Shipping Parts / Identification

Label Standard

(Asia, Africa, North America, South America)

July 2011Ver. 070111

Acknowledgements
Supplement to Ford Production Part Packaging Guidelines (MFG 1750NA)

This Ford Motor Company Guideline was developed in conjunction with, and is an extraction from the New Trading Partner Labels Implementation Guideline (AIAG B-10, released 06/04) and the Global Transport Label Template (AIAG B-16, released 11/02) developed by the Automotive Industry Action Group (AIAG), Odette, JAMA and JAPIA. Ford Motor Company variances or additions to the AIAG standards are denoted by ⊗(1). Ford Motor Company Guidelines are subject to periodic review and users are cautioned to obtain the latest editions.

This specification applies to all locations in Asia, Africa, North America, and South America for all containers (returnable or non-returnable) of PRODUCTION, PROTOTYPE or SERVICE parts or material. Bulk materials which are carried in conveyances and raw material, i.e. coils of steel, which use lift tags, do not use labels. European locations use the Odette/VDA standard instead of this document.

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ALL NORTH AMERICAN SUPPLIERS SHOULD REFER TO APPENDIX Q FOR INFORMATION RELATING TO THE LABEL CERTIFICATION PROGRAM INSTITUTED IN 2007.

NOTE: all modified, *added* and changed *text* portions from the previous level will be *italicized and RED. Modified & changed pictures will either be red or surrounded by a red box.*

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Shipping / Parts Identification Label Specifications

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1. Introduction

These specifications provide guidelines for shipping/parts identification labels for suppliers shipping to Ford Motor Company facilities. The label is designed to improve the productivity and controls at suppliers and Ford Motor Company, by allowing effective and efficient capture of data for production counts, warehouse input/output, shipper generation, forwarding, freight transfer control, receiving, and other inventory controls. Strict adherence to these specifications for the Shipping/Parts Identification Label will benefit both suppliers and Ford Motor Company.

In this document, the word "SHALL" indicates a requirement and the word "SHOULD" indicates a recommendation.

2. Definitions

2D
See Two-Dimensional Symbol

Alphanumeric
A character set that contains alphabetic characters (letters), numeric digits (numbers), and usually other characters such as punctuation marks

ANSI
American National Standards Institute

⊗ASSOCIATE CONTAINER LABEL
The labels on containers of parts that are used in a master or mixed load. Example; labels on each of 20 totes in a Master Load are Associates to the Master Load Label.

Autodiscrimination
The ability of a bar code reader to distinguish automatically between two or more symbologies (e.g. Interleaved 2 of 5, Code 39, Code 128, PDF417).

Bar code symbol
An array of rectangular bars and spaces that are arranged in a predetermined pattern following specific rules to represent elements of data that are referred to as characters; A bar code symbol typically contains a leading quiet zone, start character, data character(s), stop character, and a trailing quiet zone.

Carrier
The party that provides freight services

Character
In a bar code symbol, the smallest group of elements that represents one or more numbers, letters, punctuation marks, or other information

Code 39
For the purposes of this guideline, Code 39 (also known as Code 3 of 9) shall be the symbology as specified by ANSI AIM BC

Code 128
For the purposes of this standard, Code 128 shall mean the symbology as described in ISO/IEC15417. Code 128 generally uses a check digit for validation. For the purposes of this document, the ONLY check digit type NOT TO BE USED is the EAN/UCC type. Code 128, should have an 'x' dimension of 0.010"- 0.017".

Compliance Indicator
A specified character or string of characters indicating that the message that follows complies with an industry, regional or international standard

Container
A receptacle for shipping goods; examples are palletboxes, totes, and racks. (See also Pack, Package or Load)

Customer
In a transaction, the party that receives, buys, or consumes an item or service

Customer Part Number
The part number as defined by the customer

Data Element
The smallest named item of information that can convey data, analogous to a field in a data record or a word in a sentence

Data Element Separator
The special character used to separate data elements in a data format

Data Identifier (DI)
A specified character (or string of characters) that defines the general category or intended use of the data that follow; data identifiers are defined by ANSI MH10.8.2 / ISO 15418. The DI is not part of the data.

Date
The date field is to be formatted in two ways, one for use in the 2D bar code in the following format: data identifier of D, 2 digit day, month & year: dYYMMDD, example: d050430; and for human readability in the format of a 2 digit day, 3 character month & 4 digit year: DDMMMYYYY, example 30APR2005.

Decoder
An electronic assembly, that translates the proportional electrical signals from a scanner into recognizable or computer-compatible data

D-U-N- S®
Data Universal Number System, a 9-character company identifier assigned by Dun & Bradstreet to uniquely identify business establishment

ECC (Error Correcting Code)
A technique used at the byte level to detect and correct data transmission errors. Supplemental bits introduced or source encoded into a data stream to allow automatic correction of erroneous bits and/or derivation of missing bits, in accordance with a specific computational algorithm. See also "Error Correction Level."

Electronic Data Interchange (EDI)
The computer-to-computer exchange of formatted data between trading partners.

EDI Message Data
The data communicated between business trading partners in a standard format and syntax, e.g., ANSI ASC X12 or UN/EDIFACT.

Element
A single bar or space in a linear or stacked symbol or a single cell (module) in a matrix symbol (not the same as Data Element)

Element Width
The thickness of an element measured from the leading edge of an element to the trailing edge of the same element (see X dimension.)

Error Correction
A method used to correct erroneous data produced during the transmission, transfer, or storage of data

Error Correction Level
An indicator of the number of characters used in a two-dimensional symbol commonly referred to as "ECC", for error correction. Higher levels of error correction allow the correction of greater potential symbol damage.

Error Detection
The automatic determination that a decoded message's content is incorrect. Error detection will keep the two-dimensional symbol from being decoded as erroneous data.

Error Detection Characters
Symbol characters that are reserved for error detection. These characters are calculated automatically from other symbol characters.

Goods
A term that refers to raw material and/or produced parts

⊗GSDB code
Global Supplier Data Base code, a 5-character company identifier assigned by UCCS. It is used to identify a physical location for a supplier, customer, warehouse, etc.

Half Height Label
A label 1/2 the height of the standard label, for AIAG they are 2 inches (50.8mm), for Odette, 3 inches (76.2mm) tall. Half Height labels are used on containers that do not

have enough space for a full height label. Half Height labels are the same length as their full height versions. Half height labels contain less data due to their size and are may be used on small containers or trays in master and mixed packs as Associate Container Labels, rarely alone.

Highlighting line
A horizontal divider line(s) placed above and/or below building block or blocks. Highlighting lines are easily distinguishable from the horizontal separator lines used to separate other building blocks. This visual difference may be the result of using a thicker line chosen by the labeler.

Human Readable Interpretation
The human readable letters, digits or other characters representing the data encoded in/and printed along with the linear bar code or 2D symbol.

ID
Abbreviation for Identification

Item
A single part or material purchased, manufactured, and/or distributed

Label
A card, strip of paper, plastic, card stock or metal that is marked (by printing or some other means) and attached to an object to convey information

Labeller
A term to identify the organization responsible for the labelling of a container or unit load

Labelling Area
Area on the label available for printing

⊗License Plate
NOTE: Ford Motor Company will not require the use of this label element by suppliers at this time.
A license plate is assigned to a transport unit by its issuer. Any license plate issuer shall be authorised by an issuing agency in accordance with the rules set up by that agency and 15459-1 (ISO/IEC JTC 1/SC 31 - Procedural Standard for unique identification of transport units). Issuing agencies are authorised and registered by the Registration Authority.
A license plate number:

a) SHALL start with a string of characters, the issuing agency code (IAC), assigned to the issuing agency by the Registration Authority;
b) SHALL conform to a format specified by the issuing agency;
c) SHALL be unique in the sense that no issuer re-issues a number until a sufficient period of time has passed so that the first number has ceased to be of significance to any user responsible to the Issuing Agency;
d) SHALL contain only numeric and upper case alphabetic characters SHALL not contain more than 22 characters;

Like Parts
Same part/item number

Linear Symbol
A one-dimensional bar code Symbol, such as Code 128
An array (linear sequence) of variable width rectangular bars and/or spaces, arranged in a predetermined pattern, following specific rules, to represent elements of data; these bar and space patterns are referred to as characters. A bar code symbol typically contains a leading quiet zone, a start character, data character(s) including a check character (if any), a stop character and a trailing quiet zone

Lines Per Block (LPB)
Units of measure defining the height of text characters (see appendix D for examples and approximate conversion to inches and millimetres).

Lot
A quantity of homogeneous material either manufactured or received.

Manufacturer
Actual producer or fabricator of an item; not necessarily the supplier in a transaction

Master Label Packing List
Is a plain paper listing of all the associate labels used in a master pack. Data should include each serial number, part number (all the same) and quantity of each associate label. (It MAY include the same bar codes that are found on the corresponding labels.)

Master Load
A multiple pack or unit load of common items (sharing a single part number), such as a pallet of totes or trays, each with Associate labels.

Master Load Label
A label used to identify and summarize the total contents of a master pack.

Master Pack
A unit load containing common (like parts) items.

Mixed Item Pack
A pack containing items with different part/ item numbers

Mixed Load
A multiple pack or unit load of mixed items (different part numbers), such as a mixed-container pallet of totes or trays, each with Associate labels.

Mixed Load Label
A label used to designate mixed item, shipping packs.

Mixed Label Packing List
Is a plain paper listing of all the associate labels used in a mixed item pack. Data should include each serial number, part number and quantity of each associate label. (It MAY include the same bar codes that are found on the corresponding labels.)

Mixed-Master Label
A label used to designate the total quantity of a single part number in mixed load shipping packs.

Mixed-Master Load List
A paper listing of label data (part number, quantity, supplier code) both human readable and bar coded, used to designate each part, each total quantity and each supplier of the parts in mixed load shipping packs. This can be used instead of the Mixed-Master Summary Card

Mixed-Master Summary Card
The single grouping of Mixed-Master labels on a mixed load shipping pack used for scanning of mixed load shipments through Logistic Partner cross dock operations.

Multiple Pack
A pack containing smaller packages of items

Normative
Establishing a norm or standard.

Non-Standard Quantity Pack
A pack containing variable quantities of like items

Pack, Package or Load
A container that provides protection and containment of items plus ease of handling by manual or mechanical means (e.g. totes, palletboxes, and racks)

Pallet
A platform to hold unit loads, permitting stacking of materials and the movement of the materials as a single load.

Part
An identifiable item that has a unique name and/or number assigned to it.

Part Number
A unique code that identifies a part, assembly, component or kit

PDF417
A stacked 2D symbol use in the AIAG B16 Global Transport Label Standard for the Automotive Industry as a portable data base. Symbology: 2D=PDF 417 should have an 'x' dimension of at least 0.010"

Quantity
On a label, the marking that indicates the number of parts or items or the amount in any other unit of measure that is contained within the package.

Quiet Zone
Areas free from interfering markings surrounding a bar code symbol and, in particular, preceding the start character and following the stop character
Also referred to as "light margin" or "clear area".

Reader
A device consisting of a scanner and a decoder

Scanner
An electronic device to collect and convert reflected light from the elements (e.g. bars and spaces in linear symbols) of a symbol into electrical signals for processing by the decoder.

Serial Number
A string of numeric or alphanumeric characters in the issuer's information system used for uniquely identifying an individual item or entity for its life. This character string shall not be repeated within 365 days to a single customer.

Shall/Should
In this document, the word "SHALL" indicates a requirement and the word "SHOULD" indicates a recommendation.

Ship From
On a transport label, the address of the location where the carrier will return the shipment if the container is undeliverable

Ship To
On a transport label, the address of the location where a carrier will deliver the shipment

Shipping Pack / Container
A pack or container used for shipping items from one plant to another and can be any of the packs described above (totes, palletboxes or racks).

Shipping / Parts Identification Label
A label used to identify the contents of a shipping pack

Standard Quantity Pack
A pack which always contains the same quantity of like items

Supplier
In a transaction, the party that provides or furnishes an item or service

Symbol
A graphic array of light and dark elements that forms a complete scannable entity

Symbology
A standard means of representing data in bar code form; each symbology specification sets out its particular rules of composition or symbol architecture.

Syntax
The way in which data are combined to form messages; syntax also includes rules governing the use of appropriate identifiers, delimiters, separator character(s) and other non-data characters within the message. Syntax is the equivalent of grammar in spoken language.

Tag
A label that is hung from an object, usually with a wire placed through a reinforced eyelet in the label/ tag

Trading Partner
Any organization in a customer/supplier relationship; all members within the channels of distribution within an industry (suppliers, carriers, customers and intermediaries)

Two-dimensional Symbol
A machine-readable symbol that must be examined both vertically and horizontally to read the entire message. A 2D symbol may be one of two types of machine-readable symbols: a Matrix Symbol or a Stacked Symbol. 2D symbols differ from linear bar codes in that they have the capability for high data content, small size, data efficiency, and error correction.

UN/EDIFACT
United Nations/EDI For Administration, Commerce, and Transport
The acronym for the international data standard for electronic business messages

⊗UCCS code
Uniform Company Coding System; an alphanumeric field which identifies a specific company

Unit Load
One or more containers held together by means such as seatbelts or banding, making them suitable for transport, stacking and storage as a unit.

3. Size and Materials

3.1. Labels

The size of the standard Ford Motor Company North American label is changing from 4.0 inches (102 mm) high by 6.5 inches (165 mm) wide to the AIAG standard label of 4.0 inches (102mm) high by 6.0 inches (154.6mm). This 4x6 inch size SHOULD be used from now on. NOTE: suppliers may continue to use the previous stock size of 4 x 6.5 inches at this time. Suppliers must now print long Ford Motor Company part numbers on either size label stock on a single line. This SHOULD be achieve be using a narrower font such as UPPERCASE NARROW ARIAL, HELVETICA CONDENSED or equivalent, not a smaller

font. The label paper SHALL be white in color with black printing. Unless special written specifications are authorized for printing of color labels, no color shall appear on supplier labels that reduce the scan distance. It is also recommended that no red or green shades be used due to the occurrences of people with red/green color blindness.

3.1.1. Adhesives for Returnable Containers
SHALL be removable type pressure sensitive adhesive based on synthetic elastomers featuring moderately high initial tack, good resistance to static shear, a high level of ultimate adhesive and clean removability

3.1.2 Adhesives for Expendable Containers
SHALL be wrinkle free and assure adherence to the package substrate; adhesive types can be pressure sensitive or dry gummed. If the specified label cannot be affixed to the package/container because of container size or design, special arrangements will be required. See Exhibits 8 & 9.

3.2. Hang Tags
The tag size SHALL be the same as described in Section 3.1 plus the material necessary to add a reinforced eyelet. The tag SHALL be durable enough to assure readability at its destination. See Exhibit 7 for example.

3.3 See Exhibits 8 and 9.1-9.5 for container label placement.

4. Data Area Characteristics: See Exhibits 4.1 and 4.2 for field positions.

4.1 Data Areas and Titles
There are ten data areas for each label: SUPPLIER SHIP FROM CODE and name (Block A1), SUPPLIER BAR CODE (Block A2), 2D PDF417 Bar Code and Mixed/Master Label title (Block A3), Quantity, both numeric and bar coded (Block B1), Suppliers area 1 with Container part number, Gross weight/Unit of Measure & Label Date, optional work center, optional shift and optional lot number (Block B2), Part Number, alpha-numeric and BAR CODE (128 for all linear), prefix base suffix delimited by spaces, inverted delta for safety items (Block C1), Storage/Market Place/Location 1 (Block D1), Line Feed Loc 2 (Block D2). Suppliers area with Serial Number, description, optional supplier's part number, optional Mixed/Master Label title, optional assembled/manufactured in, optional User ID and optional Label ID (Block E1), and Dock Code, Customer (ship to) Name and Plant Code and optional Engineering Alert number (Block E2). Each data area SHALL be separated by thin lines (except for blocks A2, A3, & B3) and SHALL contain its title in the upper left hand corner (except for blocks A2, A3, C1 E1 & E2) or as shown in the Block Titles Exhibit, #3. Outer borderlines are not required. Titles SHOULD be printed in 0.08 inch (1.5 mm) high letters, 8 LPB (see appendix D). The data area titles are: SUPP (V), QTY (Q), CONTAINER, GROSS WEIGHT, DATE, PART (P), STR LOC 1, LINE FEED LOC 2, SERIAL NO. (S) or (3S), TO, DOCK CODE, CUST, & when required, ENG ALERT. Optional titles include MADE IN, W/C, SHIFT and LOT. The following fields SHALL be in a BOLD font,

Storage Location 1, Quantity, Line Feed Location 2, Customer code, Part number, Supplier code, Gross weight, Container Part number, Serial number and Dock Code.

4.2 Data Identifier Codes
A data identifier code in the first position following the start code of the bar code symbol SHALL be used to identify the information below. This character is not to be included in the human readable line, but is shown in human readable characters under the title for the appropriate data area. See Exhibits 3, 4, 5 and 6.

Using additional bar code symbols on shipping packages is not encouraged, but may be appropriated in some circumstances. To prevent reading wrong data into a system, and to differentiate among all bar code symbols, any added bar code symbols placed on the Shipping/ Parts Identification label SHALL use data identifiers. Any bar code symbol placed elsewhere on a shipping package SHOULD container a data identifier.

⊗The following identifier codes are assigned for the different types of data:
P – Part Number, Prefix and Base
C – Part Number Suffix – NOTE: No longer used in this specification
Q – Quantity
V – Supplier Number
⊗S or 3S - Unique Serial Number – Shipping / Parts Identification Label
⊗M or 4S – Unique Serial Number – Master Label
5S –Unique Serial Number – Mixed Label
G – Unique Serial Number – Mixed Load ILVS (in line vehicle sequencing)
D – Date
1T – Lot number
L – Storage Location
1L – Dock Code
20L – Line Feed Location
The 18D will not be used at this time.(18D – "Global Date" may be the future DI for bar code use.)
8V– Customer ID

5. Label Data Positions and Specifications

5.1. Block A1: See Exhibits 4.1 and 4.2 for field positions
NOTE: For all human readable fields, the font SHALL BE at the largest specified unless the field area cannot contain the data, then you may reduce to the lower specification

5.1.1. ⊗Supplier
The title for the Supplier SHALL be human readable, 8LPB and located in the upper left corner of Block A1. The Supplier GSDB Bar Code SHALL be code 128, a maximum of .375 in (9.5mm) high. The nominal starting

position of the bar code SHOULD be 0.25 in. (73.2mm) from the left edge of the label.
A vertical separator line MAY be located nominally 2.375 inches (60.3mm) from the left side of the label to separate Block A1 from A2.

