CHAPTER	SUB-CHAPTER	REQUIREMENT	CRITERION	Description - V6	WEIGHT V6		WEIGHT V7		Status (WORDING UNCHANGED ADDED MOVED)	Comment	Basic Profile
1				STRATEGY AND IMPROVEMENT		STRATEGY AND IMPROVEMENT			Unchanged		
1	1			Vision and Strategy		Vision and Strategy			Unchanged		
1	1	1		Requirement: The organization has a documented Supply Chain Management (SCM) vision and strategy. Why is this important? The organization's SCM vision and strategy should be a fundamental part of the overall business vision and strategy, even though it may already meet the required standard supporting customers. Vision and strategy develop a continual improvement culture to achieve a higher level of performance within a given timeframe. For SCM processes to be efficient and effective, the SCM vision, including MMOG/LE, should be acknowledged as an important part of the operation and resources allocated accordingly.		Requirement: The organization has a documented Supply Chain Management (SCM) vision and strategy. Why is this important? The organization's SCM vision and strategy is a fundamental part of the overall business vision and strategy, even though it may already meet the required standard supporting customers. Vision and strategy develop a continual improvement culture to achieve a higher level of performance within a given timeframe. For SCM processes to be efficient and effective, the SCM vision, including MMOG/LE, is acknowledged as an important part of the operation and resources allocated accordingly.			Wording		
1	1	1	1	There is a documented vision which includes an SCM strategy that supports the organization's overall business objectives. The strategy should incorporate customer requirements, continual improvement, and reviewed at planned intervals. The strategy is communicated to and understood by all employees within the organization.	F3	A documented vision and SCM strategy shall support the organization's overall business objectives. The strategy incorporates (as a minimum): • customer Requirements • continual Improvement • reviews at planned intervals The strategy is communicated to SCM employees.	F3		Wording & Format		X
1	2			Environmental, Social and Governance (ESG)		Environmental, Social and Governance (ESG)			Unchanged		
1	2	1		Requirement: The organization has an Environmental, Social and Governance (ESG) program focusing on their expectations towards business ethics, working conditions, human rights, health and safety and environmental leadership. Why is this important? ESG programs are based on fundamental principles of social, environmental and governance responsibility that are consistent with applicable laws and international standards.		Requirement: The organization has an Environmental, Social and Governance (ESG) program focusing on topics such as business ethics, working conditions, human rights, health and safety and environmental leadership. Why is this important? ESG programs are based on fundamental principles of social, environmental and governance responsibility that are consistent with applicable laws, international standards and customer requirements			Wording		
1	2	1	1	In its strategic plan, the organization has taken into consideration ESG. ESG considers topics such as business ethics, environment, working conditions, health & safety, responsible supply chain management, human rights.	F1	In its strategic plan, the organization has taken into consideration ESG. ESG considers topics such as business ethics, environment, working conditions, health & safety, responsible supply chain management, human rights.	F2		Change weight		X
1	2	1	2	The SCM function is involved in ESG action plans (e.g. reduction of CO footprint of the transport chain, reduction of waste, sustainable packaging).	F1	The SCM function is involved in ESG action plans (e.g. reduction of CO2 footprint of the transport chain, reduction of waste, sustainable packaging).	F1		Wording		
1	3			Objectives and Indicators		Objectives and Indicators			Wording		
1	3	1		Requirement: There is a process in place to define SCM objectives. Objectives should be measurable, communicated, reviewed and understood within the organization. Why is this important? SCM objectives should define the deliverables necessary to achieve the strategy in terms that can be quantified and measured and can provide a focus for departments and employees to prioritize improvement activities. Key objectives could include customer satisfaction, waste elimination, and internal and external supply chain performance.		Requirement: There is a process in place to define SCM objectives. Objectives are measurable, communicated, reviewed and understood within the organization. Why is this important? SCM objectives define the deliverables necessary to achieve the strategy in terms that can be quantified and measured and provide a focus for departments and employees to prioritize improvement activities. Key objectives could include customer satisfaction, waste elimination, and internal and external supply chain performance.			Wording		
1	3	1	1	Objectives are documented, specific, measurable, achievable, realistic, timely and consistent with the organization's SCM strategy. The objectives should be considered when the organization establishes its annual SCM plan and should be clearly communicated to all levels of the organization.	F2	Objectives are documented, specific, measurable, achievable, realistic, timely and consistent with the organization's SCM strategy. The objectives are considered when the organization establishes its annual SCM plan and are: • clearly communicated to all levels of the organization • reviewed with top management at planned intervals	F2		Wording & Merged	Merged 1.3.1.1 with 1.3.1.2	X

1	3	2		Requirement: The organization shall have Key Performance Indicators (KPIs) in place for key areas of the SCM process that support meeting the organization's business objectives, customer requirements and to drive the continual improvement process. Why is this important? Defining, collecting, and analyzing KPI data are important for the organization to measure and assess the efficiency and effectiveness of the supply chain operations. This process helps identify and correct deficiencies in order to achieve the organization's business objectives and support customer satisfaction.		Requirement: The organization has Key Performance Indicators (KPIs) in place for key areas of the SCM process that support meeting the organization's business objectives, customer specific requirements (CSRs) and to drive the continual improvement process. Why is this important? Defining, collecting, and analyzing KPI data are important for the organization to measure and assess the efficiency and effectiveness of the supply chain operations. This process helps identify and correct deficiencies in order to achieve the organization's business objectives and support customer satisfaction.			Wording		
1	3	2	1	Customer supply chain performance indicators (e.g. customer performance rating, ASN accuracy and timeliness, ship-to-schedule, shipping discrepancies, corrective action report/problem report and resolution, production losses) shall be defined and measured.	F3	Customer supply chain performance indicators shall be defined and measured. (e.g. customer performance rating, ASN accuracy and timeliness, ship-to-schedule, shipping discrepancies, corrective action report/problem report and resolution, production losses)	F3		Wording		X
1	3	2	2	Supplier performance indicators (e.g. on-time delivery, receipt discrepancies, ASN accuracy) shall be defined and measured for suppliers, subcontractors, and service providers.	F3	Supplier performance indicators shall be defined and measured for suppliers, subcontractors, and service providers. (e.g. on-time delivery, receipt discrepancies, ASN accuracy)	F3		Wording		X
1	3	2	3	Internal performance indicators (e.g. build to schedule, scrap/rework, labor performance, labor effectiveness) shall be defined and measured. Customer specific requirements shall be considered when KPI s are developed.	F3	Internal performance indicators shall be defined and measured. (e.g. build to schedule, scrap/rework, labor performance, labor effectiveness)	F3		Wording		X
1	3	2	4	Lead times for all supply chain processes within the organization s responsibility (e.g. procurement, manufacturing, transport, schedule preparation) are defined and measured, including standard and expedited lead-times.	F2	Standard and expedited lead times for all supply chain processes are defined and measured. (e.g. procurement, manufacturing, transportation, planning, scheduling, etc.).	F2		Wording		X
1	3	2	5	Indicators are defined to measure the quality of work within SCM processes that specifically include indicators monitored by the customer business process (e.g. incorrect/missing documentation, IT system downtime, EDI error messages, packaging and labeling errors, on-time delivery, receipt discrepancies, ASN accuracy).	F2	Indicators are defined to measure the quality of SCM processes. (e.g. incorrect/missing documentation, IT system downtime, EDI error messages, packaging and labeling errors, receipt discrepancies, ASN accuracy).	F2		Wording		
1	3	2	6	Standard costs related to SCM processes (e.g. freight, labor, packaging) and extraordinary costs associated with inefficiencies (e.g. premium freight, overtime, damaged or alternative packaging) are identified and measured in order to be used in continuous improvement process.	F2	Supply chain costs are identified and measured for use in the continuous improvement process: • standard costs (e.g. freight, labor, packaging) • exceptional costs (e.g. premium freight, overtime, damaged or alternative packaging)	F2		Wording		X
1	4			Measurement, Analysis, and Action Plans		Measurement, Analysis, and Action Plans			Unchanged		
1	4	1		Requirement: The organization has a process in place for monitoring, measuring, and analyzing SCM performance indicators throughout the supply chain (e.g. internal, customer, and sub-supplier) on a regular basis to ensure customer satisfaction and that the organization s objectives are met. Why is this important? Regular review and analysis of indicators is essential to monitor progress and performance against objectives. Monitoring, measurement, and analysis of the SCM processes are necessary to demonstrate conformity and continually improve the organization s effectiveness.		Requirement: The organization has a process in place for monitoring, measuring, and analyzing SCM performance indicators throughout the supply chain (e.g. internal, customer, and sub-supplier) on a regular basis to ensure customer satisfaction and that the organization's objectives are met. Why is this important? Regular review and analysis of indicators is essential to monitor progress and performance against objectives. Monitoring, measurement, and analysis of the SCM processes are necessary to demonstrate conformity and continually improve the organization's effectiveness.			Wording		
1	4	1	1	Performance against objectives is measured and reviewed with top management and communicated to all relevant personnel/functions/supply chain partners at planned intervals. Graphical analysis tools (e.g. pareto charts) displaying historical and trend data are used to track key metrics over time.	F2	Performance against objectives is measured and reviewed with top management and communicated to all relevant personnel/functions/supply chain partners at planned intervals. Graphical analysis tools (e.g. pareto charts) displaying historical and trend data are used to track key metrics over time.	F2		Unchanged		X

1	4	2		Requirement: There is a process in place to document, implement, and verify the effectiveness of preventive and corrective actions for any deficiency within the SCM process. The timing and status of the corrective actions are reviewed with management to prioritize actions and provide the necessary resources to achieve the results. Why is this important? An effective corrective action process for supply chain issues prevents recurrence of the issue, thus avoiding extraordinary cost and improving customer satisfaction. Formally documenting the corrective action process provides a more controlled method for monitoring, implementing, and verifying the results of the corrective action.		Requirement: The organization has a documented problem solving and corrective action process for identifying, investigating, correcting, and preventing recurrence of SCM process deficiencies. The process includes containment, root cause analysis, corrective actions, effectiveness verification, and the application of lessons learned. Why is this important? An effective problem solving and corrective action process helps prevent recurrence of supply chain issues, avoiding extraordinary costs, improve customer satisfaction, and support continual improvement of SCM processes. Formally documenting the corrective action process provides a more controlled method for monitoring, implementing, and verifying the results of the corrective action.			Wording		
1	4	2	1	The organization shall have a documented process(es) for problem solving including: a) defined approaches for various types and scale of problems (e.g. late/inaccurate ASNs, late/missed shipments, BOM errors); b) containment, interim actions, and related activities necessary for control of nonconforming outputs; c) root cause analysis, methodology used, analysis, and results; d) implementation of systemic corrective actions, including consideration of the impact on similar processes; e) verification of the effectiveness of implemented corrective actions; f) reviewing and, where necessary, updating the appropriate documented information; (e.g. update work instructions, train personnel, poka-yoke); g) lessons learned should be applied to other relevant processes. Where the customer has specific prescribed processes, tools (e.g. 8D, A3), or systems for problem solving, the organization shall use those processes, tools, or systems unless otherwise approved by the customer..	**F3**	The organization shall have a documented process for problem solving and implementation of corrective actions including: • defined approaches for various types and scale of problems (e.g. late/inaccurate ASNs, late/missed shipments, BOM errors) • containment, interim actions, and related activities necessary for control of nonconforming outputs • root cause analysis, methodology used, analysis, and results • development, assignment, implementation and tracking of corrective actions, including consideration of the impact on similar processes • verification of the effectiveness of implemented corrective actions • reviewing and, where necessary, updating the appropriate documented information; (e.g. update work instructions, train personnel, poka-yoke) • lessons learned are applied to other relevant processes Where the customer has specific prescribed processes, tools (e.g. 8D, A3), or systems for problem solving, the organization shall use those processes, tools, or systems unless otherwise approved by the customer.	**F3**		Wording		X
1	5			Continual Improvement		Continual Improvement			Unchanged		
1	5	1		Requirement: There is a process in place that engages management, employees, and business partners in continually improving the efficiency and effectiveness of the SCM processes throughout the entire organization and with all supply chain partners. Why is this important? The deployment of improvement activities throughout the supply chain is necessary in order to increase efficiency, reduce waste and cost, and improve overall customer satisfaction. The objective is to develop a continual improvement culture in all supply chain partners so that the resulting processes are lean, stable, and sustainable.		Requirement: There is a process in place that engages management, employees, and business partners in continually improving the efficiency and effectiveness of the SCM processes throughout the entire organization and with all supply chain partners. Why is this important? The deployment of improvement activities throughout the supply chain is necessary in order to increase efficiency, reduce waste and cost, and improve overall customer satisfaction. The objective is to develop a continual improvement culture in all supply chain partners so that the resulting processes are lean, stable, and sustainable.			Unchanged		
1	5	1	1	A documented continual improvement process is in place and used throughout the entire organization with all supply chain partners. The supply chain improvement action plan emphasizes the reduction of process variation, risk and waste.	**F2**	A documented supply chain continual improvement process is in place and used throughout the entire organization and with all supply chain partners.	**F2**		Wording		
1	5	1	2	The organization's material flow is designed to minimize handling and transportation (e.g. one-piece flow, cellular manufacturing, use of milk runs, load consolidation). Lean techniques (e.g. value stream mapping) are employed to optimize the material flow for new and current parts and production processes.	**F1**	The organization's material flow is designed to minimize handling and transportation (e.g. one-piece flow, cellular manufacturing, use of milk runs, load consolidation). Lean techniques (e.g. value stream mapping) are employed to optimize the material flow for new and current parts and production processes.	**F1**		Format		
1	5	1	3	The continual improvement process encourages employees and all supply chain stakeholders to submit proposals for continual improvement and time is given to employees to actively participate in continual improvement activities.	**F1**	The continual improvement process encourages employees and all supply chain stakeholders to submit proposals for continual improvement. Time is given to employees to actively participate in continual improvement activities.	**F1**		Wording		

