Appendix B

General Program Description

# 2028 T1XX-2 SUV

# FRT SIDE DOOR MIRROR REINFORCEMENT CASTINGS

# 27 June 2024

**Note 1: Appendix F5** shall contain all Appearance related technical content (color, grain,

gloss, etc.)

**Appendix F10** shall contain any additional Material requirements not stated in **Appendix B**

**Note 2:** Throughout this document **the term “Buyer”** on its own refers to the legal entity

issuing this document. The term “Buyer’s Buyer” refers to the person within that

legal entity performing the job function of the Buyer.

1. **SCOPE of PRODUCT/COMMODITY**

All of the components in this appendix are joined to the vehicle via various joining methods that may have additional quality and performance requirements. Some components may also require secondary processing such as e-coating or painting. (Reference appendix B2 for details).

High severity levels within the DFMEA require specific PFMEA process controls. (Reference section 10.0 Risk Analysis and Review for details).

1. **OVERVIEW of the PROGRAM**.

This SOR may include sub-assemblies and loose stampings denoted as MP (Manufacturing supported Purchased parts and assemblies). Information on MP process can be found in Appendix F43, CG5615.

2.1 Program Applications, Duration and Model and/or Calendar Years

The *commodity* covered by this SOR is applicable to the following Program(s):

*T1UCF/T1UGF/T1ULF/T1YCF/T1YGF/T1YLF MY 2028 – 2032*

**2.2 Timing Information**

For Body Shop Material dates, quantities, and part submission requirements, refer to Appendix E10.

Supplier must submit NS PPAP documentation two weeks prior to APPV or PPV MRD (whichever comes first) and Full PPAP documentation (or Saleable action plan) two weeks prior to Saleable MRD.

If Supplier is to provide pre-production parts, see Section 10.4.

|  |  |  |
| --- | --- | --- |
| **MRDs** | **T1UCF/T1UGF/T1YCF/T1YGF** | **T1ULF/T1YLF** |
| Production Release (PVER) | 17-Oct-2025 | 5-Dec-2025 |
| Production Tooled Build - Critical (PTB-C) | 16-Mar-2026 | 11-May-2026 |
| Production Tooled Build - Main (PTB-M) | 21-Sep-2026 | N/A |
| MRD Matching Closures | 12-Oct-2026 | 07-Dec-2026 |
| MRD APPV Closure Details | 27-Nov-2026 | 22-Jan-2027 |
| APPV BIW | 18-Dec-2026 | 12-Feb-2027 |
| PPV BIW | 22-Feb-2027 | 19-Apr-2027 |
| MVBns - Body | 18-Jun-2027 | 13-Aug-2027 |
| MVBs - Body | 24-Sep-2027 | 19-Nov-2027 |
| SORP | 10-Jan-2028 | 6-Mar-2028 |

1. **Communication Plan.** The following table outlines the Key Contacts for Buyer. (see table below)

## 3.1 Buyer’s Program Personnel.

Buyer key contacts and personnel assigned to the Program(s) are as follows:

|  |  |  |  |
| --- | --- | --- | --- |
| Buyer Program Support Personnel Contacts | | | |
| **Function** | **Name** | **e-Mail** | **Phone** |
| Lead Product Engineer | *Bhavin Mandalia* | *bhavin.mandalia@gm.com* | *586-234-0014* |
| System Lead Engineer | *Jacob Horn* | *jacob.t.horn@gm.com* | *931-626-3627* |
| Purchasing (Buyer) | *Jacob Malone* | *jacob.g.malone@gm.com* | *269-999-0028* |
| Global Advanced Vendor Tooling | *Joseph Thompson* | *joseph.1.thompson@gm.com* |  |
| Supplier Quality Engineering | *Paul Derouin Jr* | *paul.derouinjr@gm.com* | *586-533-8687* |
| Dimensional Engineering | *Mike Antos* | *mike.antos@gm.com* | *586-709-7950* |
| Product Interface Engineering | *Ignacio Perez* | *ignacio.perez@gm.com* | *586-291-3017* |
| Design Resource (Manager) | *John Bottiaux* | *john.bottiaux@gm.com* | *586-907-2539* |
| Validation Engineering | *Bhavin Mandalia* | *bhavin.mandalia@gm.com* | *586-234-0014* |
| Materials Engineering | *Derrick Tanner* | *derrick.tanner@gm.com* | *248-607-1915* |
| Fastener Engineering | *Edward Kortes* | *edward.kortes@gm.com* | *810-272-6852* |
| Vehicle Analysis | *Rajagopal Gudimella* | *raj.gudimella@gm.com* | *586-907-4587* |

