

Trial Codes:
 Code 100: BF/ET
 Code 101: PT1
 Code 102: PT2
 Code 103: PT3

X167 NPP Production Trial Timetable

For Updates please visit <https://team.nafta.sp.wp.corpintra.net/sites/02328/VPM/default.aspx>

SOP	Cycle 1	Cycle 2	C4/MY20.5	Mabyach
Body Start	3/20/2019	6/24/2019	1/8/2020	Feb. 2020*
Assembly Start	3/22/2019	7/8/2019	1/10/2020	Feb. 2020*
Final Ok	3/25/2019	7/11/2019	1/13/2020	Feb. 2020*

Version 3.1

REV DATE: 7/30/19

* All dates are format MM/DD/YYYY

Changes since the last revision are highlighted in RED

DRAFT

Trial	Documentation					Vehicle Ordering						Part Ordering						MRD		Trial Information						
	BOM Freeze - BIW	BOM Freeze - Assy	PEM Dates	TTZ Dates	Lot PEM	Vehicle Order Deadline	Customer Build Confirmation Deadline	GO Entry Deadline	Submit Orders to Plant	Order Scheduling Deadline	Vehicle Order Code Change Freeze	Define Order Responsibility BIW		Define Order Responsibility Assy		Order Parts BIW		Order Parts Assy		MRD - BIW	MRD - Assy	BiW Trial Start	Assy Trial Start	Sales Decade (Decade/Month/Year)	Baulos Code	Volumes
AMG/MY: Cycle 4 /MY 20.5 (800 + 050)	PT0 -C4-MY20.5 AMG/MY	2/6/2019	5/6/2019	5/7/2019	UT182981	8/22/2018	10/4/2018	11/26/2018	11/27/2018	12/10/2018	1/10/2019	1/10/2019	2/8/2019	1/10/2019	2/8/2019	1/11/2019	2/11/2019	1/11/2019	2/11/2019	4/16/2019		4/30/2019	5/9/2019	1/5/2019	60T + 100	3
	PT1 - C4-MY20.5 AMG/MY	4/10/2019	7/15/2019	7/16/2019	UT182975	10/24/2018	12/7/2018	2/6/2019	2/13/2019	2/20/2019	3/14/2019	3/14/2019	4/11/2019	3/14/2019	4/11/2019	3/15/2019	4/15/2019	3/15/2019	4/15/2019	6/18/2019		7/9/2019	7/16/2019	2/7/2019	68T + 101	30
	PT2-C4-MY20.5 AMG/MY	6/28/2019	10/2/2019	10/3/2019	UT182976	2/20/2019	3/25/2019	5/6/2019	5/7/2019	5/14/2019	5/29/2019	6/6/2019	7/8/2019	6/6/2019	7/8/2019	6/13/2019	7/15/2019	6/13/2019	7/15/2019	9/12/2019		9/26/2019	10/3/2019	1/10/2019	74T + 102	35
	PT3-C4-MY20.5 AMG/MY	8/15/2019	11/13/2019	11/14/2019	UT182977	3/18/2019	4/29/2019	6/5/2019	6/6/2019	6/19/2019	7/11/2019	7/25/2019	8/19/2019	7/25/2019	8/19/2019	8/1/2019	8/26/2019	8/1/2019	8/26/2019	10/24/2019 Series Delivery		11/8/2019	11/14/2019	2/11/2018	80T + 103	25*
MBUSI Maybach: Cycle 4 /MY 20.5 (800 + 050)	PT0 C4-MY20.5 Maybach	2/6/2019	5/6/2019	5/7/2019	UT182981	8/22/2018	10/4/2018	11/26/2018	11/27/2018	12/10/2018	1/10/2019	1/10/2019	2/8/2019	1/10/2019	2/8/2019	1/11/2019	2/11/2019	1/11/2019	2/11/2019	4/16/2019		4/30/2019	5/9/2019	1/5/2019	60T + 100	4
	PT1 C4-MY20.5 Maybach	4/10/2019	7/15/2019	7/16/2019	UT182978	10/24/2018	12/7/2018	2/6/2019	2/13/2019	2/20/2019	3/14/2019	3/14/2019	4/11/2019	3/14/2019	4/11/2019	3/15/2019	4/15/2019	3/15/2019	4/15/2019	6/18/2019		7/9/2019	7/16/2019	2/7/2019	68T + 101	28
	PT2A C4-MY20.5 Maybach	6/28/2019	10/2/2019	10/3/2019	UT182979	2/20/2019	3/25/2019	5/6/2019	5/7/2019	5/14/2019	5/29/2019	6/6/2019	7/8/2019	6/6/2019	7/8/2019	6/13/2019	7/15/2019	6/13/2019	7/15/2019	9/12/2019		9/26/2019	10/3/2019	1/10/2019	79T + 102	16
	PT2B C4-MY20.5 Maybach	8/15/2019	11/13/2019	11/14/2019	UT182980	3/18/2019	4/29/2019	6/5/2019	6/6/2019	6/19/2019	7/11/2019	7/25/2019	8/19/2019	7/25/2019	8/19/2019	8/1/2019	8/26/2019	8/1/2019	8/26/2019	10/24/2019		11/8/2019	11/14/2019	2/11/2019	81T + 102	27
	PT3 C4-MY20.5 Maybach	10/18/2019	1/22/2020	1/23/2020	UT182985	5/14/2019	6/25/2019	7/30/2019	8/1/2019	8/8/2019	9/19/2019	9/20/2019	10/22/2019	9/20/2019	10/22/2019	9/23/2019	10/23/2019	9/23/2019	10/23/2019	1/2/2020 Series Delivery		1/16/2020	1/23/2020	3/1/2020	83T + 103	20*