5.1.2. Supplier Plant Name
The Supplier Plant Name SHALL be up to 35 characters long, human readable, 8LPB on one line and located to the right of the SUPP. title at the top of the A1 and A2 blocks. Abbreviations must be used to keep data within blocks A1 and A2

5.2. Block A2: See Exhibits 4.1 and 4.2 for field positions

5.2.1. Supplier GSDB Code
The Supplier GSDB Code SHALL be human readable, 2-3LPB and located in the center of Block A2. No title will be used in this block.

5.3. Block A3

5.3.1. 2D Bar Code Symbology
The PDF417 Bar Code symbol SHALL be centrally located in Block A3, Block A3 SHALL NOT have boundary lines, and conform to the specifications found in the AIAG B16 document. Data to be contained in container labels SHALL consist of the following data elements and associated Data Identifiers (DI's):
Part number delimited with spaces (P) in the format PREFIX BASE SUFFIX CONTOL-CODE(this last 3 character field only if used by your customer and sent in the release)(NOTE: The European Part number format is limited to Prefix (6) Base (8) Suffix (8) and control code (2) due to the EDI format used.) ; Quantity (Q); Supplier Code (V); Date (D)[label date, manufacture date, or ship date] in the format of DYYMMDD, example d040110 (January 10th, 2004); Serial Number (S) or (3S), OPTIONAL FIELDS: Lot Number (1T), Storage Location 1 (L), Line Feed Location 2 (20L), Dock Code (1L).
NOTE: The order of data field entry is not important when using DI's.
When printing Master Labels, the data contained in the PDF417 SHALL consist of Part Number, delimited with spaces (P); total quantity of the pack (Q); Supplier Code (V); Date [label date, manufacture date, or ship date] in the format of YYMMDD, (D); and Serial Number (M) or (4S). OPTIONAL FIELDS: Storage Location 1 (L), Line Feed Location 2 (20L), Dock Code (1L).
NOTE: Certain Suppliers may be required, via direct notification by the customer plant or customer staff, to include an expiration date with their material. In those cases the following fields SHALL ALSO be included in the 2D bar code; Expiration Date (15D) in the format DDMMYYYY, (exp: 15D15112006). Supplier Part Number (1P), and Lot Number (1T). See Exhibit 10.0.

When printing Mixed Labels, the data contained in the PDF417 SHALL consist of the Supplier Code (V); Date [label date, manufacture date, or ship date] in the format of YYMMDD, (D); and Serial Number (5S). OPTIONAL FIELDS: Dock Code (1L).
When printing In Line Vehicle Sequenced labels, this new layout standard does not apply. The label serial number data identifier be "G" and label specifications are to be found in Appendix I.

5.3.2. Bar Code Specifications
See Annex C and Annex D of the AIAG B16 document for AIAG specifications to use when building a PDF417 2D bar code for this Ford Motor Company label.

5.3.3. ⊗Master Label
When using this design for a Master Label, the words "MASTER LABEL" SHALL appear at the top of the A2 Block, above the 2D bar code 4LPB high. Also see optional Master Label in the E1 Block.

5.3.4. ⊗Mixed Label
When using this design for a Mixed Label, the words "MIXED LABEL" SHALL appear at the top of the A1 Block, 4LPB high. Also see optional Mixed Label in the E1 Block.

5.3.5. ⊗Mixed-Master Label
When using this design for a Mixed-Master Label, the words "MIXED-MASTER" SHALL appear at the top of the A1 Block, 4LPB high. Also see optional Mixed-Master Label in the E1 Block.

5.4. Block B1

5.4.1. Quantity
The Quantity field SHALL be a maximum of nine characters, both human readable and bar coded, the human readable SHALL NOT show lead zeros (although the bar code SHOULD contain lead zeros) 2LPB, and located in Block B1.
The bar code symbol for the quantity SHALL be directly below the human readable characters and SHALL be a minimum 0.375 inches (9.5mm) high.
The nominal length anticipated for the quantity is six (6) numeric characters plus the data identifier (Q). The length of this area (the line separating the Quantity Area from the Special Area) may be adjusted to handle specific needs of the supplying location and/or Ford Motor Company for information required in the special data area of the label.
The nominal starting position of the bar code 128 SHOULD be 0.25 in. (73.2mm) from the left edge of the label.
When the unit of measure is pieces or each, notation is not required.
When the unit of measure is not pieces or each (e.g. pounds, pairs, feet, etc.), the unit of measure SHALL be noted in human readable form only.

When used, the unit of measure SHALL be directly to the right of the bar code quantity and SHALL be 7LPB high. The unit of measure SHALL not be bar coded. Unit of measure abbreviations as defined in the ASCX 12.3 – 1984 Data Element Dictionary SHALL be used. (See Appendix A).

5.5. Block B2

5.5.1. ⊗CNTR, Container

The title for the container field SHALL be human readable, 8LPB and located just above the container field in Block B2. The container field SHALL be human readable, alphanumeric, 5LPB and located at the top left corner of the B2 field, consisting of the base and suffix of the container part number separated by a dash. The maximum number of characters SHALL not exceed ~~7~~ 9 for the base (8 maximum in Europe) and 5 for the suffix.

5.5.2. Gross Weight

Each container label SHOULD have a human readable, 5LPB Gross Weight measure displayed in the left central area of Block B2. The title for Gross Weight SHALL be 8LPB, located directly above the Gross Weight data. The type of weight measure SHOULD be in English pounds (lbs) unless required otherwise by the customer plant. Gross Weight measure is optional for Master or Mixed labels but SHALL be located in the same relative location as the container label. If a Gross Weight cannot be provided, then a Net Weight is permissible for Master and Mixed labels.

5.5.3. Date CYMD

The human readable date field title SHALL be 8LPB with the title above the date, located in the bottom left corner of the B2 Block. The human readable date SHALL be no smaller than 5LPB, in the format of a two digit day followed by a three letter month (SHOULD be in English) followed by a full four digit century-year, (example: 25DEC2004). The three character month codes are to be found in Table 1, Appendix C.

5.5.4. ⊗W/C-SHIFT-LOT

These three human readable fields are totally optional, used at the discretion of the supplier, but SHALL have titles of 8LPB. They SHOULD be located to the right of the gross weight and date fields with the Lot field above the Shift and W/C(work center). If the supplier is a Ford Motor Company Plant, then the W/C will consist of a maximum size of 5 characters (6LPB), shift will be 1 character (4LPB), and lot size will be up to 5 characters (4LPB) (this field may be up to 13 characters if none of the other fields are used. In this case the maximum height will be 6LPB).

5.6. Block C1

5.6.1. ⊗Part Number

The human readable part number characters SHALL be bold and minimum of 0.5 inches (12.7mm) high (1 LPB), The format of Ford Motor Company part numbers are 7 Prefix, 9 Base, 8 Suffix, 3 Control Code (6,8,8,2 in Europe), separated by spaces in EDI and bar codes, dashes (-) when printed as human readable characters on labels. The maximum length of any bar symbol SHOULD not exceed 5.5 inches (140 mm), 30 characters including spaces. The part number separation characters between prefix-base-suffix SHALL be dashes replacing spaces for all part numbers to improve readability.

The bar code symbol of the part number SHALL be directly below the human readable characters, at least 0.25 inch (7mm) from the left label edge, see Exhibits 4, 5 & 6, and SHALL be a minimum 0.35 inches (9 mm) high. The maximum length of any bar symbol SHOULD not exceed 5.5 inches (140 mm).

The part number SHALL be the designated number assigned by Ford Motor Company. The prefix, base and suffix of the part number SHALL be located in the Block C1 area, designated by the identifier (P) with each section of the part separated by a blank space. The blank space between the prefix and base and between the base and suffix SHALL be included in the bar code symbol.

Control (safety) items SHALL be identified with an inverted delta located in Block C1 preceding, following, or below the part number depending on length of part number. The inverted delta SHALL NOT be included in the bar code symbol. The inverted delta may be enclosed by a circle. See Exhibits 4a and 5a or Appendix E.

5.6.2. Part Number Continuation

The part suffix SHALL NOT be printed in a separate Block any longer except for ILVS labels. See Appendix I.

5.7. Block D1

5.7.1. Storage Loc 1(previously the R-Code Area)

The STR LOC 1 field SHALL be human readable, no smaller than 3 LPB, located in Block D1 and SHALL be up to 10 characters long. The title for this field SHALL be located in the upper left of the block. There MAY be a separator line between blocks D1 and D2. NOTE: This data must be sent via EDI in the 830 Planning and/or the 862 Shipping release by the customer plant or the field SHALL be blank.

5.8. Block D2

5.8.1. ⊗LINE FEED LOC. 2 (previously the Linefeed Location)
The Line Feed Location 2 field SHALL be human readable, a maximum of 10 character long, no smaller than 3 LPB and located against the left side of Block D2, directly to the right of STR. LOC 1 field. The title for this field SHALL be located in the upper left corner of Block D2. NOTE: This data must be sent via EDI in the 830 Planning and/or the 862 Shipping release by the customer plant or the field SHALL be blank.

5.9. Block E1

5.9.1. Supplier Area
The supplier area is to be used primarily by the suppliers for the data required to meet their needs for MRP processes and to meet Ford Motor Company and AIAG MMOG standards for building accurate counting and shipment EDI data.

5.9.1.1. Supplier Expiration Date
When required by mutual agreement, the human readable expiration date SHALL appear in BLOCK E1 in the format of EXP DATE DDMMMYYYY, with a suggested size of 7LPB, located in the upper right corner. SEE EXHIBIT 10.0.

5.9.2. ⊗Supplier Part Number
The human readable supplier part number is an optional field with a suggested size of 6LPB Block, located in the upper left corner of Block E1.

5.9.3. Description
The Ford part number description field SHALL be human readable, 6LPB, a maximum of 34 characters long and located against the left edge of the middle of the E1 Block, below the supplier number, if supplier number is used.

5.9.4. ⊗Label Serial Number
The human readable serial number characters SHALL be a minimum of 7LPB (up to 4LBP) high and located in Block E1.
The bar code symbol for the serial number SHALL be directly below the human readable characters and SHALL be a minimum 0.35 inches (9 mm) high.
The maximum length of the serial number MAY be nine (9) alphanumeric or numeric characters (length and character type are supplier options) plus the data identifiers.
The serial number SHALL be a unique number (not necessarily in sequential order) assigned by the supplier within any calendar year. Each

Shipping container or pack having a Shipping/ Parts Identification label SHALL have a unique serial number.

5.9.5. Optional "Made In"
Below the Plant Address is an area that may optionally contain Made In country name information.

5.9.6. ⊗Master Label
When using this design for a Master Label, the words "MASTER LABEL" MAY appear in the bottom right of the E1 Block, 6LPB high. Also see Master Label in the A3 Block.

5.9.7. ⊗Mixed Label
When using this design for a Mixed Label, the words "MIXED LABEL" MAY appear in the bottom right of the E1 Block, 6LPB high. Also see Mixed Label in the A3 Block.

5.9.8. ⊗Mixed-Master Label
When using this design for a Mixed-Master Label, the words "MIXED-MASTER" MAY appear in the bottom right of the E1 Block,6LPB high. Also see Mixed-Master Label in the A3 Block.

5.10. Block E2

5.10.1. Customer Plant Name
The Ford Plant Name SHALL be up to 30 characters long on each of two lines, if necessary. The first line SHALL begin with the name FORD, located below the "To" header.

5.10.2. ⊗Dock Code
The 2 character Dock Code field SHALL be human readable, a maximum of 2 characters long, 1-2LPB and located in the center of Block E2. The title for this field SHALL be located in the upper left corner of Block E2. NOTE: This data must be sent via EDI in the 830 Planning and/or the 862 Shipping release by the customer plant or the field SHALL be blank. For shipments to FCSD, this field shall contain Intermediate Consignee GSDB code instead of Dock Code when requested by FCSD. The font size shall be reduced to fit in the same space.

5.10.3. ⊗Customer Code
The Customer Code field SHALL be human readable, 3LPB, be the Ford Global Supplier Data Base, 5 character ID of the customer plant and located in the central, bottom of Block E2.

5.10.4. ⊗ENGR. ALERT, Engineering Alert
The Engineering Alert field is to be only to be displayed when required by the customer plant. The title for the Engineering Alert field SHALL be

human readable, 8LPB and located in the bottom left corner of Block E2. The field for the Engineering Alert data SHALL be a minimum of 7LPB and a maximum of 9 characters in length. This data must be provided to the supplier verbal or in written form from the customer plant. It SHALL be displayed from the time notice is first given until the number is rescinded or changed on all container labels for a part.

6. Linear Bar Code Symbology(see AIAG B-16 Linear Bar Code, page 16

6.1. Linear Bar Code
Bar codes SHALL be the Code 128 type and SHALL as described in ISO/IEC 15417. The print quality for information encoded in the Code 128 symbol shall comply with ISO/IEC Standard for Bar Code Print Quality 15416. In addition: The Code 128 symbol SHALL be left justified, allowing for a quiet zone at each end of the symbol, of at least 0.25 inches (6.4mm).

6.2. Code Configuration
The four characters %(PERCENT SIGN), /(FORWARD SLASH), $(DOLLAR SIGN), +(PLUS SIGN) SHALL NOT be used on the container, master or mixed labels

6.3. Code Density and Dimensions
The minimum height of the symbol SHALL be 0.5 inch, (13mm) except as noted. Non-significant zeros and spaces SHALL be omitted. "X" Dimension. The dimension of the narrowest element (X dimension) range should be from 0.0010 to 0.017 inch (0.254 to 0.432mm) as determined by the printing capability of the supplier/printer of the label. Symbols with narrow elements at the lower end of this range may require special care to meet the print quality requirements. Conformance to the print quality requirements SHALL be determined in accordance with ISO/IEC 15416.

6.4. Check Digits
Check digits SHALL be used in the code 128 bar codes. The ONLY check digit type NOT TO BE USED is the EAN/UCC type.

6.5. Reflectivity and Contrast
The printed bar code symbols SHALL meet the reflectivity and contrast requirements, specified in Section 4.1 of AIAG's B1 document, at all electromagnetic wave length from B633 to B900 nanometers.

6.6. Quality Assurance Requirements
It is the responsibility of the supplier to provide bar coded labels that meet these specifications. Equipment is available to verify the bar code symbols to meet these requirements. Use of statistical process control techniques to minimize printing variability is recommended
The minimum symbol grade at point of customer scan SHALL be "C", 1.5/10/660, where:

1. 1.5 is the minimum print quality at point of production

2. 10 (=0.254mm) is the measurement of aperture, and
3. 660 (=660 nanometers [nm] +/-10nm) is the inspection wavelength

For more detailed specifications related to the automotive industry, reference the AIAG B8 document.

7. Label Location and Protection

7.1. Label Location

Illustrations of the most common shipping packs and recommended label locations are shown in Exhibits 8 and 9. In most cases two labels are specified. The bottom edge of the label SHOULD be parallel to the base of the package/container. To facilitate automatic reading of the bar code symbols, the top edges of the label, whenever possible, SHOULD NOT be more than 20 inches from the bottom of the container. Wraparound labels are acceptable for expendable containers as long as quiet zones are within specifications. NOTE: for Ford internal Stamping Business Unit plant; a single label SHOULD BE sufficient on all racks if concurred between trading partners.

7.2. ⊗Label Protection

Label protection against moisture, weathering, abrasion, etc., may be required in harsh environments and is encouraged whenever practical. Laminates, sprays, window envelopes, and clear plastic pouches are examples of possible protection methods for use on corrugated containers only. In choosing any protection method, care must be taken to assure that labels meet reflectivity and contrast requirements and can be scanned with contact and non-contact devices.

8. Special Labels

8.1. Multiple, Common Item Packs

A Master Label, as shown in Exhibits 5.1 and 5.2, SHALL be used when the supplier and Ford agree that the total contents of a multiple, common item packs SHOULD be identified. Each sub-pack/container of the multiple packs SHALL be identified with a Shipping Parts Identification Label (Example 4.2). The total multiple pack SHALL be identified with a Master Label in a location specified by Ford. The label SHALL be placed on the pack in such a manner that when the pack is broken apart the label is discarded (i.e., hang Master Label from banding or attach to stretch wrap). The balance of the label format SHALL conform to the specification for the Shipping / Parts Identification Label except that the data identifier for the serial number SHOULD Be “M” or "4S" instead of “S”. The serial number, preceded by an “M” or "4S" in the bar code form only SHALL be a unique number, not to be repeated over the course of a year. The quantity on the Master Label SHALL be the total in all the sub-packs.

8.2. Mixed Item Loads

Mixed item loads as shown in Exhibits 6.1 and 6.2, SHALL be used when the supplier and Ford agree that the total contents of a multiple, mixed item packs SHOULD be identified. Each sub-pack/container of the multiple packs SHALL

be identified with a Shipping Parts Identification Label (Example 4.2). The total multiple pack SHALL be identified with a Mixed Label in a location specified by Ford. The label SHALL be placed on the pack in such a manner that when the pack is broken apart the label is discarded (i.e., hang Mixed Label from banding or attach to stretch wrap). The Mixed Load Label serial number SHALL be a unique number, not to be repeated over the course of a year and the data identifier SHALL be "5S" instead of "G". The "G" identifier is to be used with In Line Vehicle Sequenced (ILVS) parts (See Appendix I).

8.3. ⊗ Mixed-Master Labels for scanned loads.
There is a requirement to have the ability to scan mixed load associate labels for shipments though a logistics partner without breaking down the pack. This forces a new process on suppliers that ship through these logistics partners (known as Origin Distribution Centers (ODC's).

Normal mixed load labeling SHALL be followed, labels on each associate container and mixed load labels on the whole pack. Then an added label step must be performed that is not to be included in the ASN/EDI!

The process REQUIRES that a master label SHALL be created for each part number in a mixed load. Each master label SHALL have the title "MIXED-MASTER" above the 2D bar code and be attached to a single Mixed-Master Summary Card that SHALL be attached to the whole, mixed load. Optionally, you MAY utilize a Mixed-Master Load List instead of the Mixed-Master Summary Card. The report or Mixed-Master Load Label must contain a summary, by part, of the total quantity for each part in the load.
Both the "Mixed-Master Load" and the report must have linear bar codes for the part, quantity, part continuation, and supplier code (in that order) for each part in the mixed load. They may be Code 128 (preferred) or Code 39
If labels are used, attach all Mixed-Master labels to a single card. Attach the card to the load. See the following Exhibits 6.3 – 6.8.