1. **INTEGRATION LEVEL STRATEGY.**

Level 1: Buyer has full responsibility for the Engineering of the parts. Suppliers manufacture parts according to Buyer's specs (" Build to print "). Refer to SOR Appendix A (RASIC) for details.

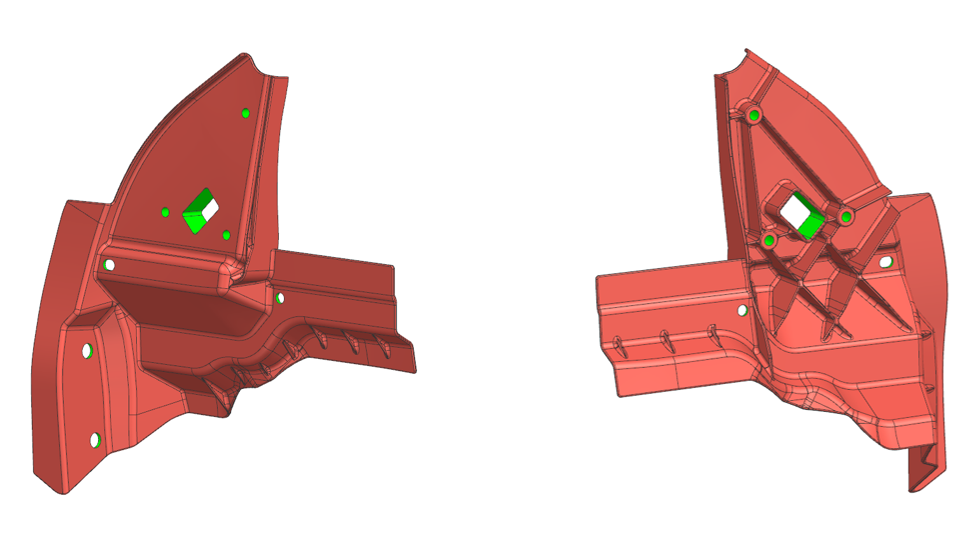
1. **LIFECYCLE SUPPORT STRATEGY.**

The supplier will supply engineering support for the development, validation, pre-production, pilot, production, and service life phase of the program.

1. **COMMODITY RELATED VTS EXCERPTS.**

*Does not apply*

1. **SKETCHES, DRAWINGS, ETC**.

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**LHS PN 85755810/001.0005 SHOWN ABOVE**

**RHS PN 85755811/001.0005 SYMMETRICALLY OPPOSITE**

* **UNIGRAGHICS MATH IS THE GOLD SOURCE FOR PART DETAILS AND MUST BE USED FOR LATEST PRODUCT DEFINITION.**
* **Deviations should be documented and agreed upon by the buyer.**
* **Math will be provided at start of sourcing and a subsequent math drop may be provided before sourcing is complete.**
* If Supplier is being kicked off to a preliminary math data file (not P2 released), Supplier is authorized to execute design and preparatory work only, such as: formability studies, process and tooling development/design, and the ordering of long lead commodity items such as tool steel or robots.  Supplier is NOT authorized to start any tool cutting and/or to begin actual tool construction until P2 math data is released, reviewed, and approved through appropriate ECR process.  At that point, Supplier must update their process and tooling to reflect P2 math data.  Supplier must also update and inform GM DRE and Buyer on any critical tooling timing milestones and any issues that would cause a risk to meeting program MRD timing and Appendix E10.

1. **SOURCED/CORPORATE COMPONENTS.**

**8.1 Sourced Components:**

*N/A*

**8.1.1          Directed Buy and Purchased Components**

When sub-tiers are used (Tier 2, Tier 3, etc.), Tier 1 shall be fully accountable for sub-tier management, per CG4355 6.2 (as called on Appendix F18).

