1. **Introduction**
   1. “Shall” in this document is mandatory. “Should” is highly recommended. These requirements are valid for any components or assemblies manufactured at the sub-supplier (Tier 1 or Tier 2… Tier x.).
      1. The Tier 1 supplier shall document that all sub tier suppliers follow CG4355 GM 1927 03 Statement of Requirements for Sub Tier Management and any exceptions shall be approved and documented.
   2. Nothing in this standard shall supersede applicable laws and regulations. In the event of a conflict between English and a domestic language, the English language shall take precedence.
   3. This document is intended to be used in conjunction with and is in addition to the GM General Standard Terms and Conditions.
      1. This document may be updated and amended from time to time. Pursuant to the section titled “Quality” of the General Motors Terms and Conditions suppliers shall comply with such amended Supplier Quality Statement of Requirements, and such amended Supplier Quality Statement of Requirements shall be deemed incorporated into the Purchase Order as of the date of such amendment. The applicable Supplier Quality Statement of Requirements is posted on Supply Power.
      2. The supplier shall conduct a review of any referenced documents that have been updated and comply with, or document acceptance of the exception, all new requirements referenced.
         1. In order to receive notification of changes to GM controlled documents, the supplier shall subscribe to updates within the Supply Power Document Library.
   4. All suppliers are expected to supply parts to General Motors with zero defects. Parts SHALL meet all engineering specifications and function with no abnormalities according to intent.
   5. Funding is to be identified in the initial quote and subsequent quotes to reflect error occurrence detection (poke yoke, error proofing devices, etc.) and defect outflow prevention to customers. Controls implemented at a later date are the financial responsibility of the supplier.
2. **References**

**Note:** Only the latest approved standards are applicable unless otherwise specified.

## GM Non Supplier Quality / Standards / Specifications

* + 1. Advanced Product Quality Planning (APQP) & Control Plan Reference Manual AIAG Manual
    2. Fundamental Statistical Process Control (SPC) Reference Manual AIAG Manual
    3. Measurement Systems Analysis (MSA) Reference Manual AIAG Manual
    4. Failure Mode and Effects Analysis (FMEA) Reference Manual AIAG Manual
    5. Production Part Approval Process (PPAP) Manual AIAG Manual
    6. CQI-9, CQI-11, CQI-12, CQI-15, CQI-17, CQI-27 Special Process Assessments AIAG
    7. Key Characteristics Designation System (KCDS) GMW15049
    8. Traceability Bar Code Standard GMW15862
    9. Record Management for Suppliers GMW15920
    10. Chrome Plated Plastic Parts Process Requirements GMW17406
    11. Injection Mold Tool Standards GMW15850
    12. Bar Code Validation Form CG2503
    13. Global Transportation Label GM1724
    14. Commodity Validation Sign-Off (CG4816) (available on IHS Markit) GM3660
    15. [International Material Database System (IMDS)](https://imdsdata.org/imds-requirement-for-manufacturers/). GM IMDS Instructions

## GM Supplier Quality Standards / Documents

* + 1. Part-Specific SOR(s) (CGxxxx) CGxxxx GM1927 03a *Name*
    2. SQ Processes and Measurements Procedure GM 1927 17
    3. Pre-Production Quality Planning (PPQP) GM Supply Power
    4. Early Production Containment GM 1927 28
    5. Fixture Standards – For Suppliers of Production Material GM 1925
    6. GM Global Supplier Quality Manual GM 1927
    7. GM Global Supplier Quality Manual Suffixed Documents GM 1927 xx
    8. Commodity Audits GM 1927 16a *Name*
    9. Process Audits GM 1927 16b *Name*
    10. Built In Quality Supply Based (BIQS) Supplier Self - Assessment GM 1927 30
    11. BIQS Training Material (BIQS Tool Box 5 modules) GM 1927 36
    12. Greenfield Development Assessment GM 1927 31
    13. Run at Rate Workbook GM 1927 35
    14. Process Failure Modes & Effects Analysis (PFMEA) Audit GM 1927 37
    15. Practical Problem-Solving Report (PPSR) GM 1927 48
    16. Continuous Improvement Audit – General Guidelines GM 1927 49
    17. GM Seat Appearance Development Guide GM Supply Power
    18. Statement of Requirements for Sub Tier Management CG4355 GM 1927 03

1. **Certifications**
   1. GM Quality Performance Requirements
      1. At the Technical Review during the General Motors Sourcing Process, the supplier shall provide documentation that shows the supplier has adequate Quality and Manufacturing System Controls in place to meet at a minimum the IATF 16949 requirements or, formal commitments to have processes, procedures and controls in place that meet IATF 16949 requirements. The required documentation shall include:
         1. Supplier currently meets the IATF 16949 requirements.
         2. A copy of the most recent IATF 16949 Certificate.
      2. GM Supplier Quality (SQ) will track IATF 16949 Certification status and supplier’s quality performance metrics in SCMS.
      3. A new supplier or a supplier that is IATF 16949 Certified and not meeting GM Quality Performance Requirements they must submit to GM SQE an Action Plan to address the deficiencies.The Action Plan must be approved by GM SQE.
      4. Each Supplier’s Senior Management shall commit to maintain and continuously improve quality.
         1. The Supplier Certification Measurement System (SCMS) and Supplier Practical Problem Solving (SPPS) system contains performance data for SPPS records, Controlled Shipping Level I and II, Major Assembly Plant Disruptions.
         2. SCMS monitors sourceability and status of IATF16949 Certifications. Suppliers shall monitor their quality performance, on-line, through SCMS.
   2. IATF16949 – Quality System Requirements
      1. Suppliers not certified to IATF16949, or those suppliers constructing or purchasing facilities to manufacture the parts being quoted, shall include a defined certification attainment plan with their quote for further consideration.
      2. All providers of a) production materials, b) production, service and accessory parts, or c) heat treating, plating, painting or other finishing services directly to General Motors shall be certified to IATF16949 by a Certification Body (CB) recognized by the International Automotive Task Force (IATF) and have a current certificate available demonstrating compliance to GM supplements
   3. China Compulsory Certification
      1. The supplier shall contact China Quality Certificate Centre (CQC) for CCC activities and ensure all CCC related parts meet the China Compulsory Certification requirements (reference CNCA- C11-10:2014).
      2. All saleable parts shall have a CCC marking after proper authorization. The GM math data or parts specific drawing general notes shall have “Part Shall Be China Compulsory Certification Compliant”.
      3. Supplier shall update and maintain their specific part and DUNS’ code to the CCC China Compulsory Certification requirements in The Supplier Quality Measurement System (SQMS) under Customer Specific attachments.
         1. A copy of the certificate for the part should be sent to GM Engineering before the PPAP has started or when saleable status is attained.
   4. Outside Test laboratories
      1. Suppliers utilizing outside test facilities shall provide evidence that the test facility is accredited per ISO/IEC 17025. The following groups are recognized to assess suppliers that accredit Independent test and/or calibration laboratories to ISO/IEC Standard 17025:2005.
         1. National Cooperation for Laboratory Accreditation [A]
         2. International Laboratory Accreditation Cooperation [B]
2. **Advanced Product Quality Planning (APQP)**

The supplier shall use an advanced product quality planning process that follows the GM APQP Project Plan (GM 1927 01) that ensures production readiness with parts that meet 100% of the product’s specifications. The supplier shall update the Supplier Readiness Valve (SRV) system weekly in GQTS for all items that change status

