Production Control
Supplier
Packaging/Labeling Manual
Supplier Packaging/Labeling Manual

Rev. 2 - March, 2010

This document is controlled by:

AM General, LLC.
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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)

<table>
<thead>
<tr>
<th>Face x Depth</th>
<th>Height, maximum</th>
</tr>
</thead>
<tbody>
<tr>
<td>48&quot; x 45&quot; (1200mm) x 1150mm</td>
<td>51&quot; (1295mm)</td>
</tr>
<tr>
<td>32&quot; x 30&quot; (820mm) x 760mm</td>
<td>40&quot; (1016mm)</td>
</tr>
<tr>
<td>36&quot; x 30&quot; (820mm) x 914mm</td>
<td>40&quot; (1016mm)</td>
</tr>
<tr>
<td>1200mm x 1000mm</td>
<td>1000mm</td>
</tr>
<tr>
<td>1200mm x 800mm</td>
<td>1000mm</td>
</tr>
<tr>
<td>44&quot; (1120mm) x 36&quot; (915mm)</td>
<td>40&quot; (1016mm)</td>
</tr>
</tbody>
</table>

+ 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

Supplier Submits Container/Packaging Change Request to AM General

Supplier Receives Container Check Sheet

Supplier submits Pre-Work Check Sheet

AMG submits Design Parameter Sheet

Develop Container/ Packaging Concept

Container/Packaging Design Evaluated

Accepted? Design Buyoff

YES

Build Prototype Container/ Packaging

Container/Packaging Prototype Evaluated

Accepted? Prototype Buyoff

YES

Build Fleet Sample Production Container/ Packaging

Fleet Shipped to Supplier

Supplier Submits Trial Shipment Parts to AM General

Supplier notified of change rejection

NO

End

NO
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 (θ):**
  Show human readable zeroes (θ) 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           |
      +---------------------------------+  +---------------------------------+
      | C AMG PART NUMBER                |  | B3 LOGISTICS REFERENCE           |
  +---------------------------------+  +---------------------------------+
      | 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)**
5.2.2 Part Label Data Sources

Exhibit 3 – Part Label Data Sources

**Data Sources**

- **Address Information**: Supplier generated based on customer order. Plant/dock code from X12 830 segment N1 ST, N3, N4.
- **Material Handling Code**: From X12 830 segment REF BO.
- **Reference Sub-block #1**: Date: specify type, e.g., ship, pack, manufacturing. Supplier generated.
- **Reference Sub-block #2**: Text is a direct pass-through of whatever data is received in X12 830 segment REF72 & PID05.
- **Fonts**: Shall be upper case bold Arial Narrow, Helvetica condensed or equivalent.
- **Unrestricted Area of Label**: For supplier’s use. Note: use appropriate data syntax for all bar codes.
- **Supplier DUNS ID Combined with Supplier Generated Ship Pack Serial Number**.
- **Data from Supplier Files**: Customer part number must match customer order X12 830 segment LIN03.
- **Data from Supplier Files**: Customer part number must match customer order X12 830 segment PO401.
- **Data from Supplier Files**: Email, phone contact assembled/made in xx.
- **Unrestricted Area of Label**: Note: supplier contact (phone or e-mail) is at the supplier’s option.

**Summary**

- ADDRESS INFORMATION: Supplier generated based on customer order. Plant/dock code from X12 830 segment N1 ST, N3, N4.
- MATERIAL HANDLING CODE: From X12 830 segment REF BO.
- REFERENCE SUB-BLOCK #1: Date: specify type, e.g., ship, pack, manufacturing. Supplier generated.
- REFERENCE SUB-BLOCK #2: Text is a direct pass-through of whatever data is received in X12 830 segment REF72 & PID05.
- UNRESTRICTED AREA OF LABEL: For supplier’s use. Note: use appropriate data syntax for all bar codes.
- SUPPLIER DUNS ID COMBINED WITH SUPPLIER GENERATED SHIP PACK SERIAL NUMBER.
- DATA FROM SUPPLIER FILES: CUSTOMER PART NUMBER MUST MATCH CUSTOMER ORDER X12 830 SEGMENT PO401.
- DATA FROM SUPPLIER FILES: CUSTOMER PART NUMBER MUST MATCH CUSTOMER ORDER X12 830 SEGMENT LIN03.
- DATA FROM SUPPLIER FILES: Email, phone contact assembled/made in xx.