**8.2 Corporate Common Components:**

*N/A*

1. **SUPPLIER ON-SITE SUPPORT REQUIREMENTS.**

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| **FUNCTION** | **QUANTITY** | **TIMING** | **PERCENT ON-SITE** | **LOCATION** |
| Supplier Engineer | *1* | *Contract Award through End of Program* | *As required* | *GM Vehicle Engineering Center* |
| Program Manager | *1* | *Contract Award through End of Acceleration* | *As required* | *GM Vehicle Engineering Center* |

1. **other constraints or requirements.**

* **Risk Analysis and Review**

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* **Organic Coating**

The supplier must provide material certification and testing results per requirements of GMW14669 and/or GMW14671 for any parts specified with organic coating.

* **Burrs and Sharp Edges**

Burrs and sharp edges must be within industry standards. Reference GMW17533 for further information. Exceptions to this requirement will be listed below.

* **Required Pierce/Trim Die Direction -RRAB Zone and Tail Lamp Pocket Zones - *DOES NOT APPLY***

10.1 SOR QUOTE GUIDELINES

The following section lists the expected requirements for quoting.

1. All quotes must fully itemize piece cost and investment for parts and tools for each specified build event including set-up charges, checking fixtures, tooling aids, SLA’s, verification models and fixtures and assembly labor and timing for the assembly of any components specified as part content.
2. Supplier is expected to supply a tool line up including piece cost, investment, measurement plan, and body shop tooling plan for Tech Review. A manpower plan, describing resources and shop capacity is also expected. Manpower plan should include, but not limited to Program Manager, Engineering Contact, along with appropriate Manufacturing Engineers (Die Engineer, Body Shop Tool Engineer, etc.)
3. The Supplier must provide all information regarding assumptions made for this SOR (i.e. materials, tooling assumptions, timing and alternate materials and processes). It is recognized that suppliers may have alternate ideas that might result in investment, piece cost, mass and/or quality improvements. These should be submitted as a separate part of your quote response so they can be considered as part of the source selection decision. The quote must respond to the original SOR specifications. Quote shall include total cost for the DIW assembly and shipping.

### **10.1.1 Supplier Proposals**

Supplier may propose alternate designs for cost savings, improved performance, etc. If Supplier’s proposal is accepted, the Buyer and Supplier use the following paragraphs to better define responsibilities.

#### 10.1.1.1 Supplier Proposals for Manufacturing/Assembly Improvements

Changes must be approved in writing by Buyer (EWO). Supplier shall build to print and assume all responsibilities to meet the documented requirements and imperatives.

#### 10.1.1.2 Supplier Proposals for Performance/Material/Design Improvements

This paragraph shall apply when Buyer agrees to Supplier’s alternate designs or materials.

Supplier shall deliver designs and math models as needed for Buyer to conduct CAE analysis and will revise models as directed by Buyer. Supplier shall provide analysis models and results at no cost to Buyer for every iteration. Supplier shall provide validation parts free of charge until sufficient physical testing has been performed to demonstrate conformance to Buyer’s validation requirements. In the event Supplier’s design fails to perform to Buyer’s requirements, Supplier must tool Buyer’s design and deliver parts to the original schedule.

### **10.1.2 Supplier Requirement to Review Designs**

Supplier shall identify issues and offer solutions throughout the development cycle. Supplier must manage an open issues list throughout the development and launch of the program. Issues must be resolved prior to the Tool Kick Off Review. Changes required for manufacture of the parts and/or assemblies after the Tool Kick Off are the responsibility of Supplier to fund.

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10.2 COST OF CHANGES

Supplier is to submit quotation based on package as is. A list of “no-cost” changes requested by the supplier for manufacturability improvements should also be included. GM will approve or negotiate the “no cost changes” list.

Pull Ahead Production Tools to Supply Pre-Production Parts

For Pull Ahead Production Tools for Pre-Production Parts, GM will continue to refine the design of the part until TKO. At T-Release, the supplier will initiate the purchase of all tooling materials intended for the Pull Ahead Production Tooling.

