.</p> <p>If spot welds (arrows) are present,</p> <p style="text-align: center;">↓</p> <p>end the measure.</p> <p>If no spot welds (arrows) are present,</p> <p style="text-align: center;">↓</p> <p>continue with operation step 3.</p>
Remove		
3	Remove respective front door.	
4	Remove respective fender.	
5	Cover all detachable parts remaining in vehicle with welding protection blankets.	

Install		
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.
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.
6	Weld affected A-pillar (1) subsequently.	
Topical note	Measures for preventing damage to vehicles or components when performing electric welding work	
	000 588 02 84 00 Welder	
7	Remove welding protection blankets.	

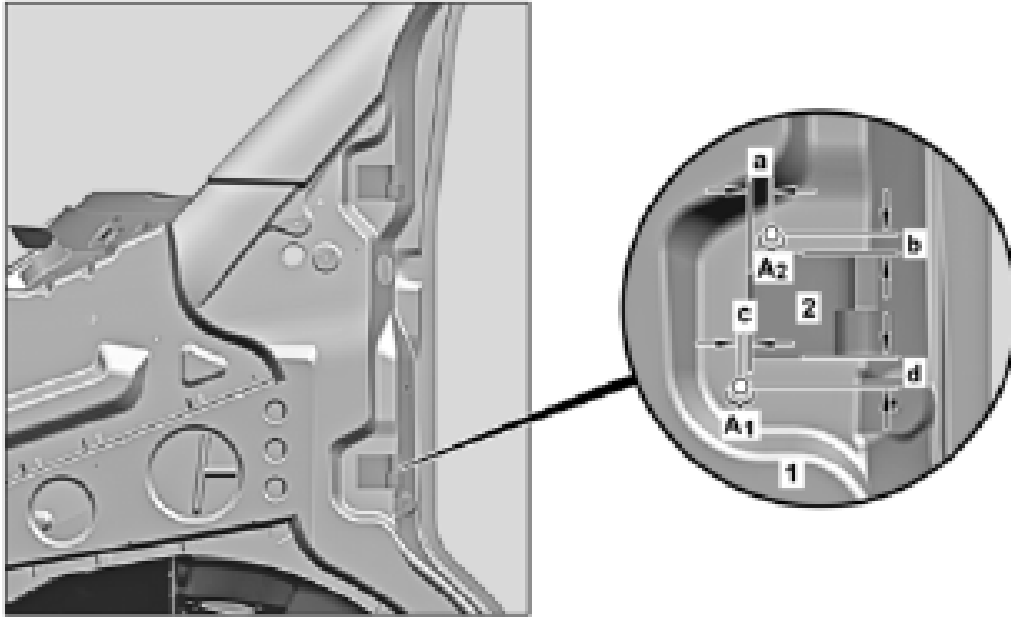
8	Clean repair area.	
Danger	Risk of explosion caused by paint vapors igniting.	No smoking! No open fire! Use respiratory protection, protective clothing, gloves, safety glasses and protective skin cream. Ensure that the area is well ventilated.
	Risk of poisoning caused by inhaling paint vapors.	
9	Prime repair area with a primer filler.	
Topical note	Notes on paintwork repairs	
		 <p>Apply spot repair.</p>  <p>Use only primer filler approved by Daimler AG: http://xentryportal.mercedesbenz.com</p>
Danger	Risk of explosion caused by paint vapors igniting.	No smoking! No open fire! Use respiratory protection, protective clothing, gloves, safety glasses and protective skin cream. Ensure that the area is well ventilated.
	Risk of poisoning caused by inhaling paint vapors.	
10	Paint repair area and adjacent surfaces.	
Topical note	Notes on paintwork repairs	
		 <p>Apply spot repair.</p>  <p>Use only paints approved by Daimler AG: http://xentryportal.mercedesbenz.com</p>
11	Supplement cavity preservation	
12	Install respective fender.	
13	Install respective front door.	

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The following steps are shown on the left side of the vehicle and must be performed analogously on the right side in the event of a problem.

a Dimension (9 mm) b Dimension (12 mm) c Dimension (9 mm) d Dimension (15 mm)



1 Use spot-weld cutter to cut holes on A-pillar outer section (1) next to lower hinge holder (2) of front door (areas A₁ and A₂).

Never cut through 2 panel thicknesses. Otherwise, inert gas plug welding will no longer be possible.



Cut through one panel thickness only.

4 A-pillar outer section (1) (area B).

5 Grind inert gas plug welds down to bare metal (area B).

6 Remove shavings.



Observe dimensions (a, b, c, d). The edges of the hinge holder (2) act here as reference edges.

2 Grind A-pillar outer section (1) down to bare metal around the holes (areas A₁ and A₂).

3 Remove shavings and milling chips.