* 1. Pre-sourcing Technical reviews:
     1. The supplier shall provide the required information referred to in GM 1927 13 Technical Review Checklist (found in SupplyPower) and submit it 3 business days prior to technical review or with the bid package response, whicherver is earlier. All information shall relate to the manufacturing site that the product will be manufactured and shall reference the RFQ number and part numbers.
        1. All listed information is required in the Quote Package.
        2. Be prepared to answer questions during the Technical Review Meeting.
        3. Referenced GM 1927 documents indicate required formats as specified
     2. The supplier shall identify any part specific (CG/GMW) SOR exceptions. Approved exceptions will be documented in appendix M7 of the eSOR.
     3. The supplier shall comply with all requirements of the Part-Specific SOR when applicable.
        1. Compliance to the Part-Specific SOR is required for the PPAP to be fully approved
        2. Any permanent deviation to a Part-Specific SOR shall be authorized by the SQ Director.
     4. For any Creativity Team / SMT that supplies a module with electrical or electronic content, in addition to the Part Specific SOR “CGXXX GM 1927 3a *Name”* dedicated to the sourced part’s Commodity, the supplier shall also comply also to the “CG4209 GM 1927 3a Electrical & Electronic Modules and Assemblies”. Its Lessons Learned shall be implemented in the product and the manufacturing process.
  2. Manufacturing Process Design and Development
     1. All suppliers are required to have effective manufacturing practices and procedures to ensure a continuous flow of defect free parts into GM production facilities. (Refer to IATF 16949 and BIQS Strategies – GM 1927 36 and GM 1927 30 BIQS Supplier Self-assessment)
     2. The Tier I (including suppliers of complex systems/sub-assemblies) supplier’s quality process shall include 100% layout of customer requirements off each manufacturing stream (including tiered supplied components to their customer’s requirements) on a set frequency determined by the potential risk to part function and considering the mfg. process capability. Supporting capability studies may be required. Documentation is to be maintained at the supplier location and available for review with customer.
     3. The tier 1 supplier is responsible for implementing or enforcing compliance to AIAG & GM requirements for all components of the assembly including directed buy parts unless otherwise specified by a written agreement from GM Purchasing.
     4. The Tier 1 supplier is responsible to implement sub-tier supplier management requirements as specified by CG4355 GM 1927 03 Sub-tier statement of requirements
     5. GM may choose to assign an SQE to work along with the tier one on selected sub-supplier components.
  3. Gauge, Tooling & Equipment:
     1. Supplier to assume the gauge construction orientates the part in vehicle position unless Supplier Quality approves a deviation.
     2. All customer monitored APQP parts shall have gauge designs approved by the Supplier Quality Engineer or the appropriate customer gauge approval group prior to the start of fixture construction (for your regional requirements, contact your supplier quality engineer). Gauge designs shall incorporate approved Gauge Dimension &Tolerance (GD&T) datum schemes and gauges/fixtures shall be capable to dimensionally evaluate parts.
     3. Supplier shall have product checking fixtures for sub-datum and openings where assembly plant or sequencer/sub assembler will install something that impacts a final vehicle specification (e.g. trim plates, extension panel, grilles, glove box door, etc.).
     4. Supplier shall have the ability to check a completed assembly. Sub-contractors shall also have the ability to check component parts. Any cubing or build fixture shall have the ability to demonstrate fit to adjoining parts and attachments.
     5. Supplier shall have appropriate functional testing and final inspection to ensure product performs as designed under actual vehicle conditions.
     6. Supplier shall ensure that fixtures are procured in a timely manner to meet major program benchmarks (i.e. first shots, PPQP, PPO (Pre-Production Operations) Build Shop events, Functional evaluations, and PPAP requirements) Supplier shall, at a minimum, have a CMM (coordinate measurement machine) holding fixture available for the inspection of first parts off prototype and production tooling.
  4. PFMEA:
     1. PFMEA Requirements shall be met as outlined in the Part and Process specific SORs.
        1. Refer to CG4317 for specific Global Propulsion Systems requirements.
     2. Where Part and Process Specific SORs do not exist, a default detection of 3 shall be applied to Severity 9 and 10 items.
     3. In cases where detection requirements outlined in the Part/Process Specific SOR are not met for Severity 9 and 10 items, the GM 1927 21 Severity / Detection Transition Process shall be completed to gain full PPAP approval.
  5. Manufacturing Process Control Plan:
     1. Operator training
        1. The training plan shall address new operators and current operators performing new functions*.* Training status should be displayed near the manufacturing process. (Refer to IATF 16949 and BIQS Strategies GM 1927 36 and GM 1927 30 BIQS Supplier Self-assessment).
        2. The training plan should include all operators including temporary or supplemental employees to ensure that they work safely, follow standardized work and meet all quality and productivity requirements
     2. Equipment Maintenance
        1. Supplier shall have in place, a proactive maintenance method to improve the longevity of the manufacturing process equipment therefore increasing their effectiveness in quality and thru-put.
        2. The manufacturing facility should have a planning process that achieves reliability excellence, with Manufacturing Engineering, Operations and Maintenance working together.
        3. Production Operator should perform daily Preventive Maintenance tasks / checks in a Standardized manner to identify potential equipment or tooling failures before breakdown.
        4. Identification of the Critical spare parts: a procedure to define Critical spare parts shall be developed by the supplier. A list of Critical spare parts shall be developed, maintained and revised periodically based on maintenance results / data.
        5. Equipment performance shall be measured. Corrective action, Problem solve, and Countermeasures should be used to update the standard.
     3. Rework Reuse Repair and Recovery/Teardown
        1. The Quality Management System shall include a documented process for rework, repair, teardown, reuse and recovery that shall include authorization from a designated individual, a recognized team of experts, or the customer (GM). D
        2. There shall be no rework or repair permitted for failure modes with a 7-10 severity ranking unless approved in writing by the GM Supplier Quality Manager or above.
        3. All rework and recovery processes shall have standardized work and be documented as separate operations in the production control plan, process flow, PFMEA and approved by the GM SQE through the normal PPAP procedures.
        4. Recovery made to a part shall be inspected by someone different from who performed the recovery, and documented for traceability purposes.
        5. Product removed from the approved process flow should be reintroduced into the process stream at or prior to the point of removal. Reintroduced product needs to be identified and have traceability. Parts that are re-usable will be re- introduced in the process following a well-defined “Part re-entry process”.
        6. For the teardown process, a standardized work shall be developed to define the components disposition process. Standardized work should clearly define what can be reused and what must be scrapped.
        7. Scrapped parts should be accounted for through a Scrap Reconciliation process.
     4. Control of non-conforming material
        1. All non-conforming and suspect material shall be controlled. The method shall be clearly defined. Visual controls should be implemented. All non-conforming material shall be segregated and identified and reconciled.
        2. When a problem is reported it is expected that all suppliers implement effective and immediate containment and comply fully with GM 1927 17 Supplier Quality Processes and Measurements Procedure requirements otherwise *Controlled Shipping* may result. (Refer to IATF 16949 and BIQS Strategies – GM 1927 36 and GM 1927 30 BIQS Supplier Self-assessment)
     5. Lot Acceptance Testing
        1. ( Intentionally left blank: place holder for future content)
     6. Error proofing
        1. Suppliers shall implement error-proofing strategies for the control of materials, processes and labeling for all products provided to GM.
        2. Supplier shall implement error proofing techniques to ensure that mistakes are detected and corrected before becoming a defect (i.e. make it impossible to produce defective items even if an error occurs) and create Error Proofing devices verification procedure/process. Error proofing devices must be checked for function (failure or simulated failure) based on volume (at least once per shift -at the beginning of the shift), or according to the process control plan. The method and frequency of the error proofing verification is defined and documented in the standardized work. A Reaction plan shall be identified in case of verification failed. Reaction Plan should include containment. Error proofing masters – “Red Rabbit” - (when used) should be clearly identified and stored in assigned location close to the point of use.
        3. Implementation of error proofing is to be measured by “% Error Proofed.” % Error Proofed is the percent of total steps in the manufacturing process which have been adequately error proofed.
        4. The supplier shall maintain an Error Proofing list and establish which ones cannot be bypassed (safety critical – severities 9 and 10 in PFMEA not recommended to be bypassed unless the alternate process has the same detection) and which ones can be bypassed with standardized procedure. The supplier shall have a clear understanding of potential severity of issue if bypass used.
        5. The supplier shall error proof to a level where it is not possible to ship defective products to GM.
     7. Control Plan Check Frequency
        1. All part characteristics shall be properly evaluated during the APQP process for determination of adequate control plan check frequencies through DFMEA/PFMEA gap analysis methodology.
        2. Common cause and special cause process variation shall be identified prior to sampling and control plan definition.
        3. Supplier shall determine any critical characteristics required for fit, form, and function beyond those specified as key characteristics on the part drawing or math model. Applies especially to customer-used features and customer interface features.
        4. All key characteristics (KPC, PQC, DR) and critical characteristics shall be verified at least once per ship window.
        5. All Attribute Quality Characteristics (AQC) require 100% check frequency.
        6. For ongoing production, all key and critical characteristics shall require control charting.
        7. All part characteristics should be included in the process control plan with a minimum check frequency determined by 4.5.7.1.
        8. All requirements in this section also apply to all subcomponents.
        9. For parts with an applicable Supplier Quality Part/Process Specific CG, the supplier shall comply with any additional control plan check frequency requirements specified therein.
  6. Traceability

