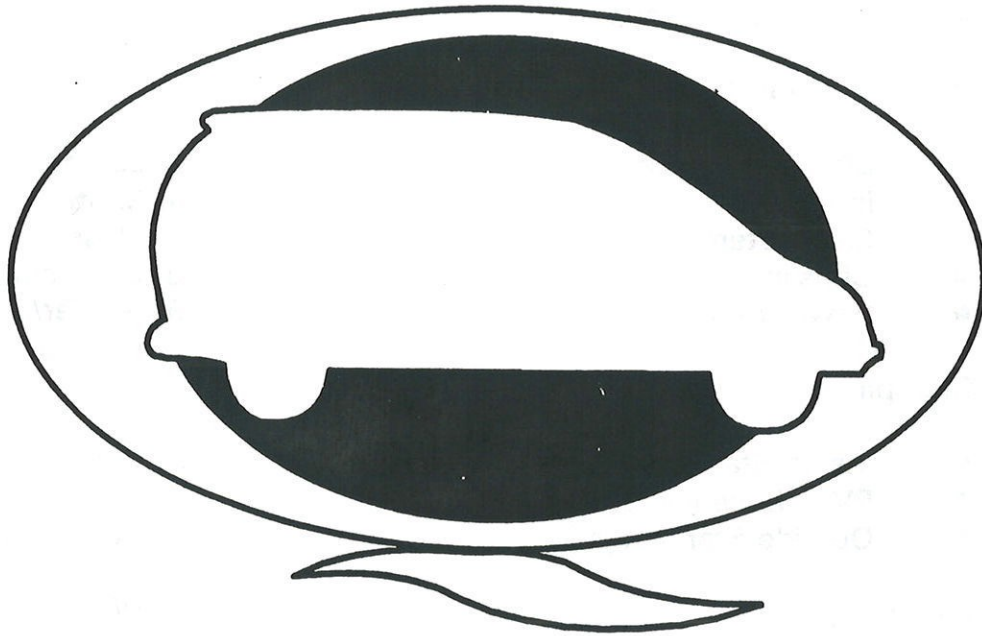


NS C1 STATUS REVIEW

DECEMBER 1, 1994



MINIVAN PLATFORM TEAM

--- CONFIDENTIAL ---

**NS C1 STATUS REVIEW
DECEMBER 1, 1994
Agenda**

1. Program Overview C. Theodore
 - Overview Remarks
 - Key Upcoming Events

2. Part Timing T. Edson
 - C1 Material Status
 - PVP Critical Parts Status
 - MITS/PCN Status

3. Product Team Reports E. Laginess
J. Sauter
C. Hess
B. Swanson
R. Reuter/
J. Wagner
 - BIW and Exterior
 - Interior
 - E/E Systems
 - Chassis
 - Powertrain

4. Stamping J. Nichols
P. Rosenfeld
 - Inside Stampings
 - PVP Home-line status
 - Outside Stampings

5. Assembly L. Wolf
 - C1 Pilot Build Status
 - Facility Status (separate presentation)

6. Vehicle Development H. Greif
 - Functional Objective Status
 - NVH/BSR Status
 - Vehicle Development Issues

8. Quality Indicators H. Grief

9. Summary and Recommendations C. Theodore

1996 NS/GS-BODY PROGRAM TIMING SUMMARY

DECEMBER 1, 1994

<u>DATE</u>	<u>EVENT</u>
12/01/94	NS-BODY FIRST SWB P0 UNIT COMPLETE (WAS 11/19)
12/01/94	NS-BODY DESIGN VALIDATION SIGN-OFF STATEMENTS TO SAFETY OFFICE
12/01/94	NS / GS - BODY PROGRAM REVIEW (WITH MR. CUNNINGHAM)
12/02/94	NS-BODY LWB LAUNCH READINESS WITH SENIOR MANAGEMENT
12/06/94E	NS-BODY FIRST LWB C1 UNIT COMPLETE (WAS 11/30)
12/08/94	NS/GS-BODY PROGRAM REVIEW AT ST. LOUIS (WITH MR. CUNNINGHAM)
12/09/94	MVP TEAM MEETING - CTC AUDITORIUM
12/12/94	NS-BODY PRESS BACKGROUNDER (RIDE / DRIVE) - CTC
12/19/94	NS-BODY SENIOR MANAGEMENT C1 RIDE / DRIVE AT APG (WITH MR.EATON)
01/03/95	NS DEADLINE FOR COMPLIANCE REPORTS SUBMISSION TO SAFETY OFFICE
01/04/95	NS-BODY PUBLIC INTRODUCTION AT DETROIT AUTO SHOW
01/07/94	SPECIAL PLATFORM TEAM EVENT AT DETROIT AUTO SHOW
01/10/95	START NS-BODY LWB BIW PVP V1 UNIT AT ST. LOUIS
02/07/95	NS/GS BODY SAE DINNER - LIVONIA
02/22/95	NS-BODY MEDIA LAUNCH AT BIG SUR (IN CALIFORNIA)
3/01-3/17	NS BODY DEALER ANNOUNCEMENTS
TBD	NS-BODY PRICING ANNOUNCEMENT

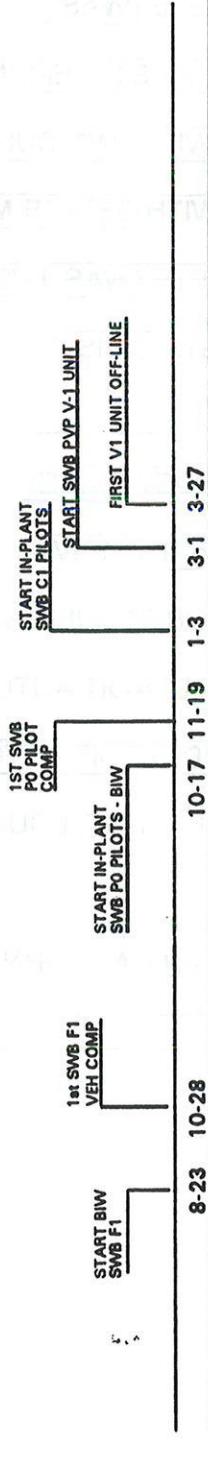
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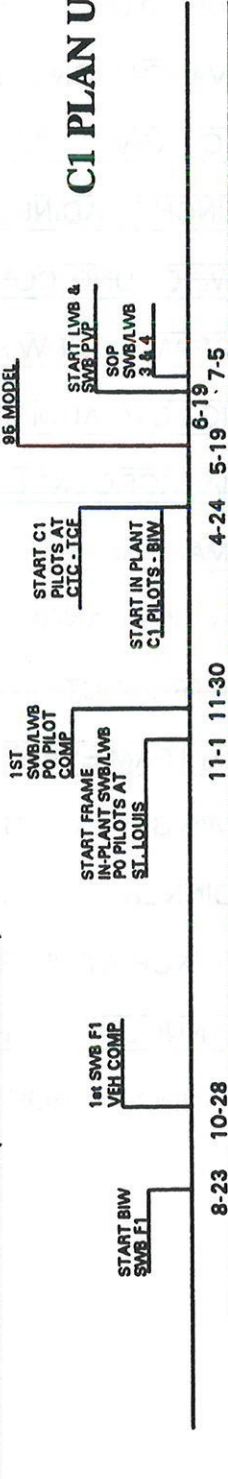
NS-BODY LWB PLAN (ST. LOUIS ASSEMBLY PLANT II - SOUTH)



NS-BODY SWB PLAN (ST. LOUIS ASSEMBLY PLANT II - SOUTH)

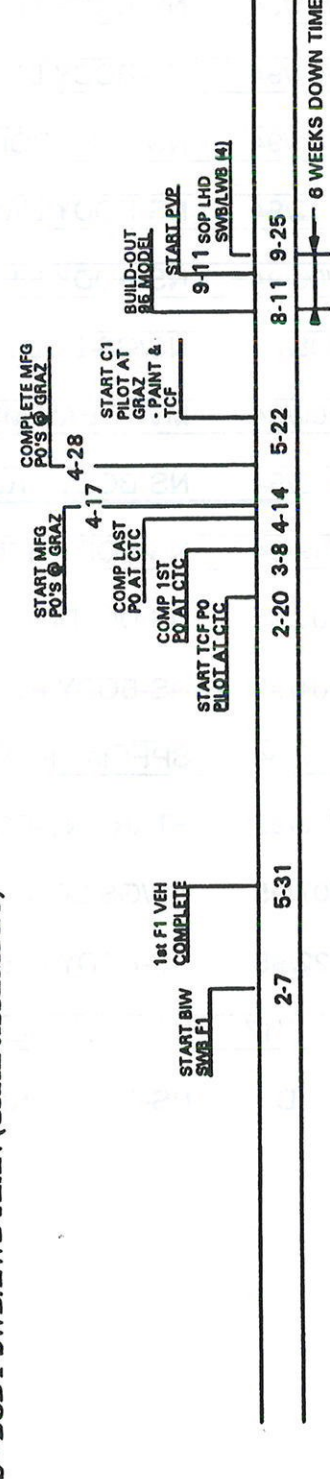


NS-BODY SWB/LWB PLAN (WINDSOR ASSY)



C1 PLAN UNDER REVIEW

GS - BODY SWB/LWB PLAN (GRAZ ASSEMBLY)



PER THE 9/16/94 PROGRAM REVIEW MEETING:
 - ST. LOUIS LWB / SWB C1 AND PVP PILOTS HAVE BEEN EXTENDED.
 - WINDSOR / GRAZ TIMING TO BE REVIEWED.

1.2 F

**NS/GS C1 STATUS REVIEW
PROGRAM TIMING**

Launch Timing

- The timing plan has been revised to reflect a 7 week deferral for Windsor start of production, and a 6 week deferral for Graz.

	<u>St. Louis</u>	<u>Windsor</u>	<u>Graz</u>
Start LWB Production	1-17-95		
First LWB PVP Unit off-line	1-30-95		
First LWB V1 Unit off-line	2-13-95		
Start SWB Production	3-1-95		
First SWB V1 Unit off-line	3-27-95		
Start SWB/LWB Production		6-19-95	
SWB/LWB V1 Ramp up		7-5-95	
Start SWB/LWB Production			9-11-95
SWB/LWB V1 Ramp up			9-25-95

- The Windsor C1 plan is under review to optimize the utilization of Windsor and CTC Pilot Operations facilities.

