

## 2.1 Vehicle and model designations

## 2.1 Vehicle and model designations






These body / equipment mounting directives are valid for the following vehicle baumuster (BM):

Vehicle							
ACTROS (BM 93X)	18 t	20 t	25 t	26 t	32 t	33 t	41 t
AXOR (BM 94X and 95X)	18 t	25 t	26 t				
ATEGO (BM 97X)	7 t	8 t	9 t	10 t	12 t	13 t	15 t
ECONIC	18 t	26 t					





## Explanation of truck model designation:

Example	2544	S	6x2 / 4	
	25			Permissible gross weight in tons (solo vehicle)
	44			Engine output in bhp (* x 10)
		S		Vehicle specification (brief description)
				Chassis / platform truck
				A All-wheel drive
				B Cement mixer
				K Tipper
				S Semitrailer tractor vehicle
				L Pneumatic suspension
			6x2 / 4	Axle designation
			6	Number of wheels or pairs of wheels
			x2	Number of driven wheels or pairs of wheels
			/ 4	Number of steered wheels






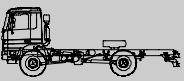
2.1 Vehicle and model designations

(BM 93X)		18 t							
VKB		1832	1836	1841	1844	1846	1850	1854	1856
Engine type		OM 501 LA	OM 501 LA	OM 501 LA	OM 501 LA	OM 501 LA	OM 502 LA	OM 502 LA	OM 502 LA
Number of cylinders		V6	V6	V6	V6	V6	V8	V8	V8
Output	kW/bhp	235 / 320	265 / 360	300 / 408	320 / 435	335 / 456	370 / 503	395 / 537	425 / 578
Maximum torque	rpm	1,800	1,800	1,800	1,800	1,800	1,800	1,800	1,800
	Nm	1,700	1,900	2,050	2,100	2,200	2,400	2,500	2,700
	rpm	1,080	1,080	1,080	1,080	1,080	1,080	1,080	1,080
Cab	S(F07) short	•	•	•	•	•	•	•	•
	M(F05) standard	S	S	S	S	S	S		
	L(F04) long	•	•	•	•	•	•		
	Mega (F15)	•	•	•	•	•	•	S	S
Transmission		G211-16	G211-16	G211-16	G211-16	G231-16	G240-16	G240-16	G260-16
 Wheelbase (mm)	4,500	•	•	•	•	•			
	4,800	•	•	•	•	•	•	•	
	5,100	•	•	•	•	•			
	5,400	•	•	•	•	•			
	5,700	•	•	•	•	•			
	6,000	•	•	•	•	•			
 L	3,900	•	•	•	•	•			
	4,200	•	•	•	•	•	•	•	
	4,500	•	•	•	•	•			
	4,800	•	•	•	•	•	•	•	•
	5,100	•	•	•	•	•			
	5,400	•	•	•	•	•	•	•	
	5,700	•	•	•	•	•			
6,000	•	•	•	•	•				
 NR	4,800	•	•	•	•	•			
	5,400	•	•	•	•	•			
	5,700	•	•	•	•	•			
 NRA	5,400	•	•	•	•				
	5,700	•	•	•	•				
 LS	3,600	•	•	•	•	•	•	•	•
	3,900	•	•	•	•	•	•	•	•
Permissible axle loads and weights (kg)	A.1	7,100	7,100	7,100	7,100	7,100	7,100	7,100	7,100
	A.2	11,500	11,500	11,500	11,500	11,500	11,500	11,500	11,500
	Total	18,000	18,000	18,000	18,000	18,000	18,000	18,000	18,000
Permissible total gross combination weight		40,000	40,000	40,000	40,000	40,000	40,000	40,000	40,000


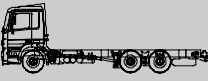
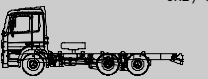
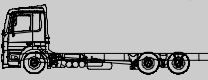

## 2.1 Vehicle and model designations

(BM 93X)		18 t							
VKB		1832	1836	1841	1844	1846	1850	1854	1856
Engine type		OM 501 LA	OM 501 LA	OM 501 LA	OM 501 LA	OM 501 LA	OM 502 LA	OM 502 LA	OM 502 LA
Number of cylinders		V6	V6	V6	V6	V6	V8	V8	V8
Output	kW / bhp	235 / 320	265 / 360	300 / 408	320 / 435	335 / 456	370 / 503	395 / 537	425 / 578
	rpm	1,800	1,800	1,800	1,800	1,800	1,800	1,800	1,800
Maximum torque	Nm	1,700	1,900	2,050	2,100	2,200	2,400	2,500	2,700
	rpm	1,080	1,080	1,080	1,080	1,080	1,080	1,080	1,080
 LS / NR	3,600	•	•	•	•	•			
 LSNRA	3,900	•	•	•	•				
 NRL	3,600	•	•	•	•	•			
 K	3,600	•	•	•	•	•			
	3,900	•	•	•	•	•	•		
AK	3,600	•	•	•	•	•			
	3,900	•	•	•	•	•			
Permissible axle loads and weights (kg)	A.1	7,100	7,100	7,100	7,100	7,100	7,100	7,100	7,100
	A.2	11,500	11,500	11,500	11,500	11,500	11,500	11,500	11,500
	Total	18,000	18,000	18,000	18,000	18,000	18,000	18,000	18,000
Permissible total gross combination weight		40,000	40,000	40,000	40,000	40,000	40,000	40,000	40,000

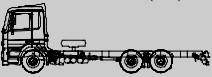






## 2.1 Vehicle and model designations

(BM 93X)			20 t					
VKB		2032	2036	2041	2044	2046	2050	2054
Engine type		OM 501 LA	OM 501 LA	OM 501 LA	OM 501 LA	OM 501 LA	OM 502 LA	OM 502 LA
Number of cylinders		V6	V6	V6	V6	V6	V8	V8
Output	kW/bhp	235 / 320	265 / 360	300 / 408	320 / 435	335 / 456	370 / 503	395 / 537
Maximum torque	rpm	1,800	1,800	1,800	1,800	1,800	1,800	1,800
	Nm	1,700	1,900	2,050	2,100	2,200	2,400	2,500
Cab	S(F07) short	●	●	●	●	●	●	●
	M(F05) standard	S	S	S	S	S	S	S
Transmission	L(F04) long	●	●	●	●	●	●	●
		G210-16	G210-16	G210-16	G240-16	G240-16	G240-16	G240-18
Wheelbase (mm)								
	4,500	●	●	●	●	●		
	4,800	●	●	●	●	●		
	5,100	●	●	●	●	●		
	S							
	3,600	●	●	●	●	●	●	●
	3,900	●	●	●	●	●	●	●
	AS							
	3,600	●	●	●	●	●	●	
	K							
	3,900	●	●	●	●	●		
	AK							
	3,900	●	●	●	●	●		
	A							
	4,500	●	●					
Permissible axle loads and weights (kg)	A.1	7,500	7,500	7,500	7,500	7,500	7,500	7,500
	A.2	13,000	13,000	13,000	13,000	13,000	13,000	13,000
	Total	20,000	20,000	20,000	20,000	20,000	20,000	20,000
Permissible total gross combination weight		40,000	40,000	40,000	40,000	40,000	40,000	40,000