1	5	1	4	The organization leverages an advanced technology supply chain project (e.g., IoT, machine learning, data lakes, augmented reality, blockchain) to improve outcomes such as shop floor digitization, improving supplier performance, delivering comprehensive traceability, reducing skills gap, safeguarding manufacturing, etc.	F1	The organization leverages advanced technologies (e.g. Artificial Intelligence (AI), Internet of Things (IoT), data lakes, augmented reality, robotics) to enhance supply chain skills, efficiency, productivity, and decision-making.	F1		Wording		
1	5	2		Requirement: There is a process in place to identify and analyze constraints that limit the organization s ability to optimize throughput. Actions are taken to reduce, minimize, or eliminate constraints. Why is this important? For organizations to remain competitive and reduce cost, specific areas of improvement need to be identified throughout the supply chain. Listed in the criteria below there are fundamental processes that should be evaluated by the SCM function as a minimum requirement. There may be additional constraints identified through the organization s internal assessment process and/or continual improvement indicators.		Requirement: There is a process in place to identify and analyze constraints that limit the organization's ability to optimize throughput. Actions are taken to reduce, minimize, or eliminate constraints. Why is this important? For organizations to remain competitive and reduce cost, specific areas of improvement need to be identified throughout the supply chain. Listed in the criteria below there are fundamental processes that are evaluated by the SCM function as a minimum requirement. There may be additional constraints identified through the organization's internal assessment process and/or continual improvement indicators.			Wording		
1	5	2	1	There shall be a process in place to identify and, where appropriate, manage constraining processes throughout the supply chain (e.g. production capacity, material flow analysis, labor, supplier) to maximize output while ensuring that production and delivery to the customer are not compromised.	F3	There shall be a process in place to identify and, where appropriate, manage constraining processes throughout the supply chain to maximize output while ensuring that production and delivery to the customer are not compromised. Constraining process can include production capacity, material flow, labor, supplier.	F3		Wording		X
1	5	2	2	Production batch/lot size and throughput times are evaluated on a regular basis and are adjusted accordingly in support of lean objectives.	F2	Production batch/lot size and throughput times are evaluated on a regular basis and are adjusted accordingly in support of lean objectives.	F2		Unchanged		
1	5	2	3	Set-up/change-over time is evaluated on a regular basis and is adjusted accordingly in support of lean objectives.	F1	Set-up/change-over time is evaluated on a regular basis and is adjusted accordingly in support of lean objectives.	F1		Unchanged		
1	6			Supply Chain Development and Collaboration		Supply Chain Development and Collaboration			Unchanged		
1	6	1		Requirement: There is a process in place to continually develop the relationship between partners in the supply chain. Why is this important? Successful supply chain relationships begin with mutual trust and respect. The development process should consider customer expectations as well as aspects of ESG such as social, environmental, economic, and legal requirements. Developing relationships relies on organizations working together for mutual benefit and reward for the medium and long term. The process provides a strong basis for responding to market conditions and increasing competitiveness by continually examining the use and introduction of new business techniques, processes, and technology.		Requirement: There is a process in place to continually develop the relationship between partners in the supply chain. Why is this important? Successful supply chain relationships begin with mutual trust and respect. Developing relationships relies on organizations working together for mutual benefit and reward for the medium and long term. The process provides a strong basis for responding to market conditions and increasing competitiveness by continually examining the use and introduction of new business techniques, processes, and technology.			Wording		
1	6	1	1	The organization has a processes and documented action plans in place for the continual development of relationships with supply chain partners. (e.g. Suppliers, subcontractors, service providers)	F2	The organization continuously evaluates and develops its relationships with all its supply chain partners (customers, suppliers, subcontractors, service providers) using formal methods of analysis. Evaluation techniques include Strengths Weaknesses Opportunities Threats [SWOT] analysis and Benchmarking.	F2		Wording & merged	merged with 1.6.1.2	
1	6	2		Requirement: There is a process in place to continually develop working relationships with other functions within the organization to ensure that overall business objectives are satisfied. Why is this important? Understanding, communicating, and satisfying the requirements of other functions are key elements for developing internal relationships in order to achieve business objectives and, ultimately, for improving external customer service. In a typical organization, other functions can be both an internal customer and a supplier. For example, Purchasing provides SCM with supplier purchase order information and SCM provides Purchasing with supplier performance indicators.		Requirement: There is a process in place to continually develop working relationships with other functions within the organization to ensure that overall business objectives are satisfied. Why is this important? Understanding, communicating, and satisfying the requirements of other functions are key elements for developing internal relationships in order to achieve business objectives and, ultimately, for improving external customer service. In a typical organization, other functions can be both an internal customer and a supplier. For example, Purchasing provides SCM with supplier purchase order information and SCM provides Purchasing with supplier performance indicators.			Unchanged		
1	6	2	1	There are procedures and/or work instructions in place to identify, record, and communicate internal customer and supplier requirements.	F2	There are procedures and/or work instructions in place to identify, record, and communicate internal customer and supplier requirements.	F2		Unchanged		

1	6	2	2	There is a process in place to continually develop working relationships between internal customers and suppliers. Internal customer satisfaction is measured, analyzed, and reviewed on a regular basis (e.g. internal service rate).	F2	There is a process in place to continually develop working relationships between internal customers and suppliers. Internal customer satisfaction is measured, analyzed, and reviewed on a regular basis (e.g. internal service rate).	F2		Format		
1	7			Risk Assessment and Development		Risk Assessment and Development			Unchanged		
1	7	1		Requirement: The organization s top management ensures that a risk management process is in place to assure continuity of supply when it is required to deviate from normal operations. Why is this important? An active risk management analysis process ensures the organization's and customer's requirements are supported during a deviation or disruption from normal business processes. The process should mitigate the risk for both planned and unplanned events.		Requirement: The organization's top management ensures that a risk management process is in place to assure continuity of supply when it is required to deviate from normal operations. Why is this important? An active risk management analysis process ensures the organization's and customer's requirements are supported during a deviation or disruption from normal business processes. The process mitigates the risk for both planned and unplanned events.			Wording		
1	7	1	1	A documented risk assessment process shall be in place to identify areas within the supply chain process that could affect the ability to meet the customer's requirements in the event of a deviation from the normal business process. This could include capacity analysis, pandemic, supplier risk, IT systems, cybersecurity, EDI, labor disruption, transportation, packaging, equipment failure, natural disasters, geopolitical event, etc.	F3	A documented risk assessment process shall be in place to identify areas within the supply chain process that could affect the ability to meet the customer's requirements in the event of a deviation from the normal business process. Risk examples include capacity, pandemics, suppliers, critical raw materials and components, IT systems, cybersecurity, EDI, labor disruption, transportation, packaging, equipment failure, natural disasters, geopolitical event, etc.	F3		Wording		X
1	7	1	2	The organization shall develop policies regarding supply chain cybersecurity threats. Typical supply chain cybersecurity activities for minimizing risks include buying only from trusted vendors, disconnecting critical machines from outside networks, and educating users on the threats and protective measures they can take, etc.	F3	The organization shall develop policies regarding cybersecurity threats which addresses risk avoidance and rapid recovery. Typically, cybersecurity activities in the Supply Chain include: security certification of data management (e.g. ISO27001 or equivalent), purchasing only from trusted third parties, preparing contingency plans, such as disconnecting critical machines from external networks, training users to combat potential threats and training in preventive actions, etc. The supplier works with the customer, as applicable, to support compliance with cybersecurity requirements, guidelines, and expectations.	F3		Wording		X
1	7	1	3	The organization s risk assessment process prioritizes which processes should be documented within the contingency/back-up procedures based on probability of occurrence, severity of the impact, detection, etc. The process could include the use of analytic tools as appropriate.	F2	The organization's risk assessment process prioritizes which processes are documented within the contingency/back-up procedures based on probability of occurrence, severity of the impact, detection, etc. The process includes the use of analytic tools as appropriate.	F2		Wording		
1	7	1	4	The organization proactively manages and reduces the level of risk identified during the assessment and prioritization process. (e.g.: amends existing cybersecurity plan based on latest prevention tools and techniques).	F1	The organization proactively reduces the level of risk identified during the assessment and prioritization process using preventive actions (e.g. amends existing cybersecurity plan based on latest prevention tools and techniques).	F2		Wording & Change weight		
1	7	2		Requirement: Back-up/contingency plans for high-risk and/or high impact SCM processes based on the risk assessment (e.g.: IT systems, equipment, transportation, troubled suppliers) are in place to ensure continuity of supply and a return to normal operations. Why is this important? An active risk management analysis process ensures the organization's and customer's requirements are supported during a deviation or disruption from normal business processes. The process should mitigate the risk for both planned and unplanned events.		Requirement: Backup/contingency plans for high-risk SCM processes, based on risk assessments, ensure continuity of supply and a controlled return to normal operations, including defined crisis exit processes and synchronization with supply chain partners. Why is this important? An active risk management process maintains business and customer requirements during disruptions by mitigating planned and unplanned risks, while a structured restart plan enables rapid recovery and prevents recurrence by accounting for supply chain lead times.			Wording		

1	7	2	1	The organization's back-up/contingency plans, based on the risk assessment, shall be documented and shall include, as a minimum, key internal/external contacts, containment actions, recovery steps to return to normal operations, and identification of key personnel responsible for execution.	F3	The organization's back-up/contingency plans, based on the risk assessment, shall be documented and shall include, as a minimum: • escalation plan for internal, customers and suppliers • key internal/external contacts • containment actions • recovery steps and confirmation of return to normal operations • identification of key personnel responsible for execution	F3		Wording		X
1	7	2	2	The organization periodically reviews, tests and validates its back-up/contingency plans and procedures. All relevant personnel are trained to ensure a successful execution. The organization incorporates lessons learned and/or incorporates corrective actions.	F3	There shall be processes in place to ensure the effectiveness of contingency plans including: • periodic reviews, tests, and validation of back-up and contingency plans and procedures • incorporating lessons learned and implementing corrective actions resulting from testing • ensuring all relevant personnel receive appropriate training to support successful plan execution	F3		Wording		X
1	7	2	3	In the event that a deviation or disruption occurs, the organization evaluates the effectiveness of the back-up/contingency plans and incorporates lessons learned and/or corrective actions as necessary.	F2	In the event that a deviation or disruption occurs, the organization evaluates the effectiveness of the back-up/contingency plans and incorporates lessons learned and/or corrective actions as necessary.	F2		Moved	Becomes to 1.7.2.3	X
1	7	2	4	There is a process in place to analyze and identify tolerable downtimes for IT systems involved in the supply chain, to ensure customer service levels are maintained. Based on the analysis, service levels are defined and maintained with internal and external IT partners. Maintenance and contingency plans exist to manage IT recovery time.	F2	To support supply-chain continuity, and customer service levels, the organization applies the following: • A documented process is used to analyze and define tolerable downtime for IT systems supporting the supply chain. • Based on this analysis, service level requirements with internal and external IT partners are defined and maintained. • Maintenance and contingency plans are established to manage and meet defined IT recovery time objectives.	F2		Wording & moved	Becomes 1.7.2.4	X
1	7	2	5	The organization maps its supply base in order to assess and critically manage potential risks such as natural disaster, geopolitical risk, trade war, port closure, etc.	F2	The organization maps its supply base in order to assess and critically manage potential risks such as natural disaster, geopolitical risk, trade war, port closure, etc. • The physical location of the supply base is known and maintained. • There is a process to monitor alerts and manage potential emergency impacts affecting the supply base.	F2		Wording & moved	Becomes 1.7.2.5	
1	7	2	6	The organization has a process that ensures that all instructions to be provided to suppliers are updated, to enable them to act in the event of problems, delays in delivery, or disruptions (e.g. alternative transport, alternative packaging, labelling, etc.).	F1	The organization establishes and communicates instructions to suppliers to ensure appropriate response to problems, such as delivery delays, or operational disruptions, (e.g. alternative transportation methods, packaging, or labeling , etc.).	F1		Wording		
2				WORK ORGANIZATION		WORK ORGANIZATION			Unchanged		
2	1			Organizational Processes		Organizational Processes			Unchanged		
2	1	1		Requirement: The organizational structure recognizes the importance within the business of supply chain management, SCM interfaces, and information and physical flows. Why is this important? It is vital to gain a clear understanding of the organizational structure and processes in order to provide a solid foundation for achieving customer satisfaction, internal strategies and objectives, and continual improvement.		Requirement: The organizational structure recognizes the importance within the business of supply chain management, SCM interfaces, and information and physical flows. Why is this important? It is vital to gain a clear understanding of the organizational structure and processes in order to provide a solid foundation for achieving customer satisfaction, internal strategies and objectives, and continual improvement.			Unchanged		
2	1	1	1	The organizational structure is documented and regularly reviewed to ensure there is sufficient focus and resource for all SCM processes.	F1	The organizational structure is documented and regularly reviewed to ensure supply chain process owners are identified and there is sufficient focus and resource for all SCM processes.	F1		Wording		
2	1	1	2	Documentation exists (e.g. flow charts) describing the physical/material and information flow of all SCM processes, including interfaces with customers, other internal functions, suppliers, subcontractors, and service providers.	F1	Documentation exists (e.g. flow charts) describing the physical/material and information flow of all SCM processes, including interfaces with customers, other internal functions, suppliers, subcontractors, and service providers.	F1		Unchanged		
2	2			Operating Procedures and Work Instructions		Operating Procedures and Work Instructions			Unchanged		