**"NS " CORPORATE PARTS STATUS
AS OF 11/28/94**

NS P0 PARTS REQUIREMENTS FOR ST. LOUIS (4088)

BIW START 10/17/94 - TCF START 11/14/94

STAMPING

PARTS REQUIRED BIW -	21
PARTS SHIPPED COMPLETE -	21
BALANCE DUE -	0

NS C1 PARTS REQUIREMENTS FOR ST. LOUIS (4088)

BIW START 10/31/94 - TCF START 11/21/94

STAMPING

PARTS REQUIRED BIW -	132
PARTS SHIPPED COMP -	116
PARTS SHIPPED PARTIAL -	16
BALANCE DUE -	0

POWERTRAIN

PARTS REQUIRED -	17
PARTS SHIPPED COMPLETE -	7
PARTS SHIPPED PARTIAL -	10
BALANCE DUE -	0

COMPONENT OPERATIONS

PARTS REQUIRED -	68
PARTS SHIPPED COMPLETE -	27
PARTS SHIPPED PARTIAL -	41
BALANCE DUE -	0

TEXTRON PLANTS

PARTS REQUIRED -	91
PARTS SHIPPED COMPLETE -	66
PARTS SHIPPED PARTIAL -	25
BALANCE DUE -	0

NS PURCHASE PARTS STATUS
AS OF 11-28-94

NS P0 PART REQUIREMENTS FOR ST. LOUIS (4088)

BIW START 10-17-94 - TCF START 11-14-94 (NOW 11-21-94)

PARTS REQUIRED	1376	EXTERIOR MLDG.	(3)
PARTS SHIPPED	1367	INTERIOR MLDG.	(6)
BALANCE DUE	(9)		

LWB NS C-1 PART REQUIREMENTS FOR ST. LOUIS (4088)

BIW START 10-31-94 - TCF START 11-21-94 (NOW 12-01-94)

PARTS REQUIRED	1823	EXTERIOR MLDG.	(14)
PARTS SHIPPED	1771	INTERIOR MLDG.	(22)
BALANCE DUE	(52)	CARPET	(6)
		FASCIA	(10)

WINDSOR BIW TOOL TRYOUT - PARTS DUE 11-28-94

PARTS REQUIRED	110
PARTS SHIPPED	92
BALANCE DUE	18

GS BIW TOOL TRYOUT - PARTS DUE 11-28-94

PARTS REQUIRED	178
PARTS SHIPPED	126
BALANCE DUE	52

**1996 NS-BODY
LWB St. Louis V1 Part Timing Analysis
Data Date: 11-28-94**

PRE-PVP	
MRD:	12-12-94 BW 12-19-94 TCF
START	
BUILD:	12-13-94 BW 12-26-94 TCF

PVP/V1	
MRD:	1-9-95 BW 1-17-95 TCF
START	
BUILD:	1-10-95 BW 1-24-95 TCF

	PRE-PVP Parts		
	Late To MRD Supt's Build	PPA Reqd.	PPA Apprv.
BW/DOORS	0 (0)	61* (81)	11
EXTERIOR	0 (0)	18 (18)	10
CHASSIS	1 (1)	17 (22)	9
ELECTRICAL	0 (0)	5 (7)	3
INTERIOR	3 (3)	76 (87)	55
POWERTRAIN	0 (0)	2 (2)	0
TOTAL	4 (4)	179 (197)	88

	PVP/V1 Parts		
	Late To MRD Supt's Build	IAA Reqd.	IAA Apprv.
BW/DOORS	0 (0)	43** (37)	0
EXTERIOR	0 (0)	12 (12)	0
CHASSIS	0 (0)	14 (14)	0
ELECTRICAL	0 (0)	4 (6)	1
INTERIOR	11 (10)	34 (38)	0
POWERTRAIN	0 (0)	2 (2)	0
TOTAL	11 (10)	109 (109)	1

PPA PLANS INCLUDE ALL END ITEM PARTS WHICH DO NOT CONFORM TO V1 DEFINITION BUT ARE PERMISSIBLE FOR PRE-PVP BUILD. THEY INCLUDE SPECIAL MEANS TOOLING, NON-HOMELINE SOURCE, NOT FINAL PRODUCTION PROCESS, INCOMPLETE PROCESS SIGN-OFF, AND NON-PPAP. EXCEPTION LETTERS, PPA PLANS OR OTHER AGREED-TO DOCUMENTS ARE REQUIRED.

IAA PLANS ARE SUITABLE FOR VOLUME PRODUCTION AND COVER A FIXED QUANTITY OR TIME PERIOD. AN IAA PLAN REQUIRES AUTHORIZATION OF GM-ENGRG, GM-MFG, AND GM-P&S.

* 12 CORPORATE SOURCED PARTS
** 3 CORPORATE SOURCED PARTS

lwbV1lpp

RJC MPE PROG TIMING DEPT 9900

NS-BODY LAUNCH READINESS - PART TIMING ISSUES

QUAN.	P/N	DESCRIPTION	V1 PROMISE DATE	V1 MAT'L REQ'D DATE	CLEAN POINT DATE	ISSUE	LAUNCH RISK
1	4674559	RR RAIL ASS'Y	12/12/94B	1/9/95	1/8/95E	MAT'L SPEC CHANGE TO 35 KSI MIN. FEASIBILITY TBD UNTIL RUN	(HIGH)
3	4674617	BSA- REAR LT 3 DR	12/12/94B	1/9/95	TBD	TIMING & TRYOUT AT AUTODIE	(HIGH)
4	4674894-5 4717218-9	TRACK ASS'Y- SLIDING DR UPR	11/23/94B	1/9/95	1/30/95X	SPECIAL MEANS HSS STOP BRKT	LOW
1	4716491	FRONT CLOSURE UPR C/MBR	12/12/94	1/9/95	TBD	FATIGUE FAILURE- TEST IN PROCESS	MOD
1	4716954	REINF-JACK LIFT	12/12/94	1/9/95	3/24/95	TEST FAILURE	LOW
2	4674728-9	FRONT FENDERS	12/19/94B	1/9/95	1/8/95E	AS FENDER OUTSOURCE	MOD
1	4674844	LIFTGATE ASS'Y	12/12/94B	1/9/95	1/8/95E	INNER PNL TIMING	LOW
2	4675554-5	FRONT DOOR ASS'Y	12/12/94B	1/9/95	TBD	SURFACE DISTORTION HANDLE POCKET	MOD
2	4675658-9	SLIDING DOOR ASS'Y	12/19/94B	1/9/95	TBD	SURFACE DISTORTION HANDLE POCKET	MOD
2	4716496-7	SHOCK TOWER ASSY.	12/10/94E	1/09/95	1/8/95E	DIMENSIONAL CHANGES TO DETAIL PARTS TO MEET BUILD REQUIREMENTS	(HIGH)
2	4674840-1	W/SHIELD OPNG SIDE	12/12/94B	1/09/95	TBD	SURFACE DISTORTION	(TBD)
2	4716426	REINF. SLDG. DR.	1/09/94E	1/09/95	1/09/94E	TOOLING EQUIPMENT ISSUE	LOW
2	4716498-9	FRONT RAILS	12/12/94	1/09/95	1/08/95	E/CS TO DETAIL PARTS TO MEET IMPACT	MOD
1	4674627	HOOD ASSY	12/12/94	1/09/95	TBD	BEAD ADDITION TO ADD OVERCROWN	MOD
5	4717208	HINGE & CHECK ASSTS-FRT DR	10/21/94B	1/17/95	2/16/95	PV TESTING	LOW
4	4675548-9 4675870-1	CONTROL ASSYS- SLIDING DR	12/19/94B	1/17/95	1/30/95X	PV TESTING	MOD
2	4675508-9	LATCH ASS'Y- SLIDING DR	12/19/94B	1/17/95	1/30/95X	PV TESTING	LOW
2	4716448-9	HOOD HINGE	TBD	1/17/95	TBD	IMPACT RELATED	(TBD)
2	JS12TRM	HANDLE ASS'Y- LIFTGATE	12/12/94B	1/17/95	1/15/95	PV TESTING	LOW
2	4717276-7	LATCH SHIELD	TBD	1/17/95	2/17/95X	NVH	LOW
2	4673004	WIPER MODULE	12/16/94B	1/17/95	1/27/95E	PV TESTING INCOMPLETE	(HIGH)
2	4673006-7	W/SHLD WIPER ARM ASS'Y	11/15/94B	1/17/95	1/27/95E	PV TESTING	LOW
1	4576896	GRILLE- CHRYSLER	1/17/95E	1/17/95	TBD	UPPER SURFACE APPEARANCE	(HIGH)
6	PE28TRM	SPAT- LWR W/HSE	1/17/95B	1/17/95	3/13/95	MYLAR TAPE UP TO V1; ALUMINUM- TOOL AVAILABLE 1/17/95	LOW
1	4576608	REINF- REAR BUMPER	1/13/95	1/17/95	2/28/95E	NEW FACILITY INCOMPLETE PROCESS	MOD
1	4612908	HEAT SHIELD- RR ENG MT	11/21/94B	1/17/95	2/6/95X	SOFT-TOOLED PART FOR V1	MOD
1	4612917	SHIELD- SNOW	1/3/95B	1/17/95	1/17/95E	LATE RELEASE	LOW
3	4682282	MODULE- ENGINE COOLING	12/12/94X	1/17/95	TBD	HEAVY DUTY RADIATOR PROCESS	(HIGH)
1	4683282	CABLE- PARK BRAKE REL	11/4/94B	1/17/95	TBD	DUAL PATH SOURCES	(HIGH)
4	4683360	REAR BRAKE ASS'YS	TBD	1/17/95	TBD	NOISE PROBLEM	(HIGH)
1	4472531	TIRE- 16" MICHELIN	TBD	1/17/95	1/16/95	LEFT LEAD	(HIGH)
2	4684366	KNUCKLE ASS'Y	TBD	1/17/95	2/1/95X		MOD
2	4684552	CONTROL ARM ASS'Y	TBD	1/17/95	2/1/95X	PV TESTING INCOMPLETE	LOW
1	4694725	CRADLE MODULE- FRT SUSP	TBD	1/17/95	TBD	IMPACT CHANGES	(HIGH)
2	4685516	CLUSTER ASS'Y	12/12/94B	1/17/95	1/31/95X	SOFTWARE CHANGES	LOW
1	MF83TRM	SWITCH & BEZEL- PWR WDO	12/19/94E	1/17/95	1/25/95X	IMPROVE FIT & FINISH	LOW
1	4685451	BASE- CIGAR LIGHTER	1/02/95E	1/17/95	2/6/95X	REL. LONG C/LTR. SOCK	LOW
2	4677122 4677142	UNIT ASS'Y- A/C, ZONE	TBD	1/17/95	TBD	PROCESS FAILURE	(HIGH)
1	PD80TRM	I/P ASS'Y COMPLETE	12/19/94B	1/17/95	1/31/95X	PROCESS SIGN-OFF AT LINE SPEED	MOD
11	GE64TRM	BENCH SEAT- 2 PASS.	12/19/94B	1/17/95	2/9/95	NON-HOMELINE, INITIAL LINE SPEED	LOW
8	GE90TRM	QUAD SEATS	12/19/94B	1/17/95	2/9/95	IMPACT ISSUE	(HIGH)
1	LH22TRM	HANDLE- A-PLR	11/23/94B	1/17/95	1/20/95E	SPECIAL MEANS BRKT	MOD
1	GU96TRM	TRIM PNL- D-PLR W/AC	1/12/95B	1/17/95	2/28/95	SPECIAL MEANS BRKT	LOW
6	KM34TRM	TRIM PNL- FRT DR PREM	1/17/95B	1/17/95	MAR-APR	CLOTH BOLSTER NO-BUILD	(HIGH)
2	GG55TRM	TRIM PNL- B-PLR UPR	12/15/94E	1/17/95	2/08/95E	PROCESS SIGN-OFF INCOMPLETE	MOD
2	4754528-9	BRKT- RR BOLSTER ATTACH	1/03/95E	1/17/95	3/1/95E	SPECIAL MEANS BRKT	MOD