**Fonts**: Shall be upper case bold Arial Narrow, Helvetica condensed or equivalent.
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”

- **Quantity:**
  - 6 Point, 1.5 mm, 0.1”
  - Text
  - 36 Point, 9.17 mm, 0.36”

- **Part Number:**
  - 6 Point, 1.5 mm, 0.06”
  - Part Number Text:
  - 14 Point, 3.6 mm, 0.14”
  - Graphic Optional
  - Safety/Security, Right Justified

- **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

- **To:**
  - 6 Point, 1.5 mm, 0.06”
  - Address: 4 lines max
  - 10 Point, 2.5 mm, 0.1”
  - Plant/Dock
  - 6 Point, 1.5 mm, 0.06”
  - Plant/Dock Text
  - 8 Characters max
  - 28 Point, 6.4 mm, 0.25”

- **Material Handling Code:**
  - 6 Point, 1.5 mm, 0.06”
  - Material Handling Code Text
  - 8 Characters Max
  - 36 Point, 9.17 mm, 0.36”

- **Shipment Date:**
  - 6 Point, 1.5 mm, 0.06”
  - 12 Point, 4.3 mm, 0.17”
  - Plant/Dock
  - 6 Point, 1.5 mm, 0.06”
  - Plant/Dock Text
  - 8 Characters max
  - 18 Point, 6.4 mm, 0.25”

- **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”

- **Reference Sub-Block #2:**
  - 14 point, 3.6 mm, 0.14”

- **Reference to Address:**
  - From ADDRESS LINE 1
  - FROM ADDRESS LINE 2
  - FROM ADDRESS LINE 3
  - FROM ADDRESS LINE 4
  - Email Phone Contact Assembled/Made in XX

- **Material Handling Code:**
  - 8 Characters Max

- **From:**
  - PLANT 2 DOCKA

- **Part Number:**
  - PT008140

- **License Plate:**
  - UN 2056315700 006346813

- **Empty:**
  - Stockman: XXXXXXXXXXDOKIT
  - Bracket
5.2.4 Label Data License Plate Bar Code Structure

Exhibit 5 – License Plate Bar Code Structure

CODE 128 BAR CODE STRUCTURE
FOR LICENSE PLATE

UN: Who is the assigning authority? D-U-N-S

1J: look up operation to see data to follow

D-U-N-S number
Serial number

1J: UN123456789A2B4C6D8E
Scanned Data Stream

Data Identifier:
1J = INDIVIDUAL Container
5J = MIXED LOAD
6J = MASTER LOAD

ISO Assigning authority
UN = D-U-N-S:
- assigned by Dun & Bradstreet.

9-character D-U-N-S number
- manufacturing site specific
- fixed; should never have to be changed

9-character maximum
- Unique container serial number
- generated by supplier
- leading zeros not recommended
- not to be repeated for period of 1 year

CODE 128 SPECIFICATION:
• 'X' DIMENSION SHALL BE IN THE RANGE OF 0.33 MM (0.013 INCH) TO 0.43 MM (0.017 INCH)
• BAR CODE HEIGHT SHALL BE A MINIMUM OF 13 MM (0.5 INCH)
• QUIET ZONE (AREA AT EACH END OF BAR CODE) SHALL BE A MINIMUM OF 6.3 MM (0.25 INCH)
• BAR CODE SHALL MEET A MINIMUM ANSI PRINT QUALITY GRADE OF 'C'
5.2.5 Label Data Identifiers (DIs)