In order to quickly contain, and to minimize suspect product windows of any unexpected manufacturing quality issues, the supplier shall develop a robust traceability system and have the system in place by Manufacturing Vehicle Build Saleable 1 (MVBS1). In addition to complying with GMW15862 “Bar Code Content, Format, and Label Requirements for Traceability and Error Proofing” for component to vehicle traceability (as specified in the eSOR), the supplier shall also adhere to the following:

* + 1. The traceability plan shall be documented and included in the Process Control Plan for the

SQE to review as part of the PPAP evaluation. By R@R (week -2 to SORP), the traceability

plan shall be verified.

* + 1. The supplier shall have electronic traceability data readily available upon request by GM. At a

minimum, data shall include traceability from the final assembly part manufacturing date/lot code to the component manufacturing date/lot code for all tiered suppliers, including “Directed Buy” suppliers.

* + 1. For components / assemblies that have a failure mode with a severity of 8-10 in the FMEA, the supplier shall implement a traceability system from the component to the final assembly.
    2. The supplier shall have manufacturing date and/or lot number traceability to (but not limited to)

Lot Acceptance Testing (LAT) (Refer to IATF 16949 requirements and BIQS Strategies – GM 1927 36 and GM 1927 30 BIQS Supplier Self-assessment), rework, new operator training, and tooling / equipment maintenance.

* + 1. If inline component or final assembly testing is performed, per the control plan, the supplier

shall have traceability (with verification) that the component or final assembly passed all required inline testing, including those that have been reworked.

* + 1. If assembly components are a “Directed Buy” per GM, the supplier shall adhere to the

following:

* + - 1. RASIC A: The Tier 1 Supplier shall review and approve PPAP for RASIC A components (See “Directed Buy RASIC – A”, per GM GPSC for more information), ensuring any required CG2503 bar code forms have been approved by GM.
      2. RASIC B: The Tier 1 Supplier shall obtain a Level 1 PPAP status (or the Supplier Quality Management System (SQMS) PPAP report) from the tiered supplier with associated traceability plan (See “Directed Buy RASIC – B”, per GM GPSC for more information).
    1. For parts with an applicable GM1927 03a Supplier Quality Part Specific SOR (or CG), the supplier shall comply with any additional traceability requirements specified therein.
  1. Early Production Containment (GM 1927 28)
     1. GM 1927 28 shall be implemented during launch. Upon request of GM, additional levels of proactive containment may be required.
     2. Supplier shall provide 100% layout of all customer requirements during the early production launch window at a frequency as proposed by the supplier’s assessment of potential risk to part function and expected mfg. process capability. Documentation shall be provided upon request with the sample part based on the stated layout frequency.
  2. Production Part Approval Process (PPAP)
     1. GM Specific Instructions & Requirements:
        1. Compliance with International Material Data System (IMDS) is required for approved PPAP status and IMDS data may be used by GM for any purpose consistent with the Contract. In cases where GM is responsible for approving sub-supplier PPAP (such as directed buy RASIC B or consigned parts), IMDS data shall be submitted to both GM and the next higher tier supplier.
        2. “GM3660 (CG4816) Commodity Validation Sign-Off” is required for approved PPAP status when supplier is responsible for validation. (GM3660 can be found at IHS Markit GM standards.)
        3. Compliance with GMW15862 “Bar Code Content, Format, and Label Requirements for Part Identification, Verification, and Traceability” is required when applicable. CG2503 “Bar Code Label Validation Content and Format Form” is required for approved PPAP status for all new part numbers when a 2-dimensional bar code is specified on the part drawing.
        4. An Action Plan in SQMS is required when submitting for less than approved PPAP status (non-saleable or saleable status).
        5. EFFECTIVE: January 1st, 2017, ALL “PPAP Action Plan” contents in SQMS are required to be in ENGLISH or if region-specific language is utilized, an English translation shall be provided by the Supplier.
        6. Verification of customer-used part features: (examples: fit, form, function, mating surfaces, etc.) shall be incorporated in the PFMEA, process control plan, layered audits, and error/mistake proofing. Additional items to be checked shall be defined during the APQP process. These features should be verified at a frequency of 100%. An AQC (Attribute Quality Characteristic) symbol should be used on the drawing to specify these characteristics. (Refer to IATF 16949 requirements and BIQS Strategies – GM 1927 36 and GM 1927 30 BIQS Supplier Self-assessment)
     2. Applicability:

4.8.2.1 These requirements shall apply to production, service, and unitized service parts, raw materials purchased by or contracted to GM, these requirements also apply to all commodities supplied by external independent suppliers, GM Allied and Affiliated supply organizations, plus all commodities supplied to these organizations (e.g. subcontractors and tier suppliers). Please note that for bulk, raw, or indirect material, it is the Procuring Division’s decision whether PPAP is required. When conducting a bulk material PPAP, use conventions as detailed in Section 1 and Appendix F – Bulk Material – Specific Requirements.

*NOTE: PPAP (most current edition) shall apply to suppliers providing service parts to GM unless otherwise specified by an authorized GM Customer Care & Aftersales (GMCCA) representative that the application of the Service Production Part Approval Process (Service PPAP) Manual can apply.*

* + 1. Requirements for Part Approval:
       1. Part Submission Warrant (PSW) Form (CFG-1001and Appendix A) (See PPAP most current Edition Section - PPAP Process Requirements)

NOTE: A copy of all signed PSW Forms and any related PPAP forms that require approval Signatures (e.g. GM3660 (CG4816), Proof of Validation, Final GM 1829, AAR(s) etc., as required) shall be attached to the correct sample submission in the GM SQMS database and submitted electronically using the GM Supplier Quality Management system.

* + - * 1. Multiple part numbers can be submitted on the PSW, or on a separate attached

sheet, as long as all information on the PSW applies to all part numbers listed.

* + - * 1. The Supplier code referred to on the PSW and on the Appearance Approval Report

(AAR) is the full code assigned to the manufacturing location on the Purchasing

Order, also referred to as DUNS number

* + - * 1. PSW forms will not be accepted if any information is missing.
        2. Reporting of Part Material Composition (See PPAP 4th Ed., 2.2.1.1 and GM

Specifics 5.2.7.1)

The supplier shall use the International Material Data System (IMDS) to report required information.The IMDS initial submission shall be done 2 weeks before NS PPAP as GM Program Timing. Approval in IMDS is required in order to obtain an Approved PPAP Status in the IMDS Evaluation; lack of IMDS approval shall result in the maximum of a Saleable PPAP status in the IMDS Evaluation.

* + - * 1. Marking of Polymeric Parts (See PPAP 4th 2.2.1.2) - Polymeric parts shall be

identified with appropriate ISO marking codes if applicable

* + - * 1. The supplier shall confirm that all Customer Tooling is properly tagged and

numbered.

* + - 1. Appearance Approval Report (See PPAP 4th Edition Section 2, Appearance Approval Report 2.2.13)
         1. Appearance Approval Report (CFG-1002 is required for all parts with

color, grain. gloss or textiles

NOTE: An AAR is not required for surface quality of body in white (BIW) parts. Refer to the

GMNA Surface Buyoff Procedure for Surface Requirements of BIW parts.

* + - * 1. Appearance Approval may occur concurrently with part inspection and testing.