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11/29/94

**1996 NS-BODY
SWB St. Louis C1 Part Timing Analysis
Data Date: 11-28-94**

C1
MRD: 12-12-94 BW
1-3-95 TCF

	C1 Parts	
	Late To MRD Sup's Build	PPA Reqd.
BIW/DOORS	0 (0)	0 (0)
EXTERIOR	2 (0)	10 (4)
CHASSIS	0 (0)	0 (0)
ELECTRICAL	0 (0)	0 (0)
INTERIOR	0 (0)	23 (23)
POWERTRAIN	0 (0)	0 (0)
TOTAL	2 (0)	33 (27)

PPA PLANS INCLUDE ALL END ITEM PARTS WHICH DO NOT CONFORM TO C1 DEFINITION BUT ARE PERMISSIBLE FOR PRE-PVP BUILD. THEY INCLUDE SPECIAL MEANS TOOLING, NON-HOMELINE SOURCE, NOT FINAL PRODUCTION PROCESS, INCOMPLETE PROCESS SIGN-OFF, AND NON-PPAP. EXCEPTION LETTERS, PPA PLANS OR OTHER AGREED-TO DOCUMENTS ARE REQUIRED.

**1996 NS-BODY
SWB ST. LOUIS C1 PROGRAM
PPA PARTS**

<u>COUNT</u>	<u>REF. PART NUMBER</u>	<u>DESCRIPTION</u>	<u>MATERIAL REQUIRED DATE</u>	<u>C1 MATERIAL DATE</u>	<u>CLEAN POINT DATE</u>	<u>C1 BUILD PLAN</u>
X 3	GJ94TRM	APPL ASSY SILL O/S LWR	1-3-95	1-3-95B	1-26-95X	SPECIAL MEANS
X 2	HU92TRM	APPL SILL	1-3-95	1-3-95B	1-26-95X	SPECIAL MEANS
X 3	GJ81TRM	MLDG (VARIOUS O/S)	1-3-95	1-3-95B	1-26-95X	SPECIAL MEANS
X 2	GJ81TRM	MLDG ASSY (VARIOUS O/S)	1-3-95	1-3-95B	1-26-95X	SPECIAL MEANS
I	GH48TRM	PANEL	1-3-95	12-5-94B	2-6-95X	SPECIAL MEANS
I	GH50TRM	PANEL	1-3-95	12-5-94B	2-13-95X	SPECIAL MEANS
I	GH54TRM	PANEL	1-3-95	12-5-94B	1-30-95X	SPECIAL MEANS
I	GH66TRM	PANEL	1-3-95	12-5-94B	1-23-95X	SPECIAL MEANS
I	GJ42TRM	PANEL H/LINING	1-3-95	12-5-94B	1-30-95X	SPECIAL MEANS
I	HR25TRM	MLDG ASSY RR HEADER	1-3-95	12-26-94B	1-12-95X	SPECIAL MEANS
I 2	GH58TRM	MLDG ASSY D PILLAR W/SPKR R/L	1-3-95	12-27-94B	2-17-95X	SPECIAL MEANS
I 2	GJ24TRM	MLDG ASSY D PILLAR R/L	1-3-95	2-1-95B	3-13-95X	SPECIAL MEANS
I	GZ03TRM	PANEL ASSY QTR TRIM LWR	1-3-95	1-2-95B	2-17-95X	SPECIAL MEANS
I	GZ09TRM	PANEL ASSY QTR TRIM LWR(4 DR)	1-3-95	12-2-94B	2-21-95X	SPECIAL MEANS
I 3	GZ08TRM	BOLSTER ASSY QTR TRIM RT	1-3-95	12-27-94B	2-14-95X	SPECIAL MEANS
I 6	GZ13TRM	BOLSTER ASSY QTR TRIM LT	1-3-95	10-14-94B	2-13-95X	SPECIAL MEANS
I	JF63TRM	COVER ASSY QTR TRIM PNL	1-3-95	12-13-94B	1-9-95X	SPECIAL MEANS
I	HE50TRM	PLUG	1-3-95	10-14-94B	3-27-95X	SPECIAL MEANS

- 1996 MODEL RESTRICTIONS & LATE AVAILABILITY -
MATERIAL SUPPLY

REPORT-1
PAGE: 1

SALES CODE OR MODEL	PRODUCT DESCRIPTION	VEHFAM MODEL	PERCENT SHL PLT	ORD BLK POINT	PILOT DATES	QUALITY DECISION	FRAME DATES	JOB-1 DATES	ORDERS ON/HD	REMARKS
St.Louis-1 FRAME DATE: 01/31/95 JOB 1 DATE: 02/13/95										
A.W.D.	ALL WHEEL DRIVE MODELS	NSC 53 NSD 53 NSP 53		ORDER			TBD	TBD	0	PART SUPPLY ISSUE. VENDOR UNABLE TO SUP DUAL A.W.D. SYSTEMS.
PCS	LIGHT IRIS P.C.	NS		ORDER			TBD	TBD	0	NON APPROVED PAINT.
PH2	CANDY APPLE RED C.C. (RRC BASE)	NS		ORDER			TBD	TBD	0	NON APPROVED PAINT.
PUP	SILVER WHITE PEARL TRI- COAT	NS		ORDER			TBD	TBD	0	NON APPROVED PAINT.
SER	LOAD LEVELING & HEIGHT CONTROL	NS		ORDER			TBD	TBD	0	PART ISSUE. (LOAD LEVELERS PULL OF FRAME).

ADDED OR REVISED: SINCE 11/21/94
\$ UNDER REVIEW BY SALES TO DETERMINE FEASIBILITY
E ESTIMATED (TARGET DATE)

T TENT. EFF. POINT (TEP)
F FIRM/COMMITTED
A ACTUAL

(((END OF REPORT

PRELIMINARY

**1996 MODEL YEAR NS PCN STATUS
SUMMARY AS OF 11-29-94**

	PCN's INITIATED	PCN's NOT APPROVED NOT RECVD BY PCA	PCN's NOT APPROVED RECVD BY PCA	PCN's APPROVED NOT SUMMARIZED	PCN's SUMMARIZED
P-0	718 (717)	2 (1)	0 (0)	2 (3)	714 (713)
C-1	769 (765)	16 (13)	13 (14)	93 (101)	647 (637)
V-1	439 (426)	63 (55)	42 (51)	151 (151)	183 (169)
V-2	92 (87)	35 (32)	(7)	29 (31)	20 (17)
TOTAL	2018 (1995)	116 (101)	63 (72)	275 (286)	1564 (1536)

'96 NS-BODY JOB #1 PCN FORECAST

	MIT'S TOTAL OPEN & VERIFY	MIT'S PCN REQ'D TO CLOSE	MIT'S PCN INITIATED TO CLOSE	MIT'S PCN'S YET TO GO	PCN FORCAST W/O MIT'S YTG	TOTAL PCN'S YET TO GO
BIW & EXT	102	54	48	6	41	47
INTERIOR	87	43	42	1	25	26
E/E	39	28	24	4	22	26
CHASSIS	44	15	12	3	7	10
POWERTRAIN	32	14	13	1	3	4
VEHICLE DEVELOPMENT	89	35	33	2	0	2
BIC TEAMS (7050)	232	109	104	5	0	5
TOTALS	625	298	276	22	98	120

**NS/GS C1 STATUS REVIEW
MITS/PCN STATUS**

Total MITS Summary as of 11/28/94

●	Closed	3802 (81%)	<u>1A</u>	<u>1B</u>	<u>2</u>
	Verify	554 (12%)	56	447	51
	Open	<u>339 (7%)</u>	48	251	40
		4695			

PCN Status

- A total of 2018 PCNs have been initiated as of 11/29/94. A majority of the PCNs to date were in place for PO or will affect C1

	<u>PCNs Initiated</u>	<u>% of Total</u>
PO	718 (719)	36 %
C1	769 (751)	38 %
PVP/V1	439 (331)	22 %
V2	<u>92 (56)</u>	4 %
Total	2018 (1858)	

- A PCN cut-off date of 10/30/94 has been instituted to stabilize part change levels at PVP/V1. Exceptions to the PCN cut-off date require General Manager approval. A total of 259 PCNs have been approved since the cut-off date.