8.4. ⊗Half-Height Labels for totes & trays
Containers (totes or trays) that do not have enough area available for a 4x6 inch label still require a minimum of data for proper handling through the supply chain. Examples of Half height labels are shown in Exhibits 4.9 & 4.10.

8.5. ⊗Special Handling Data
At times special handling of data requires unique label processing for data or clear identification purposes. Examples of this include Left-Right parts, invisible part differences, FIFO/LIFO processed parts, supplier processes using codes. To accommodate this, permissions to use restricted spaces on labels and/or color stripes or dots can be agreed to on a supplier to plant basis. See appendix "L".

9. ⊗Other Identification Requirements

9.1. Control Items (Inverted Delta Items)
Control Items (inverted delta items) are defined by Quality System Standard Q-101 as "parts which can affect either compliance with government regulation or safe vehicle operation". These parts are identified on part prints or other engineering documents by an inverted delta preceding the part number and shall be identified on the shipping label by an inverted delta (0.35 inches high) preceding or after the part number (human readable Only). See Exhibit 4.2.

Certain inverted delta parts require lot traceability per the part drawing or speciation. These items SHALL have their lot control code identified on a separate label (human readable code only minimum of 0.5 inches high), affixed to the container on the same side as the shipping label. NOTE: For returnable containers the adhesive for these special labels must conform to Section 3.1.1 of this standard.

THE SUPPLIER SHALL HISTORICALLY RECORD AND CROSS REFERENCE THE LOT CODE NUMBERS TO A SPECIAL LABEL SERIAL NUMBER.

9.2. Toxicology Number
When required, toxicology numbers SHALL be identified on a separate label, human readable only, affixed to the container on the same side as the shipping label. NOTE: For returnable containers the adhesive for these special labels must conform to Section 3.1.1 of this standard.

9.3. Critical Materials
Containers for critical materials shall have dispensing and venting bung holes sealed and bonded with metal caps and shall be identified as follows:

Contents	Part number
Long Life Coolant Concentrate	ESE-M97B44-A
Wheel Bearing Grease	ESA-M1C75-B
Automatic Transmission Fluid	ESP-M2C138-CJ and ESP-M2C166-H
Power Steering Fluid	ESW-M2C33-F
Engine Oil SAE #10W30	ESE-M2C96-G
Hypoid Gear Lubricant	ESP-M2C154-A and EST-M2C154-A
Extreme Pressure Lubricant SAE-80	ESP-M2C83-C
Grease – NLGI – 1-Life Time Lube	ESW-1C87-A
Hydraulic Clutch Fluid	ESA-M6C25-A

Drums can be any color, except red, as red is specified for hydraulic brake fluid* only.
*Heavy Duty Hydraulic Brake Fluid (ESA-M6C25-A)
Color of Drum Must Be M-472 --- Red Enamel
Color of Stripes Must Be M-325 --- Target Yellow Enamel

*Hydraulic brake fluid must conform to MS-100-16, "Hydraulic Brake Fluid – Procedure Relative to Drums, Tank Car or Tank Truck Shipments", prior to leaving supplier's plant. See Stencil "B", Destroy Drum – For Hydraulic Brake Fluid Drum Only.

*Drums containing hydraulic brake fluid are to have eighteen (18) vertical stripes around the circumference of the drum at each end. Stripes are to be approximately 2" wide and 9" long equally spaced around the circumference (See Exhibit 8, "Critical Material Identification").

9.3.1. The specifications for Shipping and Identification of Critical Materials are as follows (See Exhibit 8)

- The color of lettering for "Stencil A" SHALL contrast with the color of drum.
- Lettering must be bold style with letters being at least 1" high.
- Letters of part number SHALL be 2" high.
- Hazardous materials SHALL be identified by a six digit "Toxicology Number" placed on a separate label.
- Parts shipped in permanent racks or returnable containers SHALL be identified by a label placed in a label holder. The particulars of labels, holders, racks and method of attachment, etc., shall be subject to review and approval of the Material Handling Department of the requisitioning activity.

9.4. Pallet Loads Restrained by Stretch or Shrink Wrap

When a pallet load consists of identical part numbers, and the load is restrained by a plastic stretch or shrink film wrap (or similar), then a master label representing the complete load is to be attached to the outside of the wrap as well as a label on each individual container.

9.5. Hazardous Materials

All hazardous materials SHALL be marked in accordance with the latest provisions of both Title 29, Section 191-0, 1200, and Title 49, Code of Federal Regulations, published by the Office of the Federal General Services Administration. If conflict between Title 29 and Title 49 provisions should arise, then the provisions of Title 49 take precedence.

9.6. Deviation Numbers

When required the supplier SHALL cross reference and track the deviation number(s) with the serial number of the label. The deviation number SHALL NOT be printed on the shipping label.

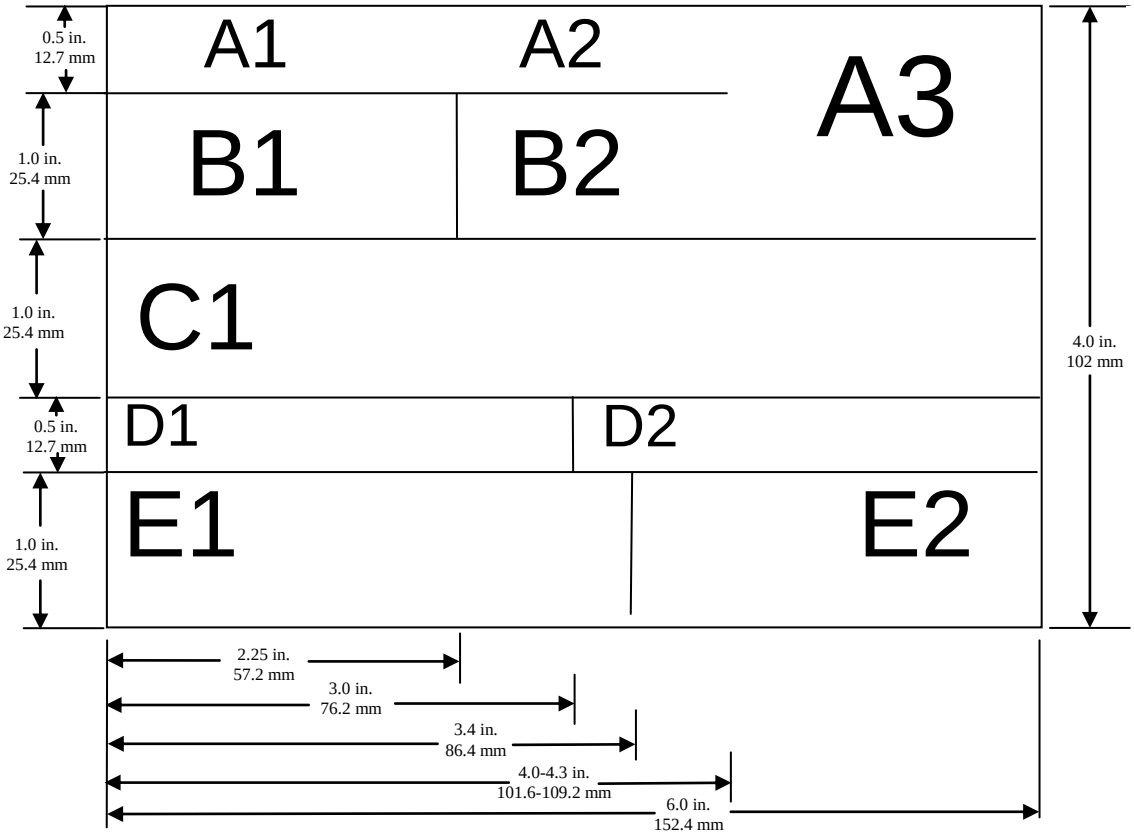
Exhibits 2.1 & 2.2

LABEL BLOCK DIMENTIONS AND BLOCK USES

Block heights are nominally 1.1 +/- .1 inch and 0.9 +/- .1 inch (27 mm and 22.9 mm +/- 2.54mm).

Exhibits not to scale – for illustrative purposes only.

2.1



2.2

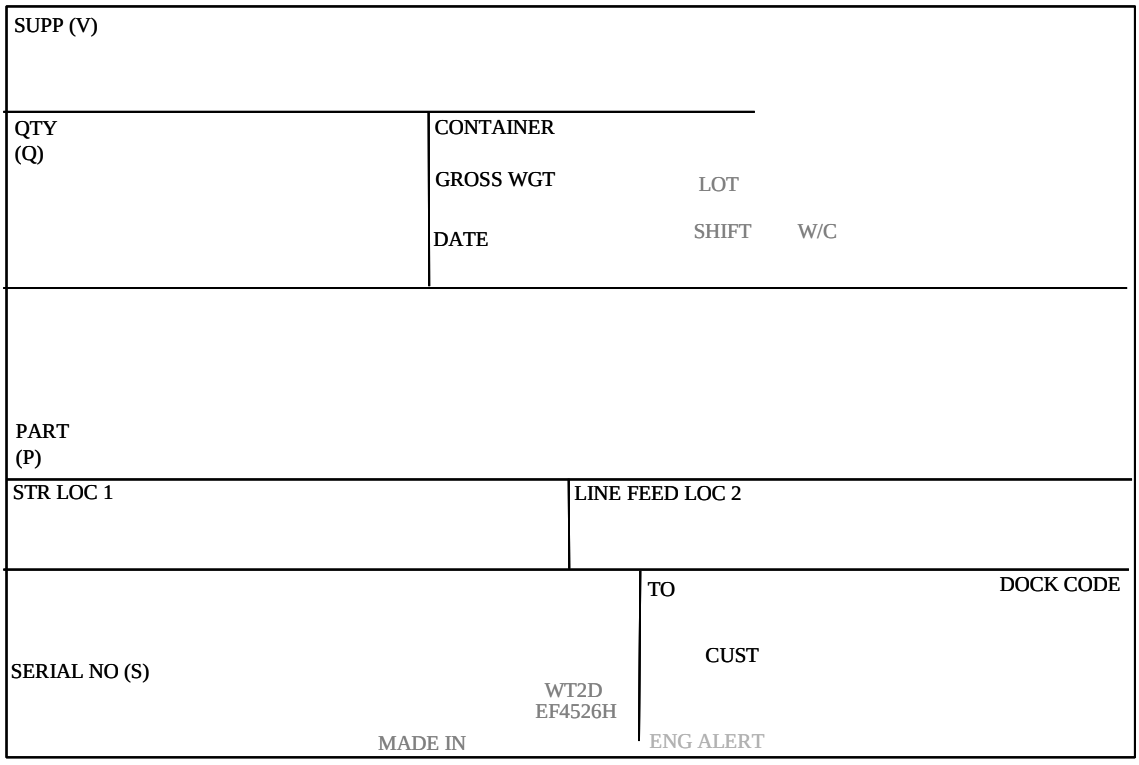
A1 Supplier Ship From name Supplier code bar code 128	A2 Supplier code alpha-numeric	A3 MASTER/MIXED LABEL
B1 Quantity in numeric & bar code 128 plus UOM	B2 Container Part number Gross weight & UOM Optional work center, shift, Lot number Label Date	PDF417 2D bar code W/part no., quantity, Supplier code, Serial #, label date And lot number
C1 Part number, alpha-numeric and bar code 128 Inverted delta for safety items		
D1 Storage/MP/Loc 1	D2 Line feed location 2	
E1 Supplier's area: Serial number, description, Supplier's part number optional label and user ID, MIXED/MASTER Optional Assembled/Mfg in Country name	E2 Customer Ship To name & Dock code Customer plant code Engineering alert number	

Exhibit 3

BLOCK TITLES

Block titles are to be left justified in each block except where noted and 8 LPB. Titles for bar coded items SHALL include the data identifier that corresponds to the field as defined in Appendix A of AIAG B-10 document. (NOTE: Ford Motor Company utilizes some codes and layouts that are not those listed in the B-10 document for serial numbers. As the supplier serial number is not scanned by Ford Motor Company, trading partners SHOULD use the recommended B-10 standard where appropriate and as their manufacturing systems allow.) Grey or light titles are Optional titles and fields, depending on supplier/customer use.

Not to scale - for illustrative purposes only.



3

NOTE ON SERIAL NUMBERS: Ford Motor Company uses the "S" data identifier for containers, "M" for master loads and "5S" for mixed load serial numbers.. The AIAG B-10 lists these data identifiers to be "3S", "4S" and "5S" respectively. Trading partners SHOULD use the AIAG B-10 standard as their manufacturing systems allow.

Exhibits 4.1 Layout & 4.2 Example

CONTAINER LABEL FIELD POSITIONS AND SIZES

The container label SHALL be placed on each single container of like parts. Linear Bar Code symbology SHALL be Code 128. All field locations, dimensions, print sizes will be found in Table #1 in appendix E.

Not to scale - for illustrative purposes only. Grey fields are optional fields.

4.1

4.2

Exhibits 4.3 Large Part Number & 4.4 Example of Method to Handle

CONTAINER LABEL FIELD POSITIONS AND SIZES

As was seen in 4.1 above, the part number size exceeds the dimensions of the label if all 27 characters and spaces are used. 4.3 below shows a label with a part number using all 3 fields. There are no such parts within Ford Motor Company at this time. However, if a part number will exceed the label dimensions, the use of a narrower font will be acceptable as shown in example 4.4. All field locations, dimensions, print sizes will be found in TABLE #1 in appendix E. Not to scale - for illustrative purposes only. Grey fields are optional fields.

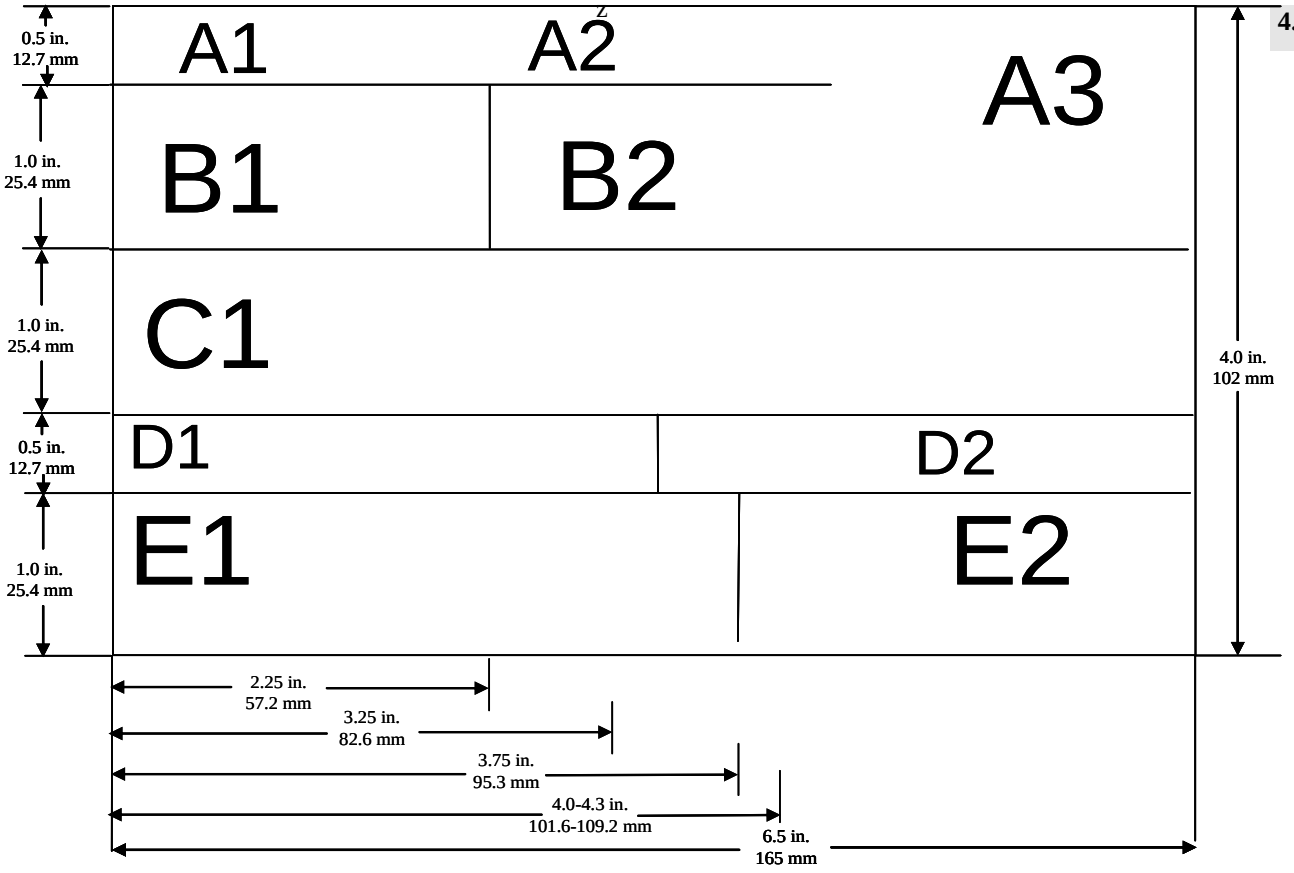
4.3

4.4

Exhibits 4.5 Layout & 4.6 Example
ALTERNATIVE CONTAINER LABEL SIZE

If the a supplier prefers to continue using the previous Ford label size of 4 x 6.5 inches (101.6 x 165.1mm) they may do so at this time. Proper dimensions are shown in example 4e below. 4f shows an example of label 4b in the 4 x 6.5 size. All field locations, dimensions, print sizes will be found in Appendix E . Not to scale - for illustrative purposes only. Grey fields are optional fields.

4.5



4.6

SUPP (V) SALINE PLASTICS PLANT **PP03B**

QTY (Q) **56** EA

CONTAINER **C630**

GROSS WGT **440** LB

LOT 3290

DATE **11NOV2003**

SHIFT 2

W/C 27210

3S4X-A045A74-AAZUYI

PART (P)

STR LOC 1 **2D33B75A-1**

LINE FEED LOC 2 **J11-232-4C**

3S4X A045A74

2527 CNSL FRT LO MED DK GRAPH

SERIAL NO (S) **0AAC219**

WT2D EF4526

MADE IN

TO FORD WAYNE STAMPING & ASSY

DOCK CODE

CUST **AP16A** **WD**

ENG ALERT DPB1023AA

Exhibits 4.7 Control Code Part Number & 4.8 Example of Method to Handle CONTAINER LABEL FIELD POSITIONS AND SIZES

There are some FORD customer plants that use the 4th portion of the Ford Motor Company part number called the CONTROL CODE. The full part number format is Prefix, 7 characters, Base, 9 characters, Suffix, 8 characters, and Control Code, 3 characters. As was seen in 4.1 above, the part number size exceeds the dimensions of the label if all 30 characters and spaces are used. 4.7 below shows a label layout using all 30 characters. There are no such parts within Ford Motor Company at this time. A more typical use of the 4th field is shown in 4.8 below. All field locations, dimensions, print sizes will be found in TABLE #1 in appendix E. Not to scale - for illustrative purposes only. Grey fields are optional fields.