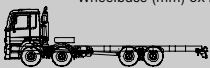




2.1 Vehicle and model designations

(BM 93X)		25 t							
VKB		2532	2536	2541	2544	2546	2550	2554	2558
Engine type		OM 501 LA	OM 501 LA	OM 501 LA	OM 501 LA	OM 501 LA	OM 502 LA	OM 502 LA	OM 502 LA
Number of cylinders		V6	V6	V6	V6	V6	V8	V8	V8
Output	kW / bhp	235 / 320	265 / 360	300 / 408	320 / 435	335 / 456	370 / 503	395 / 537	425 / 578
	rpm	1,800	1,800	1,800	1,800	1,800	1,800	1,800	1,800
Maximum torque	Nm	1,700	1,900	2,050	2,100	2,200	2,400	2,500	2,700
	rpm	1,080	1,080	1,080	1,080	1,080	1,080	1,080	1,080
Cab	S(F07) short	●	●	●	●	●	●	●	●
	M(F05) standard	S	S	S	S	S	S	S	S
	L(F04) long	●	●	●	●	●	●	●	●
	Mega (F15)	●	●	●	●	●	●	●	●
Transmission		G211-16	G211-16	G211-16	G211-16	G231-16	G240-16	G240-16	G260-16
 Wheelbase (mm) DNA 6x2	4,500	●	●	●	●	●	●	●	
	4,800	●	●	●	●	●	●	●	
 L 6x2	4,200	●	●	●	●	●	●	●	
	4,500	●	●	●	●	●	●	●	●
	4,800	●	●	●	●	●	●	●	
	5,100	●	●	●	●	●	●	●	
	6,000	●	●	●	●	●			
 6x2 / 4	3,150	●	●						
	3,450	●	●						
	3,750	●	●						
	4,050	●	●						
 NR 6x2	4,500	●	●	●	●	●			
	4,800	●	●	●	●	●			
	5,100	●	●	●	●	●	●		
 LS 6x2 / 4	2,500	●	●	●	●	●	●	●	
Permissible axle loads and weights (kg)	A.1	7,100	7,100	7,100	7,100	7,100	7,100	7,100	7,100
	A.2	10,000 / 8,000	10,000 / 8,000	10,000 / 8,000	10,000 / 8,000	10,000 / 8,000	10,000 / 8,000	10,000 / 8,000	10,000 / 8,000
DNA 6x2	Total	25,000	25,000	25,000	25,000	25,000	25,000	25,000	25,000
	Permissible total gross combination weight	40,000	40,000	40,000	40,000	40,000	40,000	40,000	40,000
L 6x2	A.1	7,100	7,100	7,100	7,100	7,100	7,100	7,100	7,100
	A.2	11,500 / 7,100	11,500 / 7,100	11,500 / 7,100	11,500 / 7,100	11,500 / 7,100	11,500 / 7,100	11,500 / 7,100	11,500 / 7,100
	Total	25,000	25,000	25,000	25,000	25,000	25,000	25,000	25,000
Permissible total gross combination weight		40,000	40,000	40,000	40,000	40,000	40,000	40,000	40,000
6x2 / 4, LS 6x2 / 4	A.1	7,100	7,100	7,100	7,100	7,100	7,100	7,100	
	A.2	7,100 / 11,500	7,100 / 11,500	7,100 / 11,500	7,100 / 11,500	7,100 / 11,500	7,100 / 11,500	7,100 / 11,500	
	Total	25,000	25,000	25,000	25,000	25,000	25,000	25,000	
Permissible total gross combination weight		40,000	40,000	40,000	40,000	40,000	40,000	40,000	








2.1 Vehicle and model designations

(BM 93X)		26 t							
VKB		2632	2636	2641	2644	2646	2650	2654	2658
Engine type		OM 501 LA	OM 501 LA	OM 501 LA	OM 501 LA	OM 501 LA	OM 502 LA	OM 502 LA	OM 502 LA
Number of cylinders		V6	V6	V6	V6	V6	V8	V8	V8
Output	kW/bhp	235 / 320	265 / 360	300 / 408	320 / 435	335 / 456	370 / 503	395 / 537	425 / 578
Maximum torque	rpm	1,800	1,800	1,800	1,800	1,800	1,800	1,800	1,800
	Nm	1,700	1,900	2,050	2,100	2,200	2,400	2,500	2,700
Transmission	rpm	1,080	1,080	1,080	1,080	1,080	1,080	1,080	1,080
		G210-16	G210-16	G210-16	G240-16	G240-16	G240-16	G240-16	G260-16
 Wheelbase (mm) 6x4	4,200	•	•	•	•	•			
	4,500	•	•	•	•	•	•	•	
	5,100	•	•	•	•	•			
 L 6x4	4,200	•	•	•	•	•			
	4,500	•	•	•	•	•	•	•	
	4,800	•	•	•	•	•			•
 S 6x4	3,300			•	•	•	•	•	
 LS 6x4	3,300			•	•	•	•	•	•
 K 6x4	3,300	•	•	•	•	•	•	•	•
	3,600	•	•	•	•	•			
	3,900	•	•	•	•	•	•	•	
 LK 6x4	3,300	•	•	•	•	•	•	•	•
 B	3,300	•	•	•	•	•			
Permissible axle loads and weights (kg)	A.1	7,100	7,100	7,100	7,100	7,100	7,100	7,100	7,100
	A.2	2x9,500	2x9,500	2x9,500	2x9,500	2x9,500	2x9,500	2x9,500	2x9,500
	Total	26,000	25,000	26,000	25,000	26,000	25,000	26,000	25,000
Permissible total gross combination weight		40,000	40,000	40,000	40,000	40,000	40,000	40,000	40,000