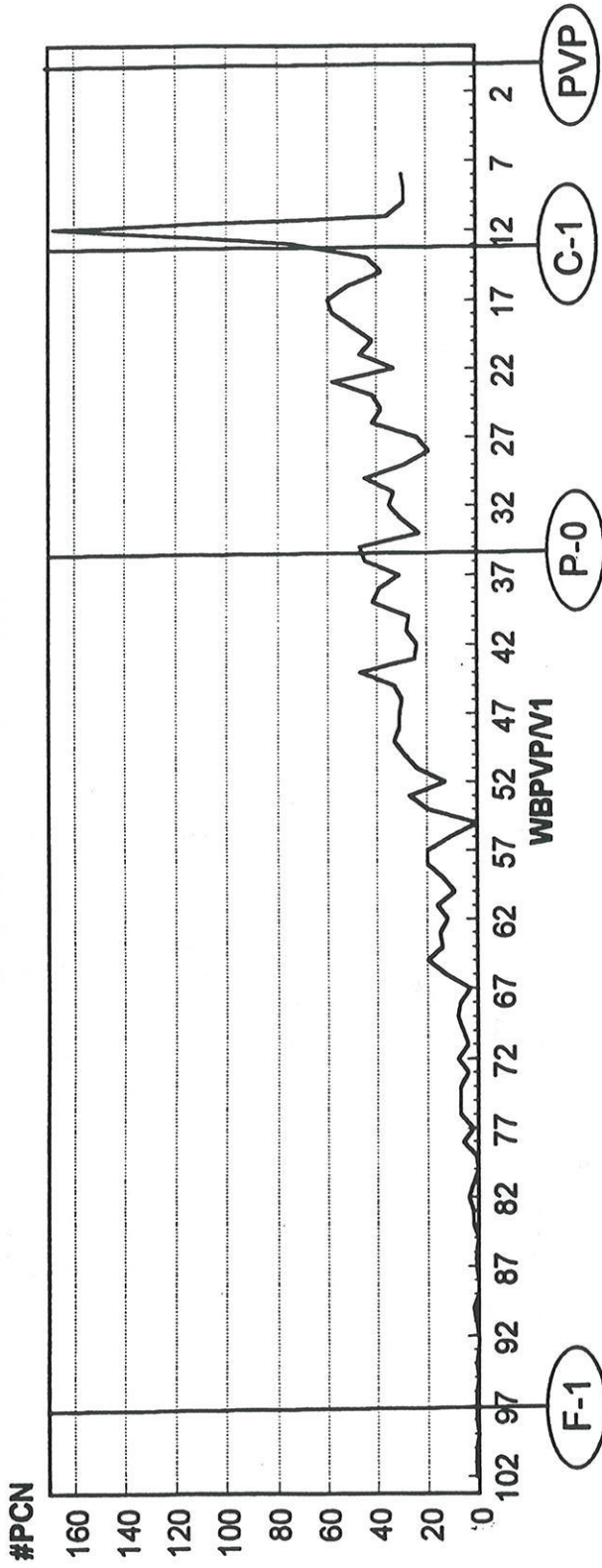
- A total of 339 PCNs are projected yet to go for approval:

PCNs Received/not app'd.	63
PCNs Initiated/not rec'd.	116
PCNs Projected	<u>120</u>
	399

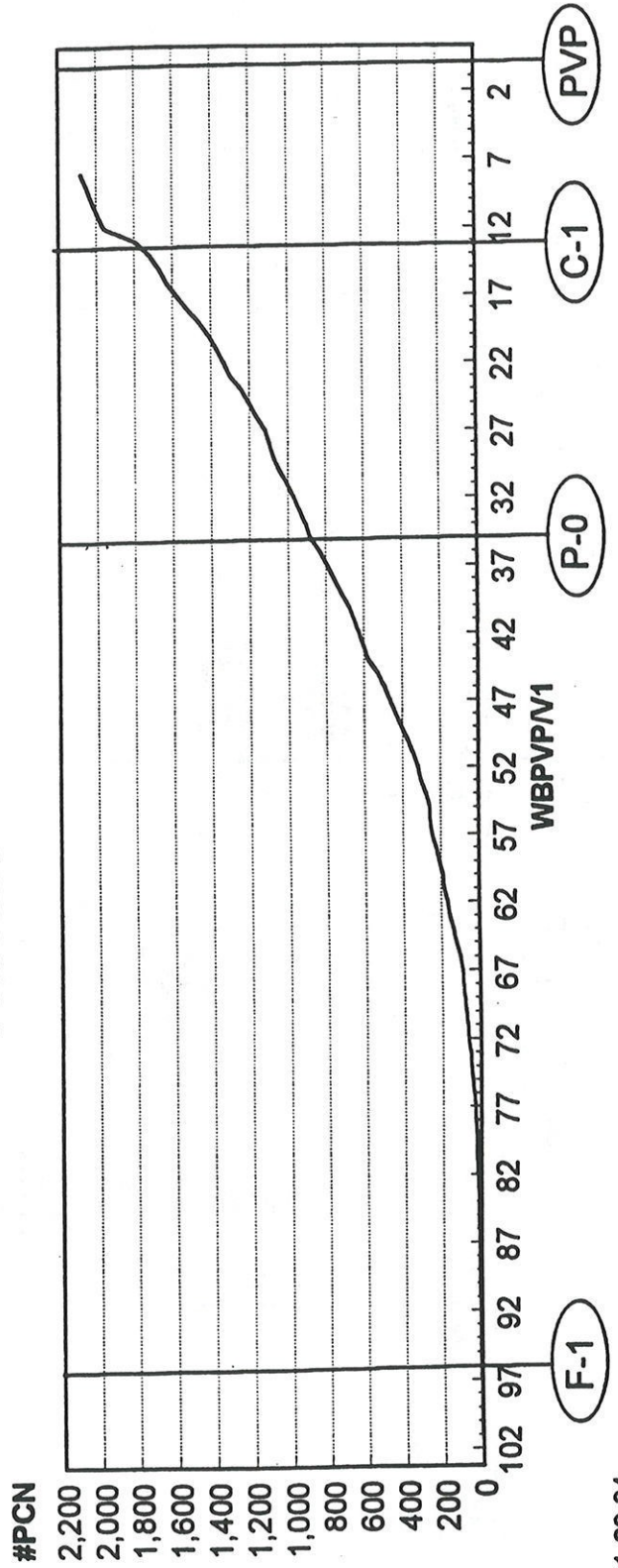
- Critical V2 PCNs not meeting V1 timing will be batched in on 3/2/95 for BIW and 3/9/95 for TCF. This is consistent with SWB start of production and prior to significant production line acceleration.

1996 NS-BODY PCN SUMMARY

PCN WEEKLY ACTIVITY



PCN CUMULATIVE ACTIVITY



PROCESS SIGN-OFF: BODY & EXTERIOR SYSTEMS

PSO Still Open With One Or More Line Items UNACCEPTABLE (Plant Visit May Be Required)				PSO Still Open With One Or More Line Items UNACCEPTABLE (Plant Visit May Be Required)				PSO Visits Still To Be Conducted (Plant Revisit Required)				PSO Visits Completed ACCEPTABLE			
Supplier	Component	Part #s	Count	Supplier	Component	Part #s	Count	Supplier	Component	Part #s	Count	Supplier	Component	Part #s	Count
Schaller	Sliding door reinf, upper hinge	2	X	Mullimatic	Checks, front door	2	2	Mullimatic	Hinge, front door	4	4	AVM	Gas props, liftgate	1	1
Schaller	Sliding door reinf, center hinge	2	X	Ran	Hinge, liftgate	2	2	Fabco	Liftgate drain trough Assy	2	2	Seeburn	Can/lever jack	1	1
			X	Mullimatic	Hinge, sliding door	5	5	Fabco	Hood hinges, hood half	2	2	Mascotech	Glass handle and activator	2	2
			X	Shape	Bumper reinf, front	1	1	Rader	T/plate body front hinge plate	2	2	Valeo	Liftgate wiper motor	1	1
			X	Trim Trends	Roll frame Assy, front door	1	1	KTM-Atoma	Hood latch Assy	1	1	Trico	Wiper arm and blades, rear	1	1
			X	Trim Trends	Roll frame Assy, front door	1	1	KTM-Atoma	Hood plate and striker	1	1	MacCord-Wynn	Reservoir Assy	1	1
			X	Benteler	Impact beam, sliding door	2	2	Sur-Flo Plastics	Support Assy, radiator	1	1	Lescoa	License lamp Assy	2	2
			X	Benteler	Impact beam, front door	2	2	Nashville Plastics	Cowl plenum gr cover	1	1	Lescoa	CHMSL	2	2
			X	SKD	Bumper reinf, rear	1	1	Lexamar	B pillar applique	2	2	Glireath	Air dam	1	1
			X	SKD	Bumper ext, rear	2	2	Standard Products	Front door trim	2	2	5 Rubber	Weatherstrip, hood to cowl	2	2
			X	Pullman	Sliding door tracks	10	10	Standard Products	Sliding door trim	3	3	5 Rubber	End blocker	2	2
			X	Schaller	Sliding door reinf, lower hinge	2	2	Standard Products	Quarter panel trim	5	5	5 Rubber	Weatherstrip, front door sec	1	1
			X	Schaller	Door shut face striker	2	2					5 Rubber	Weatherstrip, sliding door sec	6	6
			X	Fabco	Spare tire winch	2	2					5 Rubber	Weatherstrip, liftgate opening	1	1
			X	Fabco	Sliding door stops	2	2					5 Rubber	Weatherstrip, liftgate sec	1	1
			X	Fabco	Hood hinges, body half	2	2					5 Rubber	Weatherstrip, quarter window	4	4
			X	Siegel Robert	Front door handle Assy	2	2					5 Rubber	Weatherstrip, sliding door opening	2	2
			X	Siegel Robert	Sliding door o/s handle	9	9					Schlegel	Weatherstrip, hood to grille	1	1
			X	Siegel Robert	Front door o/s handle	3	3					Schlegel	Moulding, header	2	2
			X	Rockwell	Front door window regulator	4	4					Schlegel	Moulding, A pillar	2	2
			X	KTM-Atoma	Door latch	2	2					Schlegel	Moulding, B pillar	2	2
			X	KTM-Atoma	Door latch striker	1	1					Schlegel	Glass run Assy	2	2
			X	KTM-Atoma	Control Assy, front door	2	2					Schlegel	Weatherstrip, front door outer belt	4	4
			X	KTM-Atoma	Hold open latch, sliding door	2	2					Schlegel	Weatherstrip, front door body mt	4	4
			X	KTM-Atoma	Fuel filler interlock	1	1					Schlegel	Weatherstrip, front door inner belt	2	2
			X	KTM-Atoma	Control Assy, power	2	2								
			X	KTM-Atoma	Striker Assy	1	1								
			X	KTM-Atoma	Striker stop	2	2								
			X	KTM-Atoma	Liftgate latch Assy	1	1								
			X	KTM-Atoma	Liftgate release handle	2	2								
			X	ITW Deltar	Glass Assy	7	7								
			X	Domnelly	Glass Assy	11	11								
			X	ITT-SKIF	Front wiper module	2	2								
			X	ITT-SKIF	Wiper arm	2	2								
			X	ITT-SKIF	Wiper blade	1	1								
			X	Ooram Sylvania	Lamp Assy, aero headlamp	2	2								
			X	Lowell	Mirror Assy, o/s	6	6								
			X	Ewart	Tailamp Assy	2	2								
			X	Davidson	Grille, Chrysler	1	1								
			X	Davidson	Fascia	7	7								
			X	Decoma	Fascia	4	4								
			X	ITW Deltar	Fuel door	1	1								
			X	ITW Deltar	Fuel door housing	1	1								
			X	Mascotech	Luggage rack side rail, LWB	2	2								
			X	Mascotech	Luggage rack cross rail	1	1								
			X	Mascotech	Luggage rack side rail, SWB	2	2								
			X	OEM/Eno	Liftgate applique	1	1								
			X	Lexamar	Rear fender 307 trim	2	2								
			X	Lexamar	Front door trim	2	2								
			X	Lexamar	Sliding door trim	2	2								
			X	Lexamar	Right front quarter trim	2	2								
			X	Lexamar	Left quarter trim	4	4								
			X	Lexamar	Fender applique	2	2								
			X	Lexamar	Front door applique	2	2								
			X	Lexamar	Sliding door applique	2	2								
			X	Lexamar	Front quarter applique	2	2								
			X	Andover	Front sill trim	4	4								
			X	Andover	Rear sill trim	8	8								
			X	Andover	Front door trim	4	4								
			X	Andover	Sliding door trim	6	6								
			X	Andover	Quarter panel trim	13	13								
			X	Andover	Front fender trim	4	4								
			X	Andover	Body side trim	1	1								

