

# B-Phase/Ramp-up Ordering Ver. 1.8

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**Mercedes-Benz**  
U.S. International, Inc.

<b>Revision Level</b>	<b>Change Date</b>	<b>Reason for change, affected pages</b>	<b>Author</b>
1.4	05/10/2017	Initial creation	Scott White (extern), D. Kussmaul (SC/SCSI)
1.6	03/16/2018	Change storage locations to ULP: PAD1 = MAF1 PAD2 = HTRY PB1D = UB1T PB2D = UB2T PB3D = UB3T	D. Kussmaul (SC/SCSI)
1.7	3/23/2018	Adding ULP A1J3 and A2J3	D. Kussmaul (SC/SCSI)
1.8	08/16/2019	Update Daimler Supplier Portal Links	B. Yeager (ITO/PT)

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## **1 B-Phase Process Summary**

The purpose of this document is to clarify the new B-Phase/New Model Ramp-up Ordering process and enhance the information provided during the supplier training sessions. The key topics and information that will be discussed include: Germany B-Phase production orders, MBUSI – USA production/trial orders, new scheduling agreement numbering conventions, new B-phase storage locations and unloading points, delivery addresses, sample parts ordering (PPAP), training/testing parts, and EDI analysis/review (830 specifications). The last sections of the document include Frequently Asked Questions, an embedded excel file with all AMSupply storage locations and unloading points, and a helpful map of the Tuscaloosa facility defining the delivery gates.

## **2 B-Phase/Production Trial Ordering**

### **2.1 B-Phase Ordering (Germany)**

#### **2.1.1 Unloading Points**

Currently, all B-Phase orders received should be delivered to the LGI Logistics Group International in Bondorf, Germany. This is subject to change at any time so it's very important that you are in communication with your assigned MRP controller to align with any future changes. B-Phase parts that require shipping to Germany can be determined by the unloading point sent in the EDI release. Any unloading point that begins with "AF" is required to be shipped to the Germany LGI Logistics Group location. In the following sections below all the unloading points, storage locations, and delivery addresses are listed by part type.

#### **2.1.2 New Schedule Agreement Numbering Convention**

It is important to note that the schedule agreements number convention will be different. All EDI 830 releases that are for "AFX" unloading points will be sent with a unique "881XXXXXXX" schedule agreement numbering convention. The purpose of this is to separate out the different phases in the ramp up process, which are usually ordered for different dates. Those builds are usually called, for example, V167 BL3a, V167 BL4 or the production trials (PT1, PT2, PT3). It will be important to make sure you identify each 830 transmission by the part number, unloading point, storage location, and schedule agreement number. Each lot (builds) will have its own unique schedule agreement number that starts with "881".

Sequenced parts are excluded from this logic and will be ordered to the "55XXXXXXX" schedule agreement. That agreement number will also not change over the different builds.

### 2.1.3 Assembly Parts

The storage locations for assembly parts will have multiple unloading points. The purpose of this is to identify different phases in the ramp up process, which are usually ordered for different dates. Those builds are usually called, for example, V167 BL3a, V167 BL4.

The B-Phase (Germany) assembly parts unloading points, storage locations, and delivery addresses are listed below.

Unloading Point (ULP)	Storage Location	Description/Location	Destination/Delivery Address
<b>AFPA</b>	MAF1	BAULOS AF A	LGI Logistics Group International c/o LGI Deutschland GmbH Am Römerfeld 4+6 71149 Bondorf Germany
<b>AFPB</b>	MAF1	BAULOS AF B	
<b>AFPC</b>	MAF1	BAULOS AF C	
<b>AFPD</b>	MAF1	BAULOS AF D	
<b>AFPE</b>	MAF1	BAULOS AF E	
<b>AFPF</b>	MAF1	BAULOS AF F	
<b>AFPG</b>	MAF1	BAULOS AF G	
<b>AFPH</b>	MAF1	BAULOS AF H	
<b>AFPJ</b>	MAF1	BAULOS AF J	
<b>AFPK</b>	MAF1	BAULOS AF K	
<b>AFPL</b>	MAF1	BAULOS AF L	
<b>AFPM</b>	MAF1	BAULOS AF M	
<b>AFPN</b>	MAF1	BAULOS AF N	
<b>AFPR</b>	MAF1	BAULOS AF R	
<b>AFPQ</b>	MAF1	BAULOS AF Q	
<b>AFPS</b>	MAF1	BAULOS AF S	
<b>AFPT</b>	MAF1	BAULOS AF T	
<b>AFPU</b>	MAF1	BAULOS AF U	
<b>AFPV</b>	MAF1	BAULOS AF V	
<b>AFPW</b>	MAF1	BAULOS AF W	
<b>AFPX</b>	MAF1	BAULOS AF X	
<b>AFPY</b>	MAF1	BAULOS AF Y	
<b>AFPZ</b>	MAF1	BAULOS AF Z	

