



**Production Control
Supplier
Packaging/Labeling
Manual**

Supplier Packaging/Labeling Manual

Rev. 2 - March, 2010

This document is controlled by:

AM General, LLC.
Production Control Department
12900 McKinley Hwy
Mishawaka, IN 46545.

All prior editions are obsolete and should not be used.

It is the user's responsibility to assure that only the latest revision of this standard is used. (Go to www.AMGENERAL.com for the current standard.)

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1.0 Introduction

- 1.1 **Purpose:** To clearly define packaging and labeling requirements to AM General suppliers.
- 1.2 **Scope:** This standard applies to direct material items shipped into participating AM General's facilities.
- 1.3 **Partnership:** Packaging development requires partnership. It can only function as intended when both supplier and customer work together from proposal through implementation. And then, it is absolutely crucial that both parties adhere to authorized packaging. The key is open, two-way communication.
- 1.4 **Delivery Performance Rating:** A supplier's conformance to this standard and adherence to authorized packaging is factored into the supplier's "Delivery Performance Rating" as defined in AM General's Supplier Quality Performance Manual.

2.0 Supplier Responsibility

- 2.1 **General Statements:**
 - 2.1.1 The supplier is responsible for the packaging of direct materials to assure their proper condition and quality upon delivery to AM General. **Parts must arrive at AM General without damage, rust/corrosion, or contamination.** Packaging shall be defined and agreed upon prior to the first direct material shipment to AM General.
 - 2.1.2 **Although packaging authorization is required, such authorization does not relieve the supplier of their responsibility to ensure adequate packaging for proper delivery of parts to AM General.**
 - 2.1.3 Packaging shall not be a source of contamination. Barrier materials, (e.g. plastic bags), may be required. The supplier shall be responsible to wash returnable packaging when necessary.
 - 2.1.4 Packaging is part of the supplier manufacturing process and shall be included as appropriate in the supplier's FMEA, Quality Plan, Source Release Plan, PPAP when these "tools" are used.
 - 2.1.5 Standard Packaging - Each supplier shall utilize a single size container, package, and/or pallet containing a standard quantity for each part number supplied. This requirement shall be valid for expendable and returnable packaging.
 - 2.1.6 The supplier is responsible for completing and submitting the AM General Packaging Data Sheet to the appropriate AM General packaging representative.
- 2.2 **Submit Proposal:** All packaging "modifications" or "new" proposals require authorization. (See section 9.0)
- 2.3 **Laboratory simulation testing** may be required and should be considered by the supplier to assure that the product and packaging will withstand "real-world" load conditions, handling, and any applicable transportation modes that may become necessary. If testing is required, contact your AM General packaging representative.
- 2.4 A **sample shipment** may be required to test and prove that the packaging withstands delivery conditions and to allow AM General to review the packaging. (See section 4.0)
- 2.5 **Identification of Shelf Life:** Supplier must identify the shelf life of materials for each item, package, or container. Such identification must include the standard identification requirements and the cure or manufacture date, expiration date and special storage and handling conditions.
- 2.6 **Returnable packaging** shall be used when it is cost effective or when it is needed to meet specific AM General objectives. When returnable packaging is not justifiable or feasible, environmentally friendly materials (recyclable)

shall be used. If returnable packaging is required, suppliers shall be responsible for storing returnable packaging at their site in an environment conducive to cleanliness.

- 2.7 AM General expects suppliers to proactively support and participate in actions to assure that the following conditions always exist when returnable packaging is utilized:
1. The supplier uses the shipping pack as authorized. This pack has been designed to meet the requirements set forth in this document.
 2. Management of returnables and transportation logistics are performed in the most cost effective method compatible with delivery requirements.
 3. An established minimum number of containers are available at the supplier's location when they are needed.
 4. The supplier shall have authorized back-up packaging available. The internal dimensions and quantity of parts in the back-up packaging shall be the same as the authorized returnable packaging. The external dimensions shall not exceed the dimensions of the returnable packaging. Whenever back-up packaging is used, AM General shall be notified prior to shipping with an explanation.
 5. Parts must arrive at AM General without damage, rust/corrosion, or contamination.
 6. AM General owned packaging shall not be used for storage and shipment of non-AM General owned parts.

In addition, suppliers are expected to notify AM General immediately in the event that containers are returned to the supplier:

1. With supplied direct materials (parts) inside,
2. Not properly identified (e.g. incorrect address),
3. Without the full complement of returnable packaging components in the correct proportions (e.g. no lids, or more lids than totes),
4. With trash or other foreign materials inside,
5. Not properly prepared for safe transport (e.g. totes are banded or stretch wrapped to the pallet versus being stacked loosely),
6. At a lower return rate than full packs being shipped to AM General.

3.0 Packaging Alternatives and Requirements

3.1 Requirements:

- a. Returnables using AIAG bulk containers, pallets, and totes that cube-out on AIAG standard footprint sized pallets (45" x 48" , 30" x 36", or 30" x 32") (Preferred Method)
- b. Expendable
- c. Expendable/Returnable Combination

3.2 Alternatives: *(Exceptions are subject to specific approval by individual AM General facilities. Unique requirements may exist and may be required by individual plants.)*

3.2.1 Pallet-Load Dimensions: (Expendable or Returnable)

	<u>Face</u>	x	<u>Depth</u>		<u>Height, maximum</u>
+ Footprint Size:	48" (1150mm)	x	45" (1220mm)	AIAG Standard	51" (1295mm)
(pallet)	32" (760mm)	x	30" (820mm)	AIAG Standard	40" (1016mm)
	36" (914mm)	x	30" (820mm)	AIAG Standard	40" (1016mm)
	1200mm	x	1000mm	European Standard	1000mm
	1200mm	x	800mm	European Standard	1000mm
	44" (1120mm)	x	36" (915mm)	AMG European Standard	40" (1016mm)

- + Height Restriction: Includes pallet
- + No material shall extend over the pallet edge.