2	2	1		Requirement: SCM processes are documented and controlled in procedures and/or work instructions for key elements of the supply chain, including interfaces with customers, suppliers, and other internal/external partners. Why is this important? Procedures and/or work instructions that employees can follow supports consistent, reliable and sustainable processes and can be used for training new and/or back up personnel. Effective procedures and/or work instructions define the purpose of the task, responsibilities, resources, and when, where and how the task is to be executed.		Requirement: SCM processes are documented and controlled in procedures and/or work instructions for key elements of the supply chain, including interfaces with customers, suppliers, and other internal/external partners. Why is this important? Procedures and/or work instructions that employees can follow supports consistent, reliable and sustainable processes and can be used for training new and/or back up personnel. Effective procedures and/or work instructions define the purpose of the task, responsibilities, resources, and when, where and how the task is to be executed.			Unchanged		
2	2	1	1	Procedures and/or work instructions are evaluated and reviewed at regular intervals to ensure compliance with the SCM vision, strategies, objectives, and processes.	**F2**	Procedures and/or work instructions are evaluated and reviewed by process owners at regular intervals to ensure compliance with the SCM vision, strategies, objectives, and processes.	**F2**		Wording		X
2	2	1	2	Procedures and/or work instructions documentation is controlled as defined within the organization's Quality Management System (e.g. IATF 16949)	**F2**	Procedures and/or work instructions documentation is controlled as defined within the organization's Quality Management System (e.g. ISO 9001 / IATF 16949)	**F2**		Wording		
2	2	1	3	Procedures and/or work instructions exist for customer interface aspects of the SCM process (e.g. SCM agreements, capacity planning, customer order planning, stock control, packaging procedures, and transport management).	**F2**	The organization ensures procedures and work instructions are defined, maintained, and implemented for customer-interface SCM processes (e.g. agreements, capacity planning, order planning, stock control, packaging, and transport). These are available, clear, and followed in daily operations.	**F2**		Wording		X
2	2	1	4	Procedures and/or work instructions exist for internal aspects of the SCM process (e.g. assembly and production planning, scheduling, material handling, stock control, and warehousing including MRO inventory).	**F2**	The organization ensures procedures and work instructions are defined, maintained, and implemented for internal SCM processes (e.g. assembly and production planning, scheduling, material handling, stock control, and warehousing including MRO inventory). These are available, clear, and followed in daily operations.	**F2**		Wording		X
2	2	1	5	Procedures and/or work instructions exist for the interface with suppliers and other partners in the supply chain process (e.g. performance assessment, receipt of material, stock control, and requirement calculations).	**F2**	The organization ensures procedures and work instructions are defined, maintained, and implemented for supplier interface SCM processes (e.g. performance assessment, receipt of material, stock control, and requirement calculations). These are available, clear, and followed in daily operations.	**F2**		Wording		X
2	3			Resource Planning		Resource Planning			Unchanged		
2	3	1		Requirement: A process exists to ensure that adequate resources are in place and that availability and flexibility are assured. Why is this important? It is essential that resources (e.g. employees, IT systems, equipment) are optimized and adaptable to meet the requirements of all SCM operations.		Requirement: A process exists to ensure that adequate resources are in place and that availability and flexibility are assured. Why is this important? It is essential that resources (e.g. employees, IT systems, equipment) are optimized and adaptable to meet the requirements of all SCM operations.			Unchanged		
2	3	1	1	The organization has the ability to adapt its human resources in order to manage and balance workload (e.g. flexibility agreements, peak hours, avoid overtime as long term solution, absenteeism, and different industrial calendars) in compliance with customer requirements.	**F2**	The organization performs periodic and event-driven reviews (e.g., new product launches or demand shifts) to ensure sufficient capacity is available to meet customer requirements across all SCM processes. The review includes the allocation of physical resources (space and equipment) and workforce capacity.	**F2**		Wording & merged	Merge 2.3.1.1 & 2.3.1.2	X
2	3	2		Requirement: An internal communication process exists for notifying and reviewing any incidents or deviations from the supply plan. Why is this important? It is important to communicate potential disruptions or deviations from the supply plan with all relevant internal parties so that the extent of any problems can be assessed, contained, and an interim plan established to mitigate or minimize the impact.		Requirement: An internal communication process exists for notifying and reviewing any incidents or deviations from the supply plan. Why is this important? It is important to communicate potential disruptions or deviations from the supply plan with all relevant internal parties so that the extent of any problems can be assessed, contained, and an interim plan established to mitigate or minimize the impact.			Unchanged		
2	3	2	1	There is a process in place to formally review and communicate deviations from the supply plan (e.g. scheduling changes, quality issues) to all relevant parties (e.g. formal meetings, reports, documented alerts of part shortages).	**F2**	There is a process in place to formally review and communicate deviations from the supply plan (e.g. scheduling changes, quality issues) to all relevant parties (e.g. formal meetings, reports, documented alerts of part shortages).	**F2**		Unchanged		X
2	4			Work Environment and Human Resources		Work Environment and Human Resources			Unchanged		

2	4	1		Requirement: A process exists for the control and continual improvement of the work environment. Why is this important? People are the organization's main asset. Management is responsible for providing safe and healthy working conditions. The environment should provide a forum for effective communication through all levels of the organization.		Requirement: A process exists for the control and continual improvement of the work environment. Why is this important? People are the organization's main asset. Management is responsible for providing safe and healthy working conditions. The environment should provide a forum for effective communication through all levels of the organization.			Unchanged		
2	4	1	1	The working environment should be in compliance with the customers corporate social responsibilities.	F2	The working environment is in compliance with the customer's corporate social responsibility requirements.	F2		Wording		X
2	4	1	2	The organization performs regular reviews to ensure compliance with all applicable health and safety rules.	F2	The organization performs regular reviews to ensure compliance with all applicable health and safety rules.	F2		Unchanged		
2	4	1	3	Management is actively engaged in improving the work environment (e.g. 5S program, ergonomic principles).	F1	Management is actively engaged in improving the work environment (e.g. 5S program, ergonomic principles).	F1		Unchanged		
2	4	2		Requirement: The roles and responsibilities for each job function within the SCM department are clearly defined and documented. Why is this important? Clearly defined roles and responsibilities identify ownership of issues, improve customer satisfaction, and reduce the risk of conflict.		Requirement: The roles and responsibilities for each job function within the SCM department are clearly defined and documented. Why is this important? Clearly defined roles and responsibilities identify ownership of issues, improve customer satisfaction, and reduce the risk of conflict.			Unchanged		
2	4	2	1	Job descriptions for each job function within the SCM department are documented with clearly defined roles and responsibilities. Where applicable job descriptions should reference internal, customer, industry, and government/international requirements. Job descriptions are reviewed regularly and updated as required.	F2	Job descriptions for each job function within the SCM department are documented with clearly defined roles and responsibilities. Where applicable job descriptions reference internal, customer, industry, and government/international requirements. Job descriptions are reviewed regularly and updated as required.	F2		Wording & Format		X
2	4	2	2	Standardized work sheets are made available for all SCM personnel. (e.g. a. presented in the language(s) understood by the personnel responsible to follow them; b. include rules for operator safety).	F2	Standardized work instructions are made available in the language(s) understood by personnel and include rules for operator safety.	F2		Wording		X
2	4	3		Requirement: There is a process in place to identify current and required skills for each position and function within the SCM department. Why is this important? Identifying the required skills and qualifications assists human resources in selecting qualified candidates and is the basis for assessing employee competency and training needs. Understanding the competence gap is important to continually improve the capability and strength of the organization.		Requirement: There is a process in place to identify current and required skills for each position and function within the SCM department. Why is this important? Identifying the required skills and qualifications assists human resources in selecting qualified candidates and is the basis for assessing employee competency and training needs. Understanding the competence gap is important to continually improve the capability and strength of the organization.			Wording		
2	4	3	1	The effectiveness of each function is assessed to ensure the needs of the organization are met. The skills and qualifications required for each function within the SCM department are documented.	F1	The organization evaluates the effectiveness of each SCM function to ensure it meets organizational requirements. The necessary skills and qualifications, for each function are documented.	F1		Wording		
2	4	5	2	The current competency of each employee within the SCM department is documented and reviewed on a regular basis. There is a process in place to identify gaps between current and required competency.	F1	The current competency of each employee within the SCM department is documented and reviewed on a regular basis. There is a process in place to identify gaps between current and required competency.	F1		Moved	Becomes to 2.4.5.2	X
2	4	4		Requirement: A training and development plan exists for each employee in the SCM department, making sure all business requirements are met. Why is this important? A flexible and effective organization requires competent and knowledgeable personnel to support both internal and external customers in the event of any absence.		Requirement: A training and development plan exists for each employee in the SCM department, making sure all business requirements are met. Why is this important? A flexible and effective organization requires competent and knowledgeable personnel to support both internal and external customers in the event of any absence.			Unchanged		
2	4	4	1	There is a process in place to ensure that sufficient, fully trained employees are in place for all job functions including primary, new hires, contract, third party, relief coverage, and back-ups.	F3	There shall be a process in place to ensure that sufficient, fully trained employees are in place for all job functions including primary, new hires, contract, third party, relief coverage, and back-ups.	F3		Wording		X
2	4	4	2	There is a training management process in place. Training objectives are clearly defined within the SCM organization. Training plans are implemented and reviewed. There is a process in place to monitor the effectiveness of the training on a regular basis.	F1	There is a training management process in place which includes: • clearly defined training objectives • training plans implemented and periodically reviewed • monitoring training effectiveness on a regular basis	F1		Moved	Becomes 2.4.4.2	

2	4	4	3	Individual development plans exist for each employee including education opportunities. The organization regularly assesses development opportunities through internal, external, customer, and industry resources.	F1	Individual development plans exist for each employee including education opportunities. The organization regularly assesses development opportunities through internal, external, customer, and industry resources.	F1		Format & Moved	Becomes to 2.4.4.3	
2	4	5		Requirement: A process is in place to assess and improve employee motivation and performance within the SCM function. Why is this important? Managers should provide feedback on the employee's performance in order to recognize outstanding achievement and/or to take corrective actions when improvement is needed. The appraisal process is also an opportunity for the manager and employee to discuss issues that could improve performance in the entire organization.		Requirement: A process is in place to assess and improve employee motivation and performance within the SCM function. Why is this important? Managers provide feedback on the employee's performance in order to recognize outstanding achievement and/or to take corrective actions when improvement is needed. The appraisal process is also an opportunity for the manager and employee to discuss issues that could improve performance in the entire organization.			Wording		
2	4	5	1	There is a regular (minimum once a year) performance review process with the employee that includes an evaluation of their performance against department and the organization's objectives. Opportunities for professional development may also be discussed.	F1	Employees have a regular (at least yearly) performance review against personal, team and company goals. During the review, development needs and training are identified, and action plans are created as needed to support improvement and growth.	F1		Wording & Merged	Merged with 2.4.5.3 / 2.4.5.1 Becomes 2.4.5.1	
3				CAPACITY and PRODUCTION PLANNING		CAPACITY AND PRODUCTION PLANNING			Format		
3	1			Product Realization		Product Realization			Unchanged		
3	1	1		Requirement: The SCM function shall formally participate in, and sign off on, the Product Realization process (e.g. new product, engineering changes). Why is this important? The material organization is involved in each stage (e.g. quoting, engineering) of the Product Realization process (e.g. new product, engineering changes) to ensure that supply chain issues are addressed and parts are available for all phases of production (e.g. prototypes, preproduction, production).		Requirement: The SCM function formally participates in, and sign off on, the Product Realization process (e.g. new product, engineering changes). Why is this important? The material organization is involved in each stage (e.g. quoting, engineering) of the Product Realization process (e.g. new product, engineering changes) to ensure that supply chain issues are addressed and parts are available for all phases of production (e.g. prototypes, preproduction, production).			Wording		
3	1	1	1	The SCM function shall participate in the Product Realization process (e.g. new product, engineering changes) to ensure that all material planning and logistics requirements are considered (e.g. capacity, bill of material [BOM], routings, material flow, effectivity dates, supplier notification, scheduling, shipping).	F3	The SCM function shall participate in the Product Realization process (e.g. new product, engineering changes) to ensure that all material planning and logistics requirements are considered (e.g. capacity, bill of material [BOM], routings, material flow, effectivity dates, supplier notification, scheduling, shipping).	F3		Unchanged		X
3	1	1	2	There are procedures and/or work instructions in place for Product Realization (e.g. new product, engineering changes). The process is reviewed on a regular basis for effectiveness and potential improvements.	F2	There are procedures and/or work instructions in place for Product Realization (e.g. new product, engineering changes). The process is reviewed on a regular basis for effectiveness and potential improvements.	F2		Unchanged		
3	1	1	3	All internal and external stakeholders (e.g. Engineering, Production, suppliers, customer) are represented in the review process for Product Realization and Engineering Changes. The results are communicated to all stakeholders.	F1	All internal and external stakeholders (e.g. Engineering, Production, suppliers, customer) are represented in the review process for Product Realization and Engineering Changes. The results are communicated to all stakeholders.	F2		Change weight		
3	2			Capacity Planning		Capacity Planning			Unchanged		
3	2	1		Requirement: The organization periodically performs a comparison of its anticipated resources against the customer's long-term projections using contracted capacity volumes, forecasts, incoming projects, evolution of the industry and strategic business scenarios.(e.g. new materials, new technologies, new legislation, new suppliers, localization, globalization) Why is this important? Part of the strategic plan is to review requirements far enough in advance to ensure sufficient resources will be in place and to meet future business scenarios.		Requirement: The organization periodically performs a comparison of its anticipated resources against the customer's long-term projections using contracted capacity volumes, forecasts, incoming projects, evolution of the industry and strategic business scenarios.(e.g. new materials, new technologies, new legislation, new suppliers, localization, globalization) Why is this important? Part of the strategic plan is to review requirements far enough in advance to ensure sufficient resources will be in place and to meet future business scenarios.			Unchanged		
3	2	1	1	The organization has developed a strategic planning process including future business scenarios. SCM considerations have been taken into account (e.g. equipment requirements, internal/external capacities, infrastructure needs).	F2	The organization has developed a strategic planning process including future business scenarios. SCM considerations have been taken into account (e.g. equipment requirements, internal/external capacities, infrastructure needs).	F2		Unchanged		X

3	2	2		Requirement: The organization shall perform a comparison of its resources against the customer's short-, medium-, and long-term requirements for both production and service/spare parts. A process shall be in place that ensures prompt communication to the customer of any risk that could affect their operations. Why is this important? A major goal of the planning system is to review customer requirements far enough in advance to ensure sufficient resources are in place and to detect potential problems in meeting the demand for both production and service/spare parts. This process must occur in a timeframe that allows for corrective action and minimizes the impact to the customer.		Requirement: The organization compares its resources against the customer's short-, medium-, and long-term requirements for both production and service/spare parts. A process is in place that ensures prompt communication to the customer of any risk that could affect their operations. Why is this important? A major goal of the planning system is to review customer requirements far enough in advance to ensure sufficient resources are in place and to detect potential problems in meeting the demand for both production and service/spare parts. This process must occur in a timeframe that allows for corrective action and minimizes the impact to the customer.			Wording		
3	2	2	1	There shall be procedures and/or work instructions in place to review resources (e.g. employees, equipment) upon receipt of the production and service/spare parts forecasts and shipping schedules (e.g. 830/DELFOR/planning release and 862/DELJIT, 866/DELJIT/sequenced schedule) and notify the customer of any limitations in meeting the requirements.	F3	There shall be procedures and/or work instructions in place to: • review resources (e.g. employees, equipment) upon receipt of the production AND service/spare parts forecasts and shipping schedules (e.g. 830/DELFOR/planning release and 862/DELJIT, 866/DELJIT/sequenced schedule) • notify the customer of any limitations in meeting the requirements	F3		Format		X
3	2	2	2	The SCM function shall participate in the capacity management process throughout the product life cycle. The customer's requirements regarding capacity planning management and communication are understood, incorporated, managed, and reviewed regularly. (e.g.: customer/supplier contracted volumes, capacity planning systems, logistics, storage, container fleet size).	F3	The SCM function shall participate in the capacity management process throughout the product life cycle. The customer's requirements regarding capacity planning management and communication are understood, incorporated, managed, and reviewed regularly. (e.g. customer/supplier contracted volumes, capacity planning systems, logistics, storage, container fleet size).	F3		Format		X
3	2	3		Requirement: The organization s capacity planning process has the capability to ensure that the Production Part Approval Process (PPAP) requirements are available in a timely manner to support customer requirements. Why is this important? The organization s capacity planning process should account for production, service, and PPAP requirements, to ensure that all requirements are met.		Requirement: The organization's capacity planning process has the capability to ensure that the Production Part Approval Process (PPAP) requirements are available in a timely manner to support customer requirements. Why is this important? The organization's capacity planning process accounts for production, service, and PPAP requirements, to ensure that all requirements are met.			Wording		
3	2	3	1	PPAP requirements are incorporated into the capacity planning process and scheduled accordingly.	F1	The capacity planning process ensures: • PPAP requirements are incorporated into the capacity planning process and scheduled accordingly. • SCM representation (e.g. Scheduling, Production, Material Control) is included in PPAP reviews to resolve issues with meeting customer requirements.	F2		Wording & Merged & Change weight Merge	Merge with 3.2.3.2	
3	2	4		Requirement: The capacity planning process includes the review and management of running changes and phase-out parts. Why is this important? The proper management of running changes and phase-out parts avoids unnecessary cost such as the purchase and/or overproduction of materials that would be obsolete.		Requirement: The capacity planning process includes the review and management of running changes and phase-out parts. Why is this important? The proper management of running changes and phase-out parts avoids unnecessary cost such as the purchase and/or overproduction of materials that would be obsolete.			Unchanged		
3	2	4	1	A process is in place to manage running changes and phase-out parts, to ensure sufficient lead time to communicate within the entire supply chain (e.g. customer, suppliers, subcontractors, and service providers). The process ensures continuity of supply of the current part (e.g. inventory buffer).	F2	The capacity planning process ensures: • A process is in place to manage running changes and phase-out parts, to ensure sufficient lead time to communicate within the entire supply chain (e.g. customer, suppliers, subcontractors, and service providers). • There is continuity of supply of the current part (e.g. inventory buffer).	F2		Wording & Format		X