### 2.1.4 Bodyshop Parts

B-Phase (Germany) Bodyshop parts will be processed the same as assembly parts described above including the unloading points and storage locations utilized.

### 2.1.5 Sequenced Parts

B-Phase (Germany) sequenced part orders will be sent with the standard 55XXXXXXXXX numbering convention. No “881XXXXXXXX” schedule agreement numbers will be used.

The B-Phase (Germany) sequenced parts unloading points, storage locations, and delivery addresses are listed below.

Unloading Point (ULP)	Storage Location	Description/Location	Destination/Delivery Address
AFJ1	JAF1	B-PHASE JIS SIFI	LGI Logistics Group International c/o LGI Deutschland GmbH Am Römerfeld 4+6 71149 Bondorf Germany
AFJ2	JAF2	B-PHASE JIS SIFI SPLIT	
AFJ3	JAF3	B-PHASE JIS SIFI SPLIT	

## 2.2 Production Trial Ordering (MBUSI - USA)

The production trial orders can be identified in the EDI 830 releases by either the “T1XX” or “T2XX” unloading points. Production trial orders will also use the unique “881XXXXXXX” schedule agreement numbering convention to identify the ramp up part by lot/build for PD1....PD2...PD3. Please note, that a series part can be converted from a previously sent “55XXXXXXX” series order to a unique “881XXXXXXX” schedule agreement lot specific numbering convention.

Sequenced parts are excluded from this logic and will be ordered to the “55XXXXXXX” schedule agreement. That agreement number will also not change over the different builds.

### 2.2.1 Assembly Parts

The production trial orders assembly parts unloading points, storage locations, and delivery addresses are listed below.

Unloading Point (ULP)	Storage Location	Description/Location	Destination/Delivery Address
T1PA	HTRY	BAULOS PLANT 1 A	MLC Warehouse Gate #8 MLC Truck Gate 11069 M Class Blvd. Vance AL 35490
T1PC	HTRY	BAULOS PLANT 1 C	
T1PE	HTRY	BAULOS PLANT 1 E	
T1PG	HTRY	BAULOS PLANT 1 G	
T1PJ	HTRY	BAULOS PLANT 1 J	
T1PL	HTRY	BAULOS PLANT 1 L	
T1PN	HTRY	BAULOS PLANT 1 N	
T1PQ	HTRY	BAULOS PLANT 1 Q	
T1PS	HTRY	BAULOS PLANT 1 S	
T1PU	HTRY	BAULOS PLANT 1 U	
T1PW	HTRY	BAULOS PLANT 1 W	
T1PY	HTRY	BAULOS PLANT 1 Y	
T2PA	HTRY	BAULOS PLANT 2 A	
T2PC	HTRY	BAULOS PLANT 2 C	
T2PE	HTRY	BAULOS PLANT 2 E	

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<b>T2PG</b>	HTRY	BAULOS PLANT 2 G	
<b>T2PJ</b>	HTRY	BAULOS PLANT 2 J	
<b>T2PL</b>	HTRY	BAULOS PLANT 2 L	
<b>T2PN</b>	HTRY	BAULOS PLANT 2 N	
<b>T2PQ</b>	HTRY	BAULOS PLANT 2 Q	
<b>T2PS</b>	HTRY	BAULOS PLANT 2 S	
<b>T2PU</b>	HTRY	BAULOS PLANT 2 U	
<b>T2PW</b>	HTRY	BAULOS PLANT 2 W	
<b>T2PY</b>	HTRY	BAULOS PLANT 2 Y	

### 2.2.2 Bodyshop Parts

The production trial orders for Bodyshop parts will be processed the same as assembly parts described above, **except** they will have separate unloading points and storage locations assigned.