4.7

SUPP (V) SUPPLIER NAME **ABC45**

QTY (Q) **999999** EA

CONTAINER **BASE56789 SUFIX**

GROSS WGT **999999** LB

LOT 99999

SHIFT A

W/C 99999

DATE DDMMMCCYY

PART NO. (P) **PREFIX7-BASE56789-SUFFIX78-CC3**

PART (P)

STR LOC 1 **A1C2E3G4H0**

LINE FEED LOC 2 **1B2D3F4H5J**

SUPPLIER PART NUMBER1234

PART DESCRIPTION UP TO 35 CHAR

SERIAL NO (S) **ABCD9999**

WT2D EF4526

MADE IN

TO FORD CUSTOMER PLANT NAME 67893

DOCK CODE **AB**

CUST **ABC45**

ENG ALERT 12345678

4.8

SUPP (V) VISTEON PPD SALINE PL **PP03B**

QTY (Q) **56** EA

CONTAINER **SK32 C630L**

GROSS WGT **440** LB

LOT 27210

SHIFT 2

W/C 32903

DATE **11NOV2003**

3S4X-4A574-AA-KIT

PART (P)

STR LOC 1 **2D33B75A-1**

LINE FEED LOC 2 **J11-232-4C**

3S4X A045A74 AAZUYI

2527 CNSL FRT LO MED DK GRAPH KIT

SERIAL NO (S) **0AAC2195**

WT2D EF4526

MADE IN

TO WAYNE STAMPING & ASSEMBLY

DOCK CODE **WD**

CUST **AP16A**

ENG ALERT DPB1023AA

Exhibits 4.9 Layout & 4.10 Example of Method to handle Half-Height Labels for Totes & Trays, & Example of Use

CONTAINER LABEL FIELD POSITIONS AND SIZES

Some suppliers have containers that require the use of a smaller label. This label must still contain the required minimum data for material handling. Containers (totes or trays) that do not have enough area available for a 4x6 inch label still require a minimum of data for proper handling through the supply chain. An example of the format and required data elements for half height label use is provided below in example 4.9. The label MAY be made from the current 4 x 6 or 6.5 inch stock that is folded in half (or upper half is cut off). 1D bar codes SHALL be a minimum of .25 inches tall. Human readable fonts are to be as large as will fit in the remaining area when bar codes are in the same block. Not to scale - for illustrative purposes only. Grey fields are optional fields.

Suppliers area, fold over or cut off for shipment.

QTY (Q) **56** EA

STR LOC 1 EF4526 **2D33B75A-1**

DATE 11NOV200

LINE FEED LOC 2 WT2H **J11-232-4C**

ENG ALERT DPB1023AA

PART NO. (P) MADE IN **3S4X-A045A74-AAZUYI**

SERIAL NO (S) **0AAC2195**

SUPP (V) **PP03B**

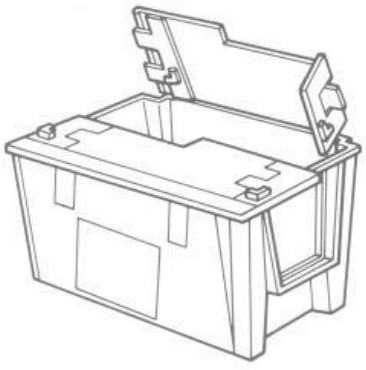
CONTAINER **SK32 C630L**

GROSS WGT **440** LB

DOCK CODE **WD**

CUST **AP16A**

4.9



4.10

Exhibits 5.1 Layout & 5.2 Example

MASTER LABEL FIELD POSITIONS AND SIZES

Not to scale - for illustrative purposes only.

Exhibits 6.1 Layout & 6.2 Example

MIXED LOAD LABEL FIELD POSITIONS AND SIZES

NOTE ON MIXED LOAD DOCK CODE: All parts SHALL HAVE the same dock code in a mixed load if the label displays a dock code. A DOCK CODE SHALL NOT BE DISPLAYED on a mixed label if no part has a dock code designated by the customer.

Not to scale - for illustrative purposes only.

6.1

SUPP (V) SUPPLIER NAME

ABC45 MIXED LABEL

QTY
(Q)

CONTAINER
BASE56789 SUFIX

GROSS WGT
999999 LB

DATE
DDMMMCCYY

PART
(P)

STR LOC 1

LINE FEED LOC 2

SERIAL NO (5S) **ABCD9999**

WT2D
EF4526
MIXED LABEL

TO DOCK CODE
FORD CUSTOMER PLANT NAME 67893

CUST
ABC45 **AB**

6.2

SUPP (V) SALINE PLASTICS PLANT

PP03B MIXED LABEL

QTY
(Q)

CONTAINER
SK32 C630L

GROSS WGT
240 LB

DATE
11NOV2003

PART
(P)

STR LOC 1

LINE FEED LOC 2

SERIAL NO (5S) **0AAC2197**

WT2D
EF4526
MIXED LABEL

TO DOCK CODE
FORD WAYNE STAMPING & ASSEMBLY

CUST
AP16A **WD**

Exhibits 6.3 Examples of Mixed-Master Load List & 6.4 Mixed-Master Label. Mixed pack handling for ODC shipments using Mixed-Master Labels and Summary Cards or Mixed-Master Load Lists

There must be a report or batch of "Mixed-Master Load" labels attached to the Mixed container. The report or "Mixed-Master Load"List (Exhibit 6.3) must contain a summary, by part number, of the total quantity for each part in the load. Both the "Mixed-Master Load" and the report must have linear bar codes, .50 inch (12.7mm) tall for the part number, quantity, and supplier code (in that order) for each part in the mixed load. They SHOULD be Code 128 (preferred) or Code 39 if necessary. If labels are used, attach all Mixed-Master labels to a single Summary Card (Exhibit 6.6). Multiple bar codes for supplier code are optional as is the addition of the dock code in the upper right corner of the sheet. Attach the card to the load. See the following 7 Examples. Not to scale - for illustrative purposes only

6.3

MIXED-MASTER LOAD LIST DOCK CODE *WD*

PART	QUANTITY	SUPPLIER
3S4X-A045A74-AAZUYI	560	PP03B
3S4X-A045A74-AAZFFA	590	PP03B
4VAE-7A540-AA	56	PP03B
4VAE-7A540-AG	256	PP03B
XRM3S4X-A045A74GD-AAZUYI78	56	PP03B
-W0457433-S100	5600	PP03B

etc…

6.4

SUPP (V) SALINE PLASTICS PLANT

PP03B **MIXED-MASTER**

QTY (Q) **560** EA

CONTAINER **SK32 C630L**

GROSS WGT **4400** LB

DATE **11NOV2003**

3S4X-A045A74-AAZUYI

PART (P)

STR LOC 1 **2D33B75A-1**

LINE FEED LOC 2 **J11-232-4C**

3S4X A045A74

2527 CNSL FRT LO MED DK GRAPH

SERIAL NO (M) **0AAC219**

WT2D

EF4526

MASTER LABEL

TO FORD WAYNE ASSEMBLY

CUST **AP16A**

DOCK CODE **WD**

ENG ALERT DPB1023AA

Exhibits 6.5 Examples of Mixed-Master Label Compared to a Mixed and a Master Label & 6.4 Mixed-Master Load List.

Summary of Differences between old Mixed Label or new AIAG B16 Label and this version of Mixed-Master Label

1. It does not follow the AIAG B-16 label format for Mixed or Master Labels. It is equal to the Master Label in layout and functionality.
2. The Mixed-Master Label title SHALL be at the top right (A3) block.
3. All parts in the mixed load SHALL be destined for the same dock and display the same Dock Code.
4. The linear bar codes SHOULD be Code 128, (Code 39 if necessary).
5. DO NOT INCLUDE THE MIXED-MASTER SERIAL NUMBER IN THE 856, Advanced Shipping Notice!!!

6.5

6.6

Exhibit 6.7 Examples of Building a Mixed Container using a Mixed-Master Summary Card and Mixed-Master Labels.

NOTE: See Exhibits 12.1 and Appendix O for special handling by Fastener Suppliers

1) Mixed-Master Label

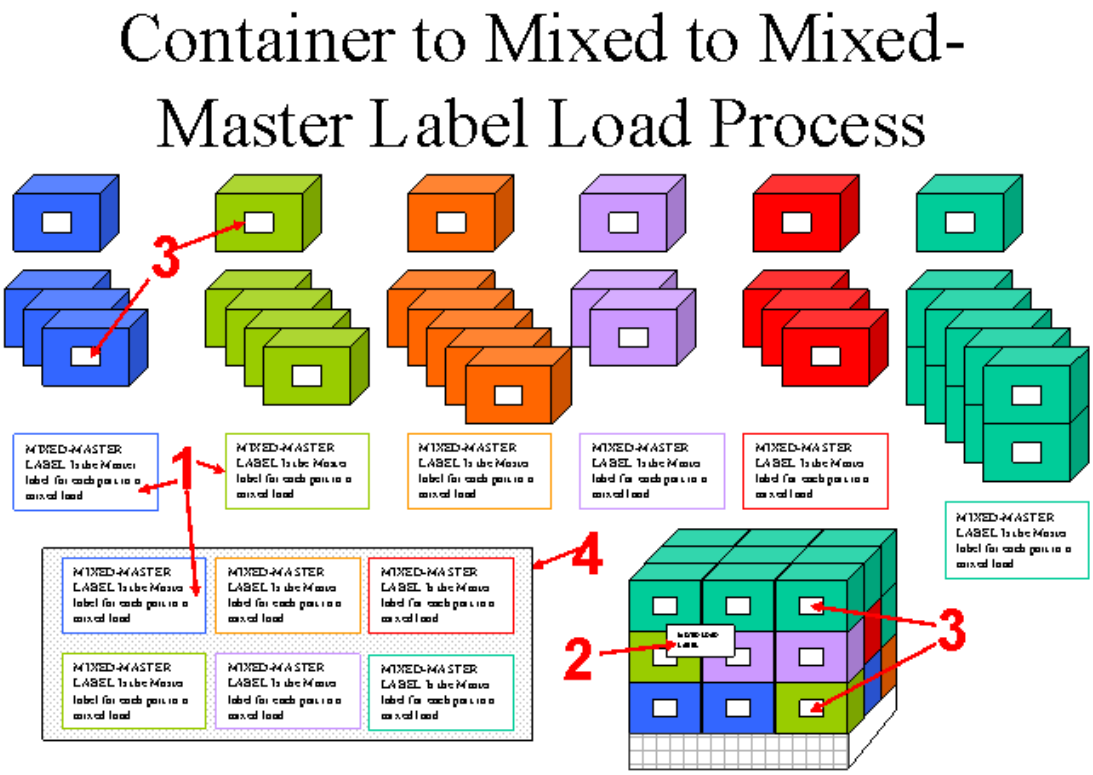
2) Mixed Label

3) Container Labels

4) Mixed-Master Summary Card

5) Mixed-Master Load List

6.7



MIXED - MASTER LOAD LIST WD

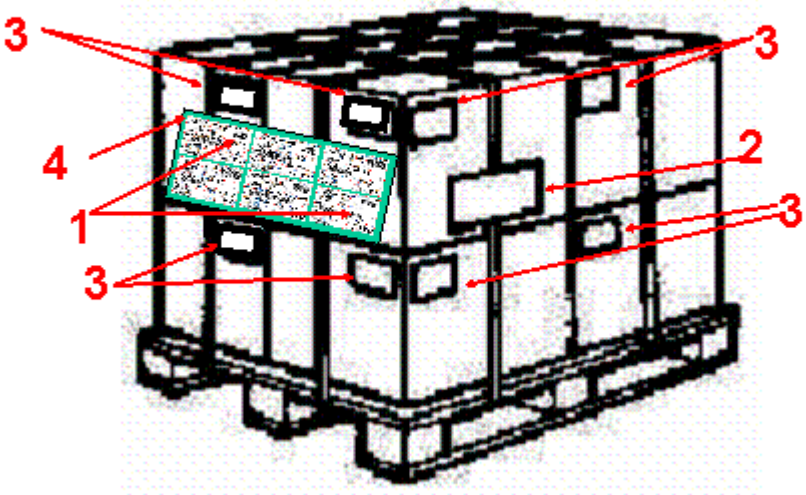
PART	QUANTITY	SUPPLIER
3S4X - A045A74 - AAZUYI	560	PP03B
3S4X - A045A74 - AAZFFA	590	
4VAE - 7A540 - AA	56	
4VAE - 7A540 - AG	256	
XRM3S4X - A045A74GD - AAZUYI78	56	
- W0457433 - S100	5600	
etc....		

Exhibits 6.8 Mixed Load with Mixed-Master Summary Card & 6.9 and Mixed-Master Load List.

1) Mixed-Master Label 2) Mixed Label 3) Container Labels

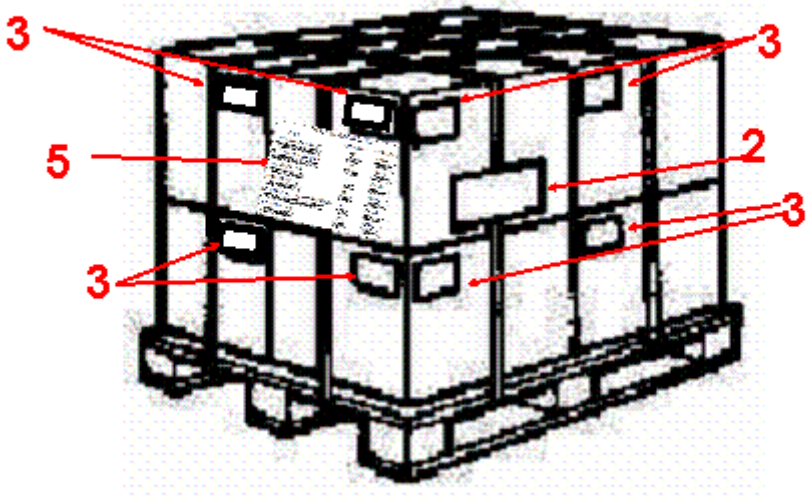
4) Mixed-Master summary card 5) Mixed-Master Load List

Example of Mixed-Master summary card attached to Mixed Load



6.8

Example of Mixed-Master Load List attached to Mixed Load



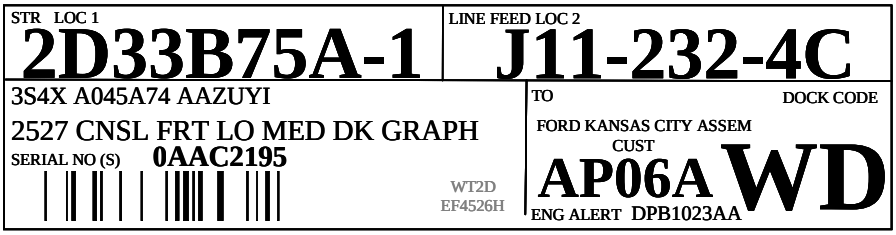
6.9

Exhibit 6.10 Example of Use of Stickers on container labels by Suppliers to aid in applying customer specific data

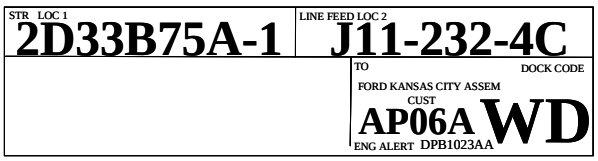
To attach customer specific data on labels for parts used by multiple customers, stickers may be used. Stickers MAY be used for data in Blocks D1, D2, E1 and E2 as well as the 2D bar code in Block A3. The data on the sticker SHALL be identical to the original label or if a new serial number is generated on the sticker, all original label data but be linked to the new serial number

Exhibit 6.11 Alternative Examples of the Use of Stickers, Overlays, Extensions on container labels by Suppliers to aid in applying customer specific data

Extension



Extension/overlay **MAY** exclude block E1



Extension/overlay: Could be on different side of container

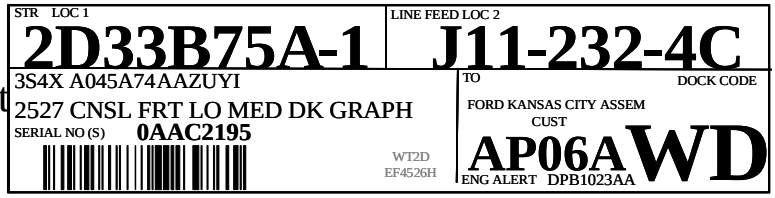


Exhibit 7

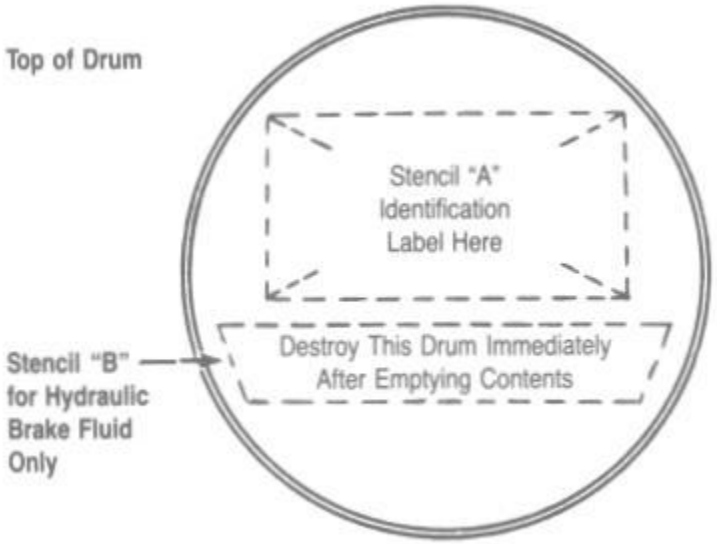
HANG TAG

Not to scale - for illustrative purposes only.

