



TM23 MERCEDES GLE / GLS 2019> Including Hybrid Models

Item	Qty	Description	Item	Qty	Description
A	1	TM23 Crossmember	E	2	M16 x 50 Bolts & Nyloc Nuts
B	2	Side Arms	F	4	M12 x 35 (10.9) Bolts, 2 Nyloc Nuts & 2 S/P Washers
C	2	Handed Bolt Straps	G	4	M12 x 45 Bolts & Nyloc Nuts
D	1	Extension	H	1	M12 x 130 (10.9) Bolts & Nyloc Nut
			J	1	M8 x 40 Bolt & Nyloc Nut
			K	3	8 x 25 Flat Washers
			L	10	12 x 25 Flat Washers
			M	2	M12 Flange Nut
			T1	1	30mm O/D x 60mm Long Spacer Tube
			X	8	Original Mercedes M2 Nuts (120 Nm)
			X1	1	Original Mercedes M6 Nuts (5 Nm)

BUMPER REMOVAL:

1. Remove eight fixings from the bumper lower edge, four fixings from each wheel arch, peel back wheel arch liners to reveal two more fixings to remove.
2. Pull bumper tips sideways to release from vehicle body then rearward disconnecting any necessary wiring looms.
3. Remove boot floor trim for access to mounting point.
4. Remove the rearmost fixing securing the AdBlue Tank to the rear impact beam.
5. **Hybrid Models:** Remove the speaker bracket located to the inside of the right hand impact beam leg from body, three fixings. Unclip the wiring loom retaining clip to allow the speaker to be relocated. (Speaker refitted using one fixing).
6. Remove the rear impact beam and retain fixings for fitting Item A. (Rear impact beam is not refitted with the Towbar assembly).

HYBRID MODEL ADDITIONAL INSTRUCTIONS:

1. Remove the two studs nearest to the chassis opening where the speaker bracket was attached, once removed coat any bare metal to prevent corrosion.
2. Using Item X1 and Fig 2 as a guide remount the bracket to the stud located just to the left of the plastic bracket for the bumper.
3. Insert Items C through the mounting point from inside the boot, securing Items B inside each chassis member using Items M. Fully tighten through the chassis opening, ensuring arm is square and in position. (See Fig 3).

TOWBAR INSTALLATION:

1. **(Standard Models)** Fix Items B using Items C with Items M.
2. Using Item X fix Item A to the rear panel. Always fully seal the rear panel and chassis openings with a suitable sealant to prevent water ingress.
3. Fix Items B to Item A using Item F and Item L.
4. Using Item J with Items K fix the AdBlue Tank to Item A.
5. Fully tighten all fixings ensuring the Towbar is rigid, square and secure.
6. Cut the rear bumper as shown below and refit.
7. Using Item G with Item L and Item H with Items L fix Item D to Item A ensuring Item T1 is fitted between the rearmost lower mounting point.
8. Using Item E fix your desired ball bracket and wiring plate (Not supplied in this kit) to Item D.
9. Fully tighten all remaining fixings.

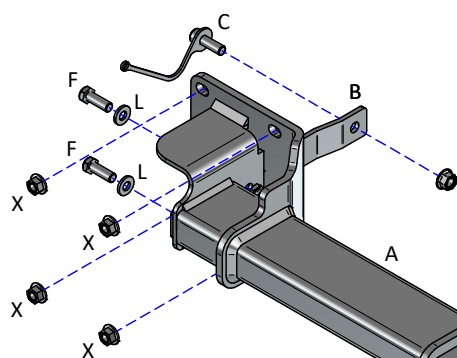


Fig 1 Hybrid Models (O/S View)

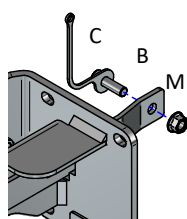
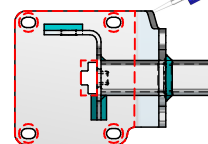
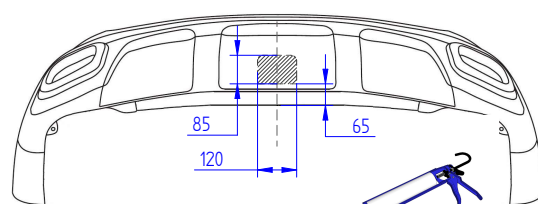


Fig 2

BUMPER CUT / OUTSIDE VIEW



L/H shown, always seal both ends

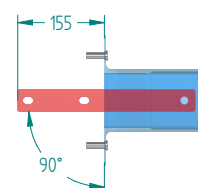


Fig 3

Notes:

1. For Torque settings see general notes overleaf.
2. Nose load limits and vehicle manufacturer's trailer / caravan weight limits must be observed.