Unloading Point (ULP)	Storage Location	Description/Location	Destination/Delivery Address
B1TA	UB1T	BAULOS BODY 1 A	MBUSI West Gate Gate #20 West Gate 10770 Daimler Benz Blvd. Vance, AL 35490
B1TC	UB1T	BAULOS BODY 1 C	
B1TE	UB1T	BAULOS BODY 1 E	
B1TG	UB1T	BAULOS BODY 1 G	
B1TJ	UB1T	BAULOS BODY 1 J	
B1TL	UB1T	BAULOS BODY 1 L	
B1TN	UB1T	BAULOS BODY 1 N	
B1TQ	UB1T	BAULOS BODY 1 Q	
B1TS	UB1T	BAULOS BODY 1 S	
B1TU	UB1T	BAULOS BODY 1 U	
B1TW	UB1T	BAULOS BODY 1 W	
B1TY	UB1T	BAULOS BODY 1 Y	
B2TA	UB2T	BAULOS BODY 2 A	
B2TC	UB2T	BAULOS BODY 2 C	
B2TE	UB2T	BAULOS BODY 2 E	
B2TG	UB2T	BAULOS BODY 2 G	
B2TJ	UB2T	BAULOS BODY 2 J	
B2TL	UB2T	BAULOS BODY 2 L	
B2TN	UB2T	BAULOS BODY 2 N	
B2TQ	UB2T	BAULOS BODY 2 Q	
B2TS	UB2T	BAULOS BODY 2 S	
B2TU	UB2T	BAULOS BODY 2 U	
B2TW	UB2T	BAULOS BODY 2 W	
B2TY	UB2T	BAULOS BODY 2 Y	
B3TA	UB3T	BAULOS BODY 3 A	
B3TC	UB3T	BAULOS BODY 3 C	
B3TE	UB3T	BAULOS BODY 3 E	
B3TG	UB3T	BAULOS BODY 3 G	
B3TJ	UB3T	BAULOS BODY 3 J	
B3TL	UB3T	BAULOS BODY 3 L	
B3TN	UB3T	BAULOS BODY 3 N	
B3TQ	UB3T	BAULOS BODY 3 Q	
B3TS	UB3T	BAULOS BODY 3 S	
B3TU	UB3T	BAULOS BODY 3 U	
B3TW	UB3T	BAULOS BODY 3 W	
B3TY	UB3T	BAULOS BODY 3 Y	

### 2.2.3 Sequenced Parts

The production trial orders for sequenced parts unloading points, storage locations, and delivery addresses are listed below.

Please Note: Production trial orders for sequenced parts can be delivered in sequence directly to the line or in a batch job to storage location. It will be very important that you are in communication with your assigned MRP controller, so you can align with the requirement.

Unloading Point (ULP)	Storage Location	Description/Location	Destination/Delivery Address
A1J1	JA11	JIS TO A1	MBUSI Gate #6 East Truck Gate 10999 M Class Blvd. Vance AL 35490
A1J2	JA12	JIS TO A1 (FOR JIS SPLITT)	
A1J3	JA13	JIS TO A1 (FOR JIS SPLITT)	
A2J1	JA21	JIS TO A2	
A2J2	JA22	JIS TO A2 (FOR JIS SPLITT)	
A2J3	JA23	JIS TO A2 (FOR JIS SPLITT)	

### 3 Sample Parts Ordering (PPAP)

PPAP parts are ordered free of charge for testing purposes. They will be ordered on a “56XXXXXXX” scheduling agreement numbering convention.

Unloading Point (ULP)	Storage Location	Description/Location	Destination/Delivery Address
T1M2	MSP1	(DIRECT) DELIVERY TO SMP	MBUSI Gate #6 East Truck Gate 10999 M Class Blvd. Vance AL 35490
564	MSP2	PPAP PARTS SINDELFFINGEN	Daimler AG Werk Sindelfingen Building 3/7 Abladestelle 564 GPEC D71059 Sindelfingen

### 4 Training Parts/Testing Parts (PPS)

PPS parts are ordered for testing or training purposes. These parts are ordered to a separate storage location to exclude them from the regular production relevant inventory.