NOTE: Suppliers should contact the appropriate Appearance Approval group for the specified GM PPAP Approval organization as soon as possible to make arrangements for AAR sample submission. Parts may be submitted for AAR approval as soon as all materials are approved

* + - 1. Sample Production Parts (See PPAP 4th Edition Section 2, Sample Production Parts 2.2.14)
         1. If submitting for level 2 or 3, the supplier shall submit two sample parts unless otherwise specified by the Procuring Division. For multiple processes, two sample parts per process e.g. two parts per cavity, tool, cells assembly lines are required unless otherwise specified by the Procuring Division. The sample parts do not have to be the same part(s) that were dimensionally measured and documented on the marked drawing or check sheet. All sample parts should be labeled with part number, change level, and supplier’s name.
      2. Control Plans (See PPAP 4th Edition Section 2, Control Plan 2.2.7)
         1. GM requires Suppliers to document and submit (depending on submission level, see PPAP 4th Edition Retention/Submission Requirements Table 4.2) their Pre-Launch Control Plan. “Early Production Containment” (GM 1927 28) provides procedures for the Pre- Launch Control Plan. All parts requiring production part approval (PPAP) shall also comply with the Early Production Containment requirements.
      3. Design Records (See PPAP 4th Edition Section 2, Design Records 2.2.1)
         1. A marked drawing can be used for PPAP submission provided the drawing is signed

by the GM Lead Engineer, contains an EWO number and is dated. A marked

drawing can be used to achieve up to a Saleable PPAP status. A complete drawing

is required for Approved PPAP status.

* + - * 1. All Supplier design records shall be GM approved.
        2. The supplier shall furnish evidence of conformance to print specifications of

each detail component when requested.

* + - * 1. For CAD parts that are data-banked, the current level in the GM design databank

is the inspection referee. The source of the data shall be provided with change level

and date.

4.8.3.5.5     The organization SHALL furnish evidence of GD&T/dimensional requirements/print specifications for each detail component for final assembly approved PPAP status.

NOTE: The Engineering Change Level and Drawing Date listed on the PSW shall match the GM

record on file.

* + - 1. Design Failure Mode and Effects Analysis (Design FMEA) if the supplier is product design***-***responsible (See PPAP 4th Section 2, 2.2.4)
         1. Suppliers that are design responsible should contact the Customer Engineering organization for clarification of acceptance of a single DFMEA to be applied to a family of similar parts or material. Conditions impacting the applicability of a single DFMEA include differences in environment, and any change that impact the physics of the design.
      2. Material / Performance Test Results (See PPAP 4th Edition Section 2, Records of Material / Performance Test Results 2.2.10 and Performance Test Results 2.2.10.2)
         1. If the Supplier is design/validation responsible, the supplier shall obtain approval from the specified GM representatives per the Commodity Validation Sign-off process GM3660 (CG4816). Detailed instructions explaining this process may be accessed at the GM Supply Power/Covisint website.
         2. An approved GM3660 (CG4816) form accepted by the appropriate GM engineering representatives is required to obtain Approved PPAP status for the Functional/Durability evaluation in SQMS, when the Supplier is design/validation responsible. If a Supplier’s ’s PPAP submission lacks a GM3660 (CG4816) form accepted by the specified GM engineering representatives a PPAP status of either Non-Saleable or Saleable will be entered for the Functional/Durability lab as applicable. Signature requirements may vary by region, reference the above web site for details or contact the appropriate GM Engineering organization.
         3. If the Supplier is design/validation responsible and all items are not completed at the time of PPAP submission, an SQMS Action Plan shall be completed by the supplier and submitted with the PPAP Part Submission Warrant (PSW). The SQMS Action Plan shall contain a detailed action/recovery plan for each item including the supplier’s individual responsible for completing each item with timing. (See GM Customer Specifics, SQMS Action Plan 5.5)
         4. International Material Data System (See PPAP 4th Ed., PSW Appendix A)

The International Material Data System (IMDS) is to be used by Tier 1 suppliers to report material content information. IMDS reporting is required for all GM components globally. The IMDS requirements are:

PPAP Approval in SQMS in the IMDS Lab, including overall part Approval, will not be attained until parts receive approval in IMDS.

Any part that requires a PPAP submission that contains changes impacting material or part weight shall require a new IMDS submission.

Information entered into IMDS will generate a unique IMDS ID Number and IMDS Version,

The PSW requires the IMDS ID Number, IMDS Version, IMDS Status and the Create Date of the IMDS record for the submission.

The DUNS number on the PSW shall match the DUNS number of the IMDS submission; separate IMDS entries are required for each DUNS location on contract.

If at the at time of PPAP PSW submission the IMDS submission is not approved and/or the GMW3059 requirements are not completed, an SQMS Action Plan shall be completed listing all items not completed including timing to complete each.

IMDS information shall be submitted to the correct facility code; commonly requested codes include the following:

GM North American Powertrain Facility Code: 5754

GM North American Vehicle Operations (includes GM Mexico) Facility Code: 5751

GM North America Customer Care & Aftersales Facility Code: 31433

NOTE: Access the following web sites for additional Facility Codes and additional information: www.mdsystem.com – site includes information on the system, a substance list (GADLS), training, Frequently Asked Questions (FAQs) contacts plus additional information. *www.gmw3059.com* –site includes IMDS Instruction manual, various presentations, on-line video, FAQs, Global regional contacts plus additional information.

* + - 1. Customer Notification of Supplier – Initiated Changes

Note: The following does not include initial submissions or changes described in PPAP 4th Ed. Submission to Customer Table 3.2. Prior notification to, or communication with, the authorized customer representative is assumed

* + - * 1. The supplier shall review the proposed change with the Procuring Division prior

to implementation to obtain concurrence per the division’s local practice. A Production Trial Run may be required, contact the GM organization authorized customer representative for applicability.

* + - * 1. Sufficient information shall be provided to explain the detailed reason(s) for the

change. Attachments and graphics are encouraged

* + - * 1. Upon approval of the proposed change, the supplier shall complete the

appropriate level of documentation required per the PPAP level of submission.

Note: PPAP Level 3 is the default level for PPAP submission unless otherwise directed by the authorized GM representative.

* + - 1. Submission Levels (See PPAP 4th Section 4 – Submission to Customer – Levels of Evidence and Retention / Submission Requirements Table 4.2)
         1. Suppliers are not required to maintain full documentation from their suppliers (subcontractors) if they have decision criteria and a process in place to establish the level of evidence required from their suppliers (subcontractors), and the appropriate level of evidence on file at their location. Upon a Procuring Division’s request for PPAP documentation, suppliers shall comply within a reasonable period of time.
      2. Part Submission Status (See PPAP 4th Customer PPAP Status Section 5)
         1. Approved – Approved PPAP status indicates the part meets all customer

requirements per the design record. The SQMS database will reflect an Approved

status.

Upon customer notification of an Approved status in SQMS, the

Supplier is authorized to ship quantities per customer releases.

* + - * 1. Saleable PPAP – (See PPAP 4th Section 5, Interim Approval 5.2.2)

If a part does not meet all design record requirements necessary to obtain

an Approved PPAP status and the customer has deemed it acceptable for limited use a part may receive a status of Saleable PPAP in SQMS. The Saleable PPAP status will authorize the supplier to ship to the customer for a limited number of pieces or a specified period of time.

All Saleable PPAP submissions require a corrective action/recovery plan to

be submitted with the PPAP submission. Upon agreement of the authorized customer representative, where it is determined that the submission will not impact vehicle assembly or customer satisfaction, items are to be identified that do not meet requirements as specified. The SQMS Action Plan is to be used for this purpose and submitted by the supplier with the PSW submission. (See Section SQMS PPAP Action Plan).

Examples of conditions resulting in a Saleable PPAP status include but are

not limited to the following (contact the designated PPAP approval organization for clarification:

Documentation improvements required; examples include DFMEA,

PFMEA, Process Flow Diagram, Process Control Plan, Work instructions.

Process Capability Studies do not meet requirements; capability study

completed on less than 300 pieces and in the judgment of the SQE, satisfactory stability and capability has not been achieved. The supplier shall implement containment actions to ensure no defective parts escape the process until capability is achieved.

Dimensional layout with one or more dimensions out of specification

requiring rework to bring part to specification prior to shipment.