## 2.1 Vehicle and model designations

(BM 93X)		32 t				
VKB		3232	3236	3241	3244	3246
Engine type		OM 501 LA	OM 501 LA	OM 501 LA	OM 501 LA	OM 501 LA
Number of cylinders		V6	V6	V6	V6	V6
Output	kW/bhp	235 / 320	265 / 360	300 / 408	320 / 435	335 / 456
	rpm	1,800	1,800	1,800	1,800	1,800
Maximum torque	Nm	1,700	1,900	2,050	2,100	2,200
	rpm	1,080	1,080	1,080	1,080	1,080
Cab	M(F05) standard	S	S	S	S	S
Transmission		G210-16	G210-16	G210-16	G240-16	G240-16
Wheelbase (mm) 8x4						
	5,400			•	•	
K 8x4 / 4						
	4,200	•	•	•	•	•
	4,500	•	•	•	•	•
	5,100	•	•	•	•	•
8x6 / 4						
	4,500					
B 8x4						
	4,200	•	•	•	•	•
	4,500	•	•	•	•	•
	5,100					
K 8x8 / 4						
	4,800					
Permissible axle loads and weights (kg)	A.1	2x7,100	2x7,100	2x7,100	2x7,100	2x7,100
	A.2	2x9,500	2x9,500	2x9,500	2x9,500	2x9,500
	Total	32,000	32,000	32,000	32,000	32,000
Permissible total gross combination weight		40,000	40,000	40,000	40,000	40,000



2.1 Vehicle and model designations

(BM 93X)		33 t							
VKB		3332	3336	3341	3344	3346	3350	3354	3358
Engine type		OM 501 LA	OM 501 LA	OM 501 LA	OM 501 LA	OM 501 LA	OM 502 LA	OM 502 LA	OM 502 LA
Number of cylinders		V6	V6	V6	V6	V6	V8	V8	V8
Output	kW/bhp	235 / 320	265 / 360	300 / 408	320 / 435	335 / 456	370 / 503	395 / 537	425 / 578
Maximum torque	rpm	1,800	1,800	1,800	1,800	1,800	1,800	1,800	1,800
	Nm	1,700	1,900	2,050	2,100	2,200	2,400	2,500	2,700
Cab									
	M(F05) standard	S	S	S	S	S	S	S	S
	L(F04) long	•	•	•	•	•	•	•	•
Mega (F15)							•	•	
Transmission		G210-16	G210-16	G210-16	G240-16	G240-16	G240-16	G240-16	G260-16
Wheelbase (mm) 6x4									
	4,200	•	•	•	•	•	•	•	•
	4,500	•	•	•	•	•	•	•	
S 6x4									
	3,300	•	•	•	•	•	•	•	
K 6x4									
	3,300	•	•	•	•	•	•		
	3,600	•	•	•	•	•			
	3,900	•	•	•	•	•	•		
B									
	3,300	•	•	•	•	•			
	3,600	•	•	•	•	•			
	3,900	•	•	•	•	•			
6x6									
	4,200	•	•	•	•	•			
	4,500	•	•	•	•	•			
S 6x6									
	3,600	•	•	•	•	•	•	•	
K 6x6									
	3,600	•	•	•	•	•	•		
	3,900	•	•	•	•	•			
Permissible axle loads and weights (kg)	A.1	7,500	7,500	7,500	7,500	7,500	7,500	7,500	7,500
	A.2	2x13,000	2x13,000	2x13,000	2x13,000	2x13,000	2x13,000	2x13,000	2x13,000
	Total	33,000	33,000	33,000	33,000	33,000	33,000	33,000	33,000
Permissible total gross combination weight		40,000	40,000	40,000	40,000	40,000	40,000	40,000	40,000



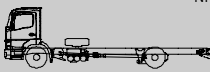
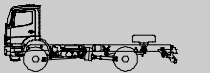
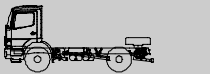
## 2.1 Vehicle and model designations

(BM 93X)		41 t			
VKB		4141	4144	4146	4150
Engine type		OM 501 LA	OM 501 LA	OM 501 LA	OM 502 LA
Number of cylinders		V6	V6	V6	V8
Output	kW / bhp	300 / 408	320 / 435	335 / 456	370 / 503
	rpm	1,800	1,800	1,800	1,800
Maximum torque	Nm	2,050	2,100	2,200	2,400
	rpm	1,080	1,080	1,080	1,080
Cab	M(F05) standard	S	S	S	S
Transmission		G240-16	G240-16	G240-16	G240-16
Wheelbase (mm) 8x4					
	5,400				
K 8x4 / 4					
	4,200	•	•	•	•
	4,500	•	•	•	•
	5,100	•	•	•	
8x6 / 4					
	4,500	•	•	•	•
B 8x4					
	4,200	•	•	•	
	4,500				
	5,100	•	•	•	
K 8x8 / 4					
	4,800	•	•	•	•
Permissible axle loads and weights (kg)	A.1	2x7,500	2x7,500	2x7,500	2x7,500
	A.2	2x13,000	2x13,000	2x13,000	2x13,000
	Total	41,000	41,000	41,000	41,000
Permissible total gross combination weight					

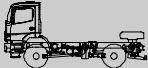
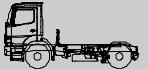
## 2.1 Vehicle and model designations

(BM 94X)		18 t			25 t		
VKB		1835	1840	1843	2535	2540	2543
Engine type		OM 457 LA	OM 457 LA	OM 457 LA	OM 457 LA	OM 457 LA	OM 457 LA
Number of cylinders		6R	6R	6R	6R	6R	6R
Output	kW/bhp	260 / 354	295 / 401	315 / 428	260 / 354	295 / 401	315 / 428
	rpm	1,900	1,900	1,900	1,900	1,900	1,900
Maximum torque	Nm	1,850	2,000	2,100	1,850	2,000	2,100
	rpm	1,100	1,100	1,100	1,100	1,100	1,100
Cab	L(F04)	S	S	S	S	S	S
	F04+DD5	●	●	●	●	●	●
Transmission		G221-9	G221-9	G221-9	G221-9	G221-9	G221-9
Wheelbase (mm) LS							
	3,600	●	●	●			
	3,900	●	●	●			
L 6x2					●	●	●
	4,500				●	●	●
	4,800				●	●	●
	5,100				●	●	●
Permissible axle loads and weights (kg)	A.1	7,100	7,100	7,100	7,100	7,100	7,100
	A.2	11,500	11,500	11,500	7,100 / 11,500	7,100 / 11,500	7,100 / 11,500
	Total	18,000	18,000	18,000	25,000	25,000	25,000
Permissible total gross combination weight		40,000	40,000	40,000	40,000	40,000	40,000