The supplier is required to provide the buyer a tooling breakdown that describes the die line up with TKO changes. The supplier will provide any other detail (e.g. size of steel) that limits future possible part design changes. Increases in part size that do not increase the tool size and do not drive added tools, stations, and process or sub-component parts shall be “No-cost” for the tooling.

GM requires supplier PDT engagement and change management between TKO and final math.

Math changes between the T-Release and P-Release which affect the part blank size, are allowed to increase up to 10% in each direction at no additional tooling cost. Holes pierced in die direction are allowed to change or be added without additional cost. Material gauge changes shall have no impact to tooling cost. Material and product design changes will need to be assessed for cost impacts based on complexity of tool change (i.e. CR4 to DP600). Cost should only include resources to revise die design.

10.3 COST OF PRE-PRODUCTION PARTS

For any pre-production parts ordered by GM, the cost to GM will be at the production piece price inclusive of internal logistics, expendable packaging, and containers.

Quality loops and iterations are required to achieve dimensional requirements.

Additional set-up charges will not be paid due to expected dimensional quality requirement activity

10.4 PRE-PRODUCTION PART REQUIREMENTS

If Supplier is responsible to provide pre-production build parts, in addition to production parts, pre-production part submission must use PPQP (GM Pre-Production Part Quality Process). These parts will be used on pre-production and production vehicles. Therefore, these parts shall be subject to pre-production and production timing, MRD’s and quality requirements

Volumes shown below are estimates.  Official bucket MRDs and quantities will be provided by the Prototype Buyer.

PHS, Rails, Floors, Battery Enclosure and other large parts require Supplier’s prototype tooling to mimic the production assembly process.

PHS, Rails, Floors, Battery Enclosure and other large parts require use of a GM approved prototype tooling supplier, if prototype parts will not be manufactured in Supplier facility.

Supplier to assign a Lead Integrator to coordinate between all prototype and production activities.

***2028 T1XX-2 SUVS***

Part Names & Numbers: 85755810 & 85755811 (REINF-FRT S/D INR PNL MIR LH AND RH)

Tooling Type: PAPT

Volume:  Preliminary: 100 BIW pieces (includes miscellaneous builds)

Duration: approximately 10-15 weeks, with demand at 7-15 pieces per week

First Prototype MRD (IVB/PVVB):  *16-Mar-2026*

**\*Note: Critical parts cannot be built in advance of each MRD**

**10.5 PROTOTYPE BUILD LOCATION**

Prototype Build

Countries: USA

Prototype Build countries provided for reference and may be subject to change. Supplier shall refer to the RFQ Letter & GM1700 documents for prototype quotation requirements.

**10.6 FORMABILITY / MATERIAL UTILIZATION ANALYSIS**

Supplier to submit to releasing GM engineer a formability report which includes: the defined forming process, forming limit diagram, thinning plot, draw in diagram, panel break down (binder wrap, 3 & 6 mm off bottom visual minimum), Z displacement/Spring back data (Advanced High Strength Steel & Aluminum Parts). This report should be submitted prior to initiating die design, utilizing analysis tools that are comparable to Autoform or PamStamp. Supplier to validate formed parts to the analysis results.

Supplier to also submit to GM engineer, a material utilization / optimized blank nesting report. This report should be submitted prior to finalizing die design with time allowed to address and improve material utilization issues.

Formability showing required modifications to achieve ‘green’ statuson all parts from the supplier to be completed by MRD 0 - 34 weeks, product math released with EWOs completed by MRD 0 -30 weeks.

All studies and documentation become the property of General Motors and could be shared with suppliers in subsequent regions to support common learning around the globe.

**10.7 PRE-PRODUCTION AND LAUNCH PART QUALITY**

All parts that have not been PPAP approved and are shipped for pre-production builds are subject to both APQP and Production SQE part quality requirements. Pre-production parts must be approved through the PPQP process. Production parts must be approved through the GM SQ PPAP process.