Exhibit 8

Specifications for Shipping Identification of Critical Materials Labels

(Hydraulic Brake Fluid Shown)



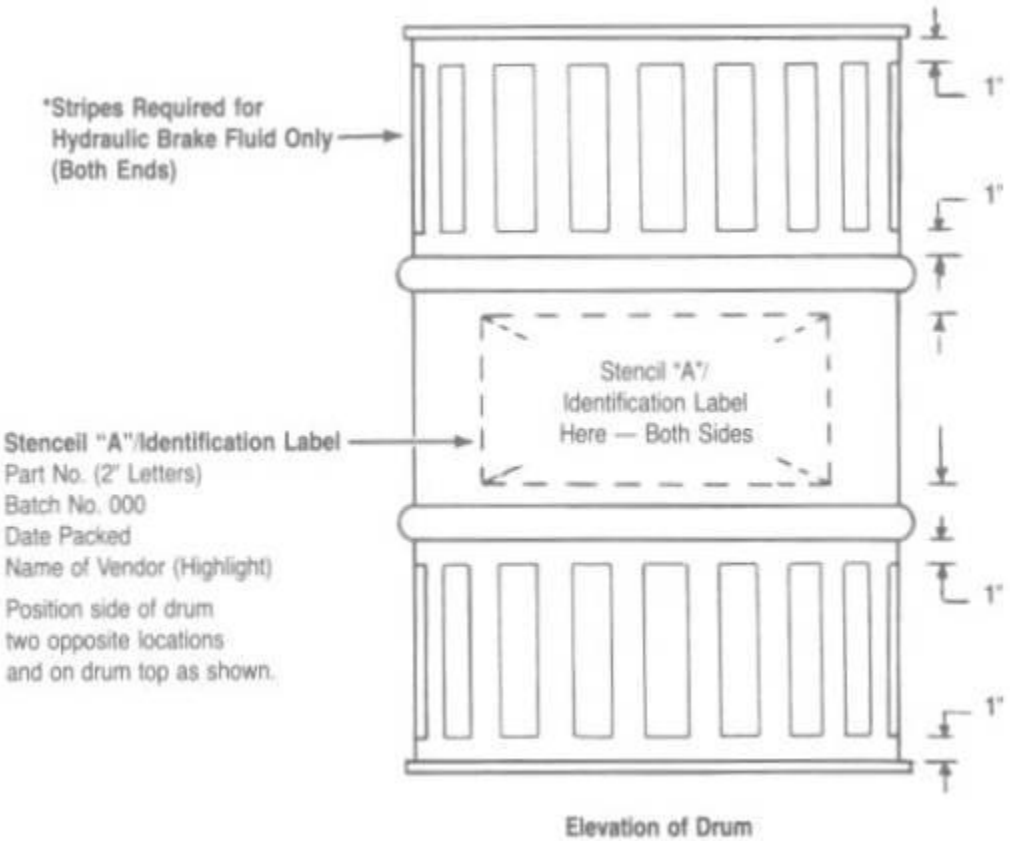


Exhibit 9.1
Label Locations on Various Shipping Packs

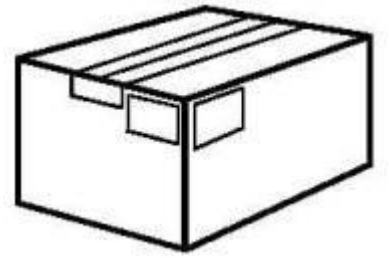
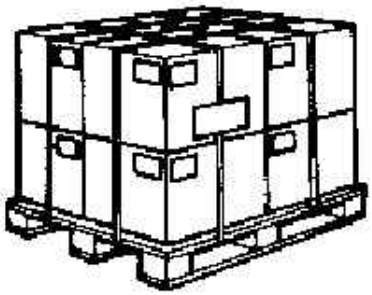
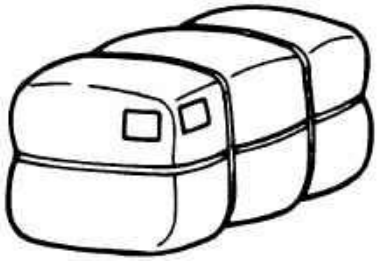
	Box or Carton Identical labels shall be located on two adjacent sides or as agreed to by the trading partners (wrap around label acceptable). The upper edges of the labels should be as high as possible up to 20 inches from bottom of carton.
	Cartons on Pallet Each carton shall be individually labeled as described above. One master label may be used as described in Section 8.1 or one mixed load label as described in 8.2. Each pallet shall contain a master label or 2 or more mixed load labels minimum. More may be agreed to by trading partners.
	Drums, Barrels, or Cylindrical Containers Identical labels shall be located on the top and near the center of the side.
	Bales Identical labels shall be located at the upper corner of an end and the adjacent side or as agreed to by the trading partners (wrap around label is acceptable).

Exhibit 9.2
Label Locations on Various Shipping Packs

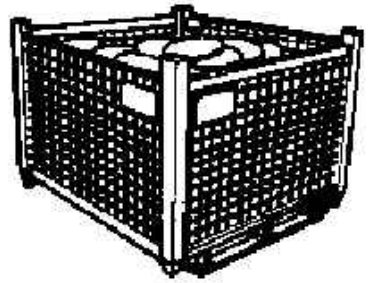
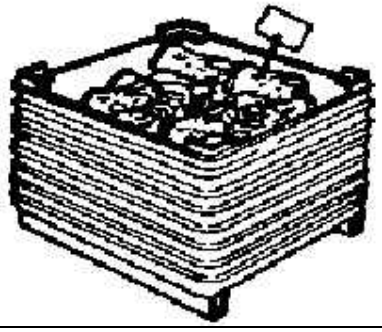
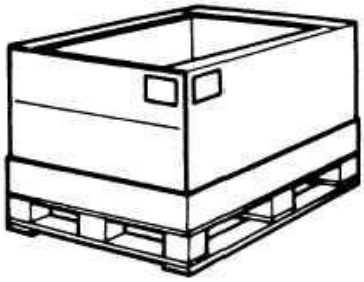
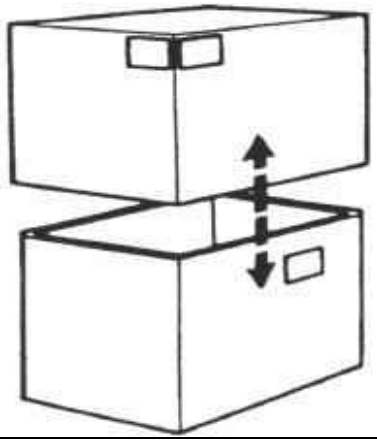
	Basket, Wire Mesh Container Identical labels shall be located on two adjacent sides or as agreed to by the trading partners.
	Metal Bin or Tub Tag one visible piece near top, or use a label holder or as agreed to by the trading partners.
	Pallet Box Identical labels shall be located on two adjacent sides or as agreed to by the trading partners (wrap around label is acceptable).
	Telescopic or Set-Up Containers Identical labels shall be located on two adjacent sides of the outer box or as agreed to by the trading partners. Some applications may also require identification of the inner box (wrap around label is acceptable).

Exhibit 9.3
Label Locations on Various Shipping Packs

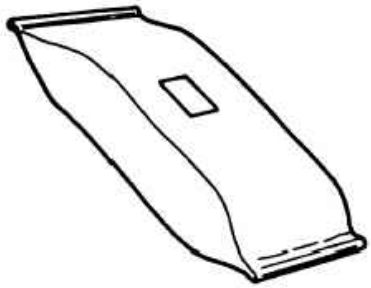
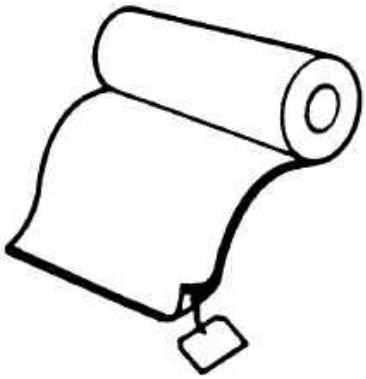
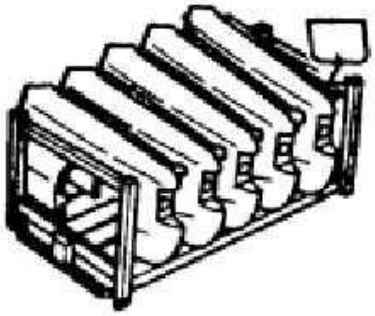
	Bundle Identical Tags shall be located at each end.
	Bag Place one label at the center of face.
	Roll This example is no longer appropriate. If used, must be in a container labeled on 2 adjacent sides or as agreed to by the trading partners.
	Rack This example is no longer appropriate. If used, must be labeled on 2 adjacent sides or as agreed to by the trading partners (may require 2,3, or more labels).

Exhibit 9.4
Label Locations on Various Shipping Packs

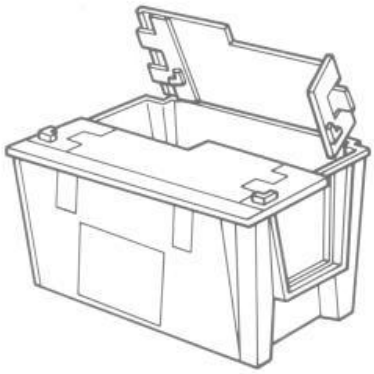
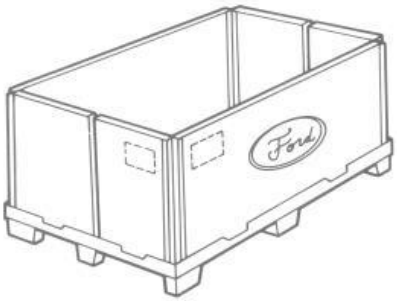
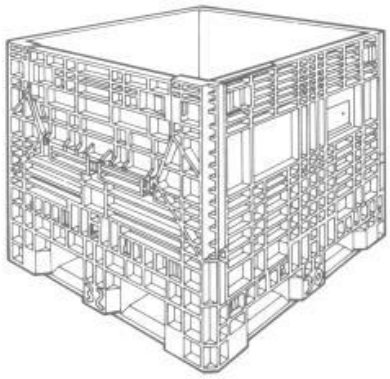
	Plastic Modular Container, Tote Identical labels shall be located on two opposite sides in designated locations or as agreed to by the trading partners.
	Collapsible Sleeve Pack Identical labels shall be located on two adjacent sides in designated locations or as agreed to by the trading partners.
	Plastic Pallet Box Identical labels shall be located on two adjacent sides in designated locations or as agreed to by the trading partners.

Exhibit 9.5
Label Locations on Various Shipping Packs

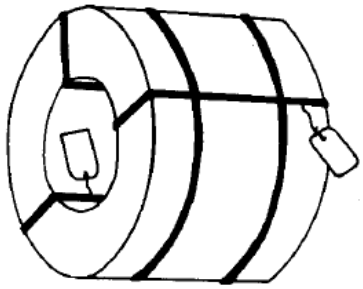
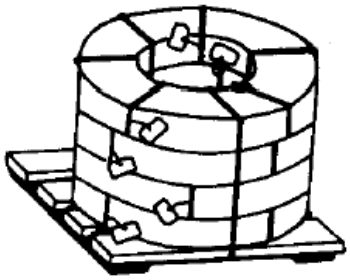
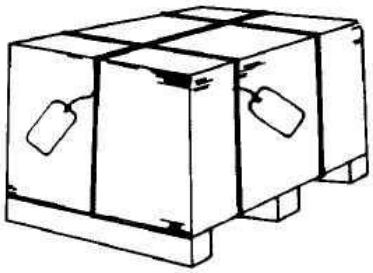
	Coil Hang two identical labels inside and outside coil, attached to banding.
	Slit Coils Hang two identical labels inside and outside each slit coil, attached to banding.
	Blanks Hang identical labels on two adjacent sides in designated locations or in holder.

Exhibit 9.6

FORD MOTOR ASSEMBLY PLANT DESTINATION ADDRESSES

The unique addresses used in the previous level of the label standards documentation will no longer be used on labels for Ford Motor Company. The 5 character Global Supplier Data Base code (GSDB) will be used from now on.
Example: Wixom Assembly Plant - AP17A .

Exhibit 10

REQUIREMENT FOR EXPIRATION DATED MATERIALS

NOTE: Besides the standard 2D bar code required and optional fields:

(Part number delimited with spaces (P) in the format PREFIX BASE SUFFIX CONTOL-CODE(this last 3 character field only if used by your customer and sent in the release)(NOTE: The European Part number format is limited to Prefix (6) Base (8) Suffix (8) and control code (2) due to the EDI format used.) ; Quantity (Q); Supplier Code (V); Date (D)[label date, manufacture date, or ship date] in the format of DYYMMDD, example d040110 (January 10th, 2004); Serial Number (S) or (3S), OPTIONAL FIELDS: Lot Number (1T), Storage Location 1 (L), Line Feed Location 2 (20L), Dock Code (1L).)

The data fields required for expiration dated materials included 2D Bar Code contains the Expiration Date (15D) in the format DDMMYYYY, (exp: 15D15112006), Supplier Part Number (1P), and Lot Number (1T).

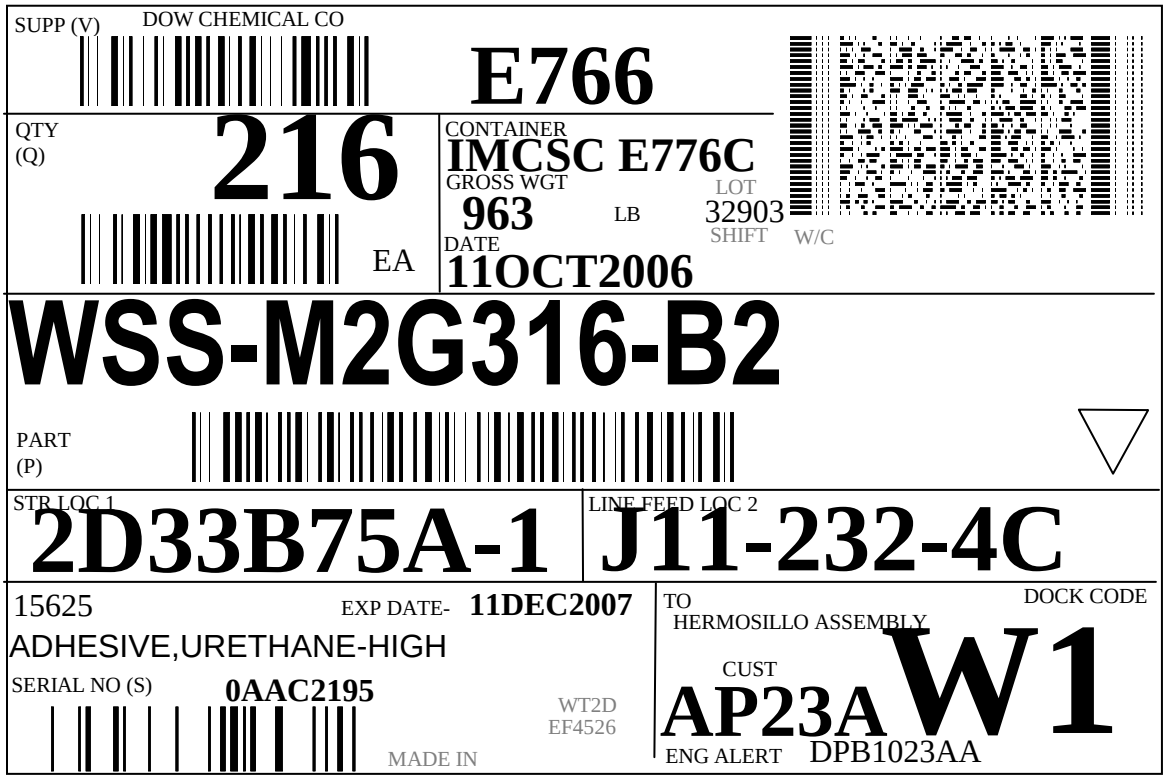


Exhibit 11

NEW MODEL PART LABEL REQUIREMENT

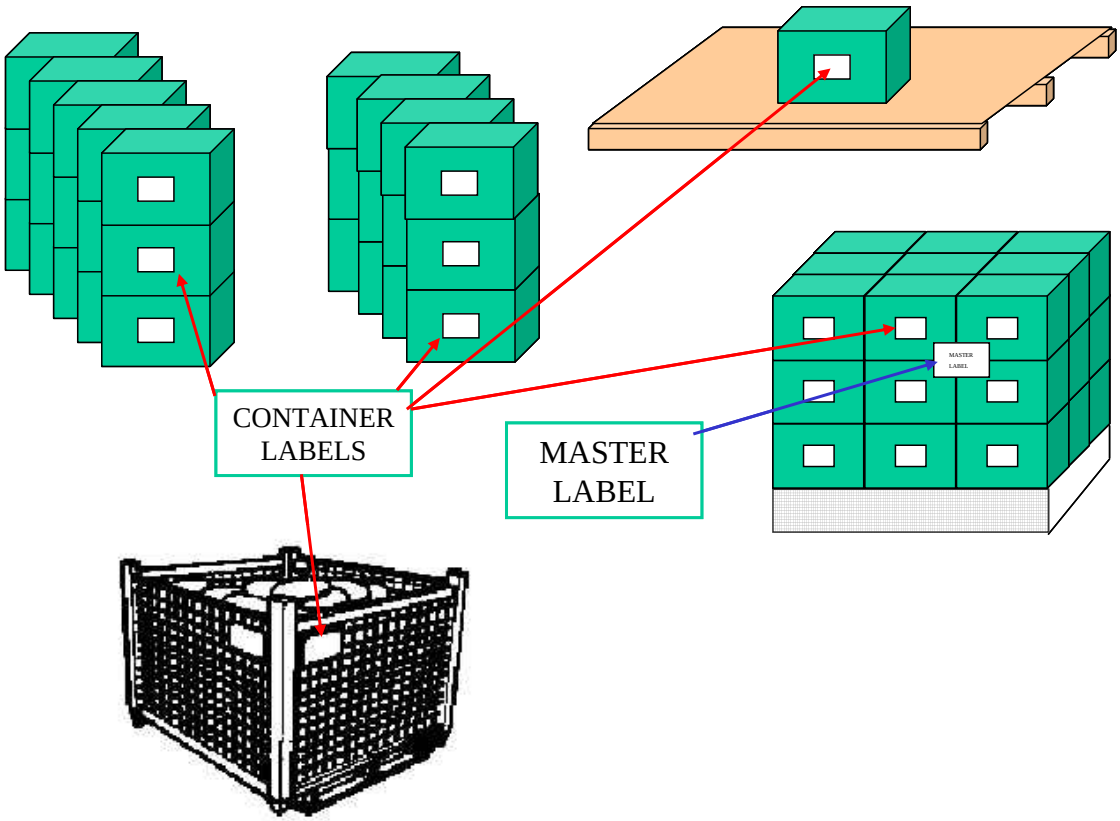
The label must be affixed to 4 adjacent sides of each container as described in Appendix K.