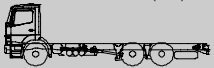

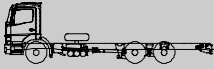
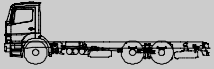
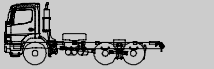

## 2.1 Vehicle and model designations

(BM 95X)		18 t		
VKB		1823	1828	1833
Engine type		OM 906 LA	OM 906 LA	OM 926 LA
Number of cylinders		6R	6R	6R
Output	kW / bhp	170 / 231	205 / 279	240 / 326
	rpm	2,200	2,200	2,200
Maximum torque	Nm	810	1,100	1,300
	rpm	1,200-1,600	1,200-1,600	1,200-1,600
Cab	S(F07)	S	S	S
	M(F20)	•	•	•
	L(F04)	•	•	•
	F04+DD5	•	•	•
Transmission		G85-6	G100-12	G221-9
 Wheelbase (mm)	3,900	•	•	•
	4,200	•	•	•
	4,500	•	•	•
	4,800	•	•	•
	5,100	•	•	•
	5,400	•	•	•
	5,700	•	•	•
	6,000	•	•	•
	6,300	•	•	•
 L	3,900	•	•	•
	4,200	•	•	•
	4,500	•	•	•
	4,800	•	•	•
	5,100	•	•	•
	5,400	•	•	•
	5,700	•	•	•
	6,000	•	•	•
	6,300	•	•	•
 NR	4,800	•	•	•
	5,400	•	•	•
	5,700	•	•	•
 A	4,200		•	
	4,500		•	
 K	3,600	•	•	•
	3,900	•	•	•
Permissible axle loads and weights (kg)	A.1	7,100	7,100	7,100
	A.2	11,500	11,500	11,500
	Total	18,000	18,000	18,000
Permissible total gross combination weight		28,000	36,000	36,000


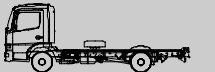


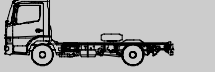
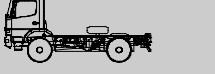
## 2.1 Vehicle and model designations

(BM 95X)		18 t		
VKB		1823	1828	1833
Engine type		OM 906 LA	OM 906 LA	OM 926 LA
Number of cylinders		6R	6R	6R
Output	kW / bhp	170 / 231	205 / 279	240 / 326
	rpm	2,200	2,200	2,200
Maximum torque	Nm	810	1,100	1,300
	rpm	1,200-1,600	1,200-1,600	1,200-1,600
 AK	3,600	•	•	
	3,900	•	•	
 LS	3,600	•	•	•
Permissible axle loads and weights (kg)	A.1	7,100	7,100	7,100
	A.2	11,500	11,500	11,500
	Total	18,000	18,000	18,000
Permissible total gross combination weight		28,000	36,000	36,000



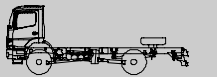

## 2.1 Vehicle and model designations

(BM 95X)		25 t			26 t	
VKB		2523	2528	2533	2628	2633
Engine type		OM 906 LA	OM 906 LA	OM 926 LA	OM 906 LA	OM 926 LA
Number of cylinders		6R	6R	6R	6R	6R
Output	kW/bhp	170 / 231	205 / 279	240 / 326	205 / 279	240 / 326
	rpm	2,200	2,200	2,200	2,200	2,200
Maximum torque	Nm	810	1,100	1,300	1,100	1,300
	rpm	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600
Cab	S(F07)	S	S	S	S	S
	M(F20)	•	•	•	•	•
	L(F04)	•	•	•	•	•
	F04+DD5	•	•	•	•	•
Transmission		G100-12	G100-12	G221-9	G100-12	G221-9
Wheelbase (mm) 6x2						
	4,200		•	•		
	4,500		•	•		
	4,800		•	•		
	5,100		•	•		
L 6x2 / 4						
	3,150		•	•		
	3,450	•	•	•		
	3,750		•	•		
	4,050		•	•		
L / NR 6x2						
	4,500		•	•		
	4,800		•	•		
6x4						
	4,200				•	•
	4,500				•	•
B 6x4						
	3,300				•	•
	3,900				•	•
K 6x4						
	3,300				•	•
	3,600				•	•
	3,900				•	•
Permissible axle loads and weights (kg)	A.1	7,100	7,100	7,100	7,100	7,100
	A.2	7,100	11,500	11,500	9,500	9,500
	A.3	11,500	7,100	7,100	9,500	9,500
	Total	25,000	25,000	25,000	2,600	2,600
Permissible total gross combination weight		32,000	36,000	36,000	40,000	40,000


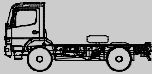
## 2.1 Vehicle and model designations

(BM 97X)		6.5 t		7.49 t			8.0 t		
VKB		712	715	812	815	818	815	818	823
Engine type		OM 904 LA	OM 904 LA	OM 904 LA	OM 904 LA	OM 904 LA	OM 904 LA	OM 904 LA	OM 906 LA
Number of cylinders		4R	4R	4R	4R	4R	4R	4R	6R
Output	kW/bhp	90/122	110/150	90/122	110/150	130/177	110/150	130/177	170/231
	rpm	2,200	2,200	2,200	2,200	2,200	2,200	2,200	2,200
Maximum torque	Nm	470	580	470	580	675	580	675	810
	rpm	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600
Cab	S(F07)	S	S	S	S	S	S	S	S
	M(F20)	•	•	•	•	•	•	•	•
	L(F04)	•	•				•	•	•
	F04+DD5	•	•				•	•	•
Transmission		G256-6	G60-6	G60-6	G60-6	G60-6	G60-6	G60-6	G85-6
 Wheelbase (mm)	3,020		•	•	•	•			
	3,320	•	•	•	•	•			•
	3,620	•	•	•	•	•			•
	4,220	•	•	•	•	•			•
	4,820					•	•		•
 L	3,020		•		•	•	•	•	
	3,320				•	•	•	•	
	3,620				•	•	•	•	•
	4,220		•				•	•	•
	4,820						•	•	•
 A	3,020				•	•			
	3,260								
 K	3,020						•	•	•
	3,320					•	•		
 KK	3,320					•	•	•	•
 AK	3,260								
Permissible axle loads and weights (kg)	A.1	2,900	2,900	3,200	3,200	3,200	3,400	3,400	3,400
	A.2	3,800	3,800	4,600	4,600	4,600	5,000	5,000	5,000
	Total	6,500	6,500	7,490	7,490	7,490	8,000	8,000	8,000
Permissible total gross combination weight		13,000	13,000	13,000	18,000	18,000	18,000	20,000	20,000