3.1 F

NS CI STATUS REVIEW BIW AND EXTERIOR

Significant Issues

- | | |
|--|--|
| <ul style="list-style-type: none"> ●R Sliding door upper hinge track ●R Cooling module attaching tabs ●R Cowl grille outboard attachment ● Wiper module supplier concern ● Side glass variability ● B-Plr Applique UV ● Exterior molding packages | <ul style="list-style-type: none"> ● Chrysler Grille appearance ●R E-coat drainage ● Cladding wet-out ● Mirror shake ● Paint UV approvals ● Shock tower dim. tuning ● Jacking pad reinforcement |
|--|--|

R - Resolved
* - Major Concern

Process Sign-off Status:

Total Number of Suppliers	40	
Total Number of Supplier Locations	45	
Total Number of Process Sign-offs	55	
Total Parts Requiring Sign-off	262	
Acceptable	48	(18%)
Conditional	4	(1%)
Rejected	184	(70%)
To Be Conducted	28	(11%)

DV/PV Testing:

DV Testing - 100% Complete
PV Testing - 60% Complete

MITs Status

Closed	970	<u>1A</u>	<u>1B</u>	<u>2</u>
Verify	64	15	47	2
Open	<u>37</u>	9	22	6
	1071			

PCN Status

	<u>Initiated</u>	<u>Not Recd.</u>	<u>Not Appd.</u>	<u>Appd./Summarized</u>
C1	232	0	0	232
V1	170	26	16	128
V2	<u>13</u>	<u>3</u>	<u>1</u>	<u>9</u>
	415	29	17	369

NS CI STATUS REVIEW INTERIOR

Significant Issues

- | | |
|---|--|
| <ul style="list-style-type: none"> ●* A/C evaporator ● Front door trim bezel fit ●R Adjustable turning loop feel and efforts ● Headliner stiffness ● Quad seat pull test | <ul style="list-style-type: none"> ●* Premium front door trim panels ●* Heater core buzz ● Interior trim fit and finish ● Interior BSR |
|---|--|

R - Resolved
* - Major Concern

Process Sign-off Status:

Total Number of Suppliers	37
Total Number of Supplier Locations	66
Total Number of Process Sign-offs	100
Total Parts Requiring Sign-off	485
Acceptable	28 (6%)
Conditional	0 (0%)
Rejected	106 (22%)
To Be Conducted	351 (72%)

DV/PV Testing:

DV Testing - 100% Complete
PV Testing - 70% Complete

MIT Status

Closed	423	<u>1A</u>	<u>1B</u>	<u>2</u>
Verify	55	5	46	4
Open	<u>27</u>	2	15	10
	505			

PCN Status

	<u>Initiated</u>	<u>Not Recd.</u>	<u>Not Appd.</u>	<u>Appd./Summarized</u>
C1	244	6	1	237
V1	119	14	18	87
V2	<u>27</u>	<u>16</u>	<u>3</u>	<u>8</u>
	390	36	22	332

PROCESS SIGN-OFF ELECTRICAL / ELECTRONIC SYSTEMS

PSO Still Open With One Or More Line Items CONDITIONALLY ACCEPTABLE (Plant Revisit May Not Be Required) SUPPLIER - COMPONENT	PSO Still Open With One or More Line Items UNACCEPTABLE (Plant Visit May Be Required) SUPPLIER - COMPONENT	PSO Visits Still To Be Conducted SUPPLIER - COMPONENT
No Components Currently Fall Into This Category	Blue Water - Thermoguard Champion - Spark Plugs (FC12YC5) 2.4L Diamond - Coil - Ignition 2.4L Donnelly - Lamp - Dome W/Lens Ebi/Hi Ram - Junction Block Assembly EMD - Wiring Harness - Dome EMD - Wiring Harness - Doors EMD - Wiring Harness - EDW EMD - Wiring Harness - Instrument Panel EMD - Wiring Harness - Mirrors EMD - Wiring Harness - Powertrain Exemplar - Power Distribution Center - Top Assembly Motorola - Relay - Radiator, SSR Nippondenso - Instrument Cluster, Base Philips - Sensor - Cam Magnet Target (Edz) Philips - Sensor - Cam Reference (Edz) Philips - Sensor - Crank Timing (Edz) Prestolite - Cable - Ignition 2.4L 4672114 Weastec - Coil - Ignition 2.4L Acustar Electronics - Module - Engine Controller SBEC-III Augat - Power Distribution Center - Base Assembly Augat - Power Distribution Center - Plastic Parts Chivas - Lamp - Courtesy W/Lens - Front Door 4685225 Chivas - Lamp - Courtesy W/Lens - Liftgate Chivas - Lamp - Reading Lp, Map (Front Header) Eaton - Switch - Memory Select (Appearance Only) Eib/Hi Ram - Relay - ABS System (Carry Over) Eib/Hi Ram - Relay - Fuel Pump (Carry Over) EMD - Wiring Harness - Modules JCI - Battery (JCI) 4727059, 4727160 Prestolite - Cable - Ignition 3.3L/3.8L TRW - Switch - Remote Mirror Control (Appearance Only) Acustar Electronics - Module, Transmission Controller EATX-III CASCO - Cigar Lighter / 12 V Outlet, Base Eaton - Switch - Electric Door Lock Eaton - Switch - Electric Window Master Eaton - Switch - Electric Window Single Interlock - 10-Way 90 Degree Dress Covers Interlock - 14-Way 90 Degree Dress Covers Micro-Switch - Sensor - Cam Reference (EGA/EGH) (C/O) Micro-Switch - Sensor - Crank Timing (EGA/EGH) (C/O) Motorola - Sensor - M.A.P. (Motorola) 3.0L (C/O) Philips - Sensor - Vehicle Speed (Carry Over) Prince - Overhead Console - W/O CMTC Prince - Overhead Console W/CMTC Spartan - Horns Thomas & Betts - 23-Way (Bc & Jb) Headers TRW - Module - Remote Keyless Entry, Transmitter	Champion - Spark Plugs - Platinum 3.3L/3.8L Hella - Relay & Bracket Hi-Stat - Switch - Oil Pressure Textron-Acustar - Module - Message Center 12-15-94 12-10-94 12-06-94 12-06-94

3.3F

NS CI STATUS REVIEW E/E SYSTEMS

Significant Issues

- | | |
|---|--|
| <ul style="list-style-type: none"> ●R EDW chute side cowl installation ●R EDW routing change verification ● One touch down switching | <ul style="list-style-type: none"> ●R Mechanical cluster software ● Door switch bezel fit ●R Lt. dash stud relocation |
|---|--|

R - Resolved
* - Major Concern

Process Sign-off Status:

Total Number of Suppliers	56
Total Number of Supplier Locations	66
Total Number of Process Sign-offs	125
Total Parts Requiring Sign-off	167
Acceptable	80 (48%)
Conditional	0 (0%)
Rejected	46 (28%)
To Be Conducted	41 (25%)

DV/PV Testing:

DV Testing - 100% Complete
PV Testing - 66% Complete

MIT Status

Closed	299	<u>1A</u>	<u>1B</u>	<u>2</u>
Verify	28	3	20	5
Open	<u>5</u>	0	5	0
	332			

PCN Status

	<u>Initiated</u>	<u>Not Recd.</u>	<u>Not Appd.</u>	<u>Appd./Summarized</u>
C1	94	1	0	93
V1	52	8	1	43
V2	<u>12</u>	<u>1</u>	<u>0</u>	<u>11</u>
	158	10	1	147