Parts are produced off non-production process or Low Volume/temp.

tooling

Parts have not been manufactured completely at the manufacturing

Site / environment

Part and drawing (design record) do not match and a part change is

not desired or anticipated. The direction for correction is to make a drawing change; the SQMS Action Plan shall document the change required and the date to be corrected. GM Engineer signature required on the SQMS Action Plan.

Dimensional, material testing, or appearance characteristics do not

meet design record requirements but, will not impact vehicle assembly or customer satisfaction; GM Validation and or Lead Engineer signatures required on the SQMS Action Plan as applicable to items listed.

Performance/Validation requirements specified in the Commodity

Specific SOR to be completed by the supplier (supplier) are not completed and a GM3660 (CG4816) is not signed, but testing has reached a percent of completion with no failures, or the risk is deemed low (an acceptable level) as agreed to by the CVE and DRE. The issue and the plan to meet the requirements shall be documented in an approved SQMS Action plan.

* + - * 1. Non-Saleable PPAP – (See PPAP 4th Section 5, Interim Approval 5.2.2)

If a part does not meet all design record requirements necessary to obtain an Approved or Saleable PPAP status the customer may deem it acceptable for limited use and assign a PPAP status of Non-Saleable in SQMS. These parts require retrofit with an Approved or Saleable PPAP level part.

A Non-Saleable PPAP status authorizes the supplier to ship a specified number of pieces or for a specified period of time. A corrective action/recovery plan is required to be submitted with the PPAP PSW submission. The SQMS Action Plan is to be used for this purpose and submitted by the supplier with the PSW submission. (See Section 4.8.4 SQMS PPAP Action Plan).

Examples of conditions resulting in a Non-Saleable PPAP status include but are not limited to the following (contact the designated PPAP approval organization for clarification:

Dimensional, material testing, or appearance characteristics do not

meet design record requirements and will impact vehicle assembly or customer satisfaction.

* + - * 1. Rejected PPAP – (See PPAP 4th Section 5, Rejected 5.2.3)

The part, associated documentation, testing etc. does not meet design

requirements. A resubmission shall be required.

The supplier is not authorized to ship any additional parts with a Reject PPAP status.

* + 1. SQMS PPAP Action Plan
       1. The supplier is responsible to communicate the PPAP Action Plan and ensure all information is accurate prior to submitting in Supplier Quality Management System (SQMS).
       2. EFFECTIVE: January 1st, 2017, ALL “PPAP Action Plan” contents in SQMS are required to be in ENGLISH or if region-specific language is utilized, an English translation shall be provided by the Supplier.
       3. The GM1927 09 PPAP Action Plan Worksheet shall be referenced when selecting approvers/recipients of the Action Plan.
          1. Select parts that do not use the normal PPAP Action Plan process shall use a GM1927 09 PPAP Action Plan Worksheet to document issues and gather signatures of approvers. See the SQE for parts that meet these criteria.

*Note:* These requirements are in addition to the standard AIAG PPAP requirements.

* 1. Capacity Planning and Run at Rate (GM 1927 35)
     1. Supplier shall have the ability to design and install adequate capacity to meet the daily contract requirements in one production day while operating under normal operating conditions and under total customer load.
     2. Supplier shall comply with all requirements of Run at Rate process including completion of the GM1927 35 run at rate workbook. Supplier shall have a trained single point contact responsible for coordinating all R@R and Capacity Analysis activities and requirements.
     3. Suppliers are required to demonstrate their ability to meet GM contractual requirements through both system capacity analysis (Shared Capacity Sheets, Manufacturing System Capacity Estimate) and actual R@R production to verify accuracy of the analysis.
     4. Supplier shall confirm in writing that all subcontractors supplying parts or services meet all quality and contractual requirements for the manufacturing of the GM contracted components to the GM Tier 1 or VAA/Sequencing.

1. **Performance Monitoring**
   1. Audits
      * 1. A documented Layered Process Audit (LPA) plan shall exist with a minimum frequency of once per shift or based on risk as *agreed per the GM SQE* to assess compliance to standardized processes. All Critical stations shall be identified and included on Layered Process Audit (LPA) schedule at an increased frequency. Non-conformities shall be addressed immediately, and corrective action shall be documented. Findings that could not be addressed immediately should have counter measures. Audit plan shall include multiple levels of management. Site leadership shall conduct and verify compliance to the documented plan. LPA data should be collected and analyzed to continuously improve performance. (Refer to IATF requirements and BIQS Strategies – GM 1927 36 and GM 1927 30 BIQS Supplier Self-assessment)
      1. Effectiveness of the heat-treating processes, the plating processes and the coating processes shall be demonstrated using the CQI-9 Heat Treat System Assessment, the CQI-11 Plating System Assessment, and the CQI-12 Coating System Assessment published by the AIAG and as required in the GM Customer Specifics.
         1. Only CQI-9 compliant suppliers shall be utilized to perform heat treat operations on General Motors parts. Tier 1 suppliers who heat treat their own parts shall be expected to pass a CQI-9 Heat Treat System Assessment published by AIAG. Tier 1 suppliers who purchase heat treat services shall do so from CQI-9 compliant commercial heat treaters. Purchased parts heat treated at Tier 2,3 or beyond shall be heat treated at CQI-9 compliant facilities. An “Approved Heat Treater” list is maintained by GM and should be consulted prior to sourcing. Requests for information should be directed to your GM SQE.
      2. Effectiveness of the welding and soldering processes shall be compliant with CQI-15 Welding System Assessment and CQI-17 Soldering System Assessment published by AIAG.
      3. Effectiveness of the casting processes shall be demonstrated using the CQI-27 Castings System Assessment published by AIAG and as required in the GM Customer Specifics.
      4. When Non-Destructive Testing (NDT) is required to be performed, either 100% or on a sampling basis, the supplier shall be compliant with the appropriate standards for the given NDT method employed.
         1. Magnetic Particle Inspection (ASTM E709-5 & E1444)
         2. X – Ray (ASTM E975-13)
         3. Zyglo (ASTM E1209-10 &E1219-16)
         4. Eddy Current (ASTM E566-14 & E703-14)
         5. Ultrasonic (ASTM E1962-14 & E1816-2)
         6. 3MA (Fraunhofer Institute Guidelines)
      5. Inspectors shall be trained to Level 1 minimum and technicians shall be trained to Level ll

in accordance with recognized standards such as:

* + - 1. ASNT SNT-TC-1A – 2016 NDT Guidelines
      2. ISO 9712:2012 NDT Qualifications and Certification of NDT Personnel
      3. other equivalent regional standard(s)
    1. Verification of compliance shall be accomplished through quarterly layered audits
  1. Production Quality Metrics
     + 1. Supplier shall provide quality-related data (e.g. historic inspection, first time quality, and reject data) to GM upon request. This data may be required to determine trends and to root cause quality problems at the GM Manufacturing or Assembly Plant. (Refer to IATF 16949 requirements and BIQS Strategies – GM 1927 36 and GM 1927 30 BIQS Supplier Self-assessment)