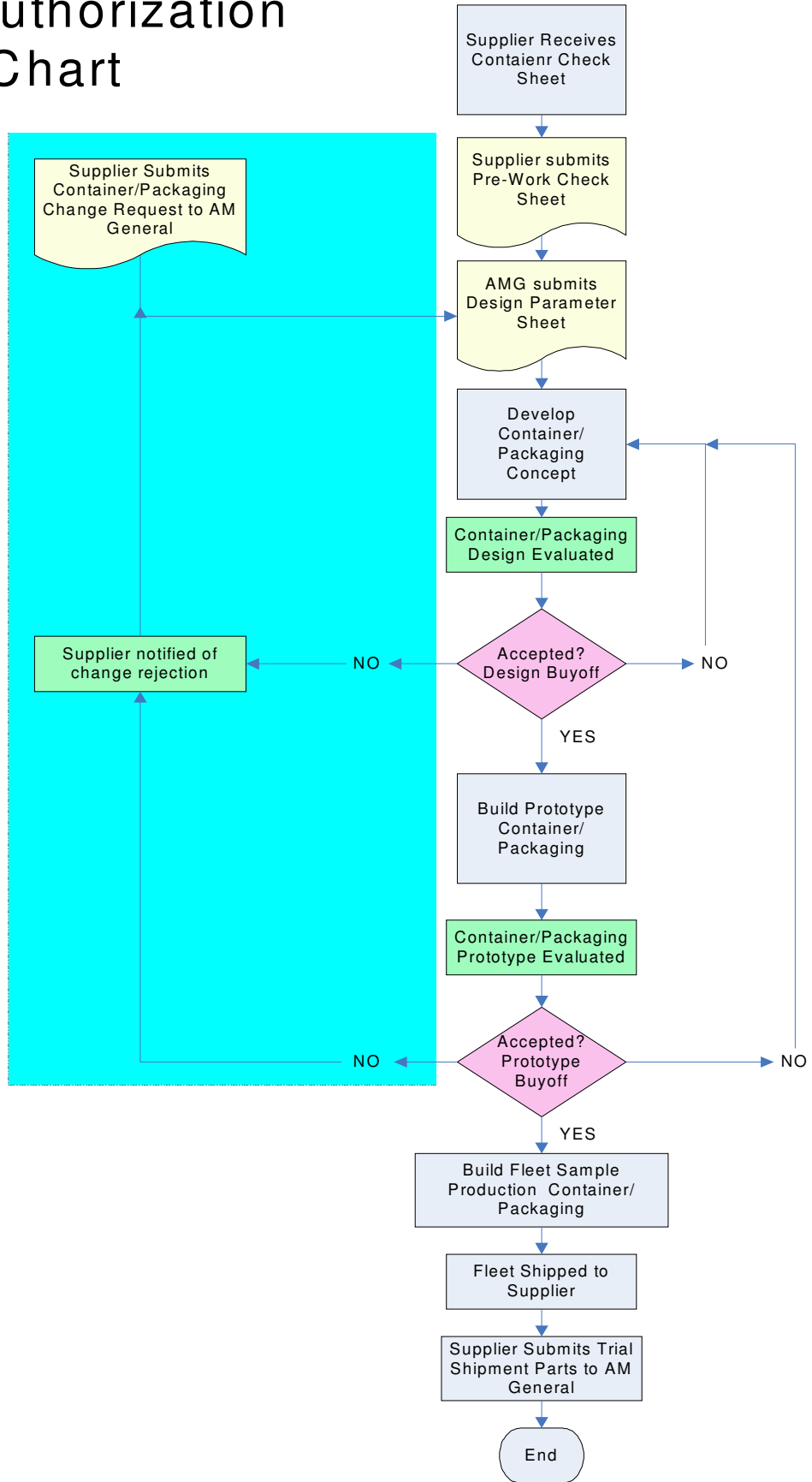
Note: European pallets or other pallet sizes require specific plant approval.

- 3.2.2 **Strapping Options:** (AM General prefers polyester strapping material that is friction welded rather than secured with a metal clip)
+ Non-Metallic Strap (Do NOT use metal banding)
+ Stretch Wrap or Shrink Wrap
+ Tape
+ Special "Seat Belt" Pallets (must be approved)
- 3.2.3 **Corner Boards:**
As required to protect the pack. Fiberboard is preferred.
- 3.2.4 **Corrugated Specifications:** Corrugated (paper fiber board) packaging material must have strength to adequately withstand transportation and handling rigors from the supplier's shipping dock to AM General's receiving dock. Corrugated packaging shall be of adequate strength to support multiple stacking of unit pallet loads. Corrugated material must have adequate ECT or burst test strength to protect the product.
+ Corrugated packaging shall not utilize metal staples.
+ If stacking exceptions are required, label accordingly: "DO NOT STACK, STACK ONLY 2 HIGH," etc.
- 3.2.5 **Weight Limitation:**
+ Max. Shipping Pack = 2,000 Lbs. (909 Kg) or as uniquely specified (may be plant specific)
+ Max. Sub Pack < 30 Lbs. (13.6 Kg)
- 3.2.6 **Pallet Style/Type:**
+ Wood
-All wood pallets shall conform to the National Wood Pallet Container Association Voluntary Standard for Wood pallets (NWPCA).
- AM General prefers stringer, double deck, non reversible, wood pallets. Stringers for wooden pallets shall have a minimum height of 3½".

+ All pallets shall be 4-way entry.
+ Pallets shall be capable of being conveyed on standard gravity or powered roller conveyor.
- 3.2.7 **Imports** into the U.S. utilizing wooden packaging shall be free of bark and pests and according to U.S. regulations. See Internet site for the most current regulations:
http://www.aphis.usda.gov/plant_health/
- 3.2.8 **Smallest packaging unit(s) such as plastic bags** may be considered to package parts inside totes, cartons, and/or bulk containers. However, when bags are used, they shall be marked with the AM General part number, quantity, and lot number or as uniquely specified. This label also requires bar code 39 (unless otherwise specified by a particular AM General facility).

4.0 Packaging Authorization

Packaging Authorization Flow Chart



5.0 Labeling Requirements

5.1 Introduction

The quality of the information on labels is essential. Bar code labels are required and used to eliminate opportunity for error. Errors made because of label deficiency are serious in nature. (Bar code print quality must pass verification per ANSI guidelines.)

Suppliers shall not include information relating to quality on shipping identification labels. The supplier shall not apply adhesive-backed color tags to any of the required labels described herein.

Individual AM General plants may deviate from the label requirements below. If a deviation is needed, the AM General plant will communicate that to the supplier.

5.1.1 AIAG Compliance:

Labels are to adhere to the specifications as detailed and illustrated in the Automotive Industry Action Group's publication "Shipping/Parts Identification Label Standard" (AIAG-B-10) Version 3, June 2004. For a copy or additional information contact the Automotive Industry Action Group at (248)-358-3003, 26200 Lahser Road, Suite 200, Southfield, Michigan 48034-7100, or their web site: <http://www.aiag.org/>

Excerpts of AIAG-B-10 are included herein. Areas of the label not specified in AIAG-B-10, left to AM General's option, are denoted by (*). In case of conflict, AM General Supplier Labeling Requirements take precedence.

Odette (VDA) Compliance:

For Odette labels, see Section 5.6

5.1.2 General Label Specifications:

+ Label Size (AIAG):

4.0 inches (102mm) high by 6.0 inches (152mm) or 6.5 inches (165mm) wide (refer to Exhibit 1).

+ Label Quantity and Placement:

Minimum 2 labels per Shipping Pack on 2 different sides. (unless otherwise specified by a particular AM General facility)

+ Label Color:

White in color with black printing. Option of colored labels if requested.

+ Adhesives:

Adhesive types can be pressure sensitive or dry gummed as long as adherence to the package substrate is assured and application is wrinkle-free. Note: If labels are applied to returnable packaging, the adhesive must not leave a residue after the label is removed, and the label must be easily removed without tearing. Paper is not preferred on returnable packaging.

+ Returnable Packaging:

Card holders are recommended to contain and protect labels in conjunction with returnable packaging. Adhesive-backed labels shall be applied directly to placards or to stretch/shrink wrap. DO NOT APPLY LABELS DIRECTLY TO THE RETURNABLE, unless the label stock is polyester material or equivalent AND the adhesive is classified as a "removable" type. The supplier is responsible for the removal of all old labels.

+ Data Identifiers:

Use data identifier codes as defined by ANSI DI/AI standard MLH10.8.2 available from the American National Standard Institute (212)-642-4900 or their web site: <http://www.ansi.org/>.

+ Human Readable Zeroes (0):

Show human readable zeroes (0) with a diagonal slash to differentiate them from alphabetic Os.