3	2	5		Requirement: As requirements for current production end and change to service/spare parts only, there is a process in place for SCM agreements to be reviewed and revised, as necessary, for operational parameters, packaging, and logistics. Why is this important? The organization recognizes that service/spare parts are equally as important as current production parts and should be managed to ensure all customer requirements are satisfied. The availability of service/spare parts also minimizes the inconvenience to the consumer whose vehicle is being serviced.		Requirement: As requirements for current production end and change to service/spare parts only, there is a process in place for SCM agreements to be reviewed and revised, as necessary, for operational parameters, packaging, and logistics. Why is this important? The organization recognizes that service/spare parts are equally as important as current production parts and are managed to ensure all customer requirements are satisfied. The availability of service/spare parts also minimizes the inconvenience to the consumer whose vehicle is being serviced.			Wording		
3	2	5	1	When requirements for current production end and change to service/spare parts only, there is a procedure and/or work instruction in place to ensure the contents of a SCM agreement (e.g., lead time, minimum order quantity, packaging, logistics) are reviewed and revised.	F2	When production transitions to service/spare parts only, ensure: • there is a defined procedure or work instruction to manage the transition • review and update of SCM agreement elements (e.g. lead time, minimum order quantity, packaging, logistics)	F2		Wording		X
3	2	5	2	The planning horizon and operational parameters (e.g. minimum order quantity, standard pack size, lead time) for service/spare parts are incorporated into the planning system to ensure customer requirements are met.	F1	The planning horizon and operational parameters (e.g. minimum order quantity, standard pack size, lead time) for service/spare parts are incorporated into the planning system to ensure customer requirements are met.	F2		Change weight & Moved	Move to 3.2.5.2	
3	2	5	3	As parts are moved from current production to service, purchase orders and other documents related to service/spare parts are reviewed to ensure customer requirements are met. Documented agreements (e.g. purchase order, Requirement of work, SCM agreement) are in place to ensure the supply of service/spare parts meets customer requirements.	F1	As parts transition from current production to service: • Purchase orders and other documents related to service/spare parts are reviewed to ensure customer requirements are met. • Documented agreements (e.g. purchase order, Requirement of work, SCM agreement) are in place to ensure the supply of service/spare parts meets customer requirements.	F1		Wording & Format & Moved	Move to 3.2.5.3	
3	3			Production Planning		Production Planning			Unchanged		
3	3	1		Requirement: A process shall exist to automatically integrate and synchronize production requirements and to maintain the parameters of the production planning system. Where systems external to the ERP system are utilized there shall be a robust process to ensure all data is synchronized. Why is this important? An effective production planning process integrates customer requirements with key operational parameters to support on-time delivery to the customer. The resulting plan should be both realistic and attainable.		Requirement: A process exists to automatically integrate and synchronize production requirements and to maintain the parameters of the production planning system. Where systems external to the ERP system are utilized, there is a robust process to ensure all data is synchronized. Why is this important? An effective production planning process integrates customer requirements with key operational parameters to support on-time delivery to the customer. The resulting plan is realistic and attainable.			Wording		
3	3	1	1	The production planning and scheduling system shall automatically integrate customer requirements when generating production schedules. It includes error checking and validation throughout the process.(e.g. invalid part number, purchase order or customer site, cumulative quantity disagreement, incorrect customer set-up, inventory levels, efficiency factor, production time, due date).	F3	The production planning and scheduling system shall automatically integrate customer requirements when generating production schedules. It includes error checking and validation throughout the process.(e.g. invalid part number, purchase order or customer site, cumulative quantity disagreement, incorrect customer set-up, inventory levels, efficiency factor, production time, due date).	F3		Unchanged		X
3	3	1	2	Operational parameters (e.g. transport time, lead times, inventory levels, packaging) and internal production requirements (e.g. supplier constraints, scrap rates, set-up times, lot sizes) shall be reviewed and integrated into the planning and production schedules.	F3	Operational parameters (e.g. transport time, lead times, inventory levels, packaging) and internal production requirements (e.g. supplier constraints, scrap rates, set-up times, lot sizes) shall be reviewed and integrated into the planning and production schedules.	F3		Unchanged		X
3	3	1	3	The impact of requirement changes on the production plan is reviewed in a timely manner.	F2	The impact of requirement changes on the production plan is reviewed in a timely manner.	F2		Unchanged		X
3	3	1	4	The operational parameters (e.g. transport time, lead times, inventory levels, packaging) for 'phase-out' parts are reviewed and adjusted in a timely manner to avoid production over-runs.	F1	The operational parameters (e.g. transport time, lead times, inventory levels, packaging) for 'phase-out' parts are reviewed and adjusted in a timely manner to avoid production over-runs.	F1		Unchanged		
3	3	1	5	There is a process to incorporate the customer's fabrication and material authorizations for phase-out parts so that the production planning system generates forecast and shipping requirements in accordance with customer requirements.	F1	There is a process to incorporate the customer's fabrication and material authorizations for phase-out parts so that the production planning system generates forecast and shipping requirements in accordance with customer requirements.	F1		Unchanged		

3	3	2		Requirement: The internal production planning process supports lean manufacturing through the use of pull systems that regulate the flow of material in a manufacturing process. Why is this important? Pull systems/Kanban control the flow of resources in a production process. They are demand driven production schedules based on consumption rather than forecasting. Implementing pull systems can help the organization to eliminate waste in handling and storing, and delivering product to the customer on time.		Requirement: The internal production planning process supports lean manufacturing through the use of pull systems that regulate the flow of material in a manufacturing process. Why is this important? Pull systems/Kanban control the flow of resources in a production process. They are demand driven production schedules based on consumption rather than forecasting. Implementing pull systems can help the organization to eliminate waste in handling and storing, and delivering product to the customer on time.			Unchanged		
3	3	2	1	Pull system concepts (e.g. Kanban, min-max) are used within the shop floor production planning process and where applicable extends to suppliers.	**F1**	Pull system concepts (e.g. Kanban, min-max) are used within the shop floor production planning process and where applicable extends to suppliers.	**F1**		Unchanged		
3	3	2	2	A process exists that uses forecast demand in the design of the pull system (e.g. Kanban loop and lot sizes) and the parameters are reviewed at appropriate intervals.	**F1**	A process exists that uses forecast demand in the design of the pull system (e.g. Kanban loop and lot sizes) and the parameters are reviewed at appropriate intervals.	**F1**		Unchanged		
3	3	3		Requirement: The Material Requirements Planning (MRP) incorporates the latest customer requirement into the production planning system. Why is this important? The MRP system **should** calculate schedules (e.g. production, shipping, supplier) based on the most current information available from the customer to ensure that any changes are processed in a timely manner.		Requirement: The Material Requirements Planning (MRP) incorporates the latest customer requirement into the production planning system. Why is this important? The MRP system calculates schedules (e.g. production, shipping, supplier) based on the most current information available from the customer to ensure that any changes are processed in a timely manner.			Wording		
3	3	3	1	The organization sets the timing and frequency of the Material Requirements Planning (MRP) system process to ensure most recent/optimum customer requirements are used.	**F3**	The organization shall set the timing and frequency of the Material Requirements Planning (MRP) system process to ensure the most recent customer requirements are used.	**F3**		Wording		X
3	4			Phase out parts		Phase-out parts			Wording		
3	4	1		Requirement: The organization has a process in place to manage inventories of phase-out parts (e.g. those affected by engineering changes and programs that are being phased out) with both supplier and customer to minimize obsolescence. Why is this important? During engineering change and product phase-out, it is imperative to know and respond to the level of stock in the whole supply chain to ensure customer requirements are met while avoiding the risk of obsolescence, waste, and cost.		Requirement: The organization has a process in place to manage inventories of phase-out parts (e.g. those affected by engineering changes and programs that are being phased out) with both supplier and customer to minimize obsolescence. Why is this important? During engineering change and product phase-out, it is imperative to know and respond to the level of stock in the whole supply chain to ensure customer requirements are met while avoiding the risk of obsolescence, waste, and cost.			Unchanged		
3	4	1	1	To minimize obsolescence, the organization has a process in place to manage physical inventories of phase-out parts for all stages (i.e. raw, WIP, finished goods).	**F3**	To minimize obsolescence, the organization shall have a process in place to manage physical inventories of phase-out parts for all stages (i.e. raw, WIP, finished goods).	**F3**		Wording		X
3	4	1	2	The organization has a process in place to manage phase-out parts with suppliers.	**F3**	The organization shall have a process in place to manage phase-out parts with suppliers.	**F3**		Wording		X
3	5			Systems Integration		Systems Integration			Unchanged		
3	5	1		Requirement: The organization electronically integrates delivery forecasts and shipping schedules using customer specified web-based tools (e.g. EDI, Web EDI, Web Portal). Why is this important? Electronic transfer of data eliminates manual data entry errors and increases efficiency by conveying schedule information more quickly through the supply chain, thus reducing reaction time and cost. The reduction of administrative tasks (e.g. re-keying customer schedules) allows resources to be more productive by working on other value-added activities.		Requirement: The organization electronically integrates delivery forecasts and shipping schedules using customer specified web-based tools (e.g. EDI, Web EDI, Web Portal). Why is this important? Electronic transfer of data eliminates manual data entry errors and increases efficiency by conveying schedule information more quickly through the supply chain, thus reducing reaction time and cost. The reduction of administrative tasks (e.g. re-keying customer schedules) allows resources to be more productive by working on other value-added activities.			Unchanged		

3	5	1	1	The organization automatically integrates delivery forecasts and delivery requirements (e.g. 830/DELFOR/planning releases and 862/DELJIT/shipping schedules, 866/DELJIT/sequenced shipping schedules) into the planning system, when available electronically from the customer. The automatic integration includes all sites involved in the manufacturing and shipping process to the customer, including warehousing and 3rd party facilities.	F3	The organization shall automatically integrate delivery forecasts and delivery requirements (e.g. 830/DELFOR/planning releases and 862/DELJIT/shipping schedules, 866/DELJIT/sequenced shipping schedules) into the planning system, when available electronically from the customer. The automatic integration includes all sites involved in the manufacturing and shipping process to the customer, including warehousing and 3rd party facilities.	F3		Wording & Format		X
3	5	2		Requirement: After integrating the customer order information and internal production requirements, the organization's planning and scheduling systems automatically creates and manages supplier schedules. Why is this important? Collecting customer and internal requirements in an integrated system, along with strong controls, should be driving the planning and scheduling process. Required adjustments are done in the planning system prior to generating supplier schedules.		Requirement: After integrating the customer order information and internal production requirements, the organization's planning and scheduling systems automatically creates and manages supplier schedules. Why is this important? Collecting customer and internal requirements in an integrated system, along with strong controls, drives the planning and scheduling process.			Wording		
3	5	2	1	The production planning system shall automatically create and manage supplier schedules.	F3	The production planning system shall automatically create and manage supplier schedules.	F3		Unchanged		X
3	5	2	2	The production planning system is synchronized with all relevant internal (e.g. financial reporting, shipping, timekeeping) and external (e.g. supplier schedules, LSP and LLP) systems.	F1	The production planning system is synchronized with all relevant internal (e.g. financial reporting, shipping, timekeeping) and external (e.g. supplier schedules, LSP and LLP) systems.	F1		Unchanged		
4				CUSTOMER INTERFACE		CUSTOMER INTERFACE			Unchanged		
4	1			Collaboration		Collaboration			Unchanged		
4	1	1		Requirement: The communication processes are defined and agreed between the customer and the organization. The methods of communication are documented and readily available, fully operational, and sustained between parties. Why is this important? The methods of communication for day-to-day operations should be fully defined and documented in order to clarify roles and responsibilities, expectations, and commitments and to avoid the possibility of misunderstandings and conflict. Ideally, the communication process should be defined in a materials management and logistics agreement (e.g. Automotive Supply Chain Management Agreement (ASCMA).		Requirement: The communication processes are defined and agreed between the customer and the organization. The methods of communication are documented and readily available, fully operational, and sustained between parties. Why is this important? The methods of communication for day-to-day operations are fully defined and documented in order to clarify roles and responsibilities, expectations, and commitments and to avoid the possibility of misunderstandings and conflict. Ideally, the communication process is defined in a materials management and logistics agreement (e.g. Automotive Supply Chain Management Agreement (ASCMA).			Wording		
4	1	1	1	There are procedures and/or work instructions that define the responsibilities, frequency, and content of communication with the customer. Communication requirements could be found in SCM agreements, supplier manuals, customer websites, etc.	F2	There are procedures and/or work instructions that define the responsibilities, frequency, and content of communication with the customer. Communication requirements are typically found in SCM agreements, supplier manuals, customer websites, etc.	F2		Wording		X
4	1	1	2	The customer's requirements are understood (e.g. schedule adherence, routing instructions, ASN performance), reviewed regularly, and communicated to the appropriate personnel.	F2	The customer's requirements are understood (e.g. schedule adherence, routing instructions, ASN performance), reviewed regularly, and communicated to the appropriate personnel.	F2		Unchanged		X
4	1	1	3	The organization provides its customer with a contact list that supports customer operations as required, including 24 hours/7 days support. The contact list comprises name, function, method of communication (e.g. office/mobile numbers, e-mail address, etc.), hours of availability, weekend and emergency contacts, and deputies/back-ups for each SCM function. The contact is able to communicate in the customer's preferred business language.	F1	The organization provides its customer with a contact list that supports customer requirements including 24 hours/7 days support. The contact is able to communicate in the customer's preferred business language. There is a process in place for reviewing and updating customer contact lists at regular intervals as defined by the customer.	F1		Wording & Merged	Merge with 4.1.1.4	
4	1	2		Requirement: The organization shall have a process to immediately communicate any potential problems (regardless of origin/responsibility), that could impact the customer's operation including a proposed corrective action. Why is this important? Notifying the customer immediately provides the parties with the opportunity to collaborate on a mutually acceptable solution to prevent interruptions in the delivery process.		Requirement: The organization has a process to communicate immediately any potential problems (regardless of origin/responsibility), that could impact the customer's operation, including a proposed corrective action. Why is this important? Notifying the customer immediately provides the parties with the opportunity to collaborate on a mutually acceptable solution to prevent interruptions in the delivery process.			Wording		