1. **Shipping and logistics**
   1. Containerization
      1. Packaging is part of the manufacturing process and shall be included as appropriate in the FMEA, Quality Plan, and PPAP. Approved Containers are used for regular production and all saleable build events.
      2. Production intent containers shall be used for any build events. Exceptions are documented, analyzed, and justified (e.g. overseas suppliers).
      3. A process should be in place to confirm container standards are maintained over the life cycle of their use. Improvement process for out of standard conditions must rapidly return containers back to standards.
      4. Packaging shall not be a source of contamination.
      5. Containers, racks and/or bins used for WIP storage and movement protect the parts from damage and easily identify the parts as WIP.
      6. Suppliers shall have a process that meets requirements outlined in GM1738 - Packaging and Identification Requirements. Customer Approval exists of shipping containers (GM1738), including alternative packaging. Supplier shall have form GM1738 filled out and approved during launch.
      7. Suppliers shall have a Process to Address Violations (Requirements outlined in GM1700, 1738 and other appropriate documentation). Violations should be addressed with countermeasures.
   2. Labeling
      1. All shipping containers shall be labeled IAW GM1724A (Individual AIAG Shipping Labels) and/or GM1724B/C (Master Load Label)
      2. Labeling Error proofing shall be included in Flow diagram, PFMEA and Control Plan.
      3. If labeling is incorrect, parts should be considered 100% defective.
2. **Current Product Improvement Process (CPIP)**
   1. Advanced Problem Solving
      1. Suppliers are required to demonstrate their capability to solve complex problems using advanced problem-solving techniques such as the “Red X” system at GM. (Refer to IATF 16949 requirements and BIQS Strategies – GM 1927 36 and GM 1927 30 BIQS Supplier Self-assessment)
      2. Suppliers shall actively participate in the timely resolution of problems identified by GM’s CPIP. Suppliers shall provide appropriate corrective action documentation and project status updates as requested.
      3. An Escalation Process for Problem Solving should be developed by Supplier to eliminate roadblocks and to support the supplier in faster solutions and implementation times. (Refer to IATF 16949 requirements and BIQS Strategies – GM 1927 36 and GM 1927 30 BIQS Supplier Self-assessment)
3. **Assembly Plant Support**
   1. Value Added Assembler
      1. The Value Added Assembler is responsible to control and record breakpoint changes resulting from EWO’s, PPAP level and quality level changes of all incoming material. The Value Added Assembler is responsible to assure that the correct PPAP and design level part is used for the given manufacturing build event (MCB, MVNS, MVS, SSF, SORP, etc).
      2. The Value-Added Assembler is not responsible for the PPAP of the individual components but is responsible for control of those within their facility.
      3. The Value-Added Assembler shall have a standardized Rework/Repair/Teardown process. For the tear down process, a standardized work must be developed to define the components disposition process. Standardized work should clearly define what can be reused and what must be scrapped.
      4. Parts that are re-usable will be re- introduced in the process following a well-defined “Part re-entry process”. Parts that are determined to be *out of standard will be scrapped.*Scrapped parts should be accounted for in Reconciliation for scrap.
      5. The Value-Added Supplier should have a documented process on what can be repaired.
      6. Failures Modes from rework/repair should be considered in the PFMEA.
   2. Supplier contacts for all shifts
      1. Supplier shall designate a specific supplier representative that will support each of the GM Plant’s shifts. At a minimum the supplier designate should have the responsibility to:
      2. Implement immediate countermeasure to contain discrepant parts and to confirm that defective parts are not shipped to GM Plant.
      3. Approve GM Plant’s/SQE’s requests for rework and sort.
      4. Coordinate and provide resources to rework and sort parts.
      5. Provide sub-assemblies / components for required repair, related to quality issues.
      6. Provide clear information regarding any defective parts in-route to GM Plant (how to identify defect, disposition guidelines).
      7. Coordinate special delivery of certified OK parts.
   3. Pre-Production and Launch Phase
      1. Upon request of SQ or GM Plant, Supplier will provide on-site support during all pre-production build phases and production launch activities.
4. **Warranty** 
   1. Warranty Part Center Support
      1. Suppliers shall designate representatives that will be invited to WPAC Warranty Reviews of supplier parts, and be the Supplier contact for Problem Resolution & Tracking System (PRTS) issues from WPAC Warranty Reviews. They shall monitor PartLink system for Recovery Group, Technical Factor, and Ordinary Warranty Term Billing
      2. Suppliers responding to a PRTS with Problem Mainly Caused By “Supplier design”, “GM assembly”, “Product design”, “Marketing”, or “No trouble found” will retain the parts for a minimum of 90 days from the date the Root Cause step of the PRTS is approved by GM, during which time GM may request the parts back for further analysis.
   2. Test / Analysis Capability
      1. Suppliers may have need to further analyze WPAC parts at their own facilities, in which case Supplier may be required to provide GM with a shipping account number/address based on the analysis location.
      2. The supplier shall report any and all safety related failure modes discovered during analysis of warranty data.
   3. Financial accountability
      1. Suppliers shall be able to account for the last 24 months of warranty expenditures
   4. Warranty reduction support
      1. The supplier shall have a plan to reduce supplier responsible warranty during the 12 month warranty time period.
5. **Systems Access** 
   1. Supply Power
      1. Suppliers shall have internet access to effectively communicate with General Motors. GM Supplier Quality procedures and systems can be accessed through the GM SupplyPower web page (www.gmsupplypower.com).
      2. Suppliers shall have access to the Global Analytical Report Tools (GART) the warranty reporting system as appropriate.
      3. Suppliers shall have access to the PartLink warranty claim system as appropriate.
         1. Instructions can be found in GM SupplyPower by selecting Collaboration then Document Library and then search for PartLink, but it is only accessible after following the on boarding instructions.
      4. Supplier shall have access to GM’s Problem Resolution & Tracking System (PRTS) in order to respond when an issue is created.
         1. The PRTS Request Form can be found in the Supply Power by selecting Collaboration then Document Library and then search for PRTS.
      5. Suppliers shall have access to Supplier Quality Management System (SQMS) to submit PPAP and Action Plans for SQE approval to ensure that parts complete the Production Part Approval Process as required.
         1. Application instructions can be found in GM Supply Power by selecting Collaboration then Document Library – Search for SQMS
      6. Suppliers shall have access to Supplier Certification Management System (SCMS)for tracking Supplier Quality throughout the manufacturing process, Global Quality Tracking System (GQTS) which shall have access to Supplier Readiness Valve (SRV), APQP, Supplier Practical Problem Solving (SPPS) which shall have access to Controlled Shipping (CS).
         1. Supplier shall have access to Supplier Readiness Valve (SRV) that checks the readiness of a supplier to provide parts for the Start of Regular Production (SORP) through GQTS
         2. Supplier shall have access to APQP module in Supplier Quality Measurement System (SQMS) where they can access Run@Rate Management, APQP Assessment and Launch Alert.
         3. Supplier shall have access to Supplier Practical Problem Solving (SPPS) System to track the status and respond with containment and corrective actions.
         4. Supplier shall have access to Controlled Shipping (CS) to monitor and control the quality of shipments (through SPPS System)
         5. Application instructions can be found in GM SupplyPower by selecting Collaboration then Document Library – Search for GQTS
      7. Suppliers shall have access to the Supplier Certification Management System (SCMS) including the Sourceability Report to document compliance with GM quality certification requirements and to communicate information on Source-ability status. (SCMS replaces the Global Quality Tracking System former modules: Supplier Certification, and Sourceability Report)
         1. Application instructions can be found in GM Supply Power by selecting Collaboration then Document Library – Search for SCMS. GM SPPS System is new and requires separate access.
6. **Commodity focused Addendums**
   1. Propulsion Systems suppliers shall adhere to the Supplier Quality Statement of Requirements found in Appendix E.
   2. Body, Interior, Exterior, Chassis, Thermal, and Electrical suppliers shall adhere to the Supplier Quality Statement of Requirements found in Appendix F.
   3. SGM : Greenfield / Brownfield (Appendix G)

**Appendix A – Revision History**

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| **GDM Change History** | | | | |
| **Date** | **Version** | **Change Summary** | **Approver** | **Approving Organization** |
| April 2012 |  | Made CQI 15 & CQI 17…. “when requested by the SQE” in section 2 | Jim Bokros | Supplier Quality and Development |
| August 2012 |  | Added 100% layout requirement in “Production Quality” section 6 |  | Supplier Quality and Development |
| October 2013 |  | Added comments in regards to tiered IMDS requirements (section 8) |  | Supplier Quality and Development |
| October 2014 |  | Annual release of changes. Added warranty analysis requirements (section 14). Added Part Link & PRTS IT system requirements (section 15). Updated IMDS date usage (section 8). Updated QSB+ requirements. Added tier supplier management requirement (section 11). Updated capacity planning requirements (section 7 & Required Quality Info). |  | Supplier Quality and Development |
| December 2014 |  | Added new requirement regarding frequency for updating Supplier Readiness Valves. (Section 5) |  | Supplier Quality and Development |
| January 2016 |  | BIQS implementation to replace QSB+ |  | S.QD |
| 2/24/2016 | A(1) | Initial Release | Scott Trantham | Supplier Quality and Development |
| 8/16/16 | B(2) | Update to “GM Procedures and Reference Documents” to ensure all documents referenced are still in use and are referenced under the correct name/location (section 2) | Scott Trantham | Supplier Quality and Development |
| 8/16/16 | C(3) | Added “GM Confidential” to the footer and file name | Scott Trantham | Supplier Quality and Development |
| 12/13/16 | D(4) | Update document to include Customer Specific (CS) requirements (section 8) | Scott Trantham | Supplier Quality and Development |
| 1/12/17 | E(5) | 1. Reformatted all sections per CG guidelines. Added items 1.1, 1.2, 4.1.2 and appendix A, B, C  2. Moved supplier signature page to Appendix H  3. Added content regarding traceability (4.6) and check frequency (4.5.7)  4. Corrected formatting and typo errors  5. Added content CQI 27( 2.16 & 5.14)  6. Added placeholders for future content (sections 4.4, 4.5, 6, & 10)  7. Revised section 4.8 (PPAP rgmts)  8. Removed table and added reference to GM1927 13 (appendix D) | Global Business Process | Supplier Quality and Development |