**Manufacturing process and Tools:**

* All Pull Ahead Production Tool (PAPT) parts are expected to be made from production tools at the final PTB MRD. For earlier PTB MRD parts, additional tools or methods may be used to make parts to comply with design requirement targets.
* The pre-production parts do not need to be manufactured on homeline presses or at homeline facilities.
* The PTB checking strategy and check routines must be production intent.
  + For the beginning of PTB, a check fixture that meets GM Supplier Quality Phase 1 gage requirements and is approved by GM SQE is acceptable. Phase 1 gages are production intent gages with production datums and hold downs (clamps) present and are suitable for use as a holding fixture for scanning or CMM. (The checking fixture must be able to locate and constrain the part according to the datum strategy and leave access to the part for CMM or scanning).
  + The Phase 1 production gage must be used to provide required dimensional data for PTB part submissions until the Phase 2 completed production gage is available.
  + Phase 2 Production check fixtures/gages must be completed and used for dimensional verification of parts off the last PTB Quality Loop.
  + Checking strategy and routines must be off the approved production check fixtures for M1 / APPV MRD and later.
* Each supplier is required to make individual runs for each batch MRD delivery. Improved part quality for each delivery is expected using this process.

**Dimensional Quality Progression:**

The dimensional performance targets below must be achieved to ship parts to GM builds (without action plans).

The supplier must plan on 3 die quality loops during the PTB. To achieve quality progression parts should be batch produced. The dimensional quality of the parts off the production tools meet the minimum Production Process % in spec threshold requirement shown in the chart below. Additional set-up charges will not be paid due to expected dimensional quality requirement activity.

Refer to the PPQP manual for the current quality requirements for pre-production parts. Supplier will create a tool development plan to achieve 100% production tooling for the last IVB/PVVB quality loop and submit 1 month after TKO.



10.8 NON-THREADED SLEEVE AND TUBE SPACER REQUIREMENTS

Non-threaded sleeves and tube spacers shall be designed to meet the permanent compression requirements of GMW14676, Compression Properties of Metal Center Tubes and Contact Surfaces of Metal Parts with Bolt Through Holes.

**10.9 BALL STUD BRACKET REQUIREMENTS**

Ball stud reinforcement brackets must be tested and meet the requirements of CG2677 and/or CG2898.

**10.10 POA BAFFLE REQUIREMENTS**

Handling and shelf life for baffles POA to sheet metal assemblies.

1. All baffle assembly components should be retained during handling and shipping. (Example: pins should not fall out and be found in the bottom of packaging container).
2. All baffle assemblies should maintain design intent during shipping, handling, and installation (Example: features should be in design position and not bent or otherwise damaged).

**11.0 MATERIAL PROCUREMENT STRATEGY**

It is understood and agreed that the responsibility to procure material will rest on the supplier for all build events up to and including production.

1. At the tech review, supplier shall provide an initial assessment of their capability to acquire the specified materials.
   1. Tool-tune-in and early builds:
      1. Identify which grade / thickness / coating / coil width combinations that are expected to be a challenge to procure.
      2. Identify potential material sources that have confirmed capability to supply material in small try-out quantities.
      3. If difficulties are identified, explain strategy to support tool tune in, and meet all build MRDs on time with correct materials.
      4. Explain strategy and timing to get die tryout material to tool source in time to meet all requirements, particularly when tool source and material supplier are in different regions. Include, Purchase Order timing relative to first use.
   2. Production Requirements
      1. Identify which grade / thickness / coating / coil width combinations that are expected to be a challenge to procure.
      2. Identify potential material sources that have confirmed capability to supply the material at needed volumes.
      3. Explain sourcing strategy to address these difficulties to support regular production volumes.
2. At tool kick-off, supplier is required to provide to buyer’s PDT and Purchasing:
   1. Confirmation of plan to acquire material.
      1. Confirm plan discussed at tech review.
         1. Date Purchase Orders will be issued - add this date to APQP Plan.
         2. Date PASU will be submitted to Steel Resale (if applicable) - add this date to APQP Plan.
         3. Provide a complete list of materials (Grade/Thickness/Coating AND Coil Width or Blank Size) to be considered for Resale; include the Strategic AP Steel Resale Buyer (Pre-PASU).
         4. Provide the timing of material shipments from supplier in coordination with the build schedule – add these dates to APQP Plan
   2. Name and contact information for the stamping supplier’s person responsible for material coordination and execution of this plan.
3. If at any time significant issues jeopardize the sourcing strategy, escalate to GM buyer and SQE immediately.