4	1	2	1	The organization shall use all customer's business systems as required (e.g. inventory management, container management, capacity planning, supplier portals, transport management).	F3	The organization shall use all customer's business systems as required (e.g. inventory management, container management, capacity planning, supplier portals, transport management).	F3		Unchanged		X
4	1	2	2	There shall be documented procedures and/or work instructions in place to notify the customer and respond immediately to any situation that could negatively impact the customer's operation, whether originated by the organization, customer, supplier, logistics provider, subcontractor, or other service providers. This process should include a) on what it will communicate; b) when to communicate; c) with whom to communicate; d) how to communicate; e) who communicates.	F3	There shall be documented procedures and/or work instructions in place to notify the customer and respond immediately to any situation that could negatively impact the customer's operation, whether originated by the organization, customer, supplier, logistics provider, subcontractor, or other service providers. This process defines: • what is to be communicated • when communication is required • with whom to communicate • how communication is to be conducted • who is responsible for communication	F3		Wording & format		X
4	1	2	3	Deviations from customer requirements (e.g. quantity, transportation mode, packaging) shall be resolved with the appropriate customer contact prior to shipment time. Backup packaging may be used based on customer specific requirements and approval.	F3	Deviations from customer requirements (e.g. quantity, transportation mode, packaging) shall be resolved with the appropriate customer contact prior to shipment time. Backup packaging may be used based on customer specific requirements and approval.	F3		Format		X
4	2			Packaging and Labeling		Packaging and Labeling			Unchanged		
4	2	1		Requirement: The organization shall have a process in place that ensures packaging solutions are agreed by all involved parties and that the labeling meets the customer's specification. Why is this important? Packaging and labeling solutions should support the efficient flow and identification of material. Effective packaging facilitates efficient storage, transportation, and accessibility of parts while providing protection and preventing deterioration. Labeling allows for visual identification of material and supports automated data entry, thus increasing the accuracy of data into the production planning and inventory management systems.		Requirement: The organization has a process in place that ensures packaging solutions are agreed by all involved parties and that the labeling meets the customer's specification. Why is this important? Packaging and labeling solutions support the efficient flow and identification of material. Effective packaging facilitates efficient storage, transportation, and accessibility of parts while providing protection and preventing deterioration. Labeling allows for visual identification of material and supports automated data entry, thus increasing the accuracy of data into the production planning and inventory management systems.			Wording		
4	2	1	1	The organization shall have a documented process to develop and define labeling and packaging solutions for standard and back-up packaging, including pack size, in conjunction with all involved parties and before the start of production. The process should define whether packaging is supplied by the customer or supplier.	F3	The organization shall have a documented process to develop and define packaging and labeling solutions. The process includes: • determination of packaging responsibility (e.g. customer or supplier) • standard and backup packaging solutions • definition of labeling requirements • validation with all involved parties (e.g. pre-production and PPAP) • formal customer sign-off prior to regular production	F3		Wording & Merged	Merge 4.2.1.1 & 4.2.1.2	X
4	2	1	2	The organization periodically conducts a physical review of shipments to ensure compliance with defined packaging and labeling requirements.	F2	The organization periodically conducts a physical review of shipments to ensure compliance with defined packaging and labeling requirements.	F2		Unchanged	Becomes 4.2.1.2	
4	2	1	3	All applicable manufacturing, storage, and shipping processes are considered when developing the customer packaging solution.	F1	All applicable manufacturing, storage, and shipping processes are considered when developing the customer packaging solution.	F1		Unchanged	Becomes 4.2.1.3	
4	2	2		Requirement: The organization has procedures and/or work instructions for the container management process to ensure availability of customer-approved containers (i.e. returnable and expendable) to support the material flow requirements. Why is this important? The organization tracks the quantity, quality, and location of containers to ensure that the customer-approved container is available at the right time, avoiding disruptions in the production and shipping process. An effective container management process/system can avoid extraordinary costs by preventing material damage, lost containers, and production down-time.		Requirement: The organization has procedures and/or work instructions for the container management process to ensure availability of customer-approved containers (i.e. returnable and expendable) to support the material flow requirements. Why is this important? The organization tracks the quantity, quality, and location of containers to ensure that the customer-approved container is available at the right time, avoiding disruptions in the production and shipping process. An effective container management process/system can avoid extraordinary costs by preventing material damage, lost containers, and production down-time.			Unchanged		
4	2	2	1	A process is in place and agreed by all parties for the procurement, allocation, and monitoring of all packaging material (e.g. returnable containers, expendable packaging, dunnage, spacers). The process includes an agreement for back-up packaging.	F2	A process is in place and agreed by all parties for the procurement, allocation, and monitoring of all packaging material (e.g. returnable containers, expendable packaging, dunnage, spacers). The process includes an agreement for back-up packaging.	F2		Format		X

4	2	2	2	There are procedures/work instructions in place to manage containers to ensure that the right quantity and quality (e.g. clean, undamaged, suitable) are available to meet customer requirements.	F2	There are procedures/work instructions in place to manage containers to ensure that the right quantity and quality (e.g. clean, undamaged, suitable) are available to meet customer requirements.	F2		Unchanged		X
4	2	2	3	The process ensures that customer-supplied packaging is properly stored and managed based on customer requirements.	F2	The process ensures that customer-supplied packaging is properly stored and managed based on customer requirements.	F2		Unchanged		
4	3			Shipping		Shipping			Unchanged		
4	3	1		Requirement: The organization has a shipping process that ensures dock operations are optimized and the quantity shipped reconciles with the customer's requirements. Why is this important? An efficient dock operation minimizes the risk of shipping errors. Missed or inaccurate shipments can result in premium freight and/or production disruption at the customer.		Requirement: The organization has a shipping process that ensures dock operations are optimized and the quantity shipped reconciles with the customer's requirements. Why is this important? An efficient dock operation minimizes the risk of shipping errors. Missed or inaccurate shipments can result in premium freight and/or production disruption at the customer.			Unchanged		
4	3	1	1	Dock operations are optimized taking into consideration capacity of preparation areas, rail docks, loading bays, limits of loading and unloading, freight capacity, scheduled window times, carrier on-time performance, etc.	F2	Dock operations are optimized taking into consideration capacity of preparation areas, rail docks, loading bays, limits of loading and unloading, freight capacity, scheduled window times, carrier on-time performance, etc.	F2		Unchanged		
4	3	1	2	Work instructions are in place that define the proper use of equipment used in the shipping process (e.g. scales, counters, scanners).	F2	Work instructions are in place that define the proper use of equipment used in the shipping process (e.g. scales, counters, scanners).	F2		Unchanged		
4	3	1	3	A detection system is in place to identify when items and/or quantities to be shipped do not match the customer's requirements. Discrepancies are investigated and resolved in a timely manner.	F2	A detection system is in place to identify when items and/or quantities to be shipped do not match the customer's requirements. Discrepancies are investigated and resolved in a timely manner.	F2		Format		X
4	3	2		Requirement: The organization shall have a process to ensure transport documents are completed according to customer, industry, and government/international standards. Additionally, Advanced Shipping Notices (ASNs) are accurate and transmitted in a timely manner. Why is this important? Accurate and timely documentation helps to avoid delays and extraordinary costs in the transportation of material, including any potential supply chain security and/or customs issues. ASNs transmit information required by the customer so they are aware of shipments that are in transit and are able to track, plan, and manage the receiving process.		Requirement: The organization has a process to ensure transport documents are completed according to customer, industry, and government/international standards. Additionally, Advanced Shipping Notices (ASNs) are accurate and transmitted in a timely manner. Why is this important? Accurate and timely documentation helps to avoid delays and extraordinary costs in the transportation of material, including any potential supply chain security and/or customs issues. ASNs transmit information required by the customer so they are aware of shipments that are in transit and are able to track, plan, and manage the receiving process.			Wording		
4	3	2	1	The shipping process shall ensure that all shipments, including documentation, shipping labels, and any additional labels (e.g. hazardous material, destination label, new model label) are prepared to customer, industry, and government/international standards and requirements (e.g. customs handling, C-TPAT, PIP, AEO) including carrier routings.	F3	The shipping process shall ensure that all shipments, including documentation, shipping labels, and any additional labels (e.g. hazardous material, destination label, new model label) are prepared to customer, industry, and government/international standards and requirements (e.g. customs handling, CTPAT, PIP, AEO/OEA) including carrier routings.	F3		Wording		X
4	3	2	2	The content of the shipping label shall be reconciled against the customer requirements at the last possible point in the shipping process. When master/mixed load labels are used, they shall be reconciled to the individual container labels.	F3	The content of the shipping label shall be reconciled against the customer requirements at the last possible point in the shipping process. When master/mixed load labels are used, they shall be reconciled to the individual container labels.	F3		Format		X
4	3	2	3	The data content of the shipping labels and/or RFID tag shall be verified using automated systems (e.g. bar code scanning/RFID) to ensure consistency between container content, labels, documentation, and ASN. Verification shall be in accordance with customer requirements.	F3	The data content of the shipping labels and/or RFID tag shall be verified using automated systems (e.g. barcode scanning/RFID) to ensure consistency between container content, labels, documentation, and ASN. Verification shall be in accordance with customer requirements.	F3		Format		X
4	3	2	4	The shipment process shall ensure that the content of each ASN is accurate. The format and content of the ASN and the timing of transmission are all in accordance with customer requirements.	F3	The shipment process shall ensure that the content of each ASN is accurate. The ASN format, content and timing of transmission shall be in accordance with customer requirements.	F3		Wording & Format		X
4	4			Transportation		Transportation			Unchanged		

4	4	1		Requirement: A process is in place to ensure effective and efficient transportation of finished goods in compliance with customer, industry, and government/international requirements. Why is this important? An efficient and effective transportation process provides the means for finished goods to be delivered on-time, undamaged, and at minimum cost.		Requirement: A process is in place to ensure effective and efficient transportation of finished goods in compliance with customer, industry, and government/international requirements. Why is this important? An efficient and effective transportation process provides the means for finished goods to be delivered on-time, undamaged, and at minimum cost.			Unchanged		
4	4	1	1	For customer-managed transportation, the organization shall monitor carrier activity and communicate issues (e.g. timeliness, trailer capacity constraint, safety concerns, cleanliness) that can negatively impact the customer. And/or: For supplier-managed transportation, the organization shall measure and monitor carrier performance and implement corrective actions for deficiencies that are identified.	F3	For customer-managed transportation, the organization shall monitor carrier activity and communicate issues (e.g. timeliness, trailer capacity constraint, safety concerns, cleanliness) that can negatively impact the customer. And/or: For supplier-managed transportation, the organization shall measure and monitor carrier performance and implement corrective actions for deficiencies that are identified.	F3		Wording		X
4	4	1	2	Appropriate equipment (e.g. bracing, banding) is used to ensure the product is delivered undamaged to the customer.	F2	Appropriate equipment (e.g. banding, wrapping, bracing) is used to ensure the product is delivered undamaged to the customer.	F2		Wording		X
4	4	1	3	Transportation planning is initiated at the beginning of the product life cycle and the carrier, LSP, and/or LLP is involved as early as possible (e.g. product development process).	F1	Transportation planning is initiated at the beginning of the product life cycle considering any special requirements (e.g. cold chain handling, hazardous material). The carrier, LSP, and/or LLP is involved as early as possible (e.g. product development process).	F1		Wording		
4	4	1	4	The organization has a process in place to review on a regular basis transportation cost and capacity together with the carrier, LSP, and/or LLP by sharing information (e.g. production volumes, routings).	F1	The organization has a process in place to review on a regular basis transportation cost and capacity together with the carrier, LSP, and/or LLP by sharing information (e.g. production volumes, routings).	F1		Unchanged		
4	4	2		Requirement: Transport utilization should be optimized and reviewed continually. Why is this important? Optimized transport utilization will reduce costs and provide environmental savings (e.g. reduce CO2 emissions).		Requirement: Transport utilization is optimized and reviewed continually. Why is this important? Optimized transport utilization will reduce costs and provide environmental savings (e.g. reduce CO2 emissions).			Wording		
4	4	2	1	The organization regularly explores opportunities to optimize transportation (e.g.: reload inbound conveyances with outbound product, full truckload through cross docks, CO2 emissions). Underused capacities (both inbound and outbound) are recorded and reviewed regularly to drive the transport optimization process.	F1	The organization regularly explores opportunities to optimize transportation (e.g. reload inbound conveyances with outbound product, full truckload through cross docks, CO2 emissions). Underused capacities (both inbound and outbound) are recorded and reviewed regularly to drive the transport optimization process.	F1		Wording		
4	5			Customer Satisfaction and Feedback		Customer Satisfaction and Feedback			Unchanged		
4	5	1		Requirement: The organization has a process to measure and improve overall customer satisfaction (including, but not limited to, delivery performance, meeting customer requirements, response to inquiries, communicating action plans, proposing improvements, etc.). Why is this important? The measurement of customer satisfaction is fundamental in identifying areas for business improvement. All customers are considered so that any significant impact with one customer does not negatively impact another customer. A high level of customer satisfaction is important in developing successful, proactive, and long-term business relationships.		Requirement: The organization has a process to measure and improve overall customer satisfaction (including, but not limited to, delivery performance, meeting customer requirements, response to inquiries, communicating action plans, proposing improvements, etc.). Why is this important? The measurement of customer satisfaction is fundamental in identifying areas for business improvement. All customers are considered so that any significant impact with one customer does not negatively impact another customer. A high level of customer satisfaction is important in developing successful, proactive, and long-term business relationships.			Unchanged		
4	5	1	1	A process is in place to determine, measure, review, and continually improve customer satisfaction, even if performance data are not formally provided by the customer.	F2	A process is in place to determine, measure, review, and continually improve customer satisfaction.	F2		Wording		X
4	5	1	2	Customer satisfaction results are published and reviewed internally at regular intervals by management and with the customer, as required. The results are presented visually using charts, graphs, monitors, etc.	F2	Customer satisfaction results are published and reviewed internally at regular intervals by management and with the customer, as required. The results are presented visually using charts, graphs, monitors, etc.	F2		Wording & Format		
5				PRODUCTION and PRODUCT CONTROL		PRODUCTION AND PRODUCT CONTROL			Format		
5	1			Material Identification		Material Identification			Unchanged		