Exhibit 6 – Part Label Data Identifier Table

<table>
<thead>
<tr>
<th>DATA IDENTIFIER</th>
<th>DEFINITION</th>
<th>COMMENT</th>
<th>EXAMPLE</th>
<th>WITHIN 2D BAR CODE</th>
</tr>
</thead>
<tbody>
<tr>
<td>P</td>
<td>AM GENERAL PART NUMBER</td>
<td>TYPICALLY EIGHT (8) ALPHA/NUMERIC CHARACTERS</td>
<td>PPT123456</td>
<td>REQUIRED</td>
</tr>
<tr>
<td>Q</td>
<td>PART QUANTITY</td>
<td>TYPICALLY EXPRESSED IN PIECES</td>
<td>Q150</td>
<td>REQUIRED</td>
</tr>
<tr>
<td>1J</td>
<td>LICENSE PLATE INDIVIDUAL</td>
<td>CONTAINER OF LIKE PARTS</td>
<td>1JUN123456789A2B2C6DB8</td>
<td>REQUIRED</td>
</tr>
<tr>
<td>20L</td>
<td>MATERIAL HANDLING CODE</td>
<td>HAS STRUCTURE (SEE PAGE B)</td>
<td>20LEA348</td>
<td>REQUIRED</td>
</tr>
<tr>
<td>21L</td>
<td>PLANT/DOCK CODE</td>
<td>IDENTIFIES PLANT AND DELIVERY DOCK</td>
<td>21UH2A</td>
<td>REQUIRED</td>
</tr>
<tr>
<td>K</td>
<td>PO Number</td>
<td>IF USED AS PART OF AMG BUSINESS PROCESS</td>
<td>K559999999999</td>
<td>REQUIRED IF PROVIDED</td>
</tr>
<tr>
<td>15K</td>
<td>KANBAN NUMBER</td>
<td>IF USED AS PART OF AMG BUSINESS PROCESS</td>
<td>15KAT24B</td>
<td>REQUIRED IF PROVIDED</td>
</tr>
<tr>
<td>B</td>
<td>CONTAINER TYPE</td>
<td>AMG SPECIFIED CONTAINER NUMBER OR IF NOT SPECIFIED USE SUPPLIER REFERENCE SUCH AS CARTON</td>
<td>BH256890</td>
<td>OPTIONAL</td>
</tr>
<tr>
<td>7Q</td>
<td>GROSS WEIGHT</td>
<td>USES ANSI X12 QUALIFIER AS LAST TWO CHARACTERS TO DEFINE UNIT OF MEASURE GT=GROSS KILOGRAMS</td>
<td>7Q10GT</td>
<td>REQUIRED</td>
</tr>
</tbody>
</table>
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)
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

MATERIAL HANDLING CODE FROM
X12 830
SEGMENT REF BO

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

SUPPLIER DUNS ID COMBINED
WITH SUPPLIER GENERATED
SHIP PACK SERIAL NUMBER

FONTs SHALL BE UPPER CASE BOLD ARIAL NARROW,
HELvETICA CONDENSED OR EQUIVALENT

12345678

LOGISTICS DATA
GROSS WEIGHT
SUPPLIER GENERATED
ROUND = NO DECIMAL
TOTAL QUANTITY:
SUPPLIER GENERATED
NUMBER OF PACKs:
SUPPLIER GENERATED
QUANTITY PER PACK:
SUPPLIER GENERATED
5.3.2 Master Label Format & Font Specs

Exhibit 4 – Master Label Format & Font Specs

FORM & FONT SPECS

FROM ADDRESS LINE 1
FROM ADDRESS LINE 2
FROM ADDRESS LINE 3
FROM ADDRESS LINE 4
EMAIL PHONE CONTACT
ASSEMBLED/MADE IN XXX

TO ADDRESS LINE 1
TO ADDRESS LINE 2
TO ADDRESS LINE 3
TO ADDRESS LINE 4

FONT SHEL LE BE UPPERCASE BOLD ARIAL NARROW, HELVETICA CONDENSED OR EQUIVALENT

MASTER LABEL:

LC 15C

A6-987

LICENSE PLATE (DLI)

6 Point, 1.5 mm, 0.06"

BAR CODE

Code 128
0.381 mm (15 mil) nominal
Height 13 mm (0.5 mm) 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, 0.25"

Non-Spaces are optional in human readable text only. SPACES SHALL NOT BE INCLUDED IN BAR CODE DATA

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5.3.3 Master Label Data Identifiers (DIs)

Exhibit 6 – Master Label Data Identifier Table

<table>
<thead>
<tr>
<th>DATA IDENTIFIER DI</th>
<th>QUALIFIER</th>
<th>DEFINITION</th>
<th>COMMENT</th>
<th>EXAMPLE</th>
<th>WITHIN 2D BAR CODE</th>
</tr>
</thead>
<tbody>
<tr>
<td>P</td>
<td>na</td>
<td>AM GENERAL PART NUMBER</td>
<td>TYPICALLY EIGHT (8) ALPHA/NUMERIC CHARACTERS</td>
<td>PPT123456</td>
<td>REQUIRED</td>
</tr>
<tr>
<td>Q</td>
<td>na</td>
<td>PART QUANTITY</td>
<td>TYPICALLY EXPRESSED IN PIECES</td>
<td>Q100</td>
<td>REQUIRED</td>
</tr>
<tr>
<td>7Q</td>
<td>pl</td>
<td>TOTAL QUANTITY</td>
<td>TOTAL QUANTITY IN MASTER PACK</td>
<td>7Q10000PL</td>
<td>REQUIRED</td>
</tr>
<tr>
<td>7G</td>
<td>pk</td>
<td>NUMBER OF PACKS</td>
<td>NUMBER OF INDIVIDUAL PACKS IN MASTER PACK</td>
<td>7G10PK</td>
<td>REQUIRED</td>
</tr>
<tr>
<td>7G</td>
<td>gt</td>
<td>GROSS WEIGHT</td>
<td>GROSS WEIGHT OF MASTER PACK ROUNDED (NO DECIMALS)</td>
<td>7G9999G</td>
<td>REQUIRED</td>
</tr>
<tr>
<td>6I</td>
<td>na</td>
<td>MASTER LICENSE PLATE</td>
<td>HAS STRUCTURE SEE EXHIBIT 5 FOR DEFINITION</td>
<td>6JUN123456789A282C8DBE</td>
<td>REQUIRED</td>
</tr>
<tr>
<td>20L</td>
<td>na</td>
<td>MATERIAL HANDLING CODE</td>
<td>DELIVERY LOCATION WITHIN PLANT</td>
<td>20LEA34B</td>
<td>REQUIRED</td>
</tr>
<tr>
<td>21L</td>
<td>na</td>
<td>PLANT/DOCK CODE</td>
<td>IDENTIFIES PLANT AND DELIVERY DOCK</td>
<td>21LH2A</td>
<td>REQUIRED</td>
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<tr>
<td>K</td>
<td>na</td>
<td>PO NUMBER</td>
<td>IF REQUIRED AS PART OF AMG BUSINESS PROCESS</td>
<td>K59999999999</td>
<td>REQUIRED IF PROVIDED</td>
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<tr>
<td>15X</td>
<td>na</td>
<td>KANBAN NUMBER</td>
<td>IF REQUIRED AS PART OF AMG BUSINESS PROCESS</td>
<td>15KAT24B</td>
<td>REQUIRED IF PROVIDED</td>
</tr>
</tbody>
</table>

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)
5.4.1 Mixed Label Data Sources

Exhibit 3 – Mixed Label Data Sources

<table>
<thead>
<tr>
<th>FROM</th>
<th>TO</th>
<th>MIXED LOAD</th>
</tr>
</thead>
<tbody>
<tr>
<td>PART A</td>
<td>PART B</td>
<td>PART C</td>
</tr>
<tr>
<td>PART E</td>
<td>PART F</td>
<td>PART G</td>
</tr>
</tbody>
</table>