**GMW3032, GMW3399** grades may require roller leveling (correcting coil set, center buckle, edge wave or bow) in addition to regular flattening for roll forming and progressive die operations or at blanking for stamped parts. Tension leveling is ineffective on CR1300T/1030Y-MS (greater than 1.0 mm gauge), CR1500T/1200Y-MS m (any gauge), or CR1700T/1350Y-MS (any gauge) and alters mechanical properties of other AHSS materials and shall not be required by the supplier without theapproval of the releasing GM Engineer. The supplier shall include detailed estimates in the quote.

**For GMW3032, HSLA grade steels only:** The supplier is responsible to determine usage of HR or CR substrate, based on the manufacturing location selected for the parts. It is expected that supplier will specify the lowest cost material required to make the part. For GMW3032 ‘LA’ variants with material gauges greater than 1.8 mm, supplier shall quote as HR material only, and exceptions require justification and appropriate GM engineering approval. Supplier shall include that information on any documents used for purchasing the steel (for example, MPS sheets, PASU forms, etc.).

**11.1ADDITIONAL REQUIREMENTS FOR ALL STAMPED PARTS.**

Supplier is responsible to fulfill all requirements of GMW17533.

11.2 COST OF MAINTAINING TOOLING

The supplier is responsible to maintain their process and tooling to insure parts meet requirements over the life of the part. Suppliers shall expect and plan for die wear caused by the stamping process. Dies can have a finite life after which some inserts / sections / dies may need to be replaced. The initial GM tooling purchase order will fund the first set and any replacement inserts / sections /dies will be the Supplier’s responsibility as part of the normal tooling maintenance costs within burden at the time of award. New inserts / sections / dies will require to have Full re-PPAP with Production Trial Runs (PTRs) run by the GM assembly plant.

**11.3 SUPPLIER DELIVERABLES**

1. Supplier shall provide product design features and criteria recommendations & manufacturing criteria to enable robust formability & manufacturing process
2. Supplier to provide design features and criteria recommendations for cost avoidance/reduction opportunities
3. Supplier to provide part optimization opportunities for improved performance (strength/ductility/corrosion), mass and cost.
4. Supplier to provide design features, criteria and process that will enable and support dimensional capability and quality requirements.
5. Supplier shall provide documentation of the entire process (for PHS, include furnace type, atmospheric controls, transfer equipment and time, Press size & tonnage, Dwell time, blank type -developed or not, draw/form die and any Pad or cam-type action required, Trim/pierce methods and quantity -die/laser, Laser Equipment and speed, shot cleaning method/media/size, etc.)
6. For PHS parts, all requirements of GMW14400 before and after thermal treatment must be fulfilled for the material itself and the delivered part.
7. For PHS parts, supplier is responsible to fulfill all requirements of GMW 16579, Material and Process Requirements for Press Hardened Steel and Stamping Suppliers. Suppliers are required to use steels that are approved by GM as listed in the MATSPC system. A change in steel suppliers is considered a significant process change and the stamping supplier will be required to have approval from the Production Part Approval Process (PPAP) before production begins.
8. For PHS parts, supplier is responsible to submit for each build phase of prototype, as well as production build phases, the thinning, hardness and tensile test reports of the part test locations identified and/or agreed upon with the GM SQA and/or Product Engineering of the parts.
9. TKO reconciliation to be completed for piece cost and investment by MRD 0 -44 weeks.
10. Manufacturability (including welding) process complete by MRD 0 – 30 weeks.
11. Failure to meet the deliverables will result in a PRR issued to the supplier for a lack of program management.
12. All EWO change requests will require a 2-week turnaround from the supplier to provide cost and timing back to Buyer for the changes requested, using the Visual Change Document when math data is not available.

**11.4 SUPPLIER RESPONSIBILITIES AFTER AWARD OF PRODUCTION TOOL/PART /ASSEMBLY CONTRACT**

1. Supplier to notify GM representatives of all Tier 2 suppliers (Name & Location) involved in Engineering, Tool build and Integration.
2. Supplier & GM to review & approve checking fixture concepts and datum coordination for all parts and assemblies
3. Supplier to have proven capability and equipment to electronically check and provide quality data of both the detail parts and assembly (CMM, White Light, Laser Scan, etc.)
4. Supplier to provide specialized “Launch team” support during any Installation, Tryout

& Production start-up of equipment and tooling for PHS parts and assemblies.