5	1	1		Requirement: The organization shall have a process in place to ensure all material is labeled accurately and/or identified clearly at all stages (e.g. finished goods, WIP, and raw material) in the supply chain. Why is this important? Material that is properly identified reduces the risk of misplaced material, delays, and/or production disruptions.		Requirement: The organization has a process in place to ensure all material is labeled accurately and/or identified clearly at all stages (e.g. finished goods, WIP, and raw material) in the supply chain. Why is this important? Material that is correctly identified reduces the risk of misplaced material, delays, and/or production disruptions.			Wording		
5	1	1	1	The organization shall have a process in place to correctly identify all material from the point of receipt to shipment (e.g. direct part marking, product label, routing card, RFID).	F3	The organization shall have a process that ensures material is correctly identified from receipt to shipment: • Labels and identification methods (e.g. direct part marking, product label, routing card, RFID) are applied accurately. • Labels are available at the required time.	F3		Wording, format & merged	Merge with 5.1.1.2	X
5	1	1	2	The organization shall have a documented procedure in place to ensure the appropriate identification of all unusable or damaged material (e.g. scrap, returns, rejections).	F3	The organization shall have a documented procedure in place to ensure the appropriate identification of all unusable or damaged material (e.g. scrap, returns, rejections).	F3		Unchanged	Becomes 5.1.1.2	X
5	2			Inventory		Inventory			Unchanged		
5	2	1		Requirement: There is a process in place to identify and control the storage conditions and access to all stages of inventory: finished goods, WIP, and raw material. Why is this important? Optimal conditions for the storage of inventory should be in place in order to avoid loss and consequential cost due to damage, deterioration, or theft.		Requirement: There is a process in place to identify and control the storage conditions and access to all stages of inventory: finished goods, WIP, and raw material. Why is this important? Optimal storage conditions are required to protect inventory from damage, deterioration, and theft, thereby preventing material loss, avoiding unnecessary costs.			Wording		
5	2	1	1	The organization shall have a process in place to accurately and clearly identify all storage locations (e.g. signage, rack labels) for all types of inventory (e.g. scrap, rework, obsolete).	F3	The organization shall have a process in place to accurately and clearly identify all storage locations (e.g. signage, rack labels) for all types of inventory (e.g. WIP, scrap, rework, obsolete).	F3		Wording		X
5	2	1	2	The organization has a process in place to safeguard fragile, hazardous, and/or high theft material. There is a controlled storage environment that ensures parts are protected against damage and deterioration.	F2	The organization has a process in place to safeguard fragile, hazardous, and/or high theft material. There is a controlled storage environment that ensures parts are protected against damage and deterioration.	F2		Format		
5	2	2		Requirement: The organization has a process to optimize material flow and track material status as it moves through key points of the process. Why is this important? The primary objective of a lean manufacturing/material flow process is to minimize lead time and costs while creating flexibility within the supply chain. Collection of data at key points of the process allows for accurate tracking and optimizing material flow.		Requirement: The organization has a process to optimize material flow and track material status as it moves through key points of the process. Why is this important? The primary objective of a lean manufacturing/material flow process is to minimize lead time and costs while creating flexibility within the supply chain. Collection of data at key points of the process allows for accurate tracking and optimizing material flow.			Unchanged		
5	2	2	1	The organization's material flow is designed to facilitate accurate identification, tracking, and recording of inventory at key production points (e.g. bar code scanning, RFID, Kanban, poka-yoke). Material flow is designed to support FIFO where applicable. The method of storage supports visual management of material (e.g. minimum and maximum levels, color coding, FIFO boards, monitors).	F2	Material flow is designed to ensure accurate inventory control, part identification, and traceability by: • ensuring clear identification and tracking of parts throughout the process (e.g. barcode scanning, RFID, Kanban, poka-yoke) • using lean methods such as visual controls for effective management (e.g. min/max levels, color coding) • applying FIFO where applicable	F2		Wording & format		X
5	2	3		Requirement: The organization has a process in place that ensures material records are maintained accurately and discrepancies are fully investigated and corrected in a timely manner. Why is this important? The maintenance of accurate stock records is a prerequisite to ensuring the availability of product for the customer and avoiding production line disruptions. Effective control procedures reduce the risk of stock errors and the consequential impact of excess inventory and obsolescence or, conversely, insufficient material to support customer requirements. The visibility of stock balances to all relevant parties is important for taking actions in a timely manner.		Requirement: The organization has a process in place that ensures material records are maintained accurately and discrepancies are fully investigated and corrected in a timely manner, and material measurement equipment is maintained and calibrated. Why is this important? The maintenance of accurate stock records is a prerequisite to ensuring the availability of product for the customer and avoiding production line disruptions. Effective control procedures reduce the risk of stock errors and the consequential impact of excess inventory and obsolescence or, conversely, insufficient material to support customer requirements. The visibility of stock balances to all relevant parties is important for taking actions in a timely manner.			Wording		

5	2	3	1	There is a process in place to ensure accurate stock balance of all inventory types (e.g. finished goods, WIP, purchased parts, scrap) and transactions are updated correctly in the organization's IT systems in a timely manner. Deviations are investigated and root causes are identified and corrective actions are implemented to prevent recurrence.	F2	The organization maintains accurate material records through an inventory management process by: • accurate stock balances across all inventory types (e.g. finished goods, WIP, purchased parts, scrap) • recording all inventory transactions correctly and promptly in IT systems • investigating IT systems discrepancies to determine root causes and implementing corrective actions to prevent recurrence	F2		Wording & format		X
5	2	3	2	Accurate stock balances are maintained by use of physical inventory and/or cycle counts. Cycle counts are performed with adequate frequency depending on usage/volume value, waste percentage, etc.	F1	Inventory balance accuracy is measured through: • Regular cycle counts / physical inventories are scheduled at a frequency appropriate to item usage, volume, value, and waste levels. • When discrepancies are identified, root causes are investigated and corrective actions are implemented to prevent recurrence.	F2		Wording & moved & Weight	Move to 5.2.3.2 Change weight from F1 to F2	
5	2	3	3	The organization has a process in place that ensures the structure of the BOM records are accurate and maintained in a timely manner in the organizations planning system. BOM deviations are investigated and the impact on inventory balances is corrected through the perpetual inventory process.	F2	The organization has a process in place that ensures the structure of the BOM records are accurate and maintained in a timely manner in the organizations planning system. BOM deviations are investigated and the impact on inventory balances is corrected through the perpetual inventory process.	F2		Moved & Format	Move to 5.2.3.3	X
5	2	3	4	The organization uses techniques and methods (e.g. bar coding, Kanban, poka-yoke) to ensure accuracy of inventory and to eliminate inventory errors.	F2	The organization uses techniques and methods (e.g. barcoding, Kanban, poka-yoke) to ensure accuracy of inventory and to eliminate inventory errors.	F2		Wording & Moved	Move to 5.2.3.4	X
5	2	3	5	The same inventory transaction is used to update both the materials management and accounting systems. All stock records are visible to all relevant functions (e.g. SCM, sales, accounting).	F1	The same inventory transaction is used to update both the materials management and accounting systems. All stock records are visible to all relevant functions (e.g. SCM, sales, accounting).	F1		Format & Moved	Move to 5.2.3.5	
5	2	3	6	The organization archives records (e.g., inventory records, customer EDI, supplier EDI) as defined by internal and customer requirements for a time period relevant to resolve any issues or potential disputes i.e. obsolescence claim. The archived records should be retrievable and readable.	F1	The organization's record management process ensures required data is retained and accessible by: • archiving records (e.g. inventory, customer/supplier EDI) per defined retention requirements • retaining records long enough to support issue resolution and disputes (e.g. obsolescence claims) • ensuring archived records remain retrievable and readable throughout the retention period.	F1		Wording & Format		
5	2	3	7	There are procedures and/or work instructions in place to manage and schedule the regular maintenance and/or calibration of equipment (e.g. scanners, scales) used from the point of receipt to shipment. The assigned process owner will ensure that the status of all equipment is clearly displayed to the respective operators. Records of these activities are maintained.	F1	There are procedures and/or work instructions in place to manage and schedule the regular maintenance and/or calibration of equipment (e.g. scanners, scales) used from the point of receipt to shipment. The assigned process owner ensures the status of all equipment is clearly displayed at the point of use. Records of these activities are maintained.	F1		Wording & Format		X
5	2	4		Requirement: The organization shall have a process in place to identify and route defective or obsolete material in a timely manner. This process shall ensure that defective or obsolete material is segregated, reworked, and/or disposed of properly in order to minimize cost. Why is this important? The process for handling defective or obsolete parts shall ensure material is segregated from production in order to prevent unauthorized routing or distribution of material. The ERP system is updated accordingly to ensure that the parts are not used.		Requirement: The organization has a process in place to identify and route defective or obsolete material in a timely manner. This process ensures defective or obsolete material is segregated, reworked, and/or disposed of properly in order to minimize cost. Why is this important? The process for handling defective or obsolete parts ensures material is segregated from production in order to prevent unauthorized routing or distribution of material. The ERP system is updated accordingly to ensure the parts are not used.			Wording		
5	2	4	1	The organization shall have a process in place that ensures all defective or obsolete material is segregated, marked, contained, reworked, and/or disposed of properly and in a timely manner. This inventory is properly blocked in the organization's ERP and not available for planning purposes.	F3	The organization shall have a process in place that ensures all defective or obsolete material is segregated, marked, contained, reworked, and/or disposed of properly and in a timely manner. This inventory is blocked in the organization's ERP and not available for planning purposes.	F3		Wording & Format		X
5	2	4	2	The disposal of material and any claims shall be in accordance with customer requirements.	F2	The disposal of material and any claims is in accordance with customer requirements.	F2		Wording		
5	3			Engineering Change Control		Change Management			Wording		

5	3	1		Requirement: The organization shall have a documented process for managing engineering change throughout the supply chain. Why is this important? The effective management and implementation of engineering change ensures the correct part or level is produced and delivered to the customer and minimizes obsolescence and warranty costs.		Requirement: The organization has a documented process for managing product and process changes throughout the supply chain. Why is this important? Effective control of product and process changes ensures the correct product configuration is produced and delivered to the customer, reducing the risk of obsolescence, nonconformity and warranty costs.			Wording		
5	3	1	1	There is a process in place to ensure that inventory affected by engineering changes is managed from the point of receipt to final shipment in order to meet delivery requirements. The organization reviews and controls changes for production or service provision, to the extent necessary to ensure continuing conformity with requirements	**F2**	SCM is involved in the engineering change process, to ensure that inventory affected by engineering changes is managed from the point of receipt to final shipment in order to meet delivery requirements. The organization reviews and controls changes for product, process or service providers to ensure conformity with customer requirements.	**F2**		Wording		X
5	3	1	2	There is a process in place to manage and communicate revision control on inbound material from the supplier, including part labeling at the correct revision level and signage to alert the change. All relevant internal and supplier personnel understand the process.	**F2**	SCM is involved with all product or process changes to ensure communication, control and tracking of: - inbound material from the supplier - internal product/processes - customer change requirements The process includes product labeling at the correct change level and signage to alert the change. All relevant internal and supplier personnel understand the process.	**F2**		Wording		X
5	3	2		Requirement: The organization manages the life cycle of tooling to ensure customer requirements can be satisfied at all stages of production. Why is this important? Tools must be available and capable of meeting customer requirements for current and/or past model parts for the entire product life cycle.		Requirement: The organization manages the life cycle of tooling to ensure customer requirements can be satisfied at all stages of production. Why is this important? Tools must be available and capable of meeting customer requirements for current and/or past model parts for the entire product life cycle.			Unchanged		
5	3	2	1	There are procedures and/or work instructions in place on how to manage and record a tool's life cycle (e.g. current status, rework history, ownership, customer authorizations, part assignment, part branding, release number) to ensure customer requirements can be met for current and/or past model parts.	**F2**	There are procedures and/or work instructions in place on how to manage and record a tool's life cycle (e.g. current status, rework history, ownership, customer authorizations, part assignment, part branding, release number) to ensure customer requirements can be met for current and/or past model parts.	**F2**		Unchanged		X
5	3	2	2	The SCM function participates in the process to determine when a tool is no longer required and tooling disposal can take place.	**F1**	The SCM function participates in the process to determine when a tool is no longer required and tooling disposal can take place.	**F1**		Unchanged		
5	3	3		Requirement: The organization shall have a process in place to obtain written customer authorization whenever the product or process deviates from that which is currently approved through the Production Part Approval Process (PPAP). Why is this important? Product or process changes by the organization could have a negative impact on the quality of the part (e.g. form, fit, and function) and/or the cycle time to produce the part.		Requirement: The organization has a process in place to obtain written customer authorization whenever the product or process deviates from that which is currently approved through the Production Part Approval Process (PPAP). Why is this important? Product or process changes by the organization could have a negative impact on the quality of the part (e.g. form, fit, and function) and/or the delivery of parts to the customer.			Wording		
5	3	3	1	There shall be a process in place to obtain formal authorization from the customer whenever the product or process deviates from that which was approved during PPAP. The organization shall retain documented information describing the results of the review of deviation, the person(s) authorizing the deviation, and any necessary actions arising from the review.	**F3**	There shall be a process in place to obtain formal authorization from the customer whenever the product or process deviates from that which was approved during PPAP, that involves the SCM function. The organization shall retain documented information recording, and communicate to the relevant personnel: • the results of the deviation review • person(s) authorizing the deviation • actions / deadlines arising from the review	**F3**		Wording & format & Merged	Merge with 5.3.3.2	X
5	4			Traceability		Traceability			Unchanged		