5J LICENSE PLATE
1D BAR CODE
LOGISTICS DATA

2D BAR CODE

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
- 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**

---

**LABEL SPECIFICATIONS**

<table>
<thead>
<tr>
<th>Font</th>
<th>Specifications</th>
</tr>
</thead>
<tbody>
<tr>
<td>ADDRESS</td>
<td>8 Point, 1.5 mm, 0.06&quot;</td>
</tr>
<tr>
<td>Phone Number</td>
<td>8 Point, 1.5 mm, 0.06&quot;</td>
</tr>
<tr>
<td>Part Number</td>
<td>8 Point, 1.5 mm, 0.06&quot;</td>
</tr>
<tr>
<td>License Plate (LJ)</td>
<td>8 Point, 1.5 mm, 0.06&quot;</td>
</tr>
<tr>
<td>Truck Number</td>
<td>8 Point, 1.5 mm, 0.06&quot;</td>
</tr>
<tr>
<td>Gross Weight</td>
<td>8 Point, 1.5 mm, 0.06&quot;</td>
</tr>
<tr>
<td>Unit of Weight</td>
<td>8 Point, 1.5 mm, 0.06&quot;</td>
</tr>
</tbody>
</table>

---

**LOGISTICS DATA**

<table>
<thead>
<tr>
<th>Field</th>
<th>Specifications</th>
</tr>
</thead>
<tbody>
<tr>
<td>Gross Weight Text</td>
<td>44 Point, 0.4 mm, 0.025&quot;</td>
</tr>
</tbody>
</table>

---

**BAR CODE DATA**

<table>
<thead>
<tr>
<th>Code</th>
<th>Specifications</th>
</tr>
</thead>
<tbody>
<tr>
<td>EAN-128</td>
<td>24 Point, 0.1 mm, 0.024&quot;</td>
</tr>
</tbody>
</table>

---

**LOGISTICS PRINTED ON SHIP-TO SIGN**

<table>
<thead>
<tr>
<th>Field</th>
<th>Specifications</th>
</tr>
</thead>
<tbody>
<tr>
<td>Gross Weight</td>
<td>44 Point, 0.4 mm, 0.025&quot;</td>
</tr>
</tbody>
</table>
5.4.3  Mixed Label Data Identifiers (DIs)