Exhibit 12.1 and 12.2

STANDARD PARTS SUPPLIER MODIFIED LABEL SPECIFICATION

Same as Container & Master Label Load Processes

12.1



New Mixed-Master Label Load Process

12.2

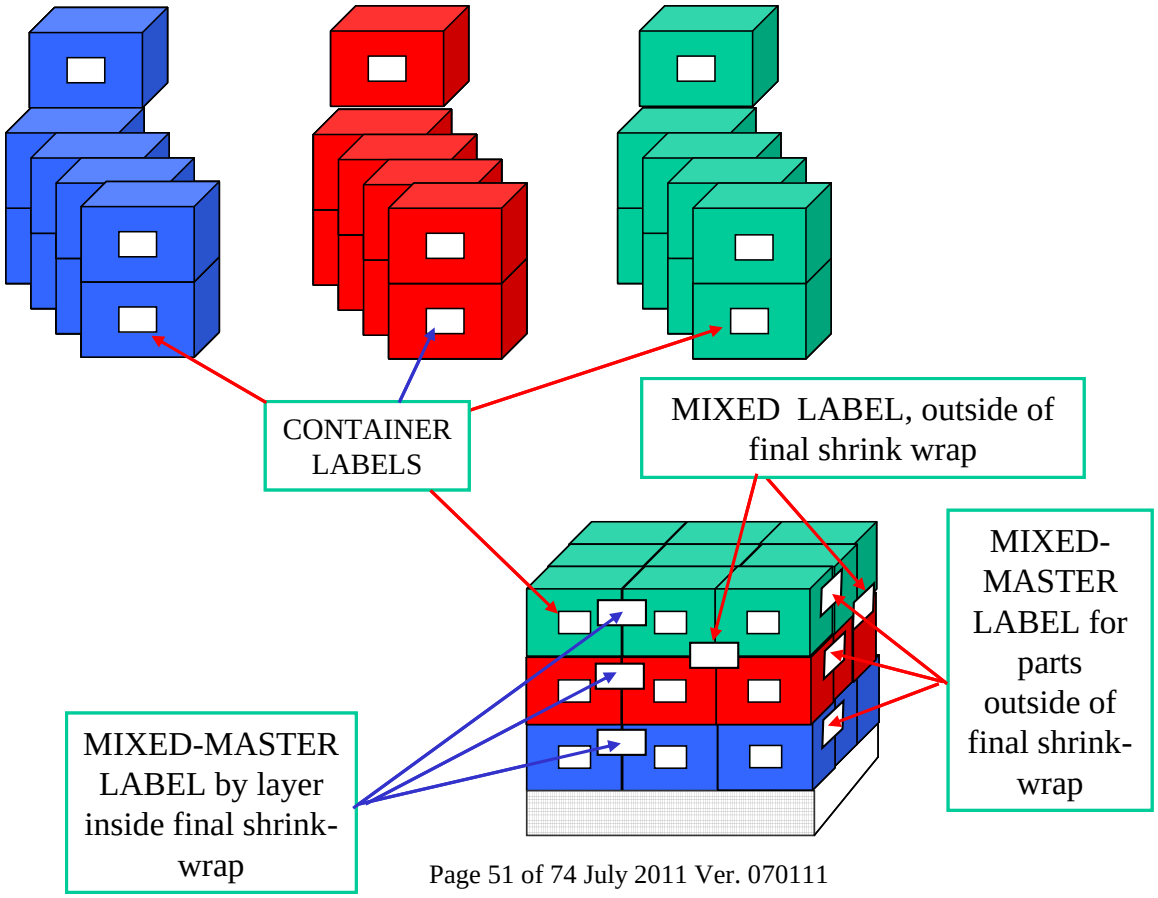
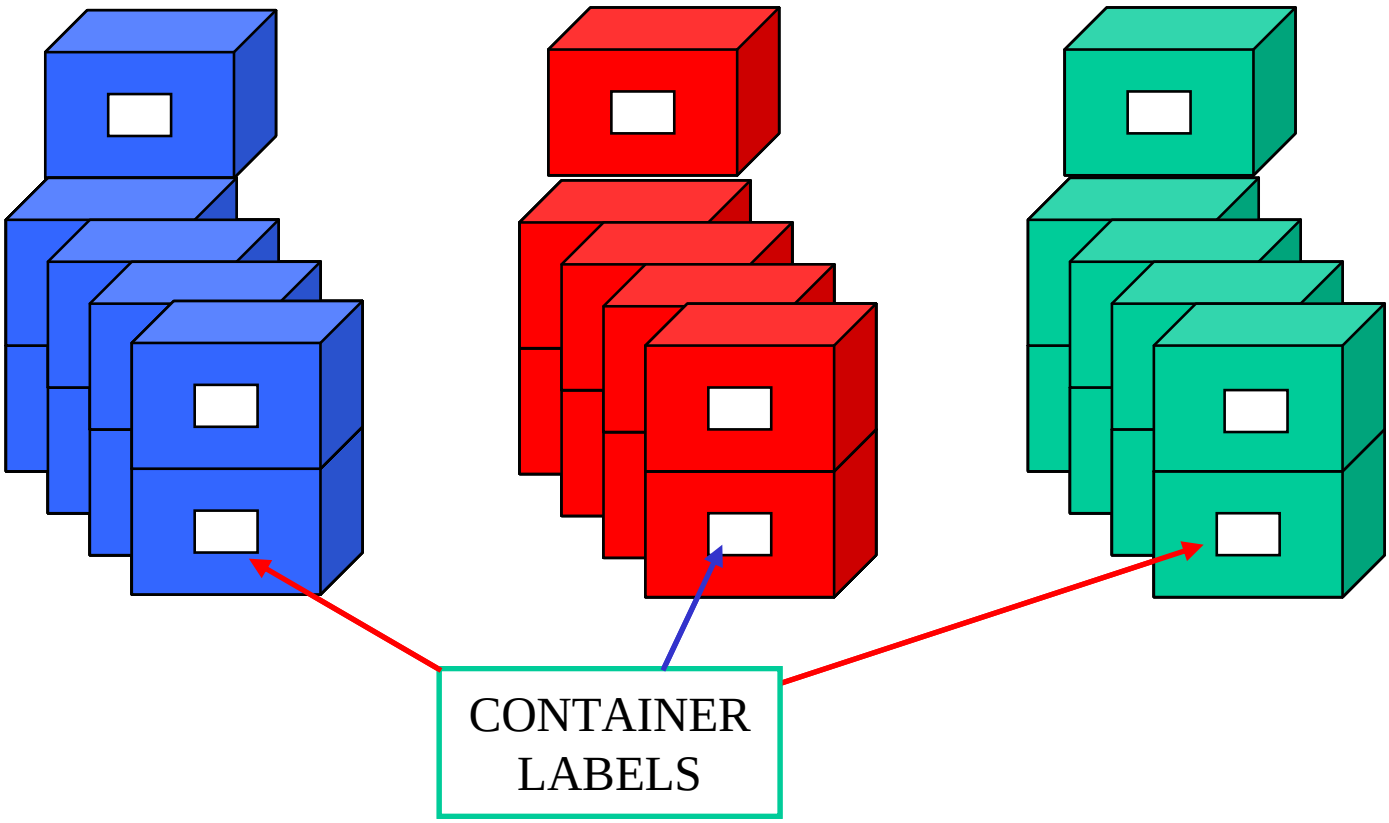


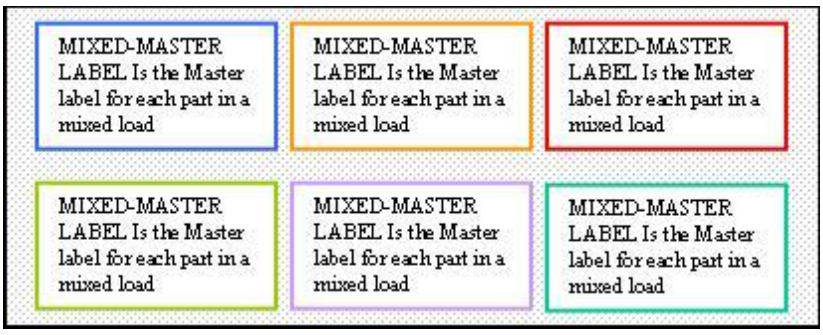
Exhibit 12.3

STANDARD PARTS SUPPLIER MODIFIED LABEL SPECIFICATION

Container & Master Label Load Processes, Start Pack



Neither Mixed-Master Summary Card nor the Mixed Master Load List for mixed loads, can be used alone to satisfy this labeling need. They can be used outside the shrink wrap as is the current process.



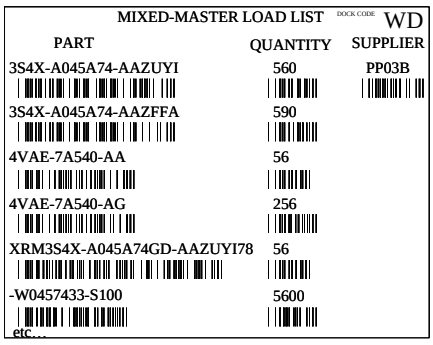
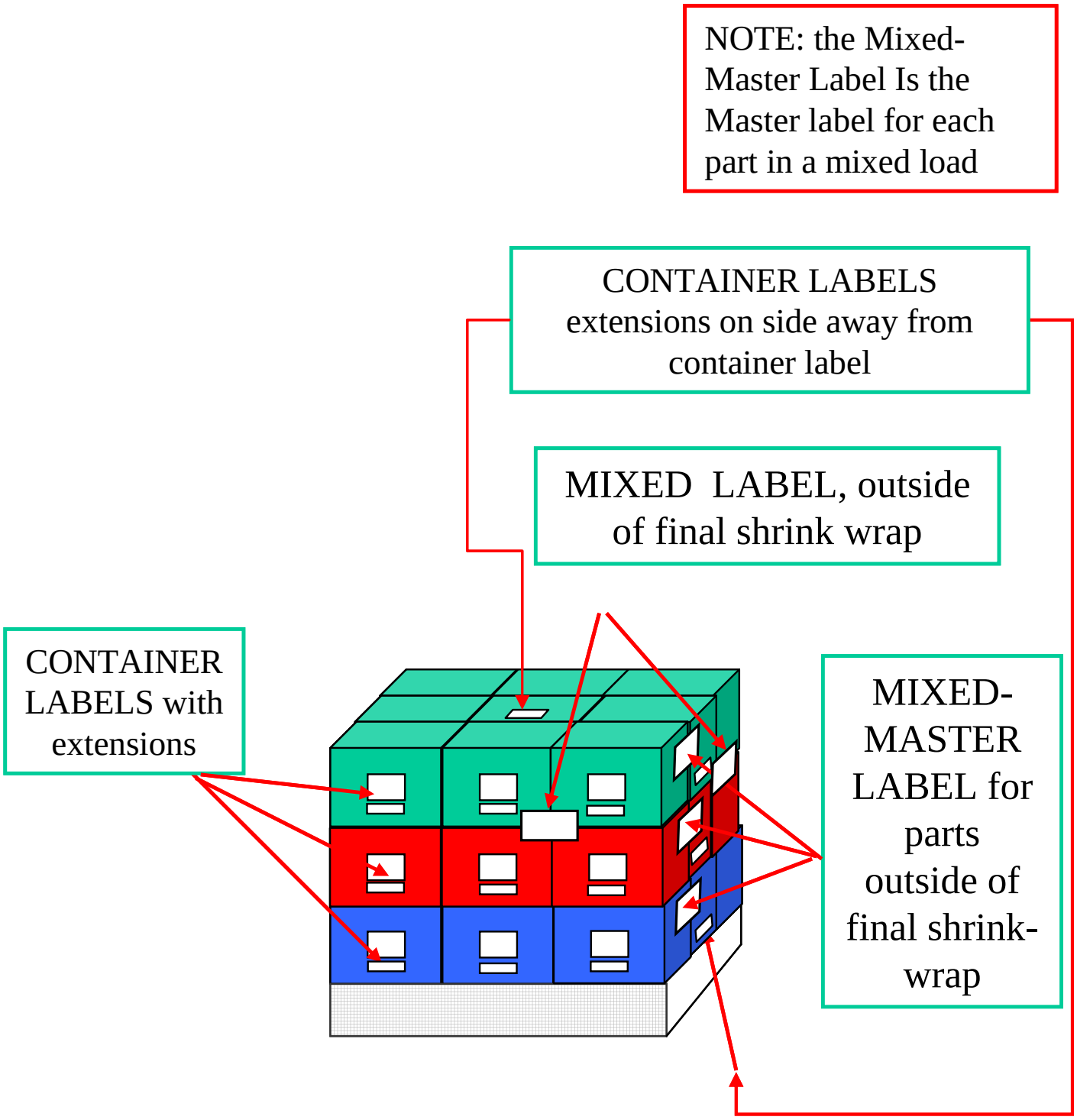


Exhibit 12.4
STANDARD PARTS SUPPLIER MODIFIED LABEL SPECIFICATION
Container & Master Label Load Processes, Final Pack



Appendix A
Unit of Measure Abbreviations
(From ASC x 12.3 – 1984 Data Element Dictionary)

(Printed December, 1984)

DATA ELEMENT #355 UNIT OF MEASUREMENT CODE

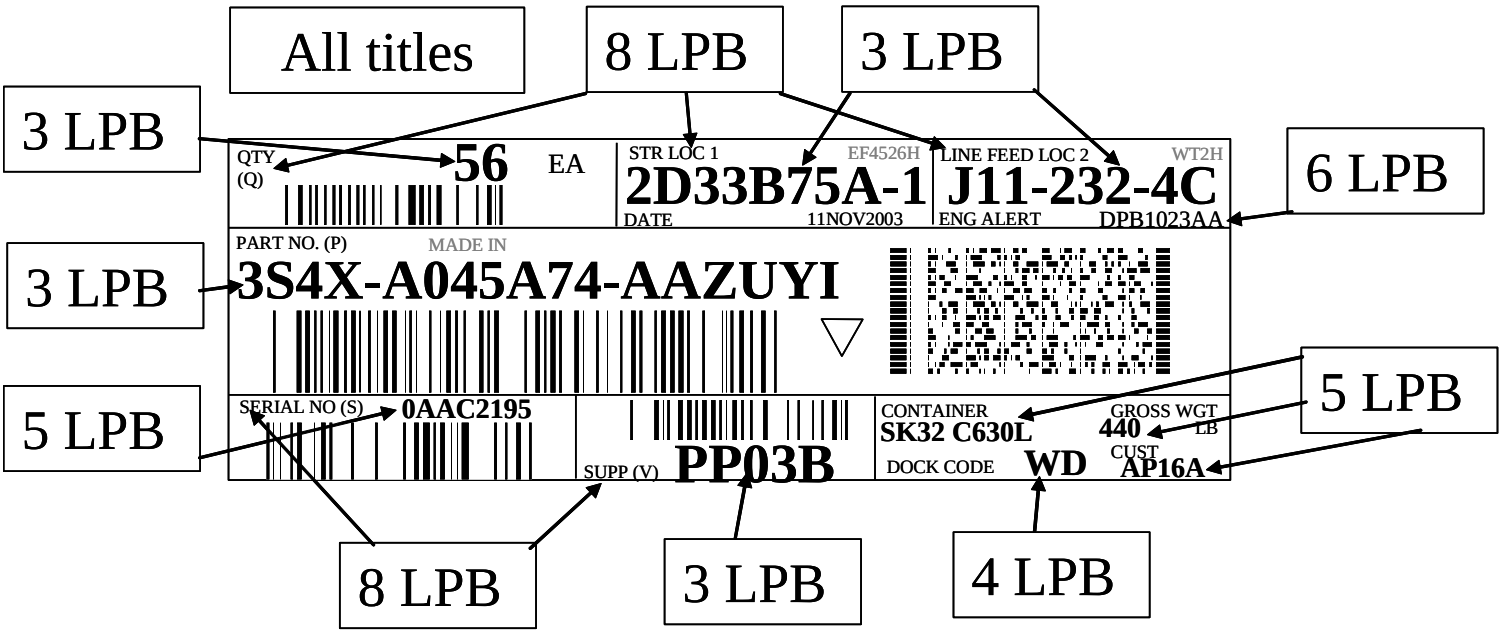
CODE	DEFINITION
DISTANCE	
DK	KILOMETERS
MI	MILES
NUMBER OF UNITS	
NB	BARGE
NC	CAR
NL	LOAD
NN	TRAIN
NR	CONTAINER
NT	TRAILER
NV	VEHICLE
PC	PIECE
TEMPERATURE	
CE	CENTIGRADE, CELCIUS
FA	FAHRENHEIT
KV	KELVIN
TIME	
DA	DAYS
HR	HOURS
LH	LABOR HOURS
MO	MONTHS
WK	WEEK
YR	YEARS
UNIT OF SALE	
AY	ASSEMBLY
BA	BALE
BB	BASE BOX
BC	BUCKET
BD	BUNDLE
BF	BOARD FEET
BG	BAG
BH	BRUSH
BI	BAR
BK	BOOK
BL	BLOCK
BN	BULK
BO	BOTTLE
BR	BARREL
BT	BELT
BU	BUSHEL
BX	BOX
CA	CASE
CB	CARBOY
CC	CUBIC CENTIMETER
CD	CARAT
CF	CUBIC FEET
CG	CARD
CH	CONTAINER
CI	CUBIC INCHES
CJ	CONE
CK	CONNECTOR
CY	CYLINDER
CM	CENTIMETER
CN	CAN
CO	COIL
UNIT OF SALE (CONT'D)	
CP	CRATE
CQ	CARTIRIDGE
CR	CUBIC METER
CS	CASSETTE
CT	CARTON
CU	CUP
CV	COVER
CW	HUNDRED POUNDS (CWT)
CY	CUBIC YARD
CZ	COMBO
DC	DISK (DISC)
DE	DEAL
DR	DRUM
DS	DISPLAY
DZ	DOZEN
EA	EACH
EV	ENVELOPE
FT	FOOT
GA	GALLON
GR	GRAM
GS	GROSS
HD	ONE-HALF DOZEN
HU	HUNDRED
IN	INCH
JB	JUMBO
JO	JOINT
JR	JAR
KE	KEG
KG	KILOGRAM
KH	KILOWATT HOUR
KT	KIT
LB	POUND
LC	LINEAR CENTIMETER
LF	LINEAR FOOT
LG	LONG TON
LI	LINEAR INCH
LK	LINK
LM	LINEAR METER
LN	LENGTH
LO	LOT
LR	LAYER
LT	LITER
LY	LINEAR YARD
MA	MACHINE UNIT
MG	METRIC GROSS TON
MM	MILLIMETER
MN	METRIC NET TON
MR	METER
MT	METRIC LONG TON
OL	OUNCE – LIQUID
OZ	OUNCE AV
PA	PAIL
PC	PIECE
PD	PAD
PE	POUNDS EQUIVALENT
PF	PALLET (LIFT)
UNIT OF SALE (CONT'D)	
PG	POUNDS GROSS
PH	PACK (PAK)
PK	PACKAGE
PL	PALLET UNIT LOAD
PN	POUNDS NET
PR	PAIR
PT	PINT
PW	PENNYWEIGHT
QD	QUARTER DOZEN
QR	QUIRE
QT	QUART
RD	ROD
RE	REEL
RL	ROLL
RM	REAM
SA	SANDWICH
SC	SQUARE CENTIMETER
SE	SECTION
SF	SQUARE FOOT
SG	SEGMENT
SH	SHEET
SI	SQUARE INCH
SL	SLEEVE
SM	SQUARE METER
SO	SPOOL
SP	SHELF PACKAGE
SQ	SQUARE
SR	STRIP
ST	SET
SY	SQUARE YARD
TB	TUBE
TG	GROSS TON
TH	THOUSAND
TK	TANK
TN	NET TON
TO	TROY OUNCE
TY	TRAY
UN	UNIT
WH	WHEEL
YD	YARD
ZZ	MUTUALLY DEFINED
VALUE	
CX	COST
LS	LUMP SUM
MV	MONETARY VALUE
VOLUME	
DL	DECILITER
DM	DRAM
FO	FLUID OUNCE
GA	GALLON
LT	LITER
ML	MILLILITER
PT	PINT
QT	QUART
OTHER	
ZZ	MUTUALLY DEFINED