5	4	1		Requirement: A lot or serial traceability process shall be in place, as required, which meets customer, industry and regulatory requirements (e.g. Transportation Recall Enhancement, Accountability and Documentation [TREAD] Act, Federal Motor Vehicle Safety Standard [FMVSS], End of Life Vehicle [ELV]). Why is this important? When an issue occurs (e.g. safety, quality), it is vital to be able to trace the affected parts, contain the problem, establish the root cause, and apply corrective measures in a timely manner. The traceability process provides the means to safeguard the consumer and minimize warranty and potential legal costs.		Requirement: A lot or serial traceability process is in place, as required, which meets customer, industry and regulatory requirements (e.g. Transportation Recall Enhancement, Accountability and Documentation [TREAD] Act, Federal Motor Vehicle Safety Standard [FMVSS], End of Life Vehicle [ELV]). Why is this important? When an issue occurs (e.g. safety, quality), it is vital to be able to trace the affected parts, contain the problem, establish the root cause, and apply corrective measures in a timely manner. The traceability process provides the means to safeguard the consumer and minimize warranty and potential legal costs.			Wording		
5	4	1	1	There shall be a process that ensures traceability and reporting requirements are met and records are retained according to customer, industry and regulatory requirements. Records shall remain legible, readily identifiable, and retrievable. This may involve traceability of partial lots and/or individual part/pallet/batches for all stages of inventory (finished goods, WIP, raw material).	F3	Traceability and record control are established to meet customer, industry and regulatory requirements by: • ensuring traceability and required reporting across all inventory stages (e.g. raw material, WIP, finished goods) • maintaining traceability at appropriate levels (e.g. partial lots, individual parts, pallets, batches) • retaining records in accordance with defined requirements • ensuring records remain legible, identifiable and readily retrievable	F3		Wording & Format		X
5	4	1	2	Collecting, recording, and tracking of lot, partial lot, and/or serial traceability data is automated (e.g. bar coding, RFID).	F2	Error-proof systems (e.g. barcoding, RFID) are used for collecting, recording and tracking of lot, partial lot and/or serial traceability.	F2		Wording		
6				SUPPLIER INTERFACE		SUPPLIER INTERFACE			Unchanged		
6	1			Supplier Selection		Supplier Selection			Unchanged		
6	1	1		Requirement: The requirements of the SCM function shall be considered when selecting suppliers, subcontractors, or service providers for new or existing products or services. Why is this important? The selection of capable and agile suppliers who can demonstrate their ability to manage quality, cost, and delivery performance is extremely important in the development of an effective and efficient supply chain.		Requirement: The requirements of the SCM function is considered when selecting suppliers, subcontractors, or service providers for new or existing products or services. Why is this important? The selection of capable and agile suppliers who can demonstrate their ability to manage quality, cost, and delivery performance is extremely important in the development of an effective and efficient supply chain.			Wording		
6	1	1	1	The organization shall have a documented process involving the SCM function for the selection process for suppliers, subcontractors, and service providers.	F3	The organization shall have a documented process involving the SCM function for the selection process of suppliers, subcontractors, and service providers.	F3		Wording		X
6	1	1	2	Supply chain performance indicators are part of the supplier, subcontractor, and service provider selection process.	F3	Supply chain performance indicators shall be part of the supplier, subcontractor, and service provider selection process.	F3		Wording		X
6	1	1	3	The Global MMOG/LE or an equivalent assessment is part of the supplier, subcontractor, and service provider selection process.	F2	The MMOG/LE or an equivalent assessment is part of the supplier, subcontractor, and service provider selection process.	F2		Unchanged / Wording		X
6	1	1	4			Supplier data is maintained and readily available through one or more controlled systems (e.g. ERP, SRM, databases) to support supplier selection, supplier performance evaluation, benchmarking, and business operations.	F1		Wording Added & Included in BASIC	New criterion 6.1.1.4 Included in BASIC	X
6	2			Supplier Compliance		Supplier ESG Compliance			Wording		
6	2	1		Requirement: The supplier is responsible to comply with governmental, safety, environmental, regulations, and laws relative to materials and products supplied to the organization. Why is this important? ESG programs are based on fundamental principles of social, environmental and governance responsibility that are consistent with applicable laws and international standards.		Requirement: The supplier is responsible for compliance with all applicable governmental, safety, and environmental laws and regulations concerning the materials and products supplied to the organization. Why is this important? ESG initiatives are driven by fundamental principles of social, environmental, and governance responsibility and adhere to applicable laws and international standards.			Wording		

6	2	1	1	The organization requires that the supplier takes ESG into consideration. ESG considers topics such as business ethics, environment, working conditions, health and safety, responsible supply chain management, human rights. The organization confirms that the supplier meets these expectations (e.g. risk assessment, sustainability assessment).	F1	The organization requires that the supplier takes ESG into consideration. ESG considers topics such as business ethics, environment, working conditions, health and safety, responsible supply chain management, human rights. The organization confirms that the supplier meets these expectations (e.g. risk assessment, sustainability assessment).	F2		Format & Change Weight		X
6	2	1	2	The organization confirms that suppliers have cascaded these requirements to their sub-suppliers.	F1	The organization confirms that suppliers have cascaded applicable ESG requirements to their sub-suppliers.	F1		Wording		
6	3			Supply Chain Management Agreement		Supply Chain Management Agreement			Unchanged		
6	3	1		Requirement: A formal Supply Chain Management (SCM) Agreement shall exist with suppliers, subcontractors, and service providers. Why is this important? The day-to-day operational relationship shall be properly defined and documented in order to clarify roles and responsibilities, expectations, and commitments and to avoid the possibility of misunderstandings and conflict. Use of the Automotive Supply Chain Management Agreement (ASCMA) or equivalent is recommended.		Requirement: A formal Supply Chain Management (SCM) Agreement exists with suppliers, subcontractors, and service providers. Why is this important? The day-to-day operational relationship is defined and documented in order to clarify roles and responsibilities, expectations, and commitments and to avoid the possibility of misunderstandings and conflict. Use of the Automotive Supply Chain Management Agreement (ASCMA) or equivalent is recommended.			Wording		
6	3	1	1	A formal SCM agreement (e.g. terms and conditions, supplier manual) is in place specifying the conditions of the relationship and is agreed by all parties before the first delivery; deviations from the SCM agreement are immediately investigated, communicated, and rectified.	F3	A formal SCM agreement (e.g. terms and conditions, supplier manual) shall be in place specifying the conditions of the relationship, and agreed by all parties before the first delivery. Deviations from the SCM agreement are immediately investigated, communicated, and rectified.	F3		Wording and format		X
6	3	1	2	A process is in place to ensure the SCM agreement is regularly reviewed and revised as necessary.	F2	A process is in place to ensure the SCM agreement is regularly reviewed and revised as necessary.	F2		Unchanged		
6	3	1	3	The SCM agreement defines the complete operational conditions of the relationship (e.g. supplier mapping, risk assessment, contingency planning, EDI/Web requirements, capacity, production flexibility, obsolescence, packaging, labeling, and shipping specifications, etc.).	F2	The SCM agreement defines all operational conditions of the relationship (e.g. supplier mapping, risk assessment, contingency planning, EDI/Web requirements, capacity, production flexibility, obsolescence, packaging, labeling, shipping specifications, etc.).	F2		Wording		X
6	3	1	4	The SCM agreement specifies the language to be used for all forms of communication, including corporate and day-to-day operations.	F2	The SCM agreement specifies the language to be used for all forms of communication, including corporate and day-to-day operations.	F2		Unchanged		
6	3	1	5	The SCM agreement includes procurement and inventory policies based on customer requirements for long lead time and critical components.	F2	The SCM agreement includes procurement and inventory policies based on customer requirements for long lead time and critical components.	F2		Unchanged		
6	4			Collaboration		Collaboration			Unchanged		
6	4	1		Requirement: A process is in place for two-way communication with suppliers, subcontractors, and service providers to resolve day-to-day issues and emergency situations. Each member is prepared and ready to communicate in the event of a disruption. Why is this important? The methods of communication for day-to-day operations should be fully defined and documented in order to clarify roles and responsibilities, expectations, and commitments and to avoid the possibility of misunderstandings and conflict.		Requirement: A process is in place for two-way communication with suppliers, subcontractors, and service providers to resolve day-to-day issues and emergency situations. Each member is prepared and ready to communicate in the event of a disruption. Why is this important? The methods of communication for day-to-day operations are fully defined and documented in order to clarify roles and responsibilities, expectations, and commitments and to avoid the possibility of misunderstandings and conflict.			Wording		
6	4	1	1	There is a process in place to ensure that suppliers, subcontractors, and logistics providers have procedures and/or work instructions in place to immediately notify the organization and respond to any situation that could negatively impact the organization s operation. This process should include a) on what it will communicate; b) when to communicate; c) with whom to communicate; d) how to communicate; e) who communicates.	F3	There shall be a process in place to ensure that suppliers, subcontractors, and logistics providers have procedures and/or work instructions in place to immediately notify the organization and respond to any situation that could negatively impact the organization's operation. The process defines: • what is to be communicated • when communication is required • with whom to communicate • how communication is to be conducted • who is responsible for communication	F3		Wording & Format		X

6	4	1	2	The organization receives a contact list from its suppliers, subcontractors, and service providers, in their preferred format, that supports the organization s operations as required, including 24 hours/7 days support. The contact list comprises name, function, method of communication (e.g. office/mobile numbers, fax number, e-mail address, etc.), hours of availability, weekend and emergency contacts, and deputies/back-ups for each SCM function. The contact is able to communicate in the organization s preferred business language. The organization provides a reciprocal list of their contact information to its suppliers, subcontractors, and service providers.	F2	The organization receives a contact list from its suppliers, subcontractors, and service providers that supports the organization's operations and includes 24 hours/7 days support. The contact list comprises: • name, Title, Function and contact information (e.g. email, phone) • weekend and emergency contacts • deputies/ back-ups for relevant SCM function. The contact is able to communicate in the organization's preferred business language. The organization provides a reciprocal list of their contact information to its suppliers, subcontractors, and service providers.	F2		Wording and format		X
6	4	2		Requirement: A process for electronic data exchange shall be in place with suppliers, subcontractors, and logistics providers. Why is this important? Fast, reliable, and integrated exchange of data significantly improves accuracy, flow, and visibility of information and reduces lead times, administration, and costs. The real-time, automatic exchange of information allows the organization and its suppliers, subcontractors, and service providers to respond more quickly by having greater visibility and thus reduce inventory.		Requirement: A process for electronic data exchange **is** in place with suppliers, subcontractors, and logistics providers. Why is this important? Fast, reliable, and integrated exchange of data significantly improves accuracy, flow, and visibility of information and reduces lead times, administration, and costs. The real-time, automatic exchange of information allows the organization and its suppliers, subcontractors, and service providers to respond more quickly by having greater visibility and thus reduce inventory.			Wording		
6	4	2	1	The organization shall electronically exchange materials and logistics information (e.g. planning releases, delivery forecasts/requirements, ASNs) with suppliers, subcontractors, and service providers using web based tools (e.g. EDI, Web EDI, Web Portal). EDI data shall be in an industry standard format. Web-based tools shall be in compliance with customer requirements. The use of emails, paper documents, faxes, and PDFs are not acceptable. The organization shall strive to implement electronic data exchange with 100% of its supply base and shall be in compliance with the customer's requirements.	F3	The organization shall use EDI with 100% of its supply base, or shall be in compliance with the customer's ~~EDI~~ requirements. The organization and its suppliers, subcontractors and service providers shall exchange materials and logistics information (e.g. 830/DELFOR, 862/DELJIT, 856/DESADV) electronically. Data shall be communicated using traditional EDI in an industry standard format (e.g. ANSI X12, EDIFACT) and/or web-based tools (e.g. Web EDI, Web Portal). The use of emails, paper documents, faxes, and PDFs, are not acceptable.	F3		Wording		X
6	4	2	2	When suppliers are required to transmit an ASN, the content of the ASNs is automatically entered and processed, without manual intervention, into the organization's system (e.g. receiving, inventory, accounts payable).	F2	The content of the ASNs transmitted by suppliers is automatically received and the data processed by the organization's receiving system.	F2		Wording		
6	4	2	3	The organization has a process in place to verify the accuracy of information transmitted and received (e.g. planning and shipping schedules, ASNs) and initiate corrective action if necessary.	F2	The organization has a process in place to verify the accuracy of information transmitted and received (e.g. planning and shipping schedules, ASNs) and initiate corrective action if necessary.	F2		Unchanged		X
6	4	2	4	Transmission frequency and planning horizons are adequate for the total lead time of the part or commodity.	F2	Transmission frequency and planning horizons are appropriate for the total lead time of the part or commodity.	F2		Wording		X
6	4	2	5	The organizations s planning system has the capability to automatically detect material shortages upon receipt of the ASN.	F1	The organization's planning system has the capability to automatically detect material shortages upon receipt of the ASN.	F1		Wording		
6	5			Packaging and Labeling		Packaging and Labeling			Unchanged		
6	5	1		Requirement: There is a process in place that ensures packaging solutions are agreed by all involved parties and that the labeling meets the organization s specification. Why is this important? Packaging and labeling solutions should support the efficient flow and identification of material. Effective packaging facilitates efficient storage, transportation, and accessibility of parts while providing protection and preventing deterioration. Labeling allows for visual identification of material and supports automated data entry, thus increasing the accuracy of data into the production planning and inventory management systems.		Requirement: There is a process in place that ensures packaging solutions are agreed by all involved parties and that the labeling meets the organization's specification. Why is this important? Packaging and labeling solutions support the efficient flow and identification of material. Effective packaging facilitates efficient storage, transportation, and accessibility of parts while providing protection and preventing deterioration. Labeling allows for visual identification of material and supports automated data entry, thus increasing the accuracy of data into the production planning and inventory management systems.			Wording		

6	5	1	1	The organization has a process in place to develop and define labeling and packaging solutions for standard and back-up packaging, including pack size, in conjunction with all involved parties and before the start of production.	F1	The organization has a documented process to develop and define packaging and labeling solutions using existing industry standards, such as AIAG and Odette. The process includes: • determination of packaging responsibility (e.g. organization or supplier) • standard and backup packaging solutions that comply with environmental guidelines, and a defined pack size • definition of labeling requirements • validation with all involved parties (e.g. pre-production and PPAP) • formal organization sign-off prior to regular production	F2		Wording & Merged & change Weight & include in BASIC	Merge with 6.5.1.2. and include in Basic	X
6	5	1	2	All applicable manufacturing, storage, and shipping processes are considered when developing the packaging solution.	F1	All applicable manufacturing, storage, and shipping processes are considered when developing the packaging solution.	F1		Unchanged		
6	5	2		Requirement: The organization has a container management process in place to ensure availability of containers to support the material flow requirements. Why is this important? The organization should track the quantity, quality, and location of containers (e.g. returnable, expendable or disposable packaging, dunnage, spacers) to ensure that the approved container is available at the right time, avoiding disruptions in the production and shipping process. An effective container management process/system can avoid extraordinary costs by preventing material damage, lost containers, and production down-time.		Requirement: The organization has a container management process in place to ensure availability of containers to support the material flow requirements. Why is this important? The organization tracks the quantity, quality, and location of containers (e.g. returnable, expendable or disposable packaging, dunnage, spacers) to ensure that the approved container is available at the right time, avoiding disruptions in the production and shipping process. An effective container management process/system can avoid extraordinary costs by preventing material damage, lost containers, and production down-time.			Wording		
6	5	2	1	There is a process in place for the procurement, allocation, monitoring and control of all aspects of packaging and container management (e.g. returnable containers, expendable or disposable packaging, dunnage, spacers).	F2	There is a process in place for the procurement, allocation, monitoring and control of all aspects of packaging and container management (e.g. returnable containers, expendable or disposable packaging, dunnage, spacers).	F2		Unchanged		X
6	5	2	2	The responsibilities for container management are agreed to and documented between the parties.	F2	The responsibilities for container management are agreed and documented between the parties.	F2		Wording		
6	5	2	3	There is a process in place to regularly review and optimize the container management process in order to reduce total SCM costs.	F1	There is a process in place to regularly review and optimize the container management process in order to reduce total SCM costs.	F1		Unchanged		
6	6			Transportation		Transportation			Unchanged		
6	6	1		Requirement: There is a process in place to ensure effective and efficient transportation of inbound material in compliance with customer, industry, and government/international requirements. Why is this important? An efficient and effective inbound transportation process provides the means for material to be delivered on-time, uninterrupted, undamaged, and at minimum cost. Considerations within the assessment process should also include environmental aspects, customs requirements, supply chain security, and performance measurements (examples available in Odette s Key Performance Indicators for Carriers and LSPs guideline).		Requirement: There is a process in place to ensure effective and efficient transportation of inbound material in compliance with customer, industry, and government/international requirements. Why is this important? An efficient and effective inbound transportation process provides the means for material to be delivered on-time, uninterrupted, undamaged, and at minimum cost. Considerations within the assessment process include environmental aspects, customs requirements, supply chain security, and performance measurements (examples available in Odette's Key Performance Indicators for Carriers and LSPs guideline).			Wording		
6	6	1	1	Transportation planning is initiated at the beginning of the product life cycle and the carrier, LSP, and/or LLP is involved in the process in a timely manner (e.g. product development process).	F2	Transportation planning is initiated at the beginning of the product life cycle and the carrier, LSP, and/or LLP is involved in the process in a timely manner (e.g. product development process).	F2		Unchanged		
6	6	1	2	There is a procedure and/or work instruction in place for resolving transportation issues related to quality (e.g. damages), cost (e.g. premium freight, demurrage), and delivery (e.g. on-time performance) in a timely manner.	F2	There is a procedure and/or work instruction in place for resolving transportation issues related to quality (e.g. damages), cost (e.g. premium freight, demurrage), and delivery (e.g. on-time performance) in a timely manner.	F2		Unchanged		X
6	6	1	3	The organization has the ability to track and trace inbound material from time of shipment through to receipt.	F2	The organization has the ability to track and trace inbound material from time of shipment through to receipt.	F2		Unchanged		X
6	7			Material Receipt		Material Receipt			Unchanged		