Team to consist of but not limited to ( Program & Production manager, Process, Quality, System & Tooling engineers)

1. Supplier to provide complete “Process Control Plans / PFEMA” of entire PHS process prior to first part submittal.

**11.5 APPROVED SOURCES FOR PHS STAMPINGS**

All press hardened steel (PHS) stamping suppliers (at any tier level) must receive Engineering qualification as an approved source per GMW16579. Only sources listed under this standard number have been qualified by Engineering as meeting the requirements of GMW16579.

**Appendix B SOR Program**

**Change Log**

This Change Log lists all approved changes implemented in this document since the last published version. For the original release of the document, the Change Log is empty.

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| **Paragraph Affected** | **Description of Change** | **Approver / Approval Date** | **Requester** | **Changes Included in Version** |
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**Appendix B SOR Template**

**Change Log**

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|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| **Paragraph Affected** | **Description of Change** | **Approver / Approval Date** | **Requester** | **Changes Included in Version** |
| Multiple | Updated template to global format | Chuck Jensen, 2/7/06 | J. Vieira | 005 |
| 10.4 | Added Material Utilization | Chuck Jensen 2/20/06 |  | 006 |
| 10.3 | Material Table | Chuck Jensen, 4/18/06 |  | 007 |
| 10.4 | Updated Material Utilization & Formability information | Linda Mank  3/31/09 |  | 008 |
| 2.0, 2.3,7.0 | Added MP Content and reference to Appendix E7 | Linda Mank  3/31/09 | K. Holland | 008 |
| 2.0, 2.3,7.0 | References to Appendix E7 change to Appendix W | Linda Mank 4/17/09 |  | 009 |
| 10.3 | Missing words that were cut off page added back into document | Linda Mank 4/7/10 |  | 010 |
| Header | Changed reference from General Motors Corporation to General Motors Company | Wendy Johnson 6/29/10 | GM Legal Staff | 7.4 (GDM) |
| Multiple,  New 10.5 | Updated part list template, added section 10.5 | Linda Mank  3/31/11 |  | 7.5 (GDM) |
| User Note | Note updated regarding appendix F10 | Linda Mank 5/4/11 | Jason Coryell | 7.6 (GDM) |
| Multiple | Updated to incorporate PHS early source specific part information | Linda Mank 8/5/11 |  | 7.7 (GDM) |
| 2.3 | Added optional AlSi coating callouts for PHS dry side parts | Linda Mank 9/26/11 |  | 7.8 (GDM) |
| 10.3 | Added timing for GVDP 5.1 | Linda Mank 9/30/11 |  | 7.9 (GDM) |
| 10.5.5 | Added direction for supplier selection of HR or CR for 3032LA materials | Linda Mank 10/13/11 | Luke Reini | 7.10 (GDM) |
| 10.4 | Added comment regarding sharing of formability learnings | Linda Mank 5/17/12 | Luke Reini | 7.11 (GDM) |
| 2.3, 10.5, 10.6 | Section 2.3, coating spec revised for zinc PHS, Section 10.5 renamed, original content moved to 10.6 | Linda Mank 9/12/12 |  | 7.12 (GDM) |
| 2.3 | Coating spec for zinc PHS revised back to 60G | Linda Mank 11/01/12 | Luke Reini | 7.15 (GDM) |
| 10.5 | Section 10.5, Attachment 1 – Author to include information on weld process & filler wire material type, if applicable | Linda Mank 11/13/12 | Dave Bohde | 7.17 (GDM) |
| 10.3 | User note regarding IVER prototype part requirements added | Linda Mank 12/12/12 | Wendy Johson | 7.18 (GDM) |