PROCESS SIGN-OFF CHASSIS SYSTEMS

PSO Still Open With One Or More Line Items CONDITIONALLY ACCEPTABLE (Plant Revisit May Not Be Required)	PSO Still Open With One or More Line Items UNACCEPTABLE (Plant Visit May Be Required)	PSO Visits Still To Be Conducted
SUPPLIER - COMPONENT	SUPPLIER - COMPONENT	SUPPLIER - COMPONENT
PV/PS/LS	PV/PS/LS	RE-VISIT
DEPT. 9610 Randall Textron Dayton Thermal Algoods Automotive Industries DEPT. 9620 K/H Mt. Vernon K/H Woodstock Teves ABS Bendix Gallagher Sebro Bendix Sumter SSI Aloma ITT Higbie Weatherhead Spartan Dominion - Canada Dominion - Mexico DEPT. 9630 Rassini Thompson Rockwell Vettri Plastech Preferred Tech Anchor Swan	DEPT. 9610 SKD - 1/13/95 Wellington - TBD Arvin - 12/19/94 Heckelhorn - 12/22/94 Solway - 12/1/94 DEPT. 9630 New Castle Machining - 12/9/94 Detroit Axle - 12/2/94 Schroeder Valve - TBD Ullica Metals - 12/7/94 Goodyear Tire - 11/30/94 Michelin - 1/10/95 Hayes Wheel - 2/3/95 Rockwell Fumagalli - 1/10/95 CMI - 12/15/94 Yale - TBD	11/30/94 12/07/94 01/12/95 12/21/94 TBD 12/15/94 12/94 12/8,9/94 TBD TBD 12/15/94 12/14, 15/94 12/09/94 TBD 12/02/94 12/13/94 12/01/94 12/07/94 01/14/95 TBD 12/05/94 TBD 12/09/94 TBD

3.4F

NS CI STATUS REVIEW CHASSIS

Significant Issues

- | | |
|--|--|
| <ul style="list-style-type: none"> ●* Rear brake howl verificaton ● Rear brake shoe rattle, adjuster performance ● Tire left lead - 16" Michelin ●R Floor pan wire trough thermal protection | <ul style="list-style-type: none"> ● ABS intermittent light ●R Fuel system impact performance ●R Heavy duty radiator processing |
|--|--|

R - Resolved

* - Major Concern

Process Sign-off Status:

Total Number of Suppliers	46
Total Number of Supplier Locations	59
Total Number of Process Sign-offs	59
Total Parts Requiring Sign-off	283
Acceptable	59 (21%)
Conditional	0 (0%)
Rejected	201 (71%)
To Be Conducted	23 (8%)

DV/PV Testing:

DV Testing - 92% Complete

PV Testing - 26% Complete

MITS Status

Closed	405	<u>1A</u>	<u>1B</u>	<u>2</u>
Verify	26	2	21	3
Open	<u>20</u>	6	12	2
	451			

PCN Status

	<u>Initiated</u>	<u>Not Recd.</u>	<u>Not Appd.</u>	<u>Appd./Summarized</u>
C1	76	2	0	74
V1	39	3	0	36
V2	<u>5</u>	<u>3</u>	<u>0</u>	<u>2</u>
	120	8	0	112

PROCESS SIGN-OFF POWERTRAIN ENGINEERING

PSO Still Open With One Or More Line Items CONDITIONALLY ACCEPTABLE (Plant Revisit May Not Be Required) SUPPLIER - COMPONENT	PSO Still Open With One or More Line Items UNACCEPTABLE (Plant Visit May Be Required) SUPPLIER - COMPONENT	PSO Visits Still To Be Conducted SUPPLIER - COMPONENT								
No Components Currently Fall Into This Category	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 10%; text-align: center;">PV</td> <td style="width: 10%; text-align: center;">PS</td> <td style="width: 10%; text-align: center;">LS</td> <td style="width: 80%;"> X Air Cleaner Assembly - Siemens X Right & Left Engine Mount Assemblies - Freudenberg X Shift Cable Brackets - M&G Engineering X Front & Rear Engine Mount Assemblies - Freudenberg X Intake Manifold Cover - Cascade Engineering X ATX Shift Cable - Teleflex Automotive X I-4 Air Induction Resonator Assembly - Siemens X Vapor Canister Assembly - Dayton Acustar X 2.4L ATX & MTX Throttle Body Assembly </td> </tr> </table>	PV	PS	LS	X Air Cleaner Assembly - Siemens X Right & Left Engine Mount Assemblies - Freudenberg X Shift Cable Brackets - M&G Engineering X Front & Rear Engine Mount Assemblies - Freudenberg X Intake Manifold Cover - Cascade Engineering X ATX Shift Cable - Teleflex Automotive X I-4 Air Induction Resonator Assembly - Siemens X Vapor Canister Assembly - Dayton Acustar X 2.4L ATX & MTX Throttle Body Assembly	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 10%; text-align: center;">PV</td> <td style="width: 10%; text-align: center;">PS</td> <td style="width: 10%; text-align: center;">LS</td> <td style="width: 80%;"> Canister Vent Harness - Bates Fabricating Air Induction Fresh Air Duct - Siemens Rear Engine Mount Heat Shield - Soundwich Air Intake Snow Shield - Huron Plastics Rear 3.3/3.8L Exhaust Heat Shield - Soundwich 3.3/3.8L Engine Assembly 2.4L Engine Assembly 31TH Transmission - Kokomo Transmission 41TE Transmission - Kokomo Transmission </td> </tr> </table>	PV	PS	LS	Canister Vent Harness - Bates Fabricating Air Induction Fresh Air Duct - Siemens Rear Engine Mount Heat Shield - Soundwich Air Intake Snow Shield - Huron Plastics Rear 3.3/3.8L Exhaust Heat Shield - Soundwich 3.3/3.8L Engine Assembly 2.4L Engine Assembly 31TH Transmission - Kokomo Transmission 41TE Transmission - Kokomo Transmission
PV	PS	LS	X Air Cleaner Assembly - Siemens X Right & Left Engine Mount Assemblies - Freudenberg X Shift Cable Brackets - M&G Engineering X Front & Rear Engine Mount Assemblies - Freudenberg X Intake Manifold Cover - Cascade Engineering X ATX Shift Cable - Teleflex Automotive X I-4 Air Induction Resonator Assembly - Siemens X Vapor Canister Assembly - Dayton Acustar X 2.4L ATX & MTX Throttle Body Assembly							
PV	PS	LS	Canister Vent Harness - Bates Fabricating Air Induction Fresh Air Duct - Siemens Rear Engine Mount Heat Shield - Soundwich Air Intake Snow Shield - Huron Plastics Rear 3.3/3.8L Exhaust Heat Shield - Soundwich 3.3/3.8L Engine Assembly 2.4L Engine Assembly 31TH Transmission - Kokomo Transmission 41TE Transmission - Kokomo Transmission							

3.51

**NS C1 STATUS REVIEW
POWERTRAIN**

Significant Issues

- R A/C Engagement bump
- R Diff. bearing ret. bolts loosening verification
- R Rear Engine Mount Grounding
- R OBD II verification
- R ATX shift cable squeak

R - Resolved

* - Major Concern

Process Sign-Off Status (PPQR Programs Only)

Total Number of Suppliers	7
Total Number of Supplier Locations	12
Total Number of Process Sign-Offs	16
Total Parts Requiring Sign-Off	58
Acceptable	7 (12%)
Conditional	0 (0%)
Rejected	25 (43%)
To Be Conducted	26 (44%)

DV/PV Testing

DV Testing - 97.6% Complete (Remaining tests are on Windsor unique components)

PV Testing - 82.6% Complete

 31 Total Tests remain to be completed

 8 of 31 remaining tests are on St. Louis unique components

 23 of 31 remaining tests are on Windsor unique components

MITs Status

		<u>Priority 1A</u>		<u>Priority 1B</u>		<u>Priority 2</u>	
		<u>Wind.</u>	<u>StL</u>	<u>Wind</u>	<u>StL</u>	<u>Wind</u>	<u>StL</u>
Closed	233						
Verify	15	1	3	3	4	0	4
Open	<u>13</u>	0	3	1	7	1	1
	261						

PCN Status

	<u>Initiated</u>	<u>Not Recd.</u>		<u>Not Appd</u>		<u>Appd/Summarized</u>
		<u>Wind</u>	<u>StL</u>	<u>Wind</u>	<u>StL</u>	
C-1	94	1	6	0	6	81
V-1	46	7	3	1	2	33
V-2	<u>28</u>	<u>9</u>	<u>3</u>	<u>2</u>	<u>1</u>	<u>13</u>
Totals	168	17	12	3	9	127

NS/GS C1 READINESS
"OFF-LOAD" STAMPING STATUS

- NS stamping "offload" program consists of 22 components which are all sourced.

- Die sets buy-off status
 - 15 die sets have been bought off by suppliers

 - Remaining 7 die sets have the following buy-off dates:
 - 2 parts: 12/1/94
 - 2 parts: 12/21/94
 - 3 parts: TBD due to engineering changes

- PVP sample date status (process sign-off complete)
 - 17 LWB parts:
 - In November of 1994: 3 parts
 - In December of 1994: 4 parts
 - By January 6 of 1995: 5 parts
 - TBD: 5 parts due to engineering changes and bull ring availability

 - 5 SWB unique parts: 1/31/95

- * note: IAA parts will be sought if process sign-off's are not successful

NS C-1STATUS REVIEW STAMPING STATUS

	<u>SSP</u>		<u>TSP</u>		<u>WSP</u>		<u>TOTALS</u>	
	<u>LWB</u>	<u>SWB</u>	<u>LWB</u>	<u>SWB</u>	<u>LWB</u>	<u>SWB</u>	<u>LWB</u>	<u>SWB</u>
PARTS / CONDITIONAL (conditionals resolved)	45 / 16 (8)	8 / 0	57 / 11 (11)	5 / 0	20 / 7 (5)	3 / 0	122 / 34 (24)	16 / 0
ASSEMBLIES / CONDITIONAL (conditionals resolved)	16 / 8 (2)	1 / 0	25 / 8 (7)	3 / 0	3 / 2 (0)	1 / 0	44 / 19 (9)	5 / 0
DIE SETS / SHIPPED	38 / 30	7 / 2	47 / 39	4 / 2	18 / 16	3 / 3	101 / 85	14 / 7
ASSY SYSTEMS / SHIPPED	15 / 14	1 / 1	19 / 19	1 / 1	3 / 3	1 / 1	37 / 36	3 / 3
PVP HOMELINE AAPROVALS	21	1	29	2	14	3	64	6
PPVP PARTS NOT IN HOMELINE	13	0	12	0	3	0	28	0

PVP CONCERNS

4674753-4 REAR RAILS LWB & SWB

MATERIAL SPECIFICATION CHANGE TO
35 KSI MINIMUM.

4716491 RADIATOR C/MEMBER ASSY.

PENDING TEST OF REVISED ASSEMBLY.