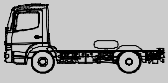

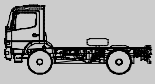
2.1 Vehicle and model designations

(BM 97X)		9.5 t			10.5 t			12 t m. R.		
VKB		915	918	923	1015	1018	1023	1215	1218	1223
Engine type		OM 904 LA	OM 904 LA	OM 904 LA	OM 904 LA	OM 904 LA	OM 906 LA	OM 904 LA	OM 904 LA	OM 906 LA
Number of cylinders		4R	4R	4R	4R	4R	6R	4R	4R	6R
Output	kW/bhp	110/150	130/177	170/231	110/150	130/177	170/231	110/150	130/177	170/231
	rpm	2,200	2,200	2,200	2,200	2,200	2,200	2,200	2,200	2,200
Maximum torque	Nm	580	675	810	580	675	810	580	675	810
	rpm	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600
Cab	S(F07)	S	S	S	S	S	S	S	S	S
	M(F20)	•	•	•	•	•	•	•	•	•
	L(F04)	•	•	•	•	•	•	•	•	•
	F04+DD5	•	•	•	•	•	•	•	•	•
Transmission		G56-6	G56-6	G85-6	G60-6	G60-6	G85-6	G56-6	G60-6	G85-6
 Wheelbase (mm)	3,020	•	•	•	•	•				
	3,320	•	•	•	•	•				
	3,620	•	•	•	•	•	•			
	3,560							•	•	•
	4,160							•	•	•
	4,220	•	•	•	•	•	•			
	4,760							•	•	•
	4,820					•	•			
	5,360							•	•	•
 L	3,020									
	3,320									
	3,620	•	•	•	•	•				
	3,560							•	•	•
	4,160							•	•	•
	4,220	•	•	•	•	•	•			
	4,760							•	•	•
	4,820	•	•	•	•	•	•			
	5,360							•	•	•
 A	3,020	•	•	•						
	3,260					•	•			
 K	3,020	•	•	•						
	3,320									
Permissible axle loads and weights (kg)	A.1	3,800	3,800	3,800	4,300	4,300	4,300	4,400	4,400	4,400
	A.2	6,200	6,200	6,200	6,700	6,700	6,700	8,100	8,100	8,100
	Total	9,500	9,500	9,500	10,500	10,500	10,500	11,990	11,990	11,990
Permissible total gross combination weight		13,000	13,000	22,000	18,000	22,000	24,000	15,500	15,500	15,500


## 2.1 Vehicle and model designations

(BM 97X)		9.5 t			10.5 t			12 t m. R.		
VKB		915	918	923	1015	1018	1023	1215	1218	1223
Engine type		OM 904 LA	OM 904 LA	OM 904 LA	OM 904 LA	OM 904 LA	OM 906 LA	OM 904 LA	OM 904 LA	OM 906 LA
Number of cylinders		4R	4R	4R	4R	4R	6R	4R	4R	6R
Output	kW/bhp	110/150	130/177	170/231	110/150	130/177	170/231	110/150	130/177	170/231
	rpm	2,200	2,200	2,200	2,200	2,200	2,200	2,200	2,200	2,200
Maximum torque	Nm	580	675	810	580	675	810	580	675	810
	rpm	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600
 KK										
	3,320	•	•	•						
 AK										
	3,260					•	•			
Permissible axle loads and weights (kg)	A.1	3,800	3,800	3,800	4,300	4,300	4,300	4,400	4,400	4,400
	A.2	6,200	6,200	6,200	6,700	6,700	6,700	8,100	8,100	8,100
	Total	9,500	9,500	9,500	10,500	10,500	10,500	11,990	11,990	11,990
Permissible total gross combination weight		13,000	13,000	22,000	18,000	22,000	24,000	15,500	15,500	15,500





## 2.1 Vehicle and model designations

(BM 97X)		12 t				13.5 t		
VKB		1215	1218	1223	1228	1318	1323	1328
Engine type		OM 904 LA	OM 904 LA	OM 906 LA	OM 906 LA	OM 904 LA	OM 906 LA	OM 906 LA
Number of cylinders		4R	4R	6R	6R	4R	6R	6R
Output	kW/bhp	110 / 150	130 / 177	170 / 231	205 / 279	130 / 177	170 / 231	205 / 279
	rpm	2,200	2,200	2,200	2,200	2,200	2,200	2,200
Maximum torque	Nm	580	675	810	1,100	675	810	1,100
	rpm	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600
Cab	S(F07)	S	S	S	S	S	S	S
	M(F20)	•		•	•	•	•	•
	L(F04)	•	•	•	•	•	•	•
	F04+DD5	•	•	•	•	•	•	•
Transmission		G56-6	G60-6	G85-6	G131-9	G60-6	G85-6	G131-9
Wheelbase (mm)								
	3,560	•	•	•	•	•	•	•
	4,160	•	•	•	•	•	•	•
	4,760	•	•	•	•	•	•	•
	5,360		•	•	•	•	•	•
	5,960		•	•	•			
	6,260		•	•	•	•		
L								
	3,560							
	4,160							
	4,760	•	•	•	•	•		•
	5,360	•	•	•	•	•	•	•
	3,260					•	•	
A								
	3,560					•	•	•
K								
	3,260							
KK								
	3,560		•	•				
AK								
	3,260					•	•	
Permissible axle loads and weights (kg)	A.1	4,400	4,400	4,400	4,400	5,000	5,000	5,000
	A.2	8,100	8,100	8,100	8,100	9,000	9,000	9,000
	Total	11,900	11,900	11,900	11,900	13,500	13,500	13,500
Permissible total gross combination weight		15,500	22,000	24,000	28,000	22,000	22,000	28,000

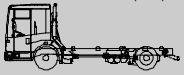
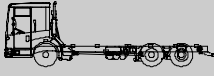
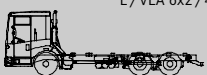

## 2.1 Vehicle and model designations

(BM 97X)		12 t				13.5 t		
VKB		1215	1218	1223	1228	1318	1323	1328
Engine type		OM 904 LA	OM 904 LA	OM 906 LA	OM 906 LA	OM 904 LA	OM 906 LA	OM 906 LA
Number of cylinders		4R	4R	6R	6R	4R	6R	6R
Output	kW / bhp	110 / 150	130 / 177	170 / 231	205 / 279	130 / 177	170 / 231	205 / 279
	rpm	2,200	2,200	2,200	2,200	2,200	2,200	2,200
Maximum torque	Nm	580	675	810	1,100	675	810	1,100
	rpm	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600
 LS							•	•
	3,260 3,560						•	•
Permissible axle loads and weights (kg)	A.1	4,400	4,400	4,400	4,400	5,000	5,000	5,000
	A.2	8,100	8,100	8,100	8,100	9,000	9,000	9,000
	Total	11,900	11,900	11,900	11,900	13,500	13,500	13,500
Permissible total gross combination weight		15,500	22,000	24,000	28,000	22,000	22,000	28,000

