SEQUENCE PARTS RACK LABEL STANDARDS

(for Racks, Pallets, and other Carriers for Multiple Production Numbers)

For Models 164 and 251

MERCEDES-BENZ U.S. INTERNATIONAL, INC.

1 April 2004

HISTORY OF CHANGES – SEE PAGE 2

Contact Partner for questions:
W. Engelke (205)507-3344

William.engelke@mbusi.daimlerchrysler.com

History of Changes

Date	Change
1 APR 04	New document

Rack Label Standards

This application standard provides guidelines for the printing of Rack Labels. These labels shall be used in all cases where sequence parts are delivered to MBUSI on racks, pallets, or other carriers that hold more than one production number ("broadcast order"). The term *rack* is used to refer to whatever packaging device is being used (rack, pallet, etc.) to carry multiple production numbers.

The objectives of the rack label are as follows:

- To provide a tracking method so conveyance team members can verify they are picking the next required rack
- To specify the linefeed location as a check of the material and feedpoint
- To convey a list of the production numbers on the rack

IT IS THE RESPONSIBILITY OF THE SUPPLIER TO PROVIDE BAR CODED RACK LABELS THAT MEET THESE SPECIFICATIONS. STRICT ADHERENCE TO THESE SPECIFICATIONS WILL REDUCE IMPLEMENTATION COSTS AND INCREASE BENEFITS FOR BOTH THE SUPPLIER AND MBUSI.

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

Rack Label for 12 or Less Production Numbers on Rack

Refer to Exhibit 1. The numbers below refer to balloon codes on the exhibit. Up to 12 production numbers may be displayed on this rack label format. The label should be standard 8-1/2" by 11" stock paper. Do not print the italicized words "*EXHIBIT 1*".

1. Vendor name or logo.
2. Commodity.
3. Linefeed location. This will not change frequently, but should be configurable without recompiling software.
4. "Tracking #" followed by the last 3 digits of a continously increasing rack number that is tied to the linefeed location. That is, if the supplier sends parts to two different linefeed locations, the supplier must maintain two different counters.
5. Date printed, with date in format DD-MMM-YYYY using 3-character alphabetic month abbreviation.
6. Barcode of the rack number, in symbology Code 128. This should be the only barcode on the rack label in Code 128. The barcode shall contain the following data:
   a. Field identifier code L
   b. The lineside location where the part will be fed.
   c. A single space
   d. Field identifier code 6S (means multiple orders of one product type)
   e. The container tracking number

   An example of the data in a complete barcode would be: `LA1-D-12A 6S0000123890`

   You may use a maximum of 10 digits to track the container; the last three being shown in the human-readable Tracking #, item 4. The lineside location is the same as shown in item 3. There is no other human-readable equivalent of the barcode shown. You must maintain a separate tracking# for each lineside location you feed.
7. Shift number and production number of the order in that rack location, as provided by the triggering checkpoint message.
8. The supplier may use the rest of the space on the page for their own purposes.
9. Supplier name.

Rack Label for More Than 12 Production Numbers on Rack

Refer to Exhibit 2. Balloon codes are the same as in the above list. Up to 24 production numbers may be displayed on this rack label format. The label should be standard 8-1/2" by 11" stock paper. Do not print the italicized words "*EXHIBIT 2*".

EXHIBIT 1.

1	2	3	4	5
Door System	Linefeed Location **A1-D-12L**	Tracking# 890		Date 10OCT2004

Position	Shift No. Production No. (7)	(8)	(8)	(8)
1	31F123 1234567890	F: 123456-123 R: 123456-123		
2	31F123 1234567890	F: 123456-123 R: 123456-123		
3	31F123 1234567890	F: 123456-123 R: 123456-123		
4	31F123 1234567890	F: 123456-123 R: 123456-123		
5	31F123 1234567890	F: 123456-123 R: 123456-123		
6	31F123 1234567890	F: 123456-123 R: 123456-123		
7	31F123 1234567890	F: 123456-123 R: 123456-123		
8	31F123 1234567890	F: 123456-123 R: 123456-123		
9	31F123 1234567890	F: 123456-123 R: 123456-123		
10	31F123 1234567890	F: 123456-123 R: 123456-123		
11	31F123 1234567890	F: 123456-123 R: 123456-123		
12	31F123 1234567890	F: 123456-123 R: 123456-123		

Supplier: supplier name (9)

EXHIBIT 2.

(1)							
Door System (2)	Linefeed Location (3) **A1-D-12L**		Tracking# 890 (4)  (6)			Date (5) 10OCT2004	
Position	Shift No. Production No. (7)			Position	Shift No. Production No. (7)		
1	31F123 1234567890	(8)		**13**	31F123 1234567890	(8)	
2	31F123 1234567890			**14**	31F123 1234567890		
3	31F123 1234567890			**15**	31F123 1234567890		
4	31F123 1234567890			**16**	31F123 1234567890		
5	31F123 1234567890			**17**	31F123 1234567890		
6	31F123 1234567890			**18**	31F123 1234567890		
7	31F123 1234567890			**19**	31F123 1234567890		
8	31F123 1234567890			**20**	31F123 1234567890		
9	31F123 1234567890			**21**	31F123 1234567890		
10	31F123 1234567890			**22**	31F123 1234567890		
11	31F123 1234567890			**23**	31F123 1234567890		
12	31F123 1234567890			**24**	31F123 1234567890		
Supplier: supplier name (9)							