Exhibit 6 – Mixed Label Data Identifier Table

<table>
<thead>
<tr>
<th>DATA IDENTIFIER DI</th>
<th>QUALIFIER</th>
<th>DEFINITION</th>
<th>COMMENT</th>
<th>EXAMPLE</th>
<th>WITHIN 2D BAR CODE</th>
</tr>
</thead>
<tbody>
<tr>
<td>P</td>
<td>na</td>
<td>AM GENERAL PART NUMBER</td>
<td>TYPICALLY EIGHT (8) ALPHA/NUMERIC CHARACTERS</td>
<td>PPT123456</td>
<td>REQUIRED</td>
</tr>
<tr>
<td>Q</td>
<td>na</td>
<td>PART QUANTITY</td>
<td>TYPICALLY EXPRESSED IN PIECES</td>
<td>Q150</td>
<td>REQUIRED</td>
</tr>
<tr>
<td>7Q</td>
<td>PL</td>
<td>TOTAL QUANTITY</td>
<td>TOTAL QUANTITY IN MASTER PACK</td>
<td>7Q100000PL</td>
<td>REQUIRED</td>
</tr>
<tr>
<td>7Q</td>
<td>PK</td>
<td>NUMBER OF PACKS</td>
<td>NUMBER OF INDIVIDUAL PACKS IN MASTER PACK</td>
<td>7Q10PK</td>
<td>REQUIRED</td>
</tr>
<tr>
<td>7Q</td>
<td>GT</td>
<td>GROSS WEIGHT</td>
<td>GROSS WEIGHT OF MASTER PACK ROUNDED (NO DECIMALS)</td>
<td>7Q9999GT</td>
<td>REQUIRED</td>
</tr>
<tr>
<td>6I</td>
<td>na</td>
<td>MASTER LICENSE PLATE</td>
<td>HAS STRUCTURE SEE EXHIBIT 5 FOR DEFINITION</td>
<td>6IUN123456789A2BACDBEE</td>
<td>REQUIRED</td>
</tr>
<tr>
<td>20L</td>
<td>na</td>
<td>MATERIAL HANDLING CODE</td>
<td>DELIVERY LOCATION WITHIN PLANT</td>
<td>20LEA348</td>
<td>REQUIRED</td>
</tr>
<tr>
<td>21L</td>
<td>na</td>
<td>PLANT/DOCK CODE</td>
<td>IDENTIFIES PLANT AND DELIVERY DOCK</td>
<td>21LAH2A</td>
<td>REQUIRED</td>
</tr>
<tr>
<td>K</td>
<td>na</td>
<td>PO NUMBER</td>
<td>IF REQUIRED AS PART OF AMG BUSINESS PROCESS</td>
<td>K59999999999</td>
<td>REQUIRED IF PROVIDED</td>
</tr>
<tr>
<td>15K</td>
<td>na</td>
<td>KANBAN NUMBER</td>
<td>IF REQUIRED AS PART OF AMG BUSINESS PROCESS</td>
<td>15K1234B</td>
<td>REQUIRED IF PROVIDED</td>
</tr>
</tbody>
</table>

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.

SHIP TO:  
AM GENERAL H2 ASSEMBLY PLANT
13001 JEFFERSON ROAD
MISHAWAKA, IN 46546
DOCK AAA / H2 BUILDING

S.I.D.:  
(2S)  
163365A278

123SUPPLIER, 123 ANYWHERE, ANYSTATE 456???
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)

<table>
<thead>
<tr>
<th>RECEIVER</th>
<th>DOCK / GATE</th>
</tr>
</thead>
<tbody>
<tr>
<td>AM General H2</td>
<td>CHARLESTON ABS</td>
</tr>
<tr>
<td></td>
<td></td>
</tr>
<tr>
<td>(N) Delivery Note No.</td>
<td>2595160</td>
</tr>
<tr>
<td></td>
<td></td>
</tr>
<tr>
<td>(P) PART NO.</td>
<td>5996820000</td>
</tr>
<tr>
<td>(Q) QUANTITY</td>
<td>100</td>
</tr>
<tr>
<td>(V) SUPPLIER</td>
<td>910276</td>
</tr>
<tr>
<td>(S) SERIAL</td>
<td>12454</td>
</tr>
<tr>
<td></td>
<td></td>
</tr>
<tr>
<td>(N)</td>
<td></td>
</tr>
<tr>
<td>(P)</td>
<td></td>
</tr>
<tr>
<td>(Q)</td>
<td></td>
</tr>
<tr>
<td>(V)</td>
<td></td>
</tr>
<tr>
<td>(S)</td>
<td></td>
</tr>
</tbody>
</table>
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.
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

<table>
<thead>
<tr>
<th>Mfg</th>
<th>Asm</th>
<th>In</th>
<th>Out</th>
<th>Dwell</th>
<th>Rtn</th>
<th>Other</th>
<th>Total</th>
</tr>
</thead>
<tbody>
<tr>
<td>8</td>
<td>7</td>
<td>3</td>
<td>3</td>
<td>1</td>
<td>1</td>
<td>3</td>
<td>26</td>
</tr>
</tbody>
</table>

Required Attachments:

1. Engineer must check one of the following:  
   ____ Isometric Drawings  
   ____ Sketch  
   ____ Photograph  
   Total Part Numbers______