Unloading Point (ULP)	Storage Location	Description/Location	Destination/Delivery Address
T1M4	MPS1	Pre-Production Parts Delivery to MBUSI	MBUSI Gate #6 East Truck Gate 10999 M Class Blvd. Vance AL 35490



<b>T1M5</b>	MPS2	Pre-Production Parts Delivery to Germany	LGI Logistics Group International c/o LGI Deutschland GmbH Am Römerfeld 4+6 71149 Bondorf Germany
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## 5 Frequently Asked Questions

1) Are we correct in our understanding of the following: one part number with a different combination of unloading point (ULP) and storage location will have always a different Schedule Agreement (SA)?

**Answer:**

When we are looking at the 881XXXXXXX (example of one of yours: 8810003911) schedule agreement numbers, that is correct. Once a certain production phase in the ramp up process (see question 5) is completed, the unloading point (ULP) can be used again for a later-build production phase with a different SA. In the series process the 55XXXXXXX SAs can have multiple SA items with different ULPs. The 55XXXXXXX SA number is usually never changing (may change in very rare situations and must be communicated by the MRP controller). The ULP on the 55XXXXXXX SA item can change but the SA number remains.

2) Within a shipment can we mix part numbers with different ULP values?

**Answer:**

That is possible in certain cases, but should be aligned with the MRP controller. That is a material flow topic and can be changing. If Material has the same storage location then usually that is possible. But for the shipment multiple ASNs must be sent because an ASN can only have 1 ULP.

3) Within a shipment can we mix part numbers with different Storage Location values?

**Answer:**

Same as 2 - should be aligned with the MRP controller. The ASN must be sent per ULP.

4) Does each combination of ULP and Storage Location require a separate shipment/ASN?

**Answer:**

The ASN must be sent per ULP. The shipment (paperwork) must be per ULP.

5) If within the lot the order date or quantity is changing, it will be reused. However, if we order a new lot, there will be a new SA#. Please explain what you mean by "Lot"? 1 lot = 1 delivery? Are we going to have a different SA by each delivery or will the same SA be used for some months or one year?

**Answer:**

With a lot I mean the different phases in the ramp up process, which are usually ordered for different dates. Those builds are usually called, for example, V167 BL3a, V167 BL4 or the production trials (PT1, PT2, and PT3).

6) Can you confirm these parts in Ramp-up will always have the Schedule Agreement (SA) start with '88'?

**Answer:**

Yes, with the current process we are ordering the ramp up parts with 881XXXXXXX schedule agreement numbers. Once we begin ordering parts in the series process we use the 55SA. Also, you will receive forecast on the 55SA for ramp-up. That forecast will go away once the ramp up order (88SA) is placed. If the forecast remains and no 88SA is sent, you must ship what is required on the 55SA.

7) When we receive a trial order with parts & SA# starting with "88XXXXXXXX" for Storage Location "HTRY" and unloading point "T1PA". Are these parts also in ramp-up and should we prepare the shipments separately considering that they have different SA#'s?

**Answer:**

Please refer to section 2.2 Production Trial Ordering (MBUSI – USA). Please note that only sequenced parts will be ordered with 55SAs with no changing SA numbers (no 88SA).

## 6 EDI Analysis/Review (830 specifications)

The link to the 830 EDI specification documents can be found and downloaded here>