**Appendix A – Revision History continued**

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| **GDM Change History** | | | | |
| **Date** | **Version** | **Change Summary** | **Approver** | **Approving Organization** |
| January 26, 2017 | F(6) | 1. Item 4.1.4 Removed reference to required signature page 2. Item 5.1.3 Revised wording to remove “When requested by GM SQE” 3. Updated Section 10 to reflect changes to GQTS, SQMS, & SCMS system requirements | Global Business Process | Supplier Quality and Development |
| August 1, 2017 | G(7) | 1. Correct typo error item 2.2.10 & 11 2. Added Items 1.3.1 & 1.3.2 & 1.3.2.1 regarding SOR revisions 3. Added item 5.1.2.1, 5.15, 5.16, and 5.17 per CQI 9 compliance requirements 4. Updated 3.1.2, 3.1.5, 3.2 regarding SCMS & IATF16949 references 5. Moved 4.8.1.7 to 4.8.1.6 (Deleted previous item 4.8.1.6) 6. Updated section 4.8.3.7.7.4.7.3 Service Parts Name | Global Business Process | Supplier Quality and Development |
| Aug 1 2018 | 8 | 1. Replaced “must” with “shall” for consistency purposes 2. Added item 1.1.1 regarding CG4355 3. Corrected file name reference in section 2 4. Updated items 2.2.12 regarding BIQS assessment 5. Added item 2.2.21 regarding CG4335 reference 6. Revised section 3.1 regarding references to QSB 7. Revised wording in item 4.3.5 regarding testing. 8. Updated section 4.5.3 regarding reuse recovery rework and repair 9. Revised item 4.8.4 regarding PPAP Action Plan worksheet 10. Removed CCT from appendix B glossary 11. Added reuse and recovery definitions to glossary 12. Updated item 9.1 & 10.1.4 regarding warranty PRTS issues 13. Added item 9.3 & 9.4 regarding warranty 14. Updated item 4.1.1 regarding technical review checklist 15. Updated verbiage in appendix D 16. Added item 4.4.1.2.3 regarding PFMEA 17. Replaced GP 5, 9 & 12 references with appropriate GM1927 references 18. Updated item 10.1 regarding PartLink & PRTS document path. 19. Updated references to GM3660 with CG4816. (6 locations) 20. Revised item 4.8.3.10.2.3.8 regarding GM3660 salable status 21. Updated Appendix F regarding SPC Addendum | Global Business Process | Supplier Quality and Development |
| July 31 2019 | 9.0 | Corrected all file names to reflect the current standard (eliminated dashes)  Took out all TS16949 references and replaced with IATF16949 throughout the document.  2.2.12 and 2.2.13 Updated to reflect current process. Added (BIQS Tool Box 5 modules)  3.1 Sourceable BIQS level replaces “Built in Quality Systems (BIQS) GM1927 30”.  3.1.1 and 3.1.3 Added IATF 16949 requirements.  3.1.2 Replaced “pass BIQS assessment” with “IATF 16949 Certification status and supplier’s quality performance metrics”  3.1.4.1 The Supplier Certification Measurement System (SCMS) and Supplier Practical Problem Solving (SPPS) system replaced “Global Quality Tracking System (GQTS)”  4.5.1.2 Added requirement regarding training plan for temporary workers.  4.5.2 Added content: Equipment maintenance requirements  4.5.3 Added teardown  4.5.3.5 Reviewed the verbiage and updated it to reflect current requirements.  4.5.3.6 and 4.5.3.7 Added requirements  4.5.4.1 Added “and reconciled”  4.5.6.2 Added requirements regarding error proofing verification.  4.5.6.4 Added requirements regarding error proofing bypass list.  5.1.1.1 Updated verbiage and added Critical station LPA requirement.  6.1.1 Added Containerization and packaging requirements  6.1.2 Added Labeling requirements.  7.1.3 Added Escalation process for Problem Solving requirement.  8.1.3 – 8.1.6 Added Value added assembler Rework/Repair/Teardown requirements  10 System access – updated with current systems and modules.  10.1.6.3 Supplier Practical Problem Solving (SPPS) System replaced “Problem Reporting and Resolution (PRR)” | Lidia Natanail | Supplier Quality and Development |
| January 14, 2020 | 10.0 | 3.1 Updated GM Quality Performance Requirements  3.1.2 and 3.1.3 Updated with current process requirements.  Added “Refer to IATF 16949 requirements and BIQS Strategies – GM1927 36 and GM1927 30 BIQS Supplier Self-assessment” where applicable across the document  4.8.3.5.5  NEW! Added Requirements for Part Approval – Design records. | Global Business Process | Supplier Quality and Development |
| April 6th, 2020 | 11.0 | 1. Added “2.1.12 [International Material Database System (IMDS)](https://imdsdata.org/imds-requirement-for-manufacturers/). GM IMDS Instructions” to page 1.  2. Added “The IMDS initial submission shall be done 2 weeks before NS PPAP as GM Program Timing” to page 9, 4.8.3.1.4.1 | Global Business Process | Supplier Quality and Development |
| April 20, 2020 | 12.0 | Appendix F 1. Capability, Page 25 added:  “Capability requirements identified in a part specific or process SORs supersede the targets noted above.” | Global Business Process | Supplier Quality and Development |
| Oct. 16, 2020 | 13.0 | 4.1.1 Added : “Technical Review Checklist (found in SupplyPower) and submit it 3 business days prior to technical review or with the bid package response, whicherver is earlier”  2.2. and 4.8.1.2 Added clarification regarding to where GM3660 can be found.  Renamed 2.2  Re-grouped reference documents per GM SQ and GM Non SQ / external from SQ documents. | Global Business Process  J. Zapata | Supplier Quality and Development |

**Appendix B – Definitions & Acronyms**

**Acronyms**

AAR Appearance Approval Report

AIAG Automotive Industry Action Group

CVE Component Validation Engineer

DR Documentation required

DRE Design Release Engineer

KPC Key Product Characteristics

PQC Product Quality Characteristic

**Definitions**

REPAIR: the act of restoring the functional capability of a defective article in a manner that does not assure compliance of the article with specifications.

REWORK: the act of reprocessing noncomplying articles, through the use of original or equivalent processing,

in a manner that assures full compliance of the article with specifications.

REUSE: The act of recovering components from a noncomplying article thru an approved recovery process

and reprocessing recovered components for a number of times, through the use of original

processing, in a manner that assures full compliance of the article with applicable drawings or

specifications.

RECOVERY: The act of disassembling a noncomplying article to recover components so the components can

be sent back to the start of the original process. A recovery is one that is done frequently enough

to be covered by validation, standardized work. Recovery personnel are certified to the recovery

process and standardized tools and techniques are used by all recovery personnel.

**Appendix C – Footnotes**

Footnotes for additional explanation of requirements:

[A] NACLA does not require its member organizations to sign an MRA for recognition.

[B] The ILAC organizations are signers of Mutual Recognition Arrangements (MRA’s) which may preclude them from accepting non-MRA signatory assessments. The MRA signatories do have procedures that may allow acceptance of assessments conducted by other organizations. GM encourages the utilization of these procedures. Specific concerns should be directed to the appropriate MRA.