2. Part Numbers:  
   ______________________
   ______________________

1. 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.
2. 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.
3. Specify type of dunnage required: Minimum of 4 seats per part to capture each part, in vehicle position made from HDPE & Metal Materials.
4. If swing type dunnage bar, indicate a swing up or down preference to open: Swing up.
5. Check any interface conditions which may impact design:
   □ Fork Truck  □ Load / Unload Devices  □ Robotic Load  □ Tugger
   □ Hoist at Fab  □ Over / Under Conveyor  □ Robotic Unload  □ Stripper System
   □ Hoist at Asm.  □ Workspace Layout  □ Turntable  □ 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. arm or w/o insulation). Additionally, parts need to be in vehicle position.
## AMG CONTAINERIZATION

### CONTAINER ENGINEER CHANGE FORM

<table>
<thead>
<tr>
<th>INFORMATION</th>
<th>COMMENTS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Date</td>
<td></td>
</tr>
<tr>
<td>Model Year &amp; Vehicle Program</td>
<td></td>
</tr>
<tr>
<td>Review Location</td>
<td></td>
</tr>
<tr>
<td>Job Number</td>
<td></td>
</tr>
<tr>
<td>Part Number</td>
<td></td>
</tr>
<tr>
<td>Part Description</td>
<td></td>
</tr>
<tr>
<td>Rack/Container Code</td>
<td></td>
</tr>
<tr>
<td>Density</td>
<td></td>
</tr>
<tr>
<td>Fleet Quantity</td>
<td></td>
</tr>
<tr>
<td>OEM Part Supplier Name</td>
<td></td>
</tr>
</tbody>
</table>

**CHANGE REQUEST NOTES**

---

**Approval Team:**

**Shipping Plant Rep.**

**Container Design Source:**

**Receiving Plant Rep.**

**Logistics Rep.:**

**Safety/Ergonomics:**

**Project Manager:**

**Material Handling Eng. Rep.:**

**Part Engineer:**

**OK TO PROCEED:**
<table>
<thead>
<tr>
<th>Names and Function</th>
<th>Action</th>
<th>Date</th>
</tr>
</thead>
<tbody>
<tr>
<td>Alan Walker</td>
<td>Signoff</td>
<td></td>
</tr>
<tr>
<td>Launch Manager</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Chuck Tabacchi</td>
<td>Signoff</td>
<td></td>
</tr>
<tr>
<td>Production Control Manager</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Casey Goatley</td>
<td>Signoff</td>
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</tr>
<tr>
<td>Planning Manager</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Linda Allen</td>
<td>Review</td>
<td></td>
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<tr>
<td>Director Supply Chain Management - Commercial</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Jerry Chizum</td>
<td>Review</td>
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<tr>
<td>Systems Coordinator</td>
<td></td>
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<tr>
<td>Juan Segura</td>
<td>Review</td>
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<tr>
<td>Group Leader/MFC</td>
<td></td>
<td></td>
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<tr>
<td>Phil Krug</td>
<td>Review</td>
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<tr>
<td>Supplier Quality Manager</td>
<td></td>
<td></td>
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<tr>
<td>Karen Hicks</td>
<td>Review</td>
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<tr>
<td>Engineering Change Coordinator/Planning</td>
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</table>
## VPG Sign-Off

<table>
<thead>
<tr>
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<th>Action</th>
<th>Date</th>
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</thead>
<tbody>
<tr>
<td>Matt DeMars</td>
<td>Signoff</td>
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</tr>
<tr>
<td>Chief Operating Officer</td>
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<td></td>
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<tr>
<td>Kathleen Doherty</td>
<td>Signoff</td>
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</tr>
<tr>
<td>Executive Program Coordinator</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Cabe Morphew</td>
<td>Signoff</td>
<td></td>
</tr>
<tr>
<td>Dir, Program Manager</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Leo Darocha</td>
<td>Review</td>
<td></td>
</tr>
<tr>
<td>Partition Mgr. &amp; Logistics</td>
<td></td>
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</tr>
</tbody>
</table>