5.2 **Shipping/Parts I.D. Label**
 5.2.1 Data Layout and Titles

Label Data Layout and Titles:

AM General requires suppliers to provide 8 data areas within the label. These fields are:




1. Ship From
2. Ship To
3. Quantity
4. Part Number
5. License Plate
6. Material Handling
7. Logistics Reference
8. Shipment Date

Exhibit 1 – Shipping/Parts I.D. Label Layout (not to scale)

A1 SHIP FROM	A2 SHIP TO	
REFERENCE #1	B2 ROUTING INFORMATION	B3 LOGISTICS REFERENCE
C AMG PART NUMBER		
D1 LICENSE PLATE		D2 REFERENCE #2
E1 SUPPLIER AREA		E2 REFERENCE #3

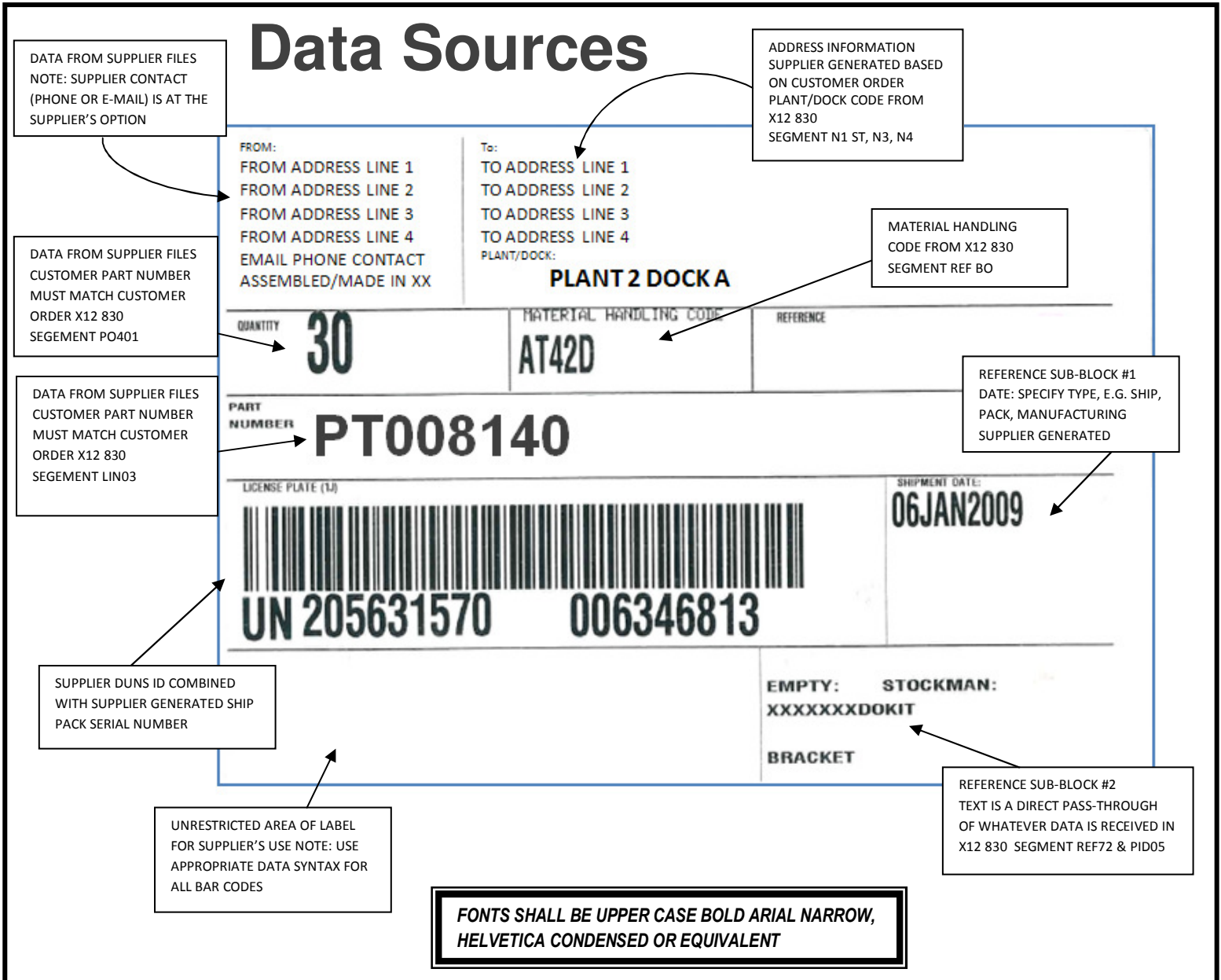
LABEL DIMENSIONS ARE NOMINAL - APPROXIMATELY 4" (102 MM) HIGH BY 6" (152 MM) WIDE

Exhibit 2 – Sample Shipping/parts I.D. Label (not to scale)

<small>FROM:</small> Alfield Industries 30 Aviva Park Drive Vaughan, On, CA L4L 9C7 MADE IN CANADA	<small>TO:</small> AM General Assembly Plant 2 13001 Jefferson Rd Mishawaka IN <small>PLANT BOOK</small> TZ AAA	
<small>QUANTITY</small> 30	<small>MATERIAL HANDLING CODE</small> AT42D	<small>REFERENCE</small>
<small>PART NUMBER</small> 15914176		
<small>LICENSE PLATE (13)</small>  UN 205631570 006346813		<small>SHIPMENT DATE:</small> 06JAN2009
		<small>EMPTY: STOCKMAN:</small> XXXXXXXXDOKIT <small>BRACKET</small>

5.2.2 Part Label Data Sources

Exhibit 3 – Part Label Data Sources



5.2.3 Label Data Format & Font Specs

Exhibit 4 – Part Label Format & Font Specs

FORMAT & FONT SPECS

From:
 6 Point 1.5 mm, 0.06"
Address 4 lines max
 10 Point, 2.5 mm, 0.1"
Phone Number (Optional)
 10 Point, 2.5 mm, 0.1"
Made in XXX or ASY in XXX
 10 Point, 2.5 mm, 0.1"

To:
 6 Point, 1.5 mm, 0.06"
 Address 4 lines max
 12 Point, 4.3 mm, 0.17"
Plant/Dock
 6 Point, 1.5 mm, 0.06"
Plant/Dock Text
 8 Characters max
 28 Point, 6.4 mm, 0.25"

Quantity:
 6 Point, 1.5 mm, 0.1"
Text
 36 Point, 9.17 mm, 0.36"

Material Handling Code
 6 Point, 1.5 mm, 0/06"
Material Handling Code Text
 8 Characters Max
 36 Point, 9.17 mm, 0.36"

Part Number:
 6 Point, 1.5 mm, 0.06"
Part Number Text:
 44 Point, 11.2 mm, 0.44"
 Graphic Optional
 Safety/Security, Right Justified

REFERENCE SUB-BLOCK #1
Shipment Date
 6 Point, 1.5 mm, 0.06"
Shipment Date Text (9 characters)
 18 Point, 6.4 mm, 0.25"

License Plate
 6 Point, 1.5 mm, 0.06"
Bar Code
 Code 128
 0.381 mm (15 mil) nominal
 Height 13 mm (0.5 inch) min
Data Identifier
 Assigning Authority: UN= DUNS
 9 digits DUNS number
 9 characters container serial number max
 Human Readable Text
 24 Point, 6.1 mm, 0.24"
 Note: Spaces are optional in human readable text only. SPACES SHALL NOT BE INCLUDED IN BAR CODE DATA