2.1 Vehicle and model designations

(BM 97X)		15 t		
VKB		1518	1523	1528
Engine type		OM 904 LA	OM 906 LA	OM 906 LA
Number of cylinders		4R	6R	6R
Output	kW / bhp	130 / 177	170 / 231	205 / 279
	rpm	2,200	2,200	2,200
Maximum torque	Nm	675	810	1,100
	rpm	1,200-1,600	1,200-1,600	1,200-1,600
Cab	S(F07)	S	S	S
	M(F20)	•	•	•
	L(F04)	•	•	•
	F04+DD5	•	•	•
Transmission		G60-6	G85-6	G100-12
 Wheelbase (mm)	3,560	•	•	•
	4,160	•	•	•
	4,760	•	•	•
	5,360	•	•	•
	5,960			
	6,260			
 L	3,560	•	•	•
	4,160	•	•	•
	4,760	•	•	•
	5,360	•	•	•
	3,260			
 A	3,560	•	•	
 K	3,260	•	•	•
 KK	3,560			
 AK	3,260		•	•
 LS	3,260			
	3,560			
Permissible axle loads and weights (kg)	A.1	5,100	5,100	5,100
	A.2	10,500	10,500	10,500
	Total	15,000	15,000	15,000
Permissible total gross combination weight		22,000	28,000	34,000

## 2.1 Vehicle and model designations

		18 t			26 t	
VKB		1823	1828	1833	2628	2633
Engine type		OM 906 LA	OM 906 LA	OM 926 LA	OM 906 LA	OM 926 LA
Number of cylinders		6R	6R	6R	6R	6R
Output	kW/bhp	170/231	205/279	240/326	205/279	240/326
	rpm	2,200	2,200	2,200	2,200	2,200
Maximum torque	Nm	810	1,100	1,300	1,100	1,300
	rpm	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600	1,200-1,600
Cab	FH7	S	S	S	S	S
	FH8	●	●	●	●	●
Transmission		MD 3060	MD 3060	MD 3066	MD 3060	MD 3066
 Wheelbase (mm) LL 4x2	3,900	●	●	●		
	4,200	●	●	●		
	4,500	●	●	●		
 L/NLA 6x2/4	3,900				●	●
	4,200				●	●
	4,500				●	●
	4,800				●	●
 L/VLA 6x2/4	3,150				●	●
	3,450				●	●
	3,900				●	●
	4,200				●	●
 LL 6x4	3,900				●	●
	4,200				●	●
Permissible axle loads and weights (kg) LL 4x2	A.1	7,100	7,100	7,100		
	A.2	11,500	11,500	11,500		
	Total	18,000	18,000	18,000		
Permissible total gross combination weight			36,000	36,000		
Permissible axle loads and weights (kg) L/NLA 6x2/4	A.1				7,100	7,100
	A.2				11,500/7,100	11,500/7,100
	A.3				25,700	25,700
Permissible total gross combination weight				36,000	36,000	
Permissible axle loads and weights (kg) L/VLA 6x2/4	A.1				7,100	7,100
	A.2				7,100/11,500	7,100/11,500
	A.3				25,700	25,700
Permissible total gross combination weight				36,000	36,000	
Permissible axle loads and weights (kg) LL 6x4	A.1				7,500	7,500
	A.2				9,500/9,500	9,500/9,500
	A.3				26,000	26,000
Permissible total gross combination weight				36,000	36,000	

## 2.1 Vehicle and model designations

<b>Legend</b>	
VKB	Sales designation
S	Standard available
<b>Example of transmission designation</b>	
G 211-16	G = Transmission 211 = Maximum input torque (x10 in Nm) 16 = Number of gear speeds
A	All-wheel-drive platform truck
AK	All-wheel-drive tipper vehicle
AS	All-wheel-drive semitrailer tractor vehicle
B	Cement mixer vehicle
K	Tipper vehicle
L	Air-sprung platform truck
LK	Air-sprung tipping vehicle
LS	Air-sprung semitrailer tractor vehicle
LL	Fully air-sprung vehicle
LS/NR	Air-sprung semitrailer tractor vehicle / low frame
KK	Crane-tipper vehicle
S	Semitrailer tractor vehicle
NR	Low frame
NRA	Low frame / Car transporter
NRL	Low frame / Lowliner
DNA	Twin-tyred trailing axle
NLA	Trailing axle
VLA	Leading axle
A.1	1st axle
A.2	2nd axle
A.3	3rd axle
Total	Total
<b>Wheel formulae</b>	
4 x 2	Two-axle vehicle with driven rear axle
4 x 4	Two-axle vehicle with all-wheel drive
6 x 4	Three-axle vehicle with two driven rear axles
6 x 6	Three-axle vehicle with all-wheel drive
6 x 2 DNA	3-axle vehicle with driven rear axle and a twin-tyred trailing axle
6 x 2 NLA	Rear axle and second rear axle as rigid trailing axle
6 x 2 / 4 NLA	3-axle vehicle with a driven rear axle and second rear axle as steered trailing axle
6 x 2 / 4 VLA	3-axle vehicle with a steered leading axle and driven rear axle
6 x 2 / 2 VLA	3-axle vehicle with a rigid leading axle and driven rear axle
8 x 4 / 4	4-axle vehicle with two driven rear axles and two steered front axles
8 x 6 / 4	4-axle vehicle with two driven rear axles and two steered front axles, of which the first front axle is driven
8 x 8 / 4	4-axle vehicle with all-wheel drive and two steered front axles

## 2.2 Technical advice and contacts

### 2.2 Technical advice and contacts

The staff members of the TPC / MVC department, the team responsible for conversion / body manufacturers and the body / equipment mounting directives for the overall vehicle development of Mercedes-Benz trucks, issue certificates of endorsement for the Mercedes-Benz ACTROS, AXOR, ATEGO and ECONIC series and answer

technical and design-engineering questions regarding vehicle registration and product liability. The relevant members of staff can be contacted on:

<b>Telephone:</b>	07 11-17-5 82 11	ATEGO (BM 97X) Fire brigade (all trucks)
	07 11-17-5 44 15 07 11-17-5 84 25	ACTROS (BM 93X), AXOR (BM 94X and 95X) ECONIC
	07 11-17-5 17 19	Team management and basic questions on all series
<b>Fax:</b>	07 11-17-5 21 91	
<b>Postal address:</b>	DaimlerChrysler AG HPC (Hauspostcode) C 108 Abteilung TPC / MVC D-70546 Stuttgart, Germany	

If you have questions, suggestions or criticism regarding these body / equipment mounting directives, you can contact the Conversions & Body Manufacturers team; Body / Equipment Mounting Directives, at the e-mail address shown on our website:

**<http://bb-portal.mercedes-benz.com>**

## 2.3 Issuing certificates of endorsement

### 2.3 Issuing certificates of endorsement

#### 2.3.1 Certificate of endorsement

DaimlerChrysler AG does not issue body / equipment approval certificates for bodies not manufactured by Mercedes-Benz. It only provides body manufacturers with important information and technical guidelines for the correct handling of the product by means of these directives. DaimlerChrysler AG therefore recommends that all work on the basic vehicle and body is carried out in accordance with these Mercedes-Benz body / equipment mounting directives.

DaimlerChrysler AG advises against bodies and equipment, fittings and conversions which:

- are not manufactured in accordance with the Mercedes-Benz body / equipment mounting directives
- exceed the permissible gross vehicle weight
- would exceed the permissible axle loads

DaimlerChrysler AG issues certificates of endorsement on a discretionary basis, based on the following requirements:

DaimlerChrysler AG bases its evaluation exclusively on the documents submitted by the body manufacturer carrying out the conversion. It inspects and declares safe only the explicitly described scopes and their general compatibility with the chassis specified and its connection points or, in the case of chassis modifications, the basic constructional permissibility for the specified chassis. The certificate of endorsement does not apply to the design of the bodywork as a whole, nor its functions or intended use. The endorsement is only valid if the design, production and installation carried out by the body manufacturer is effected to the state of the art and in accordance with the applicable Mercedes-Benz body / equipment mounting directives – unless deviations have been endorsed in these directives. The certificate of endorsement does not absolve the body manufacturer carrying out the modifications from product liability or the obligation to carry out its own calculations, checks and tests of the entire vehicle to ensure

the operating safety, road safety and handling characteristics of the entire vehicle it has manufactured. It is thus the sole responsibility of the body manufacturer to ensure the compatibility of the body, equipment, fittings or conversions with the basic vehicle, as well as to guarantee the operating and road safety of the entire vehicle.

**Comply with all national laws, guidelines and vehicle registration regulations.**

## 2.3 Issuing certificates of endorsement

### 2.3.2 Documents required

In particular cases, the body drawings may be presented to the responsible department before the work is commenced (▷ page 32). The drawings must contain the following information:

- All deviations from the Mercedes-Benz body / equipment mounting directives
- Complete data on dimensions, weights and centre of gravity (weight certificates).
- Body mounting to the vehicle.
- Conditions of vehicle operation, e.g.
  - on poor roads
  - in very dusty conditions
  - at high altitude
  - at extremely high or low ambient temperatures
- Certification (e mark, seat tensile strength test, etc.)

Submitting the required documentation in full will make queries on our part unnecessary and will speed up processing.

If complex calculations and / or vehicle tests are required for the endorsement, the resulting costs must be borne by the company carrying out the conversion or manufacturing the body, or by this company's customer. The relevant department of Mercedes-Benz Truck Development will determine the scope of the testing required (▷ page 32).

### 2.3.3 Legal claim

- No legal claim to the issue of a certificate of endorsement can be made.
- DaimlerChrysler AG reserves the right to refuse to grant a certificate of endorsement if ongoing technical development and the knowledge gained from it render such a refusal necessary, even if a similar certificate was granted in the past.
- The certificate of endorsement may be limited to single vehicles.
- The retroactive granting of a certificate of endorsement for vehicles already completed or delivered can be refused.

The body manufacturer alone is responsible for:

- the functionality and compatibility of the body and its equipment, fittings and conversion with the basic vehicle
- operating and road safety
- all attachments, bodies, equipment or modifications and fitted parts

## 2.4 Product liability

Legal product liability is the liability of a manufacturer for any consequential damage arising to the user of the product or a third party and caused by the product not possessing the degree of operating safety which the injured party can reasonably expect.

With regard to product liability, attention is drawn to the following points:

Each manufacturer is liable for the products it manufactures. As manufacturer of Mercedes-Benz vehicles, DaimlerChrysler AG is accordingly only liable for its own designs and products.

DaimlerChrysler AG does not therefore accept any liability for damage resulting from defects in retrofitted products produced by third-party manufacturers.

The vehicle body manufacturer / modifier shall bear sole responsibility for:

- the operating and road safety of the body
- the operating and road safety of parts and conversion parts
- testing and maintaining the operating and road safety of the entire vehicle after assembly (handling, braking and steering characteristics must not be adversely affected by assembly)
- the effects of parts or conversion parts on the chassis
- consequential damage resulting from the attachment, special-purpose body, installation or conversion
- consequential damage resulting from retrofitted electrical and electronic systems
- operating safety and freedom of movement of all moving parts of the chassis after the bodywork conversion (e.g. axles, springs, propeller shafts, steering, transmission linkage, etc.) even in the case of diagonal torsion with respect to the add-on equipment.

Work carried out on or modifications made to the chassis or bodywork must be entered in the "Confirmations by the body manufacturer" section of the Maintenance Booklet.

## 2.5 Warranty claims

Warranty claims can only be made within the framework of the contract of sale between purchaser and seller.

This means that each seller is liable to the purchaser for the items supplied by the former to the latter.

In the following cases in particular, DaimlerChrysler AG will assume no liability:

- if the vehicle used does not correspond to the equipment version for the country in question and field of operation
- for damage caused by the body itself or the manner in which it is mounted.

## 2.6 Information portal for body manufacturers

### 2.6 Information portal for body manufacturers

As a body manufacturer, you play a crucial part in the implementation of customer requirements. The information portal for body manufacturers has been developed to enable us, in the future, to inform you more efficiently about modifications to our products and to ensure smooth, time-saving procedures.

Product quality is essential for our business success. Therefore, it is in the interests of all concerned that the products manufactured are faultless and safe. In companies with a sense of commitment, the sharing and exchanging of information must be considered the best strategy for success when it comes to achieving the desired degree of quality and customer satisfaction.

The new Mercedes-Benz information portal for body manufacturers combines the previous body manufacturers' portal and the very successful MB-AS PC program in one portal.