<https://supplier-portal.daimler.com/docs/DOC-1473>

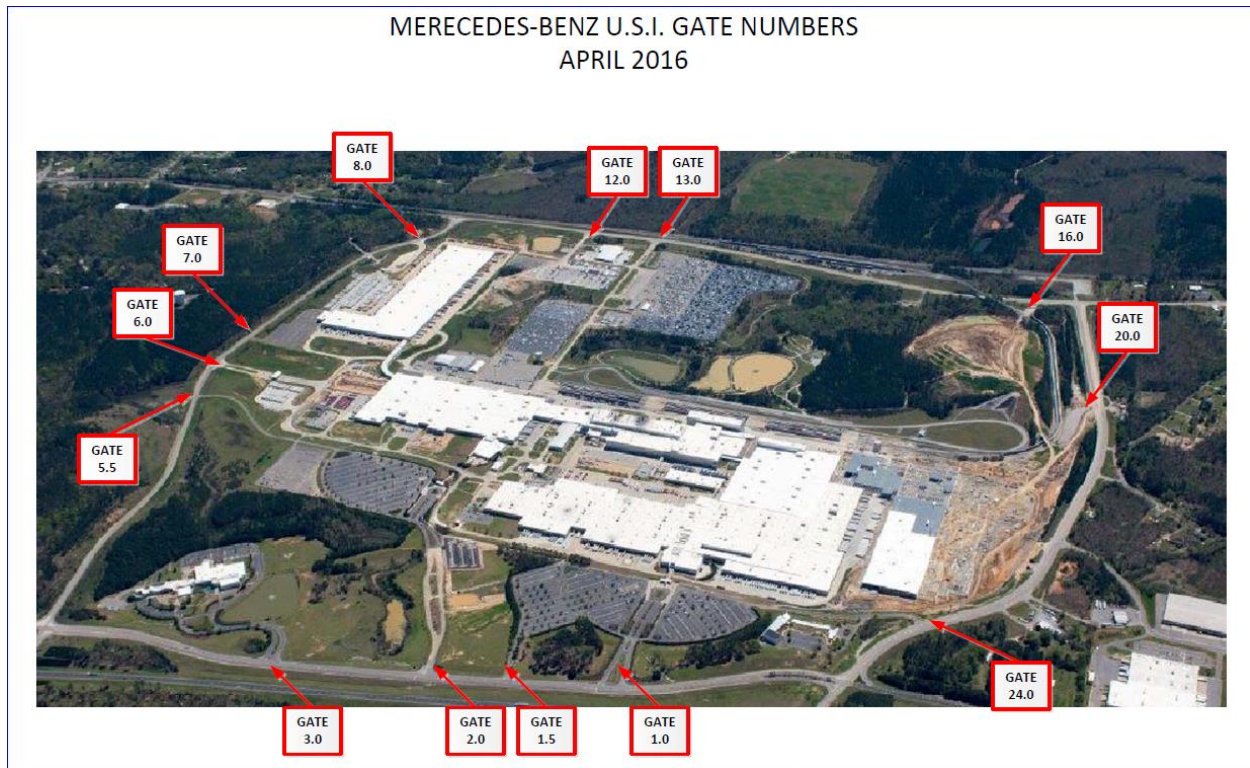
### Key Points to be aware of while reviewing the EDI 830 release for B-Phase/Ramp-up ordering:

- The EDI 830 specifications have NOT been changed for B-Phase/Ramp-up ordering releases. The specifications are the same as communicated during the R2C conversion.
- Due to multiple unloading points and unique schedule agreement numbers for B-Phase/Ramp-up ordering, it is important to extract/read the part number, schedule agreement number, storage location, & unloading point. Otherwise, you have the potential issue of wiping out demand for previously transmitted orders.
- As previously stated during the R2C conversion, **do not hard code** the part number, schedule agreement number, storage location, or unloading point.

## 7 All Unloading Point/Storage Location/Delivery Address Spreadsheet

- Please see separate attached file: ULPSLDelvall.xlsx

## 8 Tuscaloosa Gate Numbers



Gate	Description/Location	Destination/ Delivery Address
#1	Plant #1 Employee And Visitor Entrance/Exit	1 Mercedes Dr. Vance, AL 35490
#1.5	Plant #1 Employee Exit Only	2 Mercedes Dr. Vance, AL 35490
#2	Plant #2 Employee/Visitor Entrance/Exit	4 Mercedes Dr. Vance, AL 35490
#3	Mercedes Visitor Center/AIDT/Bill Taylor Institute	6 Mercedes Dr. Vance, AL 35490
#5.5	Plant #2 East Employee Entrance/Exit	10979 M Class Blvd. Vance AL 35490
#6	East Truck Gate	10999 M Class Blvd. Vance, AL 35490
#7	MLC Employee Entrance/Exit	11019 M Class Blvd. Vance AL 35490
#8	MLC Truck Gate	11069 M Class Blvd. Vance AL 35490
#12	South Construction Gate/South MLC Parking	10820 Hwy. 11 N. Vance AL 35490
#13	South Truck Gate/Central Stores/Finished Vehicle	17940 Hwy. 11 N. Vance AL 35490
#16	Railroad Service Entrance	Hwy. 11 N. Vance AL 35490
#20	West Construction Gate	10770 Daimler Benz Blvd. Vance, AL 35490
#24	Child Care Center / MAC / Family Wellness Center / West Team Member Entrance/Exit	10520 Daimler Benz Blvd. Vance, AL 35490
#30	Service and Parts Warehouse (not shown on map)	11146 Will Walker Rd Vance AL 35490