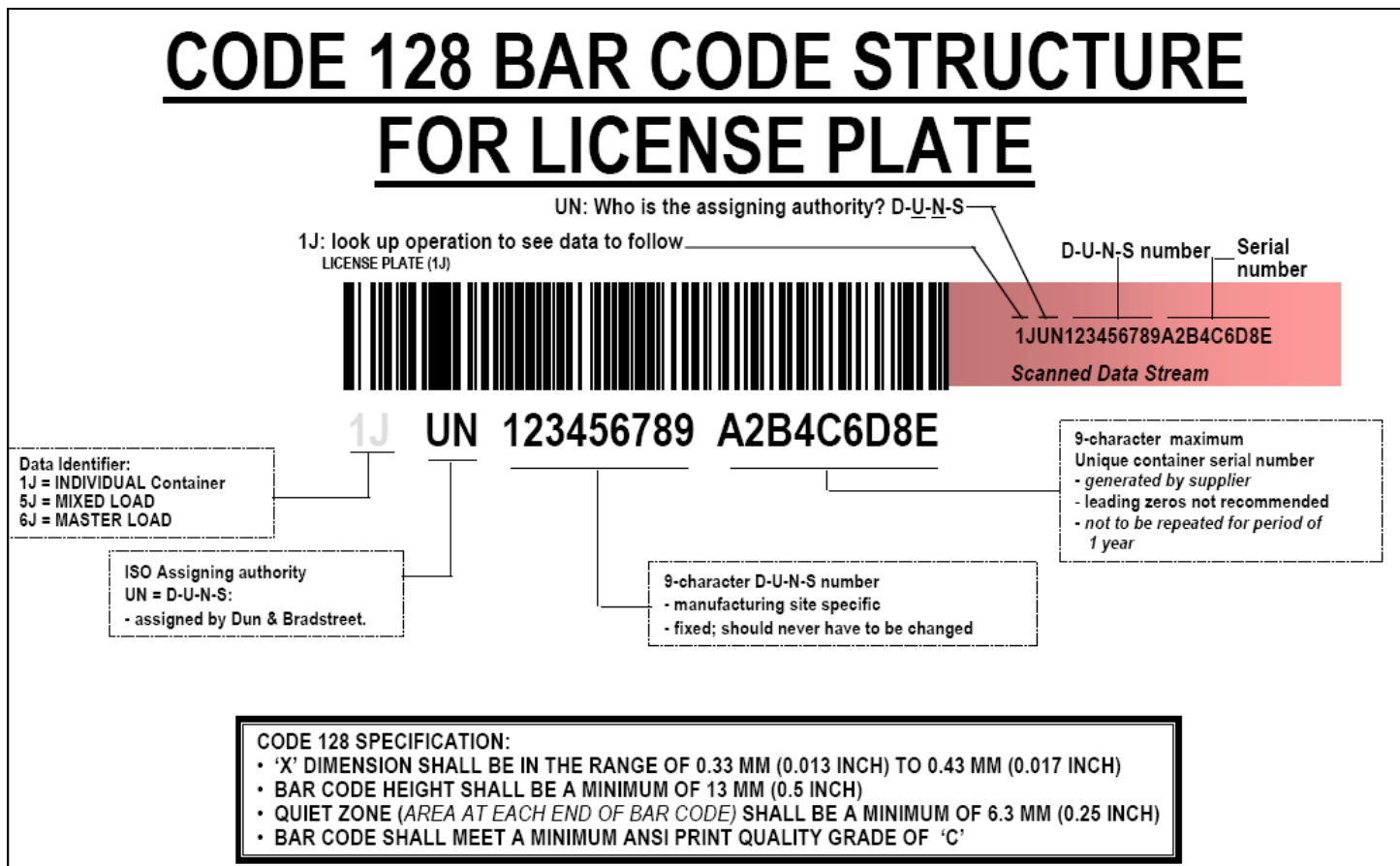
EMPTY: STOCKMAN:
 XXXXXXXDOKIT
BRACKET

REFERENCE SUB-BLOCK #2
 14 point, 3.6 mm, 0.14"

FROM: FROM ADDRESS LINE 1 FROM ADDRESS LINE 2 FROM ADDRESS LINE 3 FROM ADDRESS LINE 4 EMAIL PHONE CONTACT ASSEMBLED/MADE IN XX		To: TO ADDRESS LINE 1 TO ADDRESS LINE 2 TO ADDRESS LINE 3 TO ADDRESS LINE 4 PLANT/DOCK: PLANT 2 DOCK A	
QUANTITY 30	MATERIAL HANDLING CODE AT42D	REFERENCE	
PART NUMBER PT008140		REFERENCE SUB-BLOCK #1 Shipment Date 06JAN2009	
LICENSE PLATE (13)  UN 205631570 006346813		REFERENCE SUB-BLOCK #2	

5.2.4 Label Data License Plate Bar Code Structure

Exhibit 5 – License Plate Bar Code Structure



5.2.5 Label Data Identifiers (DIs)

Exhibit 6 – Part Label Data Identifier Table

DATA IDENTIFIERS (DIs) DEFINE THE NATURE OF THE DATA CONTAINED WITHING THE LINEAR BAR CODE. DIs ARE USED WITHIN THE 2D BAR CODE TO DEFINE THE NATURE OF THE DATA IN EACH FIELD. THE TABLE BELOW REPRESENTS TYPICAL DIs USED WITH COMMON GLOBAL SHIPPING LABEL TEMPLATES. ADDITIONAL DIs MAY BE USED AS BUSINESS PROCESSES REQUIRE AND SHALL CONFORM TO AIAG B10, B14, ANSI, AND ISO STANDARDS.				
DATA IDENTIFIER DI	DEFINITION	COMMENT	EXAMPLE	WITHIN 2D BAR CODE
P	AM GENERAL PART NUMBER	TYPICALLY EIGHT (8) ALPHA/NUMERIC CHARACTERS	PPT123456	REQUIRED
Q	PART QUANTITY	TYPICALLY EXPRESSED IN PIECES	Q150	REQUIRED
1J	LICENSE PLATE INDIVIDUAL CONTAINER OF LIKE PARTS	HAS STRUCTURE (SEE PAGE 8)	1JUN123456789A2B2C6D8E	REQUIRED
20L	MATERIAL HANDLING CODE	DELIVERY LOCATION WITHIN PLANT	20LEA34B	REQUIRED
21L	PLANT/DOCK CODE	IDENTIFIES PLANT AND DELIVERY DOCK	21LH2 A	REQUIRED
K	PO Number	IF USED AS PART OF AMG BUSINESS PROCESS	K559999999999	REQUIRED IF PROVIDED
15K	KANBAN NUMBER	IF USED AS PART OF AMG BUSINESS PROCESS	15KAT24B	REQUIRED IF PROVIDED
B	CONTAINER TYPE	AMG SPECIFIED CONTAINER NUMBER OR IF NOT SPECIFIED USE SUPPLIER REFERENCE SUCH AS CARTON	BH25890	OPTIONAL
7Q	GROSS WEIGHT	USES ANSI X12 QUALIFIER AS LAST TWO CHARACTERS TO DEFINE UNIT OF MEASURE GT=GROSS KILOGRAMS	7Q10GT	REQUIRED

5.3 Master Labels

Master labels are required when shipping multiple packages of the same part number on one pallet. (e.g.. several small cartons inside a larger pallet box)

Individual packs (sub-packs) shall have an AIAG label on each pack as per Exhibit 1.

A unique serial number must be placed on the master label. The data identifier 4S must be used on master labels.

When a master label is used, serial numbers on individual sub packs may be optional (obtain approval if serial numbers are not included on sub pack labels).

When a shipping pack requiring a master label is stretch or shrink wrapped, securely attach the master label to the outside of the wrap.