6	7	1		Requirement: There is a process in place to ensure efficient management of the material receiving process, including sufficient capacity and appropriate equipment. Why is this important? Efficient management of the material receiving process is necessary to facilitate effective material flow and ensures the activity does not become a bottleneck.		Requirement: There is a process in place to ensure efficient management of the material receiving process, including sufficient capacity and appropriate equipment. Why is this important? Efficient management of the material receiving process is necessary to facilitate effective material flow and ensures the activity does not become a bottleneck.			Unchanged		
6	7	1	1	There are sufficient capacity and resources (personnel, equipment, space, maintenance) based on the mode of delivery (e.g. truck, rail).	F2	The organization ensures there is sufficient capacity and resource (personnel, equipment, space, maintenance) based on the mode of delivery (e.g. truck, rail).	F2		Wording		
6	7	1	2	There is a process in place to optimize the use of docks, space and resources. This process considers all variables of the receiving activities (e.g. scheduling, fixed time slots).	F1	There is a process in place to optimize the organization's use of docks, space and resources. This process considers all variables of the receiving activities (e.g. scheduling, fixed time slots).	F1		Wording		
6	7	2		Requirement: There is a process in place to verify the accuracy of the labeling and shipping documentation at the point of receipt. Why is this important? Accurate labeling and shipping documentation support the identification and efficient flow of material. Missed or inaccurate information can result in premium freight and production disruption and could impact delivery to the organization s customer. When discrepancies are found, it is important for the organization to work with the suppliers, subcontractors, and/or service providers to develop corrective actions that prevent recurrence.		Requirement: There is a process in place to verify the accuracy of the labeling and shipping documentation at the point of receipt. Why is this important? Accurate labeling and shipping documentation support the identification and efficient flow of material. Missed or inaccurate information can result in premium freight and production disruption and could impact delivery to the organization's customer. When discrepancies are found, it is important for the organization to work with the suppliers, subcontractors, and/or service providers to develop corrective actions that prevent recurrence.			Wording		
6	7	2	1	The organization has a process in place to ensure complete and accurate data content (e.g. part number, quantity, revision level, purchase order) of shipping labels and documentation. Receiving discrepancies are recorded and corrective actions are implemented with suppliers, subcontractors, and/or service providers as applicable.	F2	The organization has a process in place to ensure complete and accurate data content (e.g. part number, quantity, revision level, purchase order) of shipping labels and documentation. Receiving discrepancies are recorded and corrective actions are implemented with suppliers, subcontractors, and/or service providers as applicable.	F2		Format		X
6	7	2	2	A process is in place to conduct receiving audits based on the frequency and severity of discrepancies.	F1	A process is in place to conduct receiving audits based on the frequency and severity of discrepancies.	F1		Unchanged		
6	7	2	3	Receiving transactions are assigned a unique identifier that can be referenced for audit, investigation and traceability purposes.	F1	Receiving transactions are assigned a unique identifier that can be referenced for audit, investigation and traceability purposes.	F1		Unchanged		
6	7	2	4	The organization uses scanning and/or visual controls to assist the receiving process (e.g. part display board, part identification charts, signage, Kanban tools).	F1	The organization uses scanning and/or visual controls to assist the receiving process (e.g. part display board, part identification charts, signage, Kanban tools).	F1		Unchanged		
6	7	2	5	The organization's receiving process is followed when material is received by a third party (e.g. LLP, LSP).	F1	The organization's receiving process is followed when material is received by a third party (e.g. LLP, LSP).	F1		Unchanged		
6	8			Supplier Assessment		Supplier Assessment			Unchanged		
6	8	1		Requirement: There is a process in place to assess and monitor the capability and performance of suppliers, subcontractors, and service providers on a regular basis. Why is this important? A formal process for assessing and monitoring supplier capability and performance provides the means to support the organization s SCM strategy, identify opportunities for improvement, and to make a valuable contribution to the achievement of high levels of customer satisfaction.		Requirement: There is a process in place to assess and monitor the capability and performance of suppliers, subcontractors, and service providers on a regular basis. Why is this important? A formal process for assessing and monitoring supplier capability and performance provides the means to support the organization's SCM strategy, identify opportunities for improvement, and to make a valuable contribution to the achievement of high levels of customer satisfaction.			Wording		
6	8	1	1	There is a process in place to regularly measure and review supply chain performance of suppliers, subcontractors, and service providers by the use of tools such as supplier scorecards, risks, supplier assessments, etc. The performance is regularly communicated to all relevant parties (e.g. suppliers, management, purchasing) and considered in risk assessment. Process improvement plans are initiated and implemented as required.	F3	There shall be a process in place to regularly measure and review supply chain performance of suppliers, subcontractors, and service providers by the use of tools such as supplier scorecards, risks, supplier assessments, etc. The performance is regularly communicated to all relevant parties (e.g. suppliers, management, purchasing) and considered in risk assessment. Process improvement plans are initiated and implemented as required.	F3		Wording		X

6	8	1	2	A process is in place to assess the capability of supply chain partners utilizing a formal evaluation tool (e.g. Global MMOG/LE or equivalent) that is leveraged during new product launch and performance review.	F2	A process is in place to assess the capability of supply chain partners by utilizing a formal process evaluation tool, MMOG/LE or equivalent, during new product launch and performance reviews.	F2		Include in BASIC / Wording		X
6	9			Supply Chain Resilience		Supply Chain Resilience			Unchanged		
6	9	1		Requirement: The organization shall implement a risk assessment program dedicated to improve the supply chain resilience and minimize supply chain disruptions Why is this important? In order to maintain continuity of operations the organization must involve the supply chain in identifying risks, developing contingency plans and fast recovery plans.		Requirement: The organization shall implement a risk assessment program dedicated to improve the supply chain resilience and minimize supply chain disruptions. Why is it important: In order to maintain continuity of operations the organization must involve the supply chain in identifying risks, developing contingency plans and fast recovery plans.			Wording		
6	9	1	1	The organization requires its suppliers to have a risk assessment process in place to identify areas within the supply chain process that could affect the ability to meet the organization's requirements. A supplier s risk assessment process prioritizes which processes should be documented within the contingency/back-up procedures based on probability of occurrence, severity of the impact, detection, etc. The process could include the use of analytic tools as appropriate.	F3	The organization shall require its suppliers to have a risk assessment process in place to identify areas within the supply chain process that could affect the ability to meet the organization's requirements. A supplier's risk assessment process prioritizes which processes are documented within the contingency/back-up procedures based on probability of occurrence, severity of the impact, detection, etc. The process includes the use of analytic tools as appropriate.	F3		Wording		X
6	9	1	2	The organization shall require its suppliers to develop contingency plans that would be implemented in the event of a deviation or disruption from the normal business process. This could include IT systems (e.g. EDI), transportation, packaging, equipment failure, absenteeism, etc.	F3	The organization shall require its suppliers to develop contingency plans that will be actioned in the event of a deviation or disruption from the normal business process. The required contingency plans include, but are not limited to, IT systems (e.g. EDI, ERP, cybersecurity), equipment failure, packaging, material shortages and labor related issues.	F3		Wording		X

				Deleted or merged								
1	3	1	1	Objectives are documented, specific, measurable, achievable, realistic, timely and consistent with the organization's SCM strategy. The objectives should be considered when the organization establishes its annual SCM plan and should be clearly communicated to all levels of the organization.	F2	Objectives are documented, specific, measurable, achievable, realistic, timely and consistent with the organization's SCM strategy. The objectives are considered when the organization establishes its annual SCM plan and are: • clearly communicated to all levels of the organization • reviewed with top management at planned intervals			Wording & Merged	Merge 1.3.1.1 with 1.3.1.2	X
1	5	2	4	An effective cycle counting program is in place to identify root causes of inventory variation and implement corrective actions to prevent recurrence of the cause of variation.	F1				Delete & merged	Merge with 5.3.2.5	
1	6	1	1	The organization has a processes and documented action plans in place for the continual development of relationships with supply chain partners. (e.g. Suppliers, subcontractors, service providers)	F2	The organization continuously evaluates and develops its relationships with all its supply chain partners (customers, suppliers, subcontractors, service providers) using formal methods of analysis. Examples include Strengths Weaknesses Opportunities Threats [SWOT] analysis and Benchmarking.			Wording & merged	Merge with 1.6.1.2	
2	4	5	2	There is a regular (minimum once a year) performance review process with the employee that includes an evaluation of their performance against department and the organization's objectives. Opportunities for professional development may also be discussed.	F1	Employees have a regular (at least yearly) performance review against personal, team and company goals. During the review, development needs and training are identified, and action plans are created as needed to support improvement and growth.			Wording & Merged	Merge with 2.4.5.3	
2	4	5	3	There is a process to develop action plans as a result of improvement opportunities and training needs that have been identified during the appraisal review.	F1				Delete & Merged	Merge with 2.4.5.2	
3	2	3	1	PPAP requirements are incorporated into the capacity planning process and scheduled accordingly.	F1	The capacity planning process ensures: • PPAP requirements are incorporated into the capacity planning process and scheduled accordingly.G121 • SCM representation (e.g. Scheduling, Production, Material Control) is included in PPAP reviews to resolve issues with meeting customer requirements.	F2		Wording & Change weight & Merged	Merge with 3.2.3.2	
3	2	3	2	SCM representation (e.g. Scheduling, Production, Material Control) should be included in PPAP reviews to resolve issues with meeting customer requirements.	F1		F2		Deleted & Change Weight & Merged	Merge with 3.2.3.1	

4	1	1	3	The organization provides its customer with a contact list that supports customer operations as required, including 24 hours/7 days support. The contact list comprises name, function, method of communication (e.g. office/mobile numbers, e-mail address, etc.), hours of availability, weekend and emergency contacts, and deputies/back-ups for each SCM function. The contact is able to communicate in the customer's preferred business language.	F1	The organization provides its customer with a contact list that supports customer requirements including 24 hours/7 days support. The contact is able to communicate in the customer's preferred business language. There is a process in place for reviewing and updating customer contact lists at regular intervals as defined by the customer.			Wording & Merged	Merge with 4.1.1.4	
4	2	1	1	The organization shall have a documented process to develop and define labeling and packaging solutions for standard and back-up packaging, including pack size, in conjunction with all involved parties and before the start of production. The process should define whether packaging is supplied by the customer or supplier.	F3	The organization shall have a documented process to develop and define packaging and labeling solutions. The process includes: • determination of packaging responsibility (e.g. customer or supplier) • standard and backup packaging solutions • definition of labeling requirements • validation with all involved parties (e.g. pre-production and PPAP) • formal customer sign-off prior to regular production			Wording & Merged	Merge 4.2.1.1 & 4.2.1.2	X
4	2	1	2	There is a process in place to validate the packaging and labeling solution with all involved parties prior to the start of regular production (e.g. at the pre-production and PPAP stage). The process includes a formal sign-off with the customer.	F2				Delete & Merged	Merge with 4.2.1.1	X
5	1	1	1	The organization shall have a process in place to correctly identify all material from the point of receipt to shipment (e.g. direct part marking, product label, routing card, RFID).	F3	The organization shall have a process that ensures material is correctly identified from receipt to shipment, with labels and identification methods applied accurately and available at the required time (e.g. direct part marking, product label, routing card, RFID).			Wording & merged	Merge with 5.1.1.2	X
5	1	1	2	The organization makes sure that all part and/or container labels are available at the appropriate time and are applied correctly.	F3				Delete & merged	Merge with 5.1.1.1	X
5	3	3	1	There shall be a process in place to obtain formal authorization from the customer whenever the product or process deviates from that which was approved during PPAP. The organization shall retain documented information describing the results of the review of deviation, the person(s) authorizing the deviation, and any necessary actions arising from the review.	F3	There shall be a process in place to obtain formal authorization from the customer whenever the product or process deviates from that which was approved during PPAP, that involves the SCM function. The organization shall retain documented information recording, and communicate to the relevant personnel: • the results of the deviation review • person(s) authorizing the deviation • actions / deadlines arising from the review			Wording & format & Merged	Merge with 5.3.3.2	X
5	3	3	2	For each deviation, a corrective action and timing plan is in place to return to the original or superseding specifications; this includes notification to all relevant personnel of the start and end date following approval.	F1				Delete & Merged	Merge with 5.3.3.1	
6	5	1	1	The organization has a process in place to develop and define labeling and packaging solutions for standard and back-up packaging, including pack size, in conjunction with all involved parties and before the start of production.	F1	The organization has a documented process to develop and define packaging and labeling solutions using existing industry standards, such as AIAG and Odette. The process includes: • determination of packaging responsibility (e.g. organization or supplier) • standard and backup packaging solutions that comply with environmental guidelines, and a defined pack size • definition of labeling requirements • validation with all involved parties (e.g. pre-production and PPAP) • formal organization sign-off prior to regular production	F2		Wording & change Weight & Merged & include in BASIC	Merge 6.5.1.2. with 6.5.1.1 include in BASIC	X
6	5	1	2	Existing packaging and labeling standards are used (e.g. AIAG, Odette) and environmental guidelines for packaging are incorporated where appropriate.	F1				Delete & merged	merge with 6.5.1.1	