Appendix C
TABLE 1

MONTH ABBREVIATIONS, ENGLISH, SPANISH, FRENCH

MONTH	ENGLISH	SPANISH	FRENCH
JANUARY	JAN	ENE	JAN
FEBRUARY	FEB	FEB	FEV
MARCH	MAR	MAR	MAR
APRIL	APR	ABR	AVR
MAY	MAY	MAY	MAI
JUNE	JUN	JUN	JUI
JULY	JUL	JUL	JUL
AUGUST	AUG	AGO	AOU
SEPTEMBER	SEP	SEP	SEP
OCTOBER	OCT	OCT	OCT
NOVEMBER	NOV	NOV	NOV
DECEMBER	DEC	DIC	DEC

Appendix D
EXAMPLE LABEL FIELD SIZES IN LINES PER BLOCK



Appendix E

TABLE 1 . Suggested LPB Character Parameters

LINES PER BLOCK	MAXIMUM CHARACTERS PER LINE	APPROXIMATE POINT HEIGHT	APPROXIMATE HEIGHT IN INCHES	APPROXIMATE HEIGHT IN MILLIMENTERS
1 LPB	~8	80-100	0.90-1.00	22.0-25.4
2 LPB	~18	32-36	0.40-0.50	11.0-12.7
3 LPB	~28	20-24	0.25-0.33	7.0-8.4
4 LPB	~34	16-18	0.20-0.25	5.1-6.4
5 LPB	~42	12-14	0.17-0.20	4.3-5.1
6 LPB	~48	11-12	0.14-0.17	3.6-4.3
7 LPB	~59	8-10	0.13-0.14	3.3-3.6
8-10 LPB	~68-77	6-7	0.08-0.12	2.0-3.0

NOTE: Calculation of Maximum Characters Per Line is based on a block/label width of 6 inches. Calculation of approximate heights is based on a block height of 1 inch. Actual text dimensions will depend on the data, the font used, and the capability of the label provider's printer and software.

See the summary table on next page.

When a range of size is given, the intent is to get the largest size, human readable, as will fit within the designated area.

Appendix E, Addendum Summary Chart A

BLOCK	DATA TITLE	DI	DESCRIPTION	B/C	# CHAR W/O DI	TYPE	LPB	FONT SIZE
A1	SUPPLIER ID	V	Supplier GSDB code assigned by Ford.	1D, 2D	5 CH	A/N	8LPB	6-7
	SUPPLIER PLANT NAME		The supplier plant name SHALL be printed on one line.	N	35 CH	A/N	8LPB	6-7
A2	SUPPLIER ID		Human readable supplier GSDB code assigned by Ford.	N	5 CH	A/N	2-3 LPB	24-32
A3	2D SYMBOL PDF417		Machine-readable combination of Part Number (P), Quantity (Q), Supplier Code (V), Date (D) in the format YYMMDD, and Serial Number (S/3S/4S/5S/M). OPTIONAL FIELDS: Lot Number (1T), Storage Location 1 (L), Line Feed Location 2 (20L), Dock Code (1L), Expiration Date (15D), Supplier Part Number (1P).	Y		A/N		
B1	QUANTITY	Q	Unit of Measure assumed to be "each" unless required otherwise. Nominal length is anticipated to be 6 characters.	1D, 2D	9 CH	N	2LPB	32-36
B2	CONTAINER		Container field consists of the base and suffix of the container part number separated by a dash. Maximum number of characters is 9 for the base and 5 for the suffix.	N	14 CH incl ' - '	A/N	5LPB	12-14
	GROSS WEIGHT		Unit of Measure assumed to be in English pounds (lbs) unless required otherwise by customer plant.	N	10 CH	N	5LPB	12-14
	DATE	D	The date format SHALL be DDMMMYYYY (SHOULD be in English). E.g. 25DEC2004.	2D	9 CH	DATE	4LPB	12-14
	LOT (Optional)	1T	If the supplier is a Ford Motor Company Plant, then LOT # can have a maximum of 5 characters.	2D	13 CH	A/N	7LPB	11-12
	SHIFT-W/C (Optional)		If the supplier is a Ford Motor Company Plant, then SHIFT will be 1 CH and W/C will have a maximum of 5 CH.	N		A/N	6LPB	11-12
C1	PART	P	Format of Ford Motor Company part numbers are 7 Prefix, 9 Base, 8 Suffix, 3 Control Code (6,8,8,2 in Europe), separated by spaces in bar codes and dashes in the human readable characters. Moreover control (safety) items SHALL be identified with an inverted delta.	1D, 2D	26 CH	A/N	2LPB	32-36
D1	STORAGE LOC 1 (Optional)	L	Data must be sent via EDI in the 830 Planning and/or the 862 Shipping release by the customer plant or the field SHALL be blank.	2D	10 CH	A/N	3LPB	20-24
D2	LINE FEED LOC 2 (Optional)	20L	Data must be sent via EDI in the 830 Planning and/or the 862 Shipping release by the customer plant or the field SHALL be blank.	2D	10 CH	A/N	3LPB	20-24
E1	SUPPLIER AREA		Used primarily by the suppliers for the data required to meet their needs for MRP processes and to meet Ford Motor Company and AIAG MMOG standards.					
	SUPPLIER EXP DATE (Optional)	15D	When required by mutual agreement, the supplier expiration date SHALL appear in the format EXP DATE DDMMMYYYY.	2D	9 CH	DATE	8LPB	6-7
	SUPPLIER PART NUMBER (Optional)	1P	Format of Ford Motor Company part numbers are 7 Prefix, 9 Base, 8 Suffix, 3 Control Code (6,8,8,2 in Europe), separated by spaces.	2D	26 CH	A/N	7LPB	8-10
	DESCRIPTION		Description of the part.	N	24 CH	A/N	7LPB	8-10
	SERIAL	S/3S	Serial Number assigned by supplier, used for uniquely identifying an individual transport unit not to be repeated.	1D, 2D	9 CH	A/N	6LPB	10-14
	SERIAL	M/4S	Master Serial Number assigned by supplier to master packaging containing like items on a single order.	1D, 2D	9 CH	A/N	6LPB	10-14
	SERIAL	5S	Mixed Serial Number assigned by supplier to mixed packaging containing dissimilar items on a single order.	1D, 2D	9 CH	A/N	6LPB	10-14
E2	CUSTOMER PLANT NAME		The supplier plant name SHALL be printed on one or two lines. The first line SHALL begin with the name FORD.	N	30	A/N	8LPB	6-7
	DOCK CODE (Optional)	1L	Data must be sent via EDI in the 830 Planning and/or the 862 Shipping release by the customer plant or the field SHALL be blank.	2D	2 CH	A/N	1.5-1LPB	36-60
	CUSTOMER CODE		Customer plant code SHALL be in the Ford Global Supplier Database.	N	5 CH	A/N	4LPB	20-24
	ENGR. ALERT (Optional)		Only to be displayed when required by the customer plant. The data must be provided to the supplier in verbal or written form.	N	9 CH	A/N	7LPB	8-10
	Note: Font Size shall be as large as practical for information printed. Data Titles are all uppercase and the same size (8LPB). Font shall support slash zero. Symbology: 1D=Code 128, should have an 'x' dimension of 0.010"-0.017". Symbology: 2D=PDF 417 should have an 'x' dimension of at least 0.010". N=No Bar Code.							

Appendix I

EXAMPLE OF Ford Motor Company ILVS Label Standard and ILVS Specifications.

ILVS Large Part Label

ILVS Small Part Label

ILVS Container Label

Subject: ILVS Labeling

Purpose

The purpose of this paper is to define part and rack labeling requirements to support In Line Vehicle Sequencing (ILVS). The base source data used in the development of this proposal includes:

- Current labeling standards BO-1122-L.
- Assembly plant personnel, material handling , production and ILVS suppliers (CMMS).
- Automotive Industry Action Group (AIAG) standards current and anticipated B10 rack label.

Labeling Defined

Based on several meetings with assembly plant personnel, material handling and production and suppliers, the following labeling requirements resulted. Summary agreements indicated that 2 labels would be required to support ILVS.

There would be a part label placed on every production part (except kits). The primary customer of this label is the production personnel at the supplier and assembly plant. Suppliers will verify the correct label to part. Assembly plant production will verify the blend number on the part label to the blend number on the broadcast (8502).

Rack labels will be used on each rack or pallet. The rack label is designed to support material handling and production personnel. The rack sequence number synchronizes the loading and unloading of containers. This number should substantially reduce any confusion related to the next container of material required. The rack sequence number will be maintained typically at a carline, shipping commodity level (exception example are for commodities shipped in pairs). An additional 4th position in the rack sequence is required for commodities requiring differentiation. The related coding in the fourth position is as follows: R= Right, L= Left, F= Front & B= Back. Each rack/container needs two labels with placement locations determined by the assembly plant.
Each rack should have two labels affixed to it.

Bar codes on both the part and rack labels are designed to mechanically verify material. The part and rack label bar codes can be used in conjunction to verify the correct part to rack relationship.

Part Label Specifications (Sample A)

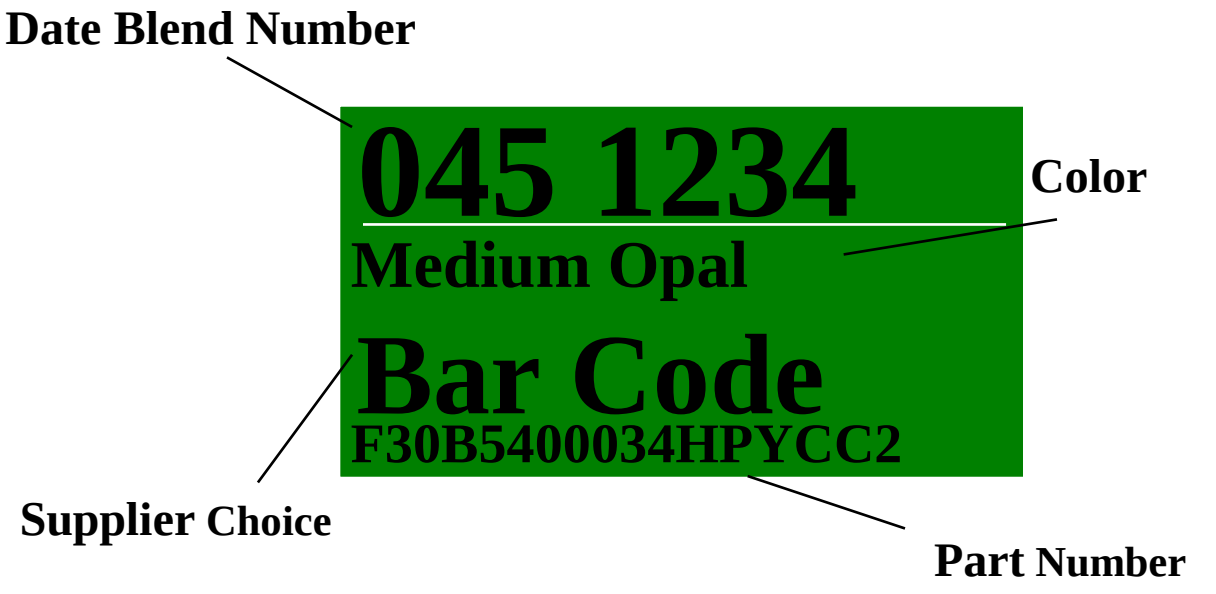
PART LABEL
4" X 2"

Element	Field Size	Print Height	Data Type	Source Location	Bar Code
Date Blend Number *	7	.6	Numeric	Seq. 866	No
Color/Description	20	.25	A/N	Supplier	No
Bar Code	9	.5	3 of 9	Supplier Choice	Yes
Part Number	23	.25	A/N	Seq. 866	No

* The date/blend number should be separated by a space between positions 3 & 4 on the printed label.

The label size will vary based on size and placement on commodity. All part labels will be attached directly to the parts (except kitted parts) on a non class A surface (if adhesive type). The specific label location on the part will be mutually defined by assembly plant and supplier.

Part Label - Example



Rack Label Specifications (Sample D)

RACK LABEL
6.5" X 4"

Element	Field Positions	Print Height	Data Type	Source Location	Bar Code
From/To	Variable	Max. 1.0	A/N	Seq. 866	No
Carlines	4	.4	Alpha	Seq. 866	No
Lowest/Highest Date Blend Number *	7	.75	A/N	Seq. 866	No
Bar Code	9	.75	3 of 9	Supplier Choice	Yes
Linefeed Location	4	.75	A/N	Seq. 866	No
Rack Sequence	3#	.75	Numeric#	Supplier	No

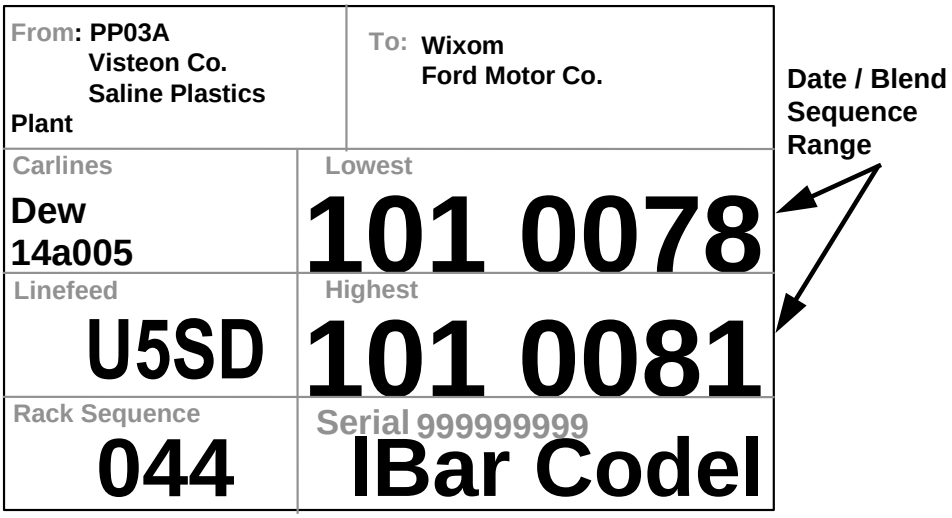
* The date/blend number should be separated by a space between positions 3 & 4 on the printed label.

The # 4 positions & alpha/numeric for parts requiring differentiation (pairs, right/left, etc.)

Rack label placement and adherence shall conform to the Ford Motor BAO-1122-L publication. New model, engineering changes and other Ford Motor labeling requirements will remain in affect.

Rack Label

6.5" X 4"



Appendix J
BROADCAST LABEL HANDLING

This appendix is to define part and rack labeling requirements to support Broadcast Sequencing. The base source data used in the development of this proposal includes:
.
- Assembly plant personnel, material handling, production and Broadcast suppliers (CMMS).
- Automotive Industry Action Group (AIAG) standards and B10 label.

Labeling Defined

The following labeling requirements resulted from several meetings with assembly plant personnel, material handling, production personnel, error proofing, and suppliers. Summary agreements indicated that 2 labels would be required to support Broadcast (One for the Rack and one for each individual part).

There would be a part label placed on every production part (except kits). The primary customer of this label is the production personnel at the supplier and assembly plant. Suppliers will verify the correct label to part. Assembly plant production will verify the trim rotation number on the part label to the trim rotation number on the broadcast to ensure the right part is placed on the right vehicle.

Rack labels will be used on each rack or pallet. The rack label is designed to support material handling and production personnel. The rack sequence number synchronizes the loading and unloading of containers. This number should substantially reduce any confusion related to the next container of material required. The rack sequence number will be maintained typically at a carline, shipping commodity level (exception example are for commodities shipped in pairs). An additional 4th position in the rack sequence is required for commodities requiring differentiation. The related coding in the fourth position is as follows: R= Right, L= Left, F= Front & B= Back. Each rack/container needs two labels with placement locations determined by the assembly plant. Each rack should have two labels affixed to it.

Bar codes on both the part and rack labels are designed to mechanically verify material. The part and rack label bar codes can be used in conjunction to verify the correct part to rack relationship. The size and information contained in the bar code must match the standard below due to error proofing requirements of the assembly plants.

Broadcast Part Label Specifications (1.5" X 3")

Element	Field Length	Print Height (in)	Data Type	Source Location	Bar Code
Trim Rotation Number	4	.25	Numeric	Broadcast	No
National Blend Bar Code	9	.4	Numeric	Seq. 866 or Broadcast	Yes
Serial Number Bar Code	Supplier Choice	.4	A/N	Supplier Choice	Yes
Part Number	26	.125	A/N	Seq. 866 or Broadcast	No

The label size will vary based on size and placement on commodity. All part labels will be attached directly to the parts (except kitted parts) on a non class A surface (if adhesive type). The specific label location on the part will be mutually defined by assembly plant and supplier.