Exhibit 8 - Master Label for Common Item Packs (not to scale)

FROM	TO	MASTER LABEL
	MATERIAL HANDLING CODE	
PART NUMBER		
6J LICENSE PLATE	LOGISTICS DATA	
2D BAR CODE		

5.3.1 Master Label Data Sources

Exhibit 3 – Master Label Data Sources

DATA SOURCES

DATA FROM SUPPLIER FILES
NOTE: SUPPLIER CONTACT (PHONE OR E-MAIL) IS AT THE SUPPLIER'S OPTION

ADDRESS INFORMATION
SUPPLIER GENERATED
BASED ON CUSTOMER
ORDER PLANT/DOCK CODE
FROM X12 830
SEGMENT N1 ST, N3, N4

FROM:	FROM ADDRESS LINE 1	TO:	ADDRESS	LINE	1
	FROM ADDRESS LINE 2		ADDRESS	LINE	2
	FROM ADDRESS LINE 3		ADDRESS	LINE	3
	FROM ADDRESS LINE 4		ADDRESS	LINE	4
	EMAIL PHONE CONTACT				
	ASSEMBLED/MADE IN XX				

PLANT/DOCK: **LC 15C**

MASTER LABEL

MATERIAL HANDLING CODE FROM X12 830
SEGMENT REF BO


DATA FROM SUPPLIER FILES
CUSTOMER PART NUMBER MUST MATCH CUSTOMER ORDER X12 830
SEGEMENT PO401

MATERIAL HANDLING CODE:
A6-987

SUPPLIER DUNS ID COMBINED WITH SUPPLIER GENERATED SHIP PACK SERIAL NUMBER

PART #:
12345678

LICENSE PLATE (SJ):



UN 123456789 A2B4C6D8E

GROSS WEIGHT KG: **999**

TOTAL QTY: **10000**

PACKS: **10**

QTY/PACK: **1000**

LOGISTICS DATA
GROSS WEIGHT:
SUPPLIER GENERATED
ROUND - NO DECIMAL
TOTAL QUANTITY:
SUPPLIER GENERATED
NUMBER OF PACKS:
SUPPLIER GENERATED
QUANTITY PER PACK:
SUPPLIER GENERATED

FONTS SHALL BE UPPER CASE BOLD ARIAL NARROW,
HELVETICA CONDENSED OR EQUIVALENT

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5.3.2 Master Label Format & Font Specs

Exhibit 4 – Master Label Format & Font Specs

FORMAT & FONT SPECS

Fonts shall be upper case bold Arial Narrow, Helvetica Condensed or equivalent

<p>FROM: 6 Point, 1.5 mm, 0.06" Address 4 lines max 10 point, 2.5 mm, 0.1" Phone Number (Optional) 10 Point, 2.5 mm, 0.1" MADE IN XXX or ASY IN XXX 10 Point, 2.5 mm, 0.1"</p>	<p>TO: 6 Point, 1.5 mm, 0.06" Address 4 lines max 12 Point, 4.3 mm, 0.17" Title: PLANT DOCK 12 Point, 1.5 mm, 0.06" Plant/Dock Text 8 Character max 28 Point, 6.4 mm, 0.25"</p>	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 30%; font-size: 8pt;">FROM ADDRESS LINE 1</td> <td style="width: 10%; font-size: 8pt;">TO:</td> <td style="width: 30%; font-size: 8pt;">ADDRESS LINE 1</td> <td style="width: 10%; font-size: 8pt;">1</td> <td rowspan="4" style="font-size: 24pt; font-weight: bold; vertical-align: middle;">MASTER LABEL</td> </tr> <tr> <td style="font-size: 8pt;">FROM ADDRESS LINE 2</td> <td style="font-size: 8pt;">TO:</td> <td style="font-size: 8pt;">ADDRESS LINE 2</td> <td style="font-size: 8pt;">2</td> </tr> <tr> <td style="font-size: 8pt;">FROM ADDRESS LINE 3</td> <td style="font-size: 8pt;">TO:</td> <td style="font-size: 8pt;">ADDRESS LINE 3</td> <td style="font-size: 8pt;">3</td> </tr> <tr> <td style="font-size: 8pt;">FROM ADDRESS LINE 4</td> <td style="font-size: 8pt;">TO:</td> <td style="font-size: 8pt;">ADDRESS LINE 4</td> <td style="font-size: 8pt;">4</td> </tr> <tr> <td colspan="2" style="font-size: 8pt;">EMAIL PHONE CONTACT</td> <td colspan="2" style="font-size: 12pt; font-weight: bold;">PLANT/DOCK: LC 15C</td> <td></td> </tr> <tr> <td colspan="2" style="font-size: 8pt;">ASSEMBLED/MADE IN XX</td> <td colspan="2" style="font-size: 12pt; font-weight: bold;">MATERIAL HANDLING CODE: A6-987</td> <td></td> </tr> </table>	FROM ADDRESS LINE 1	TO:	ADDRESS LINE 1	1	MASTER LABEL	FROM ADDRESS LINE 2	TO:	ADDRESS LINE 2	2	FROM ADDRESS LINE 3	TO:	ADDRESS LINE 3	3	FROM ADDRESS LINE 4	TO:	ADDRESS LINE 4	4	EMAIL PHONE CONTACT		PLANT/DOCK: LC 15C			ASSEMBLED/MADE IN XX		MATERIAL HANDLING CODE: A6-987		
FROM ADDRESS LINE 1	TO:	ADDRESS LINE 1	1	MASTER LABEL																									
FROM ADDRESS LINE 2	TO:	ADDRESS LINE 2	2																										
FROM ADDRESS LINE 3	TO:	ADDRESS LINE 3	3																										
FROM ADDRESS LINE 4	TO:	ADDRESS LINE 4	4																										
EMAIL PHONE CONTACT		PLANT/DOCK: LC 15C																											
ASSEMBLED/MADE IN XX		MATERIAL HANDLING CODE: A6-987																											
<p>PART NUMBER: 6 Point, 1.5 mm, 0.06" Part Number Text 44 Point, 11.2 mm, 0.44" Graphic Optional Safety/Security Right Justified</p>	<p>PART #: 12345678</p>			<p>Mat Handling Reference Sub-Block Title: MATERIAL HANDLING CODE 6 Point, 1.5 mm, 0.06" MATERIAL HANDLING CODE Text 8 Character max 36 Point, 9.17mm, 0.36"</p>																									
<p>LICENSE PLATE (6J): 6 Point, 1.5 mm, 0.06" Bar Code Code 128 0.381 mm (15 mil) nominal Height 13 mm (0.5 inch) min Data Identifier: 6J Assigning Authority: UN = D-U-N-S 9 digits D-U-N-S Number 9 characters container serial number max Human Readable Text 24 Point, 6.1 mm, 0.24" Note-Spaces are optional in human readable text only. SPACES SHALL NOT BE INCLUDED IN BAR CODE DATA</p>	<p>UN 123456789 A2B4C6D8E</p>		<p>GROSS WEIGHT KG: 999 KG TOTAL QTY: 10000 # PACKS: 10 QTY/PACK: 1000</p>	<p>Reference Sub-Block #2 Title: GROSS WEIGHT 6 Point, 1.5 mm, 0.06" Gross Weight Text 18 Point, 6.1 mm, 0.25" Unit of Measure Text KG 18 Point, 6.1 mm, 0.25" Title: TOTAL QTY 6 Point, 1.5 mm, 0.06" Total Quantity Text 18 Point, 6.1 mm, 0.25" Title: # PACKS 6 Point, 1.5 mm, 0.06" # of Packs Text 18 Point, 6.1 mm, 0.25" Title: QTY/PACK 6 Point, 1.5 mm, 0.06" Quantity per Pack Text 18 Point, 6.1 mm, 0.25"</p>																									
	<p>Title: None PDF 417 2D Bar Code</p>																												

5.3.3 Master Label Data Identifiers (DIs)

Exhibit 6 – Master Label Data Identifier Table

DATA IDENTIFIERS (DIs) DEFINE THE NATURE OF THE DATA CONTAINED WITHING THE LINEAR BAR CODE. DIs ARE USED WITHIN THE 2D BAR CODE TO DEFINE THE NATURE OF THE DATA IN EACH FIELD. THE TABLE BELOW REPRESENTS TYPICAL DIs USED WITH COMMON GLOBAL SHIPPING LABEL TEMPLATES. ADDITIONAL DIs MAY BE USED AS BUSINESS PROCESSES REQUIRE AND SHALL CONFORM TO AIAG B10, B14, ANSI, AND ISO STANDARDS.