| 2.3 | PHS optional materials for Zinc coating removed | Linda Mank 04/09/13 | Luke Reini | 7.19 (GDM) |
| Multiple | Updated to reflect sourcing for entire programs architectural variants | Linda Mank  07/18/13 | Luke Reini | 7.20 (GDM) |
| 10.3 | Added comment to use Appendix M if supplier will be responsible to supplier prototype parts | Linda Mank 02/07/14 | Wendy Johnson | 7.21 (GDM) |
| 10.6 | Added threaded sleeve and tube spacer requirements note | Linda Mank 2/11/15 | Larry Russell | 7.23 (GDM) |
| 10.7, 11.2 | Added note for ball stud bracket requirements, added supplier responsibilities for formability, EWO response | Linda Mank 6/1/15 | Joel Nixon Luke Reini | 7.24 (GDM) |
| 10.3, 10.6 | Remove part submission reqmt’s, reference to appendix E10, revise callout to non-threaded sleeves | Linda Mank 11/23/15 | Carl Herter Larry Russell | 7.25 (GDM) |
| 11.0 | Added GMW17533 requirement | Linda Mank 2/1/2016 | Pat Lalama | 7.26 (GDM) |
| 2.2 | Added timing requirement for APPV | Linda Mank 9/16/2016 | Wendy Johnson | 7.27 (GDM) |
| 10.0 | Added pierce/trim direction requirements | Linda Mank 3/8/2017 | Orlando Lomo | 7.28 (GDM) |
| 2.3, 7.0 | Deleted 2.3, edited 7.0 as part number requirements now in Appendix B2 | Linda Mank 4.3.2017 |  | 7.29 (GDM) |
| 10.7 | Added CG2898 reference for ball stud | Linda Mank 4.4.2018 | PRD #1921655 | 7.30 (GDM) |
| 10.8 | Added GMW3032 LA material greater 1.8mm to be HR | Linda Mank 5/9/2018 |  | 7.32 (GDM) |
| 10.0, 11.5 | Updated die direction requirements, Added source comment for aluminum extrusions | Linda Mank 6/14/2018 | Art Raymond Structures ECT | 7.33 (GDM) |
| 10.0 | Added requirement for organic coating | Linda Mank 7/17/2018 | Validation | 7.34 (GDM) |
| 10.0 | Added Risk Analysis and Review | Linda Mank 4/3/2019 | Marvin Loucks | 7.35 (GDM) |
| 2.0 | Corrected reference to MP, Program header instructions | Linda Mank 4/29/2019 |  | 44.0 (GDM) |
| 11.5 | Removed section | Linda Mank 12/6/2019 | Sangeeta LaForges | 44.1 (GDM) |
| 7.0 | Removed successive variant language | Linda Mank 1/17/2020 | Sangeeta LaForges | 44.2 (GDM) |
| Multiple | Added PAPT content | Linda Mank 3/6/2020 |  | 44.3 (GDM) |
| 10.0 | Updated die direction information | Linda Mank 3/17/2020 | Art Raymond | 44.4 (GDM) |
| 2.2, 7.0, 10.0, 10.4, 10.6 | Updated timing chart and math data note. Added Burrs and Sharp Edges bullet, and added Pre-Production information. Removed welding standards note, covered in SQ docs. | Corinne Jenks 7/1/2021 | Sangeeta LaForges & Chuck Jensen | 44.5 (GDM) |
| 2.2,10.4 | Added PPAP gates, GA date, and submission requirements to Section 2.2 timing chart; Section 10.4 rewritten for pre-production part requirements; added baffle requirements as Section 10.9 and renumbered successive sections. | Linda Mank 11/23/2021 | Gjovan Gojcaj Sangeeta LaForgesChrista Cooper | 44.6 (GDM) |
| 10.0, 10.4, 10.6 | Updated DFMEA instructions, added PHS & large parts, added proto build location | Linda Mank 3/4/2022 | Marv Loucks Wendy Malone Michelle Janish | 44.7 (GDM) |
| 10.0 | Updated instructions to include Tail Lamp Pocket as an acceptable zone to control pierce direction | Linda Mank, 5/31/2022 | Josh Silberstein | 44.8 |
| 7.0 | Added note to add columns in Appedix B2 | Linda Mank 7/15/2022 | Wendy Malone | 44.9 |
| 7.0 | DRE instructions for TKO checklist | Linda Mank 12/8/2022 | Wendy Malone | 45.0 |