Broadcast Part Label - Example

BROADCAST PART LABEL

1.5 x 3

Broadcast Rack Label Specifications (4" X 6.5")

Element	Field Length	Print Height (in)	Data Type	Source Location	Bar Code
From/To	Variable	Max. 1.0	A/N	Seq. 866 or Broadcast	No
Description	Variable (25)	.2	Alpha	Seq. 866 or Broadcast	No
Base Part No *1	Variable (9)	.2	A/N	Seq. 866 or Broadcast	
Lowest/Highest Rotation Number	4	.5	Numeric	Broadcast	No
Linefeed Location	Variable (10)	.25	A/N	Seq. 866	No
Serial No Bar Code	Supplier Choice	.4	A/N	Supplier Choice	Yes
Rack Sequence	3	.75	Numeric	Supplier	No

*1 – If there are multiple base numbers within the rack and the numbers only differ by the first and/or last digit, replace this digit with an "X". ex.) If a "5451967" and a "7451968" were shipped in the same rack, the base part number field should read "X45196X". If they differ by more than the first and/or last digit, list all base part numbers in the rack.

Rack label placement and adherence shall conform to the Ford Motor BAO-1122-L publication. New model, engineering changes and other Ford Motor labeling requirements will remain in affect.

Broadcast Rack Label - Example

FROM: ZF LEMFORDER F3DVT	TO: Chicago Assembly Plant (AP03A) Ford Motor Company 26/ May / 2005
DESCRIPTION: Rear Suspension BASE PART NO: 5B564	LOWEST ROTATION: 5597
LINEFEED: CIA09WA005	HIGHEST ROTATION: 5603
RACK SEQUENCE: 637	SERIAL NO (S): AAE01254

4 x 6.5

Appendix K

NEW MODEL PART TAG HANDLING

The Red "New Model Part" labeling process has been in existence for several years and communicated regularly to the supply base during Model Year changeover periods, Supplier conferences, as well as CMMS (IMS7) bulletin boards. Due to a small number of repeated instances where tags were not applied to containers, which eventually led to quality issues and production disruptions at our plants, Ford has changed the labeling process guideline regarding container labeling. In conjunction with the current Red "New Model Part" labeling process, all suppliers can and will be issued a Quality Reject (QR) for part(s) that do not have the label affixed to 4 adjacent sides of each container (next to or close as to the bar code labels as possible, fastened as appropriate for the container). This label *must* be used on all containers until the Job 1 date is reached *plus 1 additional full day of shipments*.

Effective January 1st, 2007, any extraordinary costs associated with non-compliance of launch part labeling could potentially become the responsibility of the at-fault supplier.

New or additional tags can be ordered from Moore Business Forms by downloading an order form from COVISINT.COM. Click on Ford Supplier Portal, then click LIBRARY SERVICES, search for "new model part tags" & download BAO12010 order form. Fill out one portion and fax it to the number listed.

See EXAMPLE 11 for a sample of the Red "New Model Part" tag (page 50 above).

Appendix L

EXAMPLE SPECIAL HANDLING DATA

For times when part identification and handling requires clear label differences (i.e. left/right parts, similar part number, supplier code processes, FIFO/LIFO, prototype parts, initial sample or pre-job 1 parts, etc.) mutually agreed solutions SHALL be made between supplier and plant. Restrictions include: 1) No Colored Labels!, a colored stripe that does not cover any bar code, 1D or 2D is permissible as in the example below; 2) Use of the supplier area, Block E1 is preferred in all circumstances. See the number 74 and the dot (orange in color) below; 3) Use of any other block is restricted to C1 VIA WRITTEN PERMISSION to the right of the bar code ONLY! See the number 74 below in block C1; 4) AVOID REDS & GREENS when using color due to the significant population of people who cannot distinguish between these two colors.

Appendix M

STANDARD PART SUPPLIER LABEL HANDLING

Labeling Defined

1. Suppliers continue to label individually shipped containers/racks with full container label information, Exhibit 4.2 above
2. Master labels are adequate for all parties to move material to Market Place or line side using Master Label, Exhibit 5.2 above. When a master label is used, the container label will appear as, Exhibit 4.2 above less the plant specific data such as Customer Name and Code, Dock Code, Storage Location and Line Feed Location as shown where the @'s are below.
3.Mixed loads MUST be labeled with a MIXED-MASTER label, Exhibit 6.4 above, on each Layer in a Mixed Load (inside final shrink-wrap) as well as on the total load (outside shrink-wrap) see Exhibits 12.1, 12.2, 12.3 & 12.4 above, beyond the requirement of a Mixed Label, Exhibit 6.2 above, for both ODC and non-ODC routes. * Again, the container labels will appear as below.
4. Optionally, Mixed load individual containers may be labeled with "stick on extensions" replacing "overlays" placed next to or on any visible side of the same container, Exhibits6.10 and 6.11 above. *

- Current Container and Master Labels have all the necessary data required by all parties in the supply chain. Master label loads will not require individual re-labeling to get to customer market place or line-side.
- Mixed loads MUST be in Full Layers, each layer labeled with a MIXED-MASTER label both inside and outside the final shrink wrap, beyond the requirement of a Mixed Label for both ODC and non-ODC routes. This will meet MMOG and Labeling standards. Individual re-labeling is not required.
- For all other mixed load situations, re-labeling or the use of overlays and extensions is required

* These require releases in full layers which will become the default method at Ford Motor Company at the end of November, 2006..

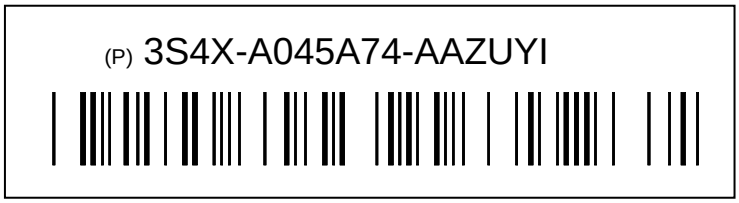
Appendix N

GENERAL PART MARKING LABEL DESIGNS

Error-Proofing Label Proposals using 1D bar code

Aug. 4th, 2005

PART # LABEL



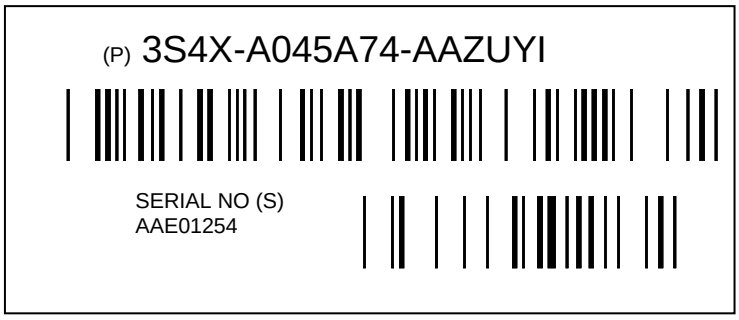
0.75 x 3.5inch/19 x 90mm label, Arial 14,
13mil code 128 bar code, .35inch/9mm height

SERIAL # LABEL

0.625 x 2inch/16 x 50mm, Arial 8

13 mil code 128 bar code , .35inch/9mm height

PART# and SERIAL# LABEL



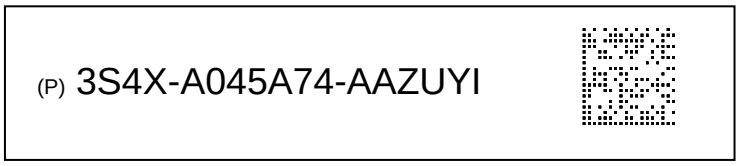
1.25 x 3.5inch/32 x 90mm label, Arial 14 part
Arial 8 serial, 13 mil code 128 bar code , .35inch/9mm height

Bar code specifications follow AIAG guide lines. Label length should expand with part length to maintain ¼ inch/6mm margin at both ends of bar codes.

Alternate Error-Proofing Label Proposals using 2D (with agreement between supplier and customer)

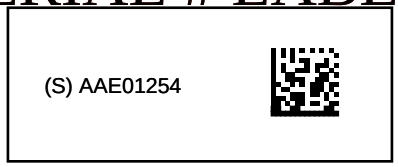
Aug. 4th, 2005

PART # LABEL



0.75 x 3.5inch/19 x 90mm label, Arial 14,
25mil Data Matrix bar code, .35inch/9mm height

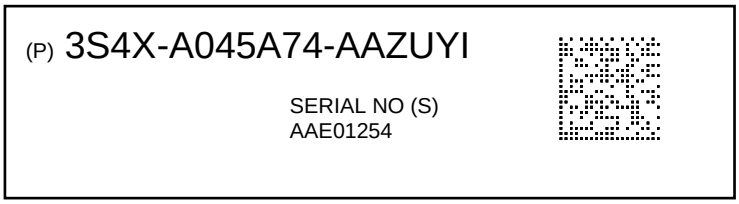
SERIAL # LABEL



0.625 x 2inch/16 x 50mm, Arial 8

25 mil Data Matrix bar code

PART# and SERIAL# LABEL



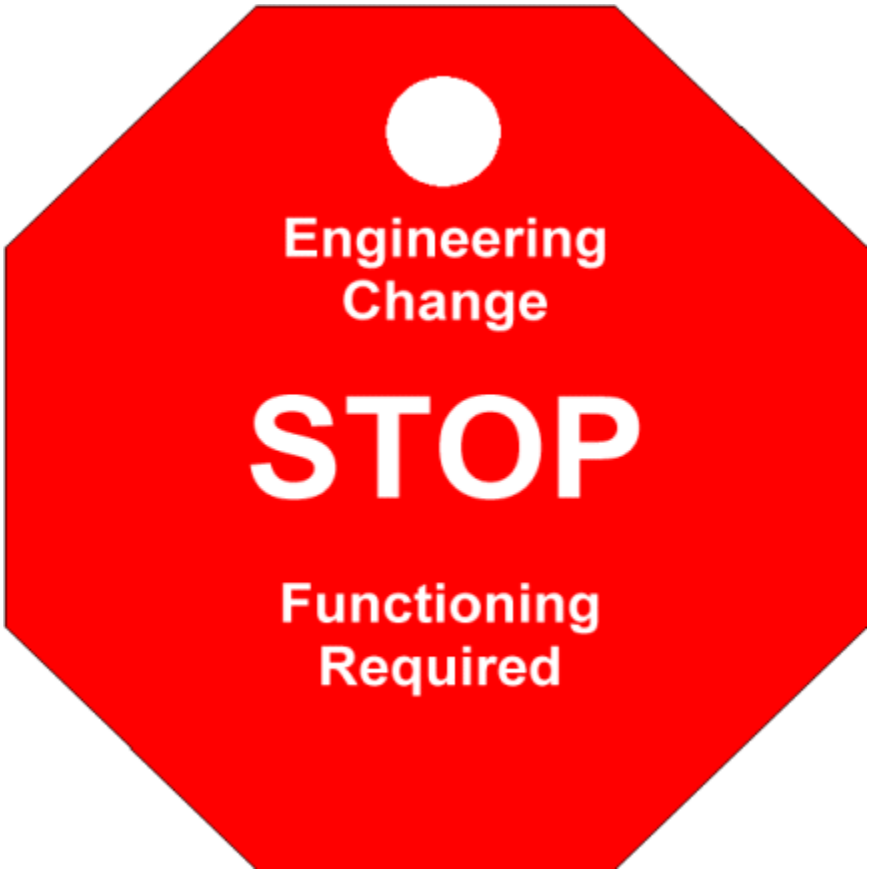
.75 x 3.5inch/19 x 90mm label, Arial 14 part
Arial 8 serial, 25 mil Data Matrix bar code

Bar code specifications follow AIAG guide lines. Label length/height should expand with bar code size to maintain ¼ inch/6mm margin around bar codes. With 2D, other data items, i.e. date of manufacture, supplier code, lot number, shift, etc. as agreed to between supplier & customer.

Appendix O

Label requirements for Engineering Changes

Suppliers should NOT utilize NEW MODEL PART labels for parts undergoing an engineering change. Initial shipment *quantities equivalent to 2 full days of Ford production* of parts undergoing an ENGINEERING CHANGE must have the label BAO 7205 shown here:



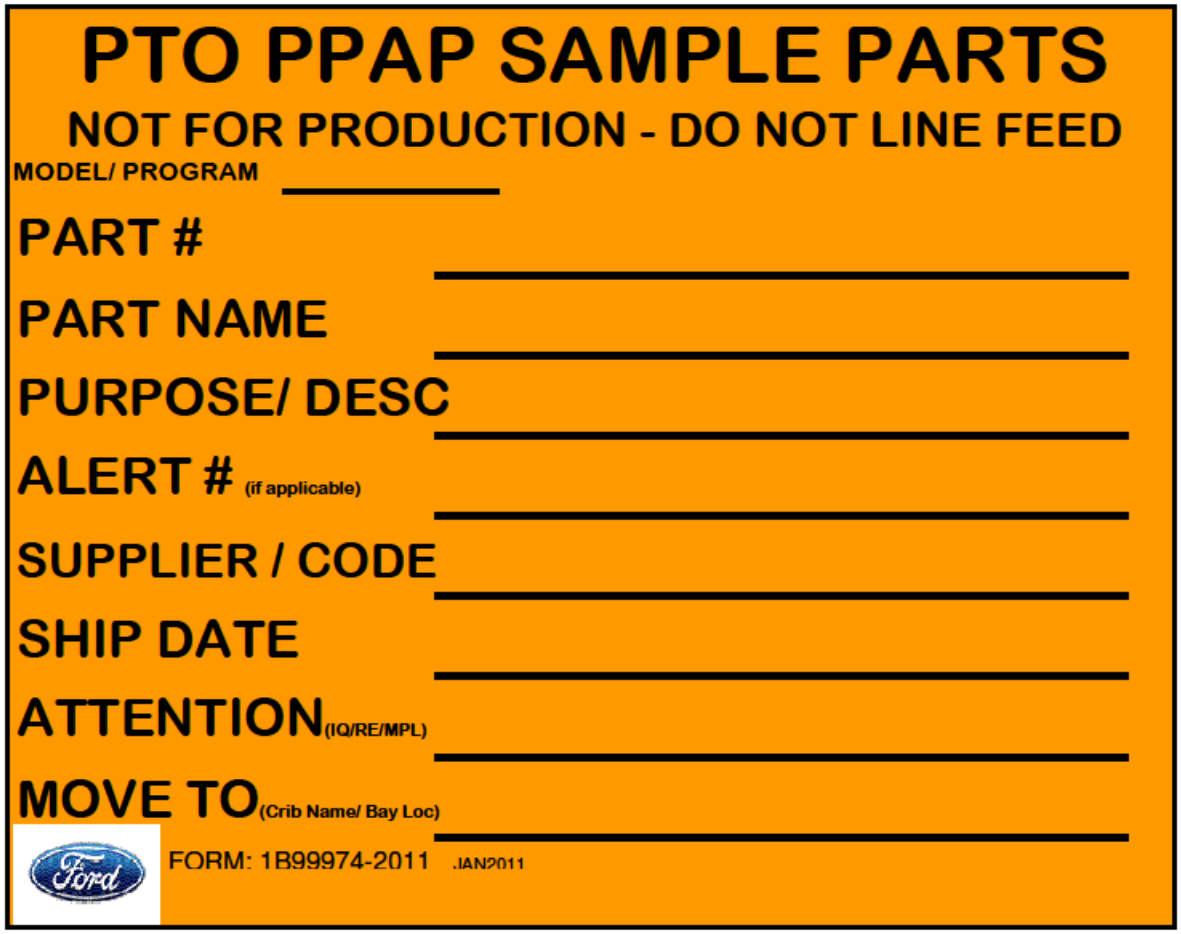
The label shall be affixed to 4 adjacent sides of each container (next to or close as to the bar code labels as possible, fastened as appropriate for the container).

New or additional tags can be ordered from Moore Business Forms by downloading an order form from COVISINT.COM. Click on Ford Supplier Portal, then click LIBRARY SERVICES, search for "Engineering Change Tags" & download BAO7205 order form. Fax the completed form to the number listed.

Appendix P

PTO PPAP Label Requirement

The PTO PPAP label is used for phase 1, 2, and 3 *Part Submission Warrants per the PPAP defined* delivery dates.



The 8.5 inch by 11 inch orange label shall be filled out and affixed to (4) adjacent sides of each container (next to or close as to the bar code labels as possible, fastened as appropriate for the container). The tag is available as an Excel file and may be downloaded from the Ford Supplier Portal of COVISINT.COM. From Covisint, click on Ford Supplier Portal, then click LIBRARY SERVICES, search for "Powertrain PPAP Samples label " and download available Excel version of label 1B99974-2011. The tag is to be printed out by any supplier shipping PSW sample parts to a North American Powertrain location.

Appendix Q

Label Certification Requirements for all North American Suppliers:

Ford Motor Company requires that all supplier shipping labels be certified by a third party provider. Labels should be certified to the current specification in this document. **If you are already producing labels to the current specification and you have received validation since July 2007, you DO NOT need to revalidate your labels at this time.**

There are four types of labels: Container, Master Load, Mixed Load and Mixed-Master. You may not use all four types – you only need to validate those that you use.

You will need to either contact one of the three suppliers (see below for a list of their web sites) for assistance and validation, **OR** you may use your own label printing supplier / formatting company to perform and validate your labels. There are three available validation companies who are authorized to perform validation (at a minimal cost -- approximately $50-$75.00 per validation attempt by supplier / system / site, until successful). Each supplier is required to validate their label layout and scan ability with the 3rd party or internal supplier.

A supplier that has one company label design and printing system for all sites is required to only validate one label set. A supplier that has multiple sites using the same central system, or copies of a master system at multiple sites and is sure all sites are in synch will only require this single validation. A supplier that has individual systems at multiple sites is required to validate each site / system.

Available bar code validation vendors are:

www.aalstec.com	Aalstec data corp.
www.freedomcorp.com	Freedom Technologies, Inc.
www.edibar.com	Edibar systems, Inc.

This process is part of your Q1, MMOG compliance guideline as of December 31, 2007. If/when a Ford Motor Company site writes a Quality Report (QR) against your labels, you will need to follow the above validation steps, presenting proof of validation and replacement of the incorrect labels with new valid labels.

Contact SMPG@FORD.COM for any questions related to a supplier Q1 delivery rating process.

Addendum

SUMMARY OF CHANGES FROM PREVIOUS 2007 VERSION

Page 2	DATE change
Page 50	Exhibit 11, New Model part label
Page 66	Appendix K, New Model part label required until Job 1 plus 1 day
Page 71	Appendix O, Engineering Change Label for 2 full days production
Page 72	Appendix P, New PTO PPAP Label