DATA IDENTIFIER DI	QUALIFIER	DEFINITION	COMMENT	EXAMPLE	WITHIN 2D BAR CODE
P	na	AM GENERAL PART NUMBER	TYPICALLY EIGHT (8) ALPHA/NUMERIC CHARACTERS	PPT123456	REQUIRED
Q	na	PART QUANTITY	TYPICALLY EXPRESSED IN PIECES	Q150	REQUIRED
7Q	PL	TOTAL QUANTITY	TOTAL QUANTITY IN MASTER PACK	7Q10000PL	REQUIRED
7Q	PK	NUMBER OF PACKS	NUMBER OF INDIVIDUAL PACKS IN MASTER PACK	7Q10PK	REQUIRED
7Q	GT	GROSS WEIGHT	GROSS WEIGHT OF MASTER PACK ROUNDED (NO DECIMALS)	7Q999GT	REQUIRED
6J	na	MASTER LICENSE PLATE	HAS STRUCTURE SEE EXHIBIT 5 FOR DEFINITION	6JUN123456789A2B2C6D8E	REQUIRED
20L	na	MATERIAL HANDLING CODE	DELIVERY LOCATION WITHIN PLANT	20LEA34B	REQUIRED
21L	na	PLANT/DOCK CODE	IDENTIFIES PLANT AND DELIVERY DOCK	21LH2 A	REQUIRED
K	na	PO NUMBER	IF REQUIRED AS PART OF AMG BUSINESS PROCESS	K5999999999	REQUIRED IF PROVIDED
15K	na	KANBAN NUMBER	IF REQUIRED AS PART OF AMG BUSINESS PROCESS	15KAT24B	REQUIRED IF PROVIDED

5.4 Mixed Load Label

Mixed item packs are only permitted in conjunction with a mixed load label. The different part numbers within the mixed item pack must be separated and contained inside sub packs. Each sub pack must be individually labeled with at least one shipping/parts I.D. label or master label if applicable.

Shipping/Parts I.D. Label:

A minimum of two shipping/parts identification labels shall be placed on each shipping pack on adjacent sides (wraparound label is acceptable). Some AM General plants may require deviations of label quantity and location.

Master Label or Mixed Load Label:

Where possible, the top of the label should be 20 inches (508mm) from the bottom of the container and centered left-to-right on the widest face of the pack.

Exhibit 8 – Mixed Load Label (not to scale)

FROM	TO			MIXED LOAD
PART A	PART B	PART C	PART D	
PART E	PART F	PART G	PART H	
5J LICENSE PLATE 1D BAR CODE			LOGISTICS DATA	
2D BAR CODE				


5.4.1 Mixed Label Data Sources

Exhibit 3 – Mixed Label Data Sources

DATA SOURCES

DATA FROM SUPPLIER FILES
NOTE: SUPPLIER CONTACT
(PHONE OR E-MAIL) IS AT THE
SUPPLIER'S OPTION

ADDRESS INFORMATION
SUPPLIER GENERATED
BASED ON CUSTOMER
ORDER PLANT/DOCK CODE
FROM X12 830
SEGMENT N1 ST, N3, N4

FROM: FROM ADDRESS LINE 1 FROM ADDRESS LINE 2 FROM ADDRESS LINE 3 FROM ADDRESS LINE 4 PHONE CONTACT # MADE IN/ASSEMBLED IN	TO: TO ADDRESS TO ADDRESS TO ADDRESS TO ADDRESS PLANT/DOCK: LC 15C	LINE 1 2 3 4	MIXED LOAD																																								
<table border="1" style="width: 100%; border-collapse: collapse; font-size: small;"> <thead> <tr> <th>PART NUMBER</th> <th>TOTAL QTY</th> <th>PART NUMBER</th> <th>TOTAL QTY</th> <th>PART NUMBER</th> <th>TOTAL QTY</th> <th>PART NUMBER</th> <th>TOTAL QTY</th> </tr> </thead> <tbody> <tr> <td>12345678</td> <td>1000</td> <td>02345678</td> <td>1200</td> <td>12245678</td> <td>1000</td> <td>12045678</td> <td>1000</td> </tr> <tr> <td># PACKS 5 @</td> <td>QTY PER # PACK 200</td> <td># PACKS 6 @</td> <td>QTY PER # PACK 200</td> <td># PACKS 5 @</td> <td>QTY PER # PACK 200</td> <td># PACKS 10 @</td> <td>QTY PER # PACK 100</td> </tr> <tr> <td>10345678</td> <td>750</td> <td>12345600</td> <td>6000</td> <td>00345678</td> <td>100</td> <td>12005678</td> <td>1000</td> </tr> <tr> <td># PACKS 5 @</td> <td>QTY PER # PACK 150</td> <td># PACKS 5 @</td> <td>QTY PER # PACK 1200</td> <td># PACKS 5 @</td> <td>QTY PER # PACK 20</td> <td># PACKS 5 @</td> <td>QTY PER # PACK 200</td> </tr> </tbody> </table>	PART NUMBER	TOTAL QTY	PART NUMBER	TOTAL QTY	PART NUMBER	TOTAL QTY	PART NUMBER	TOTAL QTY	12345678	1000	02345678	1200	12245678	1000	12045678	1000	# PACKS 5 @	QTY PER # PACK 200	# PACKS 6 @	QTY PER # PACK 200	# PACKS 5 @	QTY PER # PACK 200	# PACKS 10 @	QTY PER # PACK 100	10345678	750	12345600	6000	00345678	100	12005678	1000	# PACKS 5 @	QTY PER # PACK 150	# PACKS 5 @	QTY PER # PACK 1200	# PACKS 5 @	QTY PER # PACK 20	# PACKS 5 @	QTY PER # PACK 200			
PART NUMBER	TOTAL QTY	PART NUMBER	TOTAL QTY	PART NUMBER	TOTAL QTY	PART NUMBER	TOTAL QTY																																				
12345678	1000	02345678	1200	12245678	1000	12045678	1000																																				
# PACKS 5 @	QTY PER # PACK 200	# PACKS 6 @	QTY PER # PACK 200	# PACKS 5 @	QTY PER # PACK 200	# PACKS 10 @	QTY PER # PACK 100																																				
10345678	750	12345600	6000	00345678	100	12005678	1000																																				
# PACKS 5 @	QTY PER # PACK 150	# PACKS 5 @	QTY PER # PACK 1200	# PACKS 5 @	QTY PER # PACK 20	# PACKS 5 @	QTY PER # PACK 200																																				
LICENSE PLATE (5J):  UN 123456789 A2B4C6D8E			GROSS WEIGHT: 9999 KG																																								