**<http://bb-portal.mercedes-benz.com>**

#### 2.6.1 Body manufacturer profile

In the body manufacturer profile area you can enter and update your own data and information in the templates. In addition to your general address, your company's master data, contact persons and product information, details about quality management, sales and service will be requested.

DaimlerChrysler AG requires this information for an evaluation which, can lead to a recommendation for your company from DaimlerChrysler AG. Such a recommendation from DaimlerChrysler AG is a prerequisite for a general contractorship, a consignment contract and an entry in the Branch Information Center (BIC).

### 2.6.2 MB-AS (Mercedes-Benz body / equipment manufacturer system)

The MB-AS provides you with information about chassis for commercial vehicles. All the information required is concisely laid out on a user-friendly, attractive platform.

The following are available:

- Tender drawings with possible combinations of optional equipment for the fuel tank, exhaust, air intake, cab and rear frame overhang
- Technical data sheets
- Order data (delivery date, configuration)
- Power take-off drawings in installation position
- Optional equipment weights
- Body / equipment manufacturer information
- Descriptions of electric interfaces for the body manufacturer

#### 2.6.3 Contact persons database

The contact person database / contact person search facility provides you with an extensive tool for finding the competent contact person at DaimlerChrysler AG on a given topic. This allows you to find the information you require quickly and easily, without tedious research.

You can access the contact person database at

**<http://mbas.mercedes-benz.de>**

You can browse through the predefined topics, or search the database by key words. As a result you will find the relevant contact person by name, with their phone number, fax number and e-mail address listed.

## 2.6 Information portal for body manufacturers

### 2.6.4 Faxback system

Vehicle data can be called up and printed out using a fax machine with "faxback" function.

Additional information on this is provided in the user's manual for the fax machine. After selecting the faxback function and entering the number +49 (0)7 11-17-86 40 40, you will receive the MB-AS title page containing a summary of the information categories available and their faxback numbers.

A total of approximately 4,500 technical data sheets and over 5,000 tender drawings as well as additional information for vehicle body manufacturers / modifiers is available on faxback.

All vehicle information available, the PC program and all services associated with the faxback system are free of charge.

You can obtain further advice on the information portal for body manufacturers and the faxback system by telephone on +49 (0)711-17- 3 33 22 or by e-mail at

**[mbas.hotline@daimlerchrysler.com](mailto:mbas.hotline@daimlerchrysler.com)**

### 2.6.5 Workshop Information System (WIS)

The Workshop Information System (WIS) is available to you as an additional source of information.

For example, in the WIS you will find:

- Basic data (dimensions, tightening torques)
- Function descriptions
- Wiring diagrams
- Repair instructions
- Maintenance sheets

Information about the WIS can be obtained from any Mercedes-Benz Service Centre or from:

<b>Telephone:</b>	+49 (0)711-17-83170
<b>Fax:</b>	+49 (0)711-17- 40082
<b>Postal address:</b>	DaimlerChrysler AG HPC (in-house postcode) R800 Department GSP /TIM D-70546 Stuttgart, Germany

## 2.7 Mercedes star and logo

The Mercedes star and Mercedes-Benz logo are trademarks of DaimlerChrysler AG.

They may not be removed or attached to another point without approval.

Mercedes-Benz stars and Mercedes-Benz logos supplied separately must be attached at the points specified by Mercedes-Benz.

### Vehicle rear end positions

The Mercedes-Benz logo must be attached on the rear of the vehicle at the bottom right when viewed in the direction of travel.

### Appearance of the entire vehicle

If the vehicle fails to comply with the vehicle image and the quality standards required by Mercedes-Benz, the trademarks such as the Mercedes star and the Mercedes-Benz emblem must be removed.

### Third-party trademarks

- may not be affixed next to Mercedes-Benz trademarks
- may only be affixed to other points on the vehicle with permission from the relevant department of DaimlerChrysler AG (▷ page 32).

## 2.8 Reprocessing components – recycling

### 2.8 Reprocessing components – recycling

#### Environmental note



When planning attachments, bodies, equipment and modifications, the following principles for environmentally-compatible design and material selection shall be taken into account, in particular with regard to EU Directive 2000 / 53 / EC.



Additional information is provided in the "Commercial vehicle recycling, ecology and economy" brochure, Order no. 6702 6187 00-00 / 0952 (▷ page 37).

Materials with risk potential, such as halogen additives, heavy metals, asbestos, CFCs and CHCs, are to be avoided.

- It is preferable to use materials which permit recycling and closed material cycles.
- Materials and production processes that generate only low quantities of waste during production must be selected such that this waste can be easily recycled.
- Plastics are to be used only where they provide advantages in terms of cost, function or weight.
- In the case of plastics, and composite materials in particular, only compatible substances within one material family are to be used.
- For components which are relevant to recycling, the number of different types of plastics used must be kept to a minimum.
- It must be assessed whether a component can be made from recycled material or admits the addition of recycled components.
- Ensure that all recyclable components can be easily dismantled for recycling purposes, e.g. using snap connections, pre-weakened points, easy accessibility, and that their dismantling only requires the use of standard tools.

- It must be ensured that service products can be removed simply and in an environmentally-compatible manner by means of drain plugs, etc.
- Painting and coating components are to be avoided wherever possible; coloured plastic parts should be used instead.
- Components in areas at risk from accidents must be designed in such a way that they are damage-tolerant, repairable and easy to replace.
- All plastic parts are to be marked in accordance with VDA code of practice 260, e.g. "PP – GF30R".
- EU Directive 2000 / 53 / EC must be complied with.



## 2.9 Quality assurance system

Worldwide competition, increasingly stringent quality requirements of the entire product by customers, national and international product liability laws, new forms of organisation and increasing cost pressures require effective quality assurance systems in all areas of the automotive industry.

To be able to meet these requirements, a work group of the VDA (Association of German Automobile Manufacturers) has developed a "Guide to quality assurance for the manufacturers of trailers, bodies and containers" as VDA volume 8, based on DIN EN ISO 9000 ff.

For the above reasons, DaimlerChrysler AG strongly recommends that body manufacturers set up a quality management system with the following minimum requirements:

- Does the quality management system clearly determine responsibility and authority?
- Is there a description of processes / workflows?
- Are the contracts checked / is the feasibility of construction checked?
- Are product checks on the basis of specified instructions carried out?
- What provisions are made for the handling of faulty products?
- Are the inspection results documented and archived?
- Do all employees concerned have currently valid proof of the qualification required?
- Is the test equipment systematically monitored?
- Is there a system for labelling materials / parts?
- Are quality assurance measures carried out at suppliers?