4716496-7 SHOCK TOWER ASSY.

DIMENSIONAL CHANGES TO DETAIL PARTS TO
MEET BUILD REQUIREMENTS.

4716498-9 FRONT RAIL ASSYS.

ENGINEERING CHANGES TO DETAIL PARTS TO
MEET IMPACT REQUIREMENTS.

4675554-5 FRONT DOOR ASSYS.

SURFACE DISTORTION AT HANDLE POCKET.

4675658-9 SLIDING DOOR ASSYS.

SURFACE DISTORTION AT HANDLE POCKET.

4674627 HOOD ASSY.

BEAD ADDITIONS TO ADD OVERCROWN.

4674840-1 A PILLAR COVERS
4716349

SURFACE DISTORTION. (purchase parts to be run at active)

HOMELINE CONCERNS

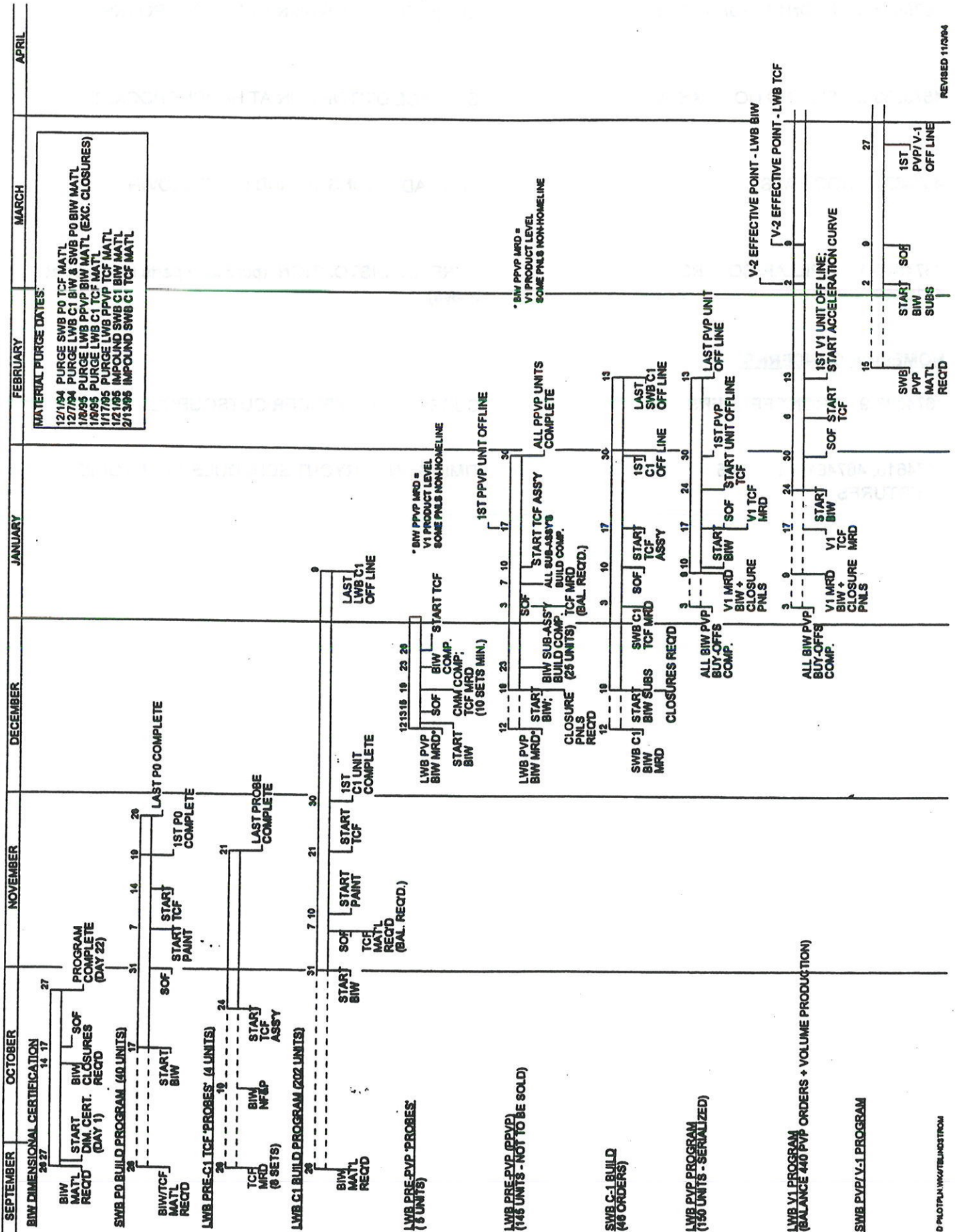
4674728-9 FRONT FENDERS

CURRENT "AS" FENDER OUTSOURCE.

4674616, 4674617, 4716005
APERTURES

TIMING AND TRYOUT SCHEDULE AT AUTODIE.

NS-BODY PILOT/LAUNCH PLAN - ST. LOUIS



5.1F

1996 NS ST. LOUIS BUILD SCHEDULE

(Number of units)

DAY	DATE	FRAME		PAINT		START TCF		FINISH TCF		REMARKS	
		SCH	ACT	SCH	ACT	SCH	ACT	SCH	ACT		
SAT	12-Nov	16	16							P0 framing complete - ACTUAL. First C1 framed - ACTUAL.	
SUN	13-Nov	0	24								
TOTALS		16	40								
MON	14-Nov	5	5	5	0						
TUE	15-Nov	5	0		0						
WED	16-Nov	5	0	6	6						
THU	17-Nov	5	5		0						
FRI	18-Nov	4	3	8	5						
SAT	19-Nov	5	3								
SUN	20-Nov	0									
CUM TOTALS		45	56	19	11					First P0 to trim, - 7 days to schedule.	
MON	21-Nov	5	7	10	8	1	1				
TUE	22-Nov	5	5		10	2	2				
WED	23-Nov			11	11	2	2				
THU	24-Nov										
FRI	25-Nov										
SAT	26-Nov										
SUN	27-Nov										
CUM TOTALS		55	68	40	40	5	5				
MON	28-Nov	10		10		5					TODAY First P0 complete. First C1 to trim, -10 days to schedule.
TUE	29-Nov	10		10		5					
WED	30-Nov	10		10		7		1			
THU	01-Dec	10		10		3		2			
FRI	02-Dec	10		10		5		2			
SAT	03-Dec										
SUN	04-Dec										
CUM TOTALS		105		90		30		5			
MON	05-Dec	20		15		10		7		P0 units are shaded. First C1 off line, -7 days to schedule (Was 11/30.)	
TUE	06-Dec	20		20		10		10			
WED	07-Dec	20		20		10		11			
THU	08-Dec	20		20		10		11			
FRI	09-Dec	20		20		10		11			
SAT	10-Dec										
SUN	11-Dec										
CUM TOTALS		205		185		80		55			
MON	12-Dec	20		20		15		15			Framing last C1s. Framing starts on pre-PVP (shaded units.)
TUE	13-Dec	17		20		15		15			
WED	14-Dec			17		15		15			
THU	15-Dec					15		15			
FRI	16-Dec					15		15			
SAT	17-Dec										
SUN	18-Dec										
CUM TOTALS				242		155		130			
MON	19-Dec					15		15		cc: Austin, Donaldson, Lindstrom, Scott.	
TUE	20-Dec					15		15			
WED	21-Dec					15		15			
THU	22-Dec					10		15			
FRI	23-Dec							15			
SAT	24-Dec										
SUN	25-Dec										
CUM TOTALS		247		242		210		205			

NS/GS CUSTOMER SATISFACTION/QUALITY STATUS

16 GLOBAL FUNCTIONAL OBJECTIVES

- **Best in Class Status - 7 Objectives**
 - Parcel/Stowage Provisions
 - Driver Controls
 - Maneuverability
 - Consistent Handling
 - Visibility
 - Entry/Exit Walk-Around
 - Information/Entertainment

- **Acceptable - 7 Objectives**
 - Seat Comfort/Versatility/Removeability
 - Climate Control
 - All Weather Traction
 - Systems Operating Sound Quality
 - Brake Response
 - Overall Electrical Noise Level
 - Ride Harshness

- **Concerns - 2 Objectives**
 - Overall Noise Level - Road Noise
 - Shake/Vibration - 2nd Seat Shake, A/C Engagement Bump

Component Functional Objectives

- **96% of the System/Component Functional Objectives have been measured.**
- **84% of the 1720 objectives have been met.**
- **9% of the 1720 objectives have not been met, but are containable in the development and verification process.**
- **6% of the 1720 objectives will not be met (accepted by the Team) or are at risk.**

NS / GS VEHICLE DEVELOPMENT STATUS

ENDURANCE / RELIABILITY

P0 Pilot

- 111,000 endurance miles complete (500,000 miles planned)

Program - F1

- Endurance complete: 788,900 customer miles (800,000 planned)
- Hot and cold road trip evaluations complete (+110° to -40°F)
- 60,000 Trailer Tow test miles completed

- 50 of 170 accelerated corrosion cycles completed; in process

Preprogram

- First and second BCQ accelerated endurance phases complete with 300,000 customer equivalent miles
- Third BCQ/Corrosion accelerated endurance in process with 200,000 customer equivalent miles (complete) & 318 of 340 corrosion cycles
- 7 structural endurance vehicle tests complete with 700,700 customer equivalent miles (700,000 planned)

- 12 powertrain endurance vehicles running with 2,237,200 customer equivalent miles (2,700,000 total miles planned)

'G-level' Skin Preprototype

BCQ accelerated endurance phases complete with 200,000 customer equivalent miles

- 1520 total issues identified by Vehicle Development
1191 closed

- 255 1A and 1B issues remain:
106 open; (27) are 1A
149 in verify; (19) are 1A

Vehicle Development
11/28/94

G.2F

NS / GS VEHICLE DEVELOPMENT ISSUES

DURABILITY / RELIABILITY

- Rear load leveling shocks - rail structure (delayed launch)
- AWD rear rail structure (delayed launch)
- Verification of exhaust flex joint
- Verification of engine compartment temperatures
- Verification of transmission upgrades:
 - 3ATX transfer gears and planet pinion carrier
 - 4EATX differential assembly
 - 5MTX design changes