Revision #	Date	Revisions	Comments
0.1	5/20/2015	Initial Creation	
0.2	9/23/2016	BF Lot 2 BiW MRD change from 10/12/2017 to 12/19/2017	Correction
0.2	9/23/2016	B0 Lot 1a change PEM Date from 5/5/2017 to 4/28/2017	Part/PU KEM date alignment
0.2	9/23/2016	B0 Lot 1a change TTZ Date from 5/8/2017 to 5/1/2017	Part/PU KEM date alignment
0.2	9/23/2016	BF Lot 1b change Assembly MRD from 12/22/2017 to 12/15/2017	Ramp Up Logistics request due to proximity to Christmas Shutdown
0.2	9/23/2016	Cyle 1 MBUSI Trials Added	
0.3	12/21/2016	B0 Lot 1b volume changed from 19 vehicles to 20 vehicles	
0.4	1/26/2017	T-Codes and volumes added for B-Phase Lots	
0.4	1/26/2017	B02a Assembly Start changed from 7/3/2017 to 8/3/2017	
0.4	1/26/2017	B02a Assembly MRD changed from 6/8/2017 to	
0.4	1/26/2017	BF3 - Corrected BiW part ordering date	
0.4	1/26/2017	Added Maybach BF1/BF2 dates	
0.5	3/23/2017	BF2b Code Change Freeze date changed from 10/31/2017 to 11/16/2017	
0.5	3/23/2017	Maybach BF 1a BiW Start changed from 4/3/2018 to 3/19/2018	dates linked to BiW Start also updated
0.6	5/11/2017	BF4B BOM Freeze date changed to 3/14/18 from 10/31/17	Correction
0.6	5/11/2017	Cycle 1, 2, and 3 T-Codes Added	
0.6	5/11/2017	Cycles 2 & 3 Added	
0.6	5/11/2017	SOP Timetable Added	
0.6	5/11/2017	B01A Assembly start delayed (5/8/17->5/24/17)	No change to subsequent dates
0.6	5/11/2017	B01B Assembly start delayed (6/9/17->6/29/17)	No change to subsequent dates
0.6	5/11/2017	BF1 Maybach MRD dates adjusted to align with PG	
0.7	6/28/2017	Addition of Cycle 4 dates	
0.7	6/28/2017	Addition of Maybach B-Phase T-Codes	
0.7	6/28/2017	BF4B volume reduction 15->11	
0.7	6/28/2017	Delay of B01B Assembly Start	No change to subsequent dates
0.7	6/28/2017	Adjustment of C2-PT3 and C3 PT1 BS and AS dates	
0.8	7/17/2017	Reduction in B0/BF volumes	Reduction due to deletion of OM656 for US/CAN
0.8	7/17/2017	Increased estimate for C2-PT1 and AMG 4-PT1	Based on PT demand query
0.8	7/17/2017	PEM #s added back in per discussion with ECC	
0.9	8/30/2017	7 car reduction in BF2 Maybach volume (7 cars now "mules" -not coordinated with plant)	Input from FSK
0.9	9/14/2017	JiT Call column removed	Automatic process with AM Supply
0.9	9/19/2017	BF2b Assembly BVA changed from 10/31/17 to 11/16/17	Correction
0.9	9/19/2017	2 day adjustment to Cycle 4 PT1	
1	10/12/2017	Aligned PT dates with C167 and V167 lots for better production flow	
1	10/12/2017	Maybach BF1a BVA BiW 12/15/18->12/15/17	Correction
1	10/12/2017	T-codes updated	
1	10/12/2017	PT quantities updated based on demand query	
1	10/16/2017	BF1a assembly start delayed by one month	
1	10/16/2017	X167 Champion Car timing added	
1	10/19/2017	1 RD order canceled from BF1b and BF2a	
1	10/26/2017	BF1 Maybach Assembly MRD changed by PG from 3/15/18 to 4/10/18	
1	10/30/2017	1 EVS car added to ET	
1	11/6/2017	Date adjustment to correct assembly parts order timing	Correction
1.1	11/29/2017	Dates adjusted for delay of AF Assembly Start for BF	
1.1	11/29/2017	BOM and PEMs updated for MY20.5	
1.1	11/29/2017	ET BiW dates adjusted to allow more time between MRD and BS	
1.1	11/29/2017	BF4 quantities changed due to Photo vehicle build plan optimization	
1.2	12/5/2018	Champion Car dates published	
1.3	2/20/2018	Updated BF dates from Anlaufabrik and delayed BF3b MRD	