[C] If you have any questions relative to the required information, please contact your GM Supplier Quality Engineer for clarification.

[D] The rework of parts can result in undesirable variation and may take parts out of process if the rework was not initially comprehended in the process.

## Appendix D

This page left intentionally blank

Appendix E

Supplier Quality Statement of Requirements: Propulsion Systems Addendum

1. **Process Capability & Control Requirements:**

|  |  |  |
| --- | --- | --- |
| **Characteristic** | **PPAP**  **Requirement** | **Ongoing**  **Production** |
| **KPC** | Xp  2.0  Xpk  1.67 | Xp  2.0  Xpk  1.5 Control charting required |
| **PQC** | Xp  2.0  Xpk  1.67 | Xp  2.0  Xpk  1.5 Control charting required |
| **Standard**  **Product Characteristic** | Xp  1.33  Xpk  1.00  (Documentation required only for DR characteristics) | Xp  1.33  Xpk  1.00  Control charting required for DR characteristics |
| **Surface Finish & Hardness** | Xp  1.0 Xpk  1.0  (Documentation required only for DR Characteristics) | Xp  1.0  Xpk  1.0  Control charting required for DR Characteristics |

Xp=Cp & Xpk=Cpk: for stable processes with normal distribution of measured values   
   
Xp=Pp & Xpk=Ppk: for stable processes with non-normal distribution of measured values  
  
**Standard Product Characteristic** – Those characteristics where reasonably anticipated variation is unlikely to significantly affect function or performance of the product. Some standard product characteristics may be designated as Documentation Required (DR).

Documentation Required (DR) - Those standard characteristics which are important to function and where reasonably anticipated variation outside of the specification is likely to have moderately negative consequences.

**2. Cleanliness Requirements:**

Cleanliness requirements for all parts will be defined in the Product Engineering Statement of Requirement and on the part print drawing. Part and process cleanliness shall be considered during the development of the PFMEA. Appropriate actions shall be taken during the APQP process as driven by the PFMEA RPNs. The supplier shall use GMW 16037 Test Method to Quantify Cleanliness of Powertrain Components.

Appendix F

Supplier Quality Statement of Requirements

Body, Interior, Exterior, Chassis, Thermal and Electrical Addendum

1. Capability:

For Key Product Characteristics (KPCs) and Product Quality Characteristics (PQCs) and Documentation Required (DR).

Reference GMW 15049 and AIAG PPAP Manual. Clauses 2.2.9

|  |  |  |
| --- | --- | --- |
|  | **6 Requirement** | |
|  | PPAP | **On- going Production** |
| **CHARACTERISTIC** |  |  |
| **KPC**  **Special Characteristics** | **Xpk ≥ 1.67** | **Xpk ≥ 1.67**  **Control Charting Required** |
| **PQC**  **Special Characteristics** | **Xp ≥ 1.33**  **Xpk ≥ 1.0** | **Xp ≥ 1.33**  **Xpk ≥ 1.0**  **Control charting Required** |
| **DR**  **Special Characteristics** | **Xpk ≥ 1.0** | **Checked to be within specification per agreed to Process Control Plan** |
| **Standard**  **Product Characteristics** | **5 samples checked to be within specification. In addition GM reserves the right to require demonstration of initial process capability** | **Checked to be within specification per agreed to Process Control Plan** |

Xp(k)=Cp(k): for stable processes with normal distribution of measured values

Xp(k)=Pp(k): for stable processes with non-normal distribution of measured values

Refer to AIAG SPC Manual Appendix G for definition of normality.

Standard Product Characteristics are any non-special characteristics identified by GM to be measured.

Samples shall to be taken from each unique production process. (Duplicate assembly line and/or work cell, each position of a multiple cavity die, mold, or tool)

Capability requirements identified in a part specific or process SORs supersede the targets noted above.

If during Product / Process development or on-going production there is indication that the manufacturing process cannot meet the above capability requirements, you shall immediately notify your Supplier Quality Engineer (SQE) and develop a plan to assure compliance utilizing necessary process improvements and tooling corrections.

The supplier shall obtain formal written approval to deviate from the capability requirements until the capability requirements are met.

**2. Part Monitoring:**

The Component control plan shall contain part monitoring requirements as defined in the SOR appendix C1 as well as any additional requirements defined by the supplier and approved by supplier quality.

**Appendix G**

**SGM全球项目中对新建、扩建厂房供应商的一般要求**

**SGM General Requirements to Greenfield / Brownfield Supplier of Global Program Addendum**

对于新建（扩建）厂房的供应商，必须在SQE发出QUAD报告前的归定时间期限内提供以下信息：

For China Green and Brownfield suppliers, the information below should be provided within the required dates to enable the completion of the sourcing recommendation.

1. 提交书面的建厂（扩建）、质量体系认证、通过SGM PSA评审（PPAP前）的计划，包括但不限于下面的内容：

- 是否在国内找合资/合作伙伴，如果是，合资/合作方的公司名称？；

- 工厂选址和公司注册成立的最后期限 (仅适用于新建厂供应商)；

- 购买/获得土地和厂房完工的最后期限；- 人员招聘和培训

- 非SGM配套供应商需提供国内及申报海外业务的兄弟公司的近期质量表现记录

Provide written plans for construction or procuring a manufacturing facility, quality system certification and commitment date to pass the Shanghai GM Potential Supplier Assessment (SGM requires for PPAP). The plans should include:

-Will there be a partnership with a Chinese entity? If yes, please identify the entity.

-What is the due date to decide the plant location and company registration (Greenfield only)?

-What is the due date for buying the land for the manufacturing plant? What will be the plant's construction capacity?

-What is the schedule for hiring personnel along with the schedule for training personnel?

-Non-SGM suppliers shall provide the quality performance of its quoted location including its global quality performance for the quoting commodity.

2. 母公司/总部对国内工厂的详细支持计划（包括人员和时间）。对于仅有设计职能的供应商，需提供支持国内项目的工程及总成级产品认可计划。

What is the Headquarters' support plan for the local plant (Whom, position, when and length of support)?A Supplier, who has design responsibility, shall provide the plans of engineering support and production validation at the assembly level.

3. 识别国内区别与海外公司在原材料/工装/设备等方面存在的制造工艺差异，提供针对自产或委外加工产品或过程的相应控制措施，以确保所生产的产品符合全球质量标准。

Provide a manufacturing process gap analysis in material, tooling and equipment of China operations that will not be congruent with the global manufacturing footprint. Define the countermeasures to either in-house or outsourcing part/process and assure the unique operations can provide product to the global quality standard.

4. 如果供应商没有按时提交上述计划和承诺，SGM SQE将拒绝推荐该供应商，并且在发出QUAD报告后，不再接受事后补交。

If the supplier fails to provide the plans and commitments on time, SGM cannot provide a recommendation. If the plans are provided following the recommendation required date, SGM SQE may not reconsider.

5. 新建(扩建)厂房的供应商须确保中国工厂的所有关键工艺与其他区域的供应商工厂完全一致。针对出

于产量或成本考虑的非关键工艺的变差,供应商应进行识别、风险评估和制定相应控制措施,并通知

SGM SQE。

Greenfield (Brownfield) supplier shall ensure that all critical process in China plant is same as that in other regions. Concerning variation in non-critical process taking into account output or cost, supplier shall assess risk upon the variation and take corresponding control measures, as well as inform SGM SQE.

**Appendix H**

**Supplier Representative Signatures Required**

Note: All of the requirements in the Supplier Quality SOR have been reviewed and

the compliance to them is fully accepted by supplier, exception made to what

is reported in the attachment of Team Feasibility Commitment as feasible

(Changes recommended) or not feasible (Design revision required to produce

product within the specified requirements).

\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

Commodity / Product Type GM Program / Program Year

\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ \_\_\_\_\_\_\_\_\_

Supplier Chief Engineer Supplier Chief Engineer Date

(Signature) (Printed Name)

\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ \_\_\_\_\_\_\_\_\_

Supplier Program Manager Supplier Program Manager Date

(Signature) (Printed Name)