DATA FROM SUPPLIER FILES
CUSTOMER PART NUMBER
MUST MATCH CUSTOMER
ORDER X12 830
SEGMENT PO401

SUPPLIER DUNS ID
COMBINED WITH SUPPLIER
GENERATED SHIP PACK

LOGISTICS DATA
GROSS WEIGHT:
SUPPLIER GENERATED
ROUND - NO DECIMAL

5.4.2 Mixed Label Format & Font Specs

Exhibit 4 – Mixed Label Format & Font Specs

FORMAT & FONT SPECS

*FONTS SHALL BE UPPER CASE BOLD ARIAL NARROW,
HELVETICA CONDENSED OR EQUIVALENT*

Title: FROM:
6 Point, 1.5 mm, 0.06"
Address 4 lines max
10 point, 2.5 mm, 0.1"
Phone Number (Optional)
10 Point, 2.5 mm, 0.1"
MADE IN XXX or ASY IN XXX
10 Point, 2.5 mm, 0.1"

<p>FROM: FROM ADDRESS LINE 1 FROM ADDRESS LINE 2 FROM ADDRESS LINE 3 FROM ADDRESS LINE 4 PHONE CONTACT # MADE IN/ASSEMBLED IN</p>	<p>TO: TO ADDRESS TO ADDRESS TO ADDRESS TO ADDRESS</p>	<p>LINE 1 LINE 2 LINE 3 LINE 4</p>	<p>1 2 3 4</p>	<h2 style="margin: 0;">MIXED LOAD</h2>			
<p>PLANT/DOCK: LC 15C</p>							
PART NUMBER	TOTAL QTY	PART NUMBER	TOTAL QTY	PART NUMBER	TOTAL QTY	PART NUMBER	TOTAL QTY
12345678	1000	02345678	1200	12245678	1000	12045678	1000
# PACKS	@	QTY PER # PACK	# PACKS	@	QTY PER # PACK	# PACKS	@
5		200	6		200	5	
# PACKS	@	QTY PER # PACK	# PACKS	@	QTY PER # PACK	# PACKS	@
10345678	750	12345600	6000	00345678	100	12005678	1000
5		150	5		20	5	

Title: TO:
6 Point, 1.5 mm, 0.06"
Address 4 lines max
12 Point, 4.3 mm, 0.17"
Title ; PLANT DOCK
6 Point, 1.5 mm, 0.06"
Plant/Dock Text
8 Character max
28 Point, 6.4 mm, 0.25"

Title: PART NUMBER
8 Point, 1.5 mm, 0.06"
Part Number Text
16 Point, 11.2 mm, 0.44"
Title: TOTAL QTY
8 Point, 1.5 mm, 0.06"
Total Qty Text
16 Point, 11.2 mm, 0.44"
Title: # PACKS
8 Point, 1.5 mm, 0.06"
Packs Text
16 Point, 11.2 mm, 0.44"
Title: QTY PER PACK
8 Point, 1.5 mm, 0.06"
Qty Per Pack Text
16 Point, 11.2 mm, 0.44"

LICENSE PLATE (5J):

UN 123456789 A2B4C6D8E

Title: LOGISTICS DATA:
Title: GROSS WEIGHT
6 Point, 1.5 mm, 0.06"
Gross Weight Text
44 Point, 6.4 mm, 0.25"
Unit of Weight Text KG
44 Point, 6.4 mm, 0.25"

Title: LICENSE PLATE (5J)
6 Point, 1.5 mm, 0.06"
Bar Code
Code 128
0.381 mm (15 mil) nominal
Height 13 mm (0.5 inch) min
Data Identifier: 5J
Assigning Authority: UN = D-U-N-S
9 digits D-U-N-S Number
9 characters container serial number max
Human Readable Text
24 Point, 6.1 mm, 0.24"
Note-Spaces are optional in human readable text only. SPACES SHALL NOT BE INCLUDED IN BAR CODE DATA

GROSS WEIGHT: **9999 KG**

5.4.3 Mixed Label Data Identifiers (DIs)

Exhibit 6 – Mixed Label Data Identifier Table

DATA IDENTIFIERS (DIs) DEFINE THE NATURE OF THE DATA CONTAINED WITHING THE LINEAR BAR CODE. DIs ARE USED WITHIN THE 2D BAR CODE TO DEFINE THE NATURE OF THE DATA IN EACH FIELD. THE TABLE BELOW REPRESENTS TYPICAL DIs USED WITH COMMON GLOBAL SHIPPING LABEL TEMPLATES. ADDITIONAL DIs MAY BE USED AS BUSINESS PROCESSES REQUIRE AND SHALL CONFORM TO AIAG B10, B14, ANSI, AND ISO STANDARDS.

DATA IDENTIFIER DI	QUALIFIER	DEFINITION	COMMENT	EXAMPLE	WITHIN 2D BAR CODE
P	na	AM GENERAL PART NUMBER	TYPICALLY EIGHT (8) ALPHA/NUMERIC CHARACTERS	PPT123456	REQUIRED
Q	na	PART QUANTITY	TYPICALLY EXPRESSED IN PIECES	Q150	REQUIRED
7Q	PL	TOTAL QUANTITY	TOTAL QUANTITY IN MASTER PACK	7Q10000PL	REQUIRED
7Q	PK	NUMBER OF PACKS	NUMBER OF INDIVIDUAL PACKS IN MASTER PACK	7Q10PK	REQUIRED
7Q	GT	GROSS WEIGHT	GROSS WEIGHT OF MASTER PACK ROUNDED (NO DECIMALS)	7Q999GT	REQUIRED
6J	na	MASTER LICENSE PLATE	HAS STRUCTURE SEE EXHIBIT 5 FOR DEFINITION	6JUN123456789A2B2C6D8E	REQUIRED
20L	na	MATERIAL HANDLING CODE	DELIVERY LOCATION WITHIN PLANT	20LEA34B	REQUIRED
21L	na	PLANT/DOCK CODE	IDENTIFIES PLANT AND DELIVERY DOCK	21LH2 A	REQUIRED
K	na	PO NUMBER	IF REQUIRED AS PART OF AMG BUSINESS PROCESS	K559999999999	REQUIRED IF PROVIDED
15K	na	KANBAN NUMBER	IF REQUIRED AS PART OF AMG BUSINESS PROCESS	15KAT24B	REQUIRED IF PROVIDED

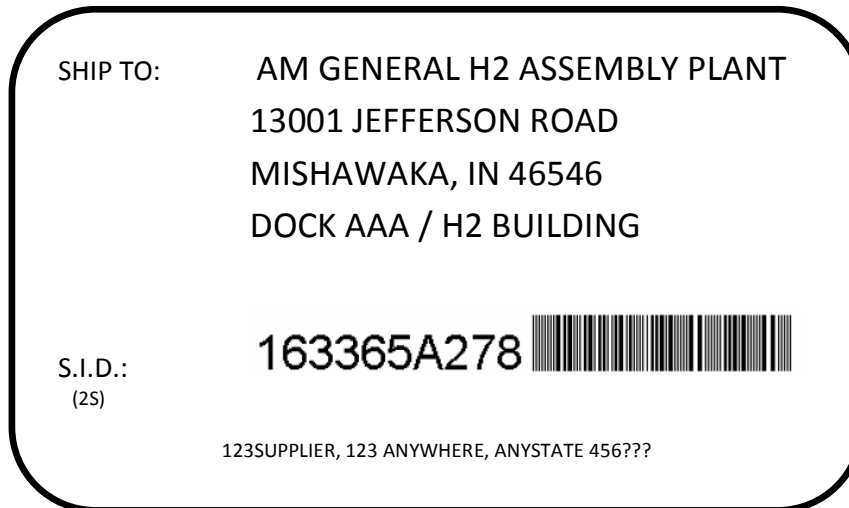
5.5 Address Label

In addition to the AIAG shipping/parts I.D. label or master label, include 2 address labels on the outer shipping pack.