1.3	2/20/2018	Body MRD is now 3 weeks before BS even for later cycles (was merged with Assembly MRD)	
1.3	2/20/2018	More closely aligned with overlapping BR167 trials	
1.3	2/20/2018	Added MY20.5 PT0	
1.3	2/20/2018	Cycle 1 PT1 quantity actualized	
1.4	3/22/2018	GLS 580 China canceled (only content planned for Cycle 3)	
1.5	5/1/2018	Adjusted Champion Assembly start	
1.5	5/1/2018	Adjust ET body/assembly and MRD timing	
1.5	5/1/2018	Corrected C2 PT2 BiW MRD	
1.5	5/1/2018	Actualized C1 PT2 and C2 PT1 order quantities	
1.6	6/13/2018	Added additional lot (CC2) for ZEUS point closure and EE Release 11.1 pre-C1 PT1	
1.6	6/13/2018	Shifted C2 to align with standard MY20 timing	
1.6	6/13/2018	Added 5 Maybachs to MY20.5/C4 PT0 after alignment in AK Anlauf	
1.6	6/13/2018	Consolidated MY20.5/C4 Maybach & AMG for PT0 and PT1 (timeline diverges at PT2)	
1.6	6/13/2018	MY20.5 dates adjusted slightly to align with V167 MY20.5	
1.61	6/22/2018	CC2 body start pulled ahead one day at request of BS	
1.61	6/22/2018	MY codes added for each cycle at request of 167 Dokhaus	
1.61	6/22/2018	Corrected typo in PEM # for CC2	
1.7	7/12/2018	X167 C2 PT2 volume actualized	
1.7	7/12/2018	X167 C1 Canceled	
1.7	7/12/2018	X167 C1 ET dates updated	
1.7	7/12/2018	X167 Maybach BF2 Assembly start updated	
1.8	8/3/2018	Cycle 1 PT1 and PT2 Order Quantities Updated due to RD order additions/cancelations	
1.8	8/3/2018	Body MRDs optimized	
1.8	8/3/2018	CC2 dates actualized after management alignment	
1.9	8/29/2018	PT1 dates actualized after management alignment	
1.9	8/29/2018	PT1 assembly MRD moved back at RUL request	
1.9	8/29/2018	Cycle 1 PT3 order quantity actualized	
2	9/28/2018	Quantities adjusted due to moves/cancelations	
2	9/28/2018	PT1 pipe cleaners moved to 11/1 (was 11/2) at request of Assembly/MOE	
2	9/28/2018	CC2 cancelation	
2.2	11/26/2018	Volume updates	
2.2	11/26/2018	Cycle 2 PT2 Out of Cycle vehicle given own t-code for parts ordering	
2.2	11/26/2018	Cycle 2 PT3 adjusted due to X167 Cycle 1 SOP	
2.3	1/31/2019	SOP Cycle 1	
2.3	1/31/2019	Trial codes added	
2.3	1/31/2019	Maybach and rest of Cycle 4 split to better show volume	
2.3	1/31/2019	trial dates and volumes adjusted	
2.3	1/31/2019	NY Show Car T-code	
2.4	2/8/2019	Volume updates	
2.4	2/8/2019	Shift of C2 PT2 Production Dates	
2.5	2/20/2019	PLS alignment to consolidate Cycle 4 PT2/PT3 by pulling ahead Maybach PT2 timing	
2.5	2/20/2019	Cycle 4 PT1 volume actualized	
2.5	2/20/2019	Cycle 4 PT2/PT3 volume estimates updated	
2.5	2/20/2019	5 units moved from C2 PT1 to C1 PT3 as PT3 "confirmation cars"	
2.6	3/18/2019	Volume adjustments	
2.7	4/15/2019	C4 PT1 and PT2 dates tweaked to align with throughput planner	
2.7	4/15/2019	2 last minute cancelations C2 PT2	
2.8	5/6/2019	1 car canceled from C4 PT1	
2.8	5/6/2019	increased to one week between code freeze and parts ordering	
2.8	5/6/2019	C4 PT1 BS and AS dates adjusted back to original plan for pipe cleaner (AS 7/18>7/16, BS 7/10>7/9)	
2.9	5/29/2019	Cycle 4 volume updates	
3	7/10/2019	1 week postponement of PT3 parts ordering due to ongoing Maybach ramp-up discussion	
3	7/10/2019	Maybach PT3 volume increased by ten to 25	
3.1	7/30/2019	Additional Maybach trial, launch TBD, and volume adjustments	