F1 DESIGN / FUNCTION / FEATURE

- Brake noise
- 3ATX transmission cooling with trailer tow - reduced rating required
- Verification of sliding door operation - inside release
- Verification of A/C engagement bump

Vehicle Development
11/28/94

VEHICLE DEVELOPMENT

NS/GS NVH Treatment Development Status

- 88 items have been identified
- 69 are closed
- 6 items are being reviewed for feasibility
- 3 on hold for C1 review
- 2 are scheduled for V2
- 8 are open

VEHICLE DEVELOPMENT

NS/GS NVH MAJOR ISSUES

- NVH

- 2.4L Idle Shake and Noise
- 2.4L Exhaust Noise (Feasibility of Larger Muffler)
- 3.3L Exhaust Noise (Latest Tuning)
- HVAC Coolant Flow Noise (Gurgle) and A/C Hiss
- 50 mph Howl (215 Hz)
- Boom
- Rear Compartment Road Noise

- BSR

- Rear Brake Shoe to Backing Plate Rattle
- I/P Cupholder Assembly Rattle
- Shift Cable Squeak at Shift Lever Attachment

NS & GS VEHICLE DEVELOPMENT

NS IMPACT

- 17 NS F-1 program vehicle impact development tests have been conducted:
 - (5) FMVSS 208 30 mph Passive Restraint for occupant injury
 - (1) FMVSS 204 30 mph Steering Column Penetration
 - (1) NCAP 35 mph
 - (6) Sensor development tests
 - (2) FMVSS 301 Fuel System (1-rear and 1-lateral)
 - (2) FMVSS 214 Dynamic Side Impact (1-left and 1-right)
- PO FWD impact development testing completed:
 - (1) NCAP 35 mph Driver 4-star, passenger 4-star with base structure and restraint system, bag + belt. Objective is 5-star. Re-evaluate with 208 modifications.
 - (4) FMVSS 208 Passive Restraint tests
 - (2) Unsatisfactory - Driver chest g's
 - (2) Satisfactory - Details on opposing page
 - (1) 8 mph threshold with base structure - Satisfactory
- PO AECM sensor verification required for structural modifications includes (1) 88 mph threshold (11/30/94), inadvertent mini-series.
- PO/C1 impact certification testing planned for December 1994 with production representative parts - timing being analyzed.

GS IMPACT

- 4 GS program vehicle impact development tests have been conducted:
 - (1) European Phase-1 Full-Overlap 30 degree with Anti-Slide Devices for occupant injury.
 - (1) Auto Motor and Sport Partial Overlap 50% Offset Rigid Barrier. Driver and passenger femur loads and driver pelvis g's need further development.
 - (2) Sensor development tests
- 1 GS Steering Column Penetration and Rise compliance witness test completed satisfactorily with base structure 9/94. Re-evaluate with 208 modifications.
- 1 GS European Phase-1 30 Degree Angled Barrier w/ASD witness test for occupant injury to be conducted first quarter 1995.

NS 208 STATUS

Four P0 vehicles tested for Passive Restraint performance.

First vehicle VC-5270 unsatisfactory with base structure and restraint - driver chest 66.8 g's. (Federal limit 60).

Second vehicle VC-5277 unsatisfactory with minor structural modifications: Inboard flange of compression cap rail removed, holes/slot in lower radiator crossmember, access holes in rails at suspension k-mbr attachment points. Driver chest 75.2 g's.

Third vehicle VC-5301 satisfactory for FMVSS-208 with significant modifications. Driver chest 44.6 g's.

Fourth vehicle VC-5306 satisfactory. Confirmation test - driver chest 47.8 g's.

Restraint: Tethered, tight-weave DAB with no discrete vents, stiff-spoke wheel, EA column with short-collapse convoluted-tube jacket, double-panel kneeblocker, reinforcement across front seat pan attachments, power seat up 20mm (to same 208 position as manual), seatback full-up. I/P over-column bezel scalloped to provide greater clearance to column tilt lever.

Structure: Multiple holes and buckle-initiator slots in lower radiator crossmember and longitudinal rails, left rail tip beveled to provide crush clearance to transmission end cover, compression cap center removed at toeboard, front bumper reinforced.

Other: Front suspension crossmember section thickness reduced at multiple locations and reinforcement plate buckle initiators in center webs, front engine mount with clearance notch in PLP strap (engine side) and isolator-retainer flange height reduced (body side).

Cost and timing effect data is being collected. All PCNs will be written under block PCN 41227-700 to track and expedite changes.

Daily meetings are on-going to resolve engineering issues.

Note: VC-5301 did not satisfy FMVSS 301 "Fuel System Integrity" requirements. The upper intake manifold separated from the lower. A fix (studs instead of screws on two of the four upper-to-lower manifold attachments, for increased section at shear plane) was optimized at CTC using static crush, and was successful on VC-5306.

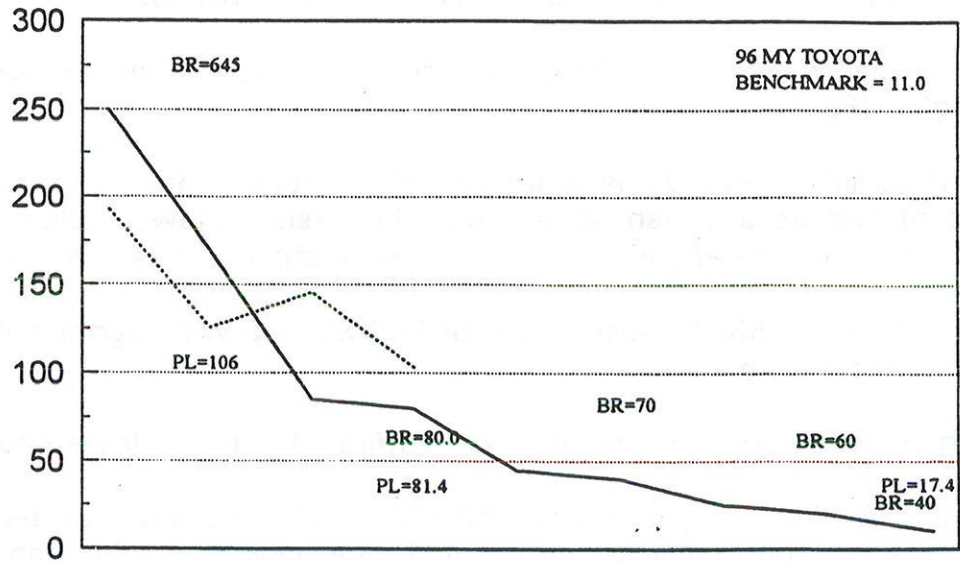
11/28/94

12-1prog.rev/mmf

VQA MEASUREMENT

1996 NS VQA C/VEHICLE

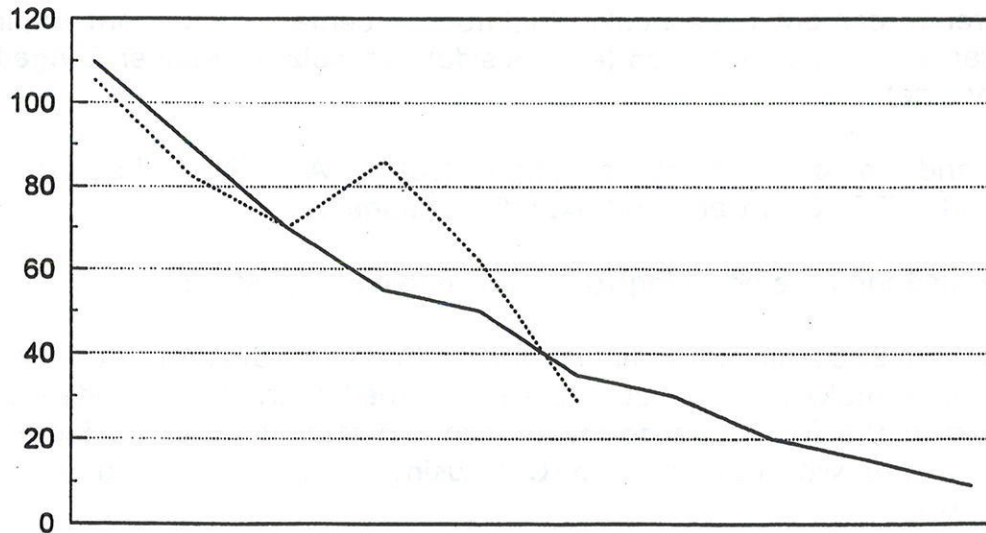
AVG . C/VEHICLE



	F1B	F1C	POS	POF	C1S	C1F	PVPS	PVPF	V1
TARGET —	250.0	170.0	85.0	80.0	45.0	40.0	25.0	20.0	10.0
ACTUAL -----	193.3	126.0	146.0	103.0					

1996 "NS"BIW CMM AUDITS

AVG DEMERITS



	F1A	F1B	F1C	POS	POF	C1S	C1F	PVPS	PVPF	V1
TARGET —	110.0	90.0	70.0	55.0	50.0	35.0	30.0	20.0	15.0	9.0
ACTUAL -----	105.7	82.5	70.0	86.0	62.0	29.0				

NS/GS C1 READINESS

QUALITY INDICATORS

- 52 of 52 PO vehicles are complete (as of 10/21/94):
- Best-in-Class quality indicator status:

	<u>F1A</u>	<u>F1B</u>	<u>F1C</u>	<u>PO</u>	<u>C1S</u>	<u>C1F</u>	<u>V1</u>	MEMO: <u>AS</u>
<u>BIW CMM AUDIT</u>								
Target	110	90	70	50	35	30	9	--
Status	106	83	51	82	29			19
<u>BODY DIM OBJ</u>								
Target	--	11	20	38		45	48	--
Status	--	11	12	TBD				N/A
<u>VQA AUDIT</u>								
Target	--	250	170	80		40	10	9.4
Status	--	194	126	107				10.3
<u>WATER TEST</u>								
Target	--	10	7	4		2	0	
Status	--	--	4	2				
<u>EIA AUDIT</u>								
Target	--	520	450	200		75	10	--
Status	--	514	267	50				13.4
<u>BSR AUDIT</u>								
Target	0	0	0	0		0	0	
Status	30	31	25	20				
<u>JDP IQS</u>								
Target	--	--	--	--		--	93	110
Status	--	--	--	TBD				129

BSRs Identified 441
 Items Closed 303
 Verify Items 90
 Open Items 48