- + Place these labels near the parts I.D. label, where possible, on adjacent sides.
- + Include address and dock designation as per AM General Purchasing documentation.
- + Include the invoice number in human readable and in bar code format. AM General requires invoice numbers to be 10 or fewer characters in length.

Exhibit 8- Sample Address Label (not to scale)

* Dock Location/Bldg. No. and shipping address as specified in the Purchase Order. Refer to AM General EDI documentation for information about ASNs.



5.6 Odette, Euro-Supplier Labeling Option

AM General recognizes the European automotive industry approved Odette transport label for the identification of packaging and container contents for suppliers located in Europe. (However, AM General strongly urges the use of the AIAG-B-10 standard label.)

The label is 'A5' size, and has standard printing with the addition of bar coding. It may be self adhesive for expendable packaging, a tie on label for durable packaging, or can be held in integral document holders on the container, if provided. AM General will accept the Odette label format with bar coding provided that it conforms to the Odette standard and satisfies informational requirements in this specification.

Include Delivery Note Number on Odette labels.

The full specification of the label is obtainable from the Odette organization through the national offices of the SMMT (UK) and the VDA (Germany) representing ODETTE.

Exhibit 9 – Foreign (Odette) Label Sample (not to scale)

RECEIVER AM General H2	DOCK / GATE CHARLESTON ABS		
(N) Delivery Note No 2595160 	SUPPLIER ADDR CH-9435 HEERBRUGG, SWITZ.		
	NET WT (KG) 125 KG	GROSS WT (KG)	NO. BOXES 1
(P) PART NO. 5996820000 			
(Q) QUANTITY 100 	DESCRIPTION LUBRICANT		
	SUPPLIER PART NO. 3530871		
(V) SUPPLIER 910276 	(2P) REVISION 4		
	PROD. DATE 07-28-97	EXP. DATE 07-28-02	HAZZARD CODE
(S) SERIAL 12454 			LOT NO.

6.0 Contacts

Contacts/Responsibility: Can be obtained through AM General Supply Chain Management or Production Control management at the AM General plant.

7.0 Terms & Definitions

Address Label

Label to denote shipping address. (See section 5.5)

Data Identifier

The first character(s) of a bar code.

Direct Material

Material that becomes part of the finished product during manufacturing processes at AM General. (See section 1.2)

Master Label

A label used to identify and summarize the contents of a multiple pack of same part number. (See section 5.2.2)

Mixed Item Pack

A pack containing items with different part numbers from the same supplier. (See section 5.3)

Pack or Package

A device which provides component protection, containment, ease of use, and information.

Shipping Pack or Pallet Load

A package used for shipping items from the supplier's facility to a AM General facility. It's description includes all the packaging materials that are used. It may be returnable or expendable.

Shipping/Parts Identification Label (AIAG Label)

A bar coded label used to identify the contents of a shipping pack and sub pack.

Sub Pack

The lowest level of packaging that contains the part, e.g. plastic bag, carton, tote, et al.

Wraparound Label

Consists of continuous label stock on which two labels are printed side by side designed to attach to adjacent sides of a carton or pallet box.

8.0 AM General Packaging Data Sheet

AMG CONTAINERIZATION

CONTAINER CONCEPT BUYOFF

Meeting Date: _____
 Model Year: _____ Program Name: _____ Project ID: _____
 Part Description: _____ Return Ratio: _____ Est. Tare Wt: _____
 Container Number: _____ Dimensions L: _____ W: _____ H: _____ Density: _____
 Part Weight: _____ Engineering Level: _____ Part Orientation: _____
 Is this a Bill of Container (BOC) container? No _____ Yes _____ Est. Production Container Qty: _____ SPLO Qty. _____

FOB: Modineer, Niles, MI Mode: Truck Flex %: 10

Mfg	Asm	In	Out	Dwell	Rtn	Other	Total
8	7	3	3	1	1	3	26

Required Attachments:

1. Engineer must check one of the following:
 Isometric Drawings
 Sketch
 Photograph

2. Part Numbers: _____

 Total Part Numbers _____

- Load from 1, 2, 3, or 4 sides of container (specify which is required): 1 sided style rack, parts placed on seats, load with hoist or lift assist from top of container.
- Unload from 1, 2, 3, or 4 sides of container (specify which is required): 1 sided style rack, parts placed on seats, unloads with hoist or lift assist from top of container.
- Specify type of dunnage required: Minimum of 4 seats per part to capture each part, in vehicle position made from HDPE & Metal Materials.
- If swing type dunnage bar, indicate a swing up or down preference to open: Swing up.
- Check any interface conditions which may impact design:

<input type="checkbox"/> Fork Truck	<input type="checkbox"/> Load /Unload Devices	<input type="checkbox"/> Robotic Load	<input type="checkbox"/> Tugger
<input type="checkbox"/> Hoist at Fab	<input type="checkbox"/> Over / Under Conveyor	<input type="checkbox"/> Robotic Unload	<input type="checkbox"/> Stripper System
<input type="checkbox"/> Hoist at Asm.	<input type="checkbox"/> Workspace Layout	<input type="checkbox"/> Turntable	<input type="checkbox"/> Other _____

In Attendance	Print Name and Phone Number	Signature	Buyoff Yes / No	Reason Must Be Given If Not Bought Off
Production Part Supplier or MFG Plant				
Assembly Plant Production				
Industrial Engineer				
Packaging Engineer/ Program Coordinator				
Process Engineer				
Design Release Eng*				
Quality Engineering*				
Ergonomics*				

* optional signatures

Notes: Re-engineer - Rack needs to be universal to contain two different diameter turret closeout panels (sm. al. w/Insulation - lg. armor w/o insulation). Additionally, parts need to be in vehicle position.

9.0 AM General Packaging Change Form

AMG CONTAINERIZATION				
CONTAINER ENGINEER CHANGE FORM				
INFORMATION	COMMENTS			
Date				
Model Year & Vehicle Program				
Review Location				
Job Number				
Part Number				
Part Description				
Rack/Container Code				
Density				
Fleet Quantity				
OEM Part Supplier Name				
CHANGE REQUEST NOTES				
Approval Team:				
Shipping Plant Rep.:		Container Design Source:		
Receiving Plant Rep.:		Logistics Rep.:		
Safety/Ergonomics:		Project Manger:		
Material Handling Eng. Rep.:				
Part Engineer:		OK TO PROCEED:		

AM General Sign-Off

Names and Function	Action	Date
Alan Walker <i>Launch Manager</i>	Signoff	
Chuck Tabacchi <i>Production Control Manager</i>	Signoff	
Casey Goatley <i>Planning Manager</i>	Signoff	
Linda Allen <i>Director Supply Chain Management - Commercial</i>	Review	
Jerry Chizum <i>Systems Coordinator</i>	Review	
Juan Segura <i>Group Leader/MFC</i>	Review	
Phil Krug <i>Supplier Quality Manager</i>	Review	
Karen Hicks <i>Engineering Change Coordinator/Planning</i>	Review	

VPG Sign-Off

Names and Function	Action	Date
Matt DeMars Chief Operating Officer	Signoff	
Kathleen Doherty <i>Executive Program Coordinator</i>	Signoff	
Cabe Morphew <i>Dir, Program Manager</i>	Signoff	
Leo Darocha <i>Partition Mgr. & Logistics</i>	Review	