

International Truck and Engine Corporation




TRUCK MANUFACTURING

Lean Production Sequence – EDI 866 BUSINESS PROCESS GUIDE

Version 004010

June 4, 2002

 INTERNATIONAL Lean EDI 866 Business Process Guide	Document Number: PUR-2048	
	Revision: 1.0	
	Revision Date: June 4, 2002	
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1. Transaction Definition

Type:	Regenerative with each message
Frequency:	Variable -- Parameter Controlled
EDI Transaction:	ANSI-X12 / AIAG-866
Application:	

The **Lean Production Sequence -- EDI-866** Transaction Set (Version 004010) will be used by selected Suppliers to identify component requirements in actual production build sequence communicating “Production Linking” requirements which identify multiple part numbers linked to specific assembly lines, sequence number and job number. However, when the part **content** of a set of features or grouping of discrete part numbers linked to a Job Number does not change, the Lean 866 Process will not restate the redundant information.

Therefore, the Lean Process is designed to diminish the volume of data transmitted to/from Suppliers by direct association of the configuration content with the Module Reference Number.

The process DEMANDS that Suppliers retrieve and process this data on a DAILY basis.

2. Business Procedure Overview

The **Lean Production Sequence -- EDI-866** will be used by INTERNATIONAL to identify component requirements in actual production build sequence for the Supplier/INTERNATIONAL business relationship.

ABR (Attribute Based Release) Components must be managed in a sequence environment. ABR is a Module Assembly Process (expressed by a grouping of Feature Part Numbers) enabling INTERNATIONAL and our suppliers to build, ship, receive, invoice, and control inventory at a specific job number level without the assignment of a top-level identifier within the Bill of Material.

- A feature could be a tangible component, or it could represent installations or a reference to a parts list.
- Features are grouped into categories where each category has one or more features (attributes/options) associated with it.
- Combining one feature from each category will create a compatible valid configuration.
- An unique identifier - such as the job number - is required and transmitted to facilitate control of the configuration for a given product.



- This unique identifier must be maintained in the system to be referenced for the life of the vehicle.
- A Module Reference Number, that can be treated as a unique identifier, will also be transmitted to facilitate control of the configuration.

Suppliers that receive and process a significantly high volume of ABR or Kit/Module data will derive the most benefit from the Lean 866 business process. Suppliers' applications must be capable of storing the Module Reference Number with its associated content for future use. Since Suppliers must perform this activity in transmitting Job Level ASN's, and later as an Accounts Receivable reference, the Lean 866 process affords a logical use of the data storage and retrieval.

2.1. Frequency and Responsiveness

The **Lean Production Sequence -- EDI-866** will be transmitted to the supplier in nightly batch. The supplier is expected to retrieve the transaction set each business day and to react accordingly with regards to any changes reflected from the prior transaction set. The transaction set will be made available on a daily basis in the Nightly Batch Process.

2.2. Availability

INTERNATIONAL will process the **Lean Production Sequence -- EDI-866** transactions on demand which will be delivered in the nightly batch process. Acknowledgment response (EDI-997) is mandatory and will be processed as defined in the following chart:

INTERNATIONAL EDI Transaction Processing Window

	From	To
Monday - Friday	00:00	23:00
Saturday	00:00	17:30
Sunday	22:00	00:00

All Times are for the Central Time Zone.

Any EDI transactions submitted to INTERNATIONAL during a downtime will remain in INTERNATIONAL's mailbox until the process is resumed. Any transactions generated by INTERNATIONAL outside of the processing windows will be suspended and delivered at the next available window.

2.3. Off Hours

For Off Hours Support, INTERNATIONAL provides a voice mail system on the EDI Hot Line number and the supplier's Plant EDI Coordinator. Contact Names and Phone Numbers are available on International's website www.internationalsupplier.com. Suppliers should leave a voice-message indicating the problem and any related information available about the problem along with a contact and telephone number.

Any EDI transactions that are sent to INTERNATIONAL by the supplier will be retained in INTERNATIONAL's mailbox until INTERNATIONAL's system becomes available. Any EDI transactions that INTERNATIONAL has to deliver to the supplier will be retained and distributed as soon as INTERNATIONAL's system becomes available.



Special Note: If, for any reason, 866 data is unavailable during the normal processing hours, it is imperative that Suppliers contact the applicable INTERNATIONAL EDI Coordinator. Contact Names and phone numbers are available on INTERNATIONAL's website, www.internationalsupplier.com.

2.4. INTERNATIONAL *Expectations of Supplier*

INTERNATIONAL expects the Supplier to retrieve each **Lean Production Sequence -- EDI-866** in a timely manner appropriate to the business process. The supplier should process the transaction and forward it to all appropriate disciplines.

2.5. *Impact on INTERNATIONAL's Supplier Performance Rating System*

Failure to acknowledge an accurate **Lean Production Sequence -- EDI-866** in a timely manner (1 business day) with an EDI-997 will result in a penalty on the Supplier Performance Evaluation.



3. EDI Transaction and Business Examples

Example of EDI 866 AIAG Formatted Data for LEAN PRODUCTION SEQUENCE -- EDI-866

See Implementation Guide for Complete Details

Day 1 (First Transmission of an 866) – The first time a set of part content is associated with the Job Number, all parts will be transmitted in the 866 data along with relevant requirements dates and parameters. This set of part content forms the configuration. Note that within the configuration, a discrete feature can be required multiple times.

It is necessary to store this information for future reference because the discrete part content forming the configuration will not be transmitted on Day 2 if no change occurs to that set of features.

MRN = Module Reference Number

Figure 1: New Lineset Requirements – Day 1

Line	Build Sequence	Lineset Sequence	MRN	Job Number	Part Content	Quantity	Labor Group	Commodity Group
1	001	5676	6DBB1D8C	608566	1234567F91	1	5400	326D
					1234578F91	1	5400	326D
					1234579F91	4	5400	326D
1	002	5677	8BC20C86	608569	1234590F91	2	5400	326D
					1234501F91	1	5400	326D
					1234602F91	1	5400	326D
2	001	5755	2FF21A2C	608541	3545450F91	1	6352	175A
					3545701F91	2	6352	175A

As the following Example illustrates, the Day 1 866 data is identical to a traditional ABR Sequence Components transaction. All ABR rules for the business process apply.



Example of EDI 866 AIAG Formatted Data - LEAN PRODUCTION SEQUENCE

See Implementation Guide for Complete Details

EDI DATA ELEMENT	DATA CONTENT	EXPLANATION
ST*866*0001 <small>N/L</small>	ANSI Transaction set 866 Transaction ID number 0002	ANSI transaction set 866, transaction ID Number 0001
BSS*05*R2617*19990622*DL*19990623*19990731*002ASM12345X1990627**** A <small>N/L</small>	Replacement Document R2617 Dated 6/22/1999, Delivery Based Horizon from 6/23/1999 to 7/31/1999, Release Number 002ASM12345X1990627, Actual discrete quantities.	Replacement Document R2617, Dated 6/22/1999, Delivery Based Horizon from 6/23/1999 to 7/31/1999, Release Number 002ASM12345X1990627, Actual Discreet Quantities
UIT*PC <small>N/L</small>	Unit of Measure	Indicates that Unit of Measure is pieces.
N1*ST**92*002ASM <small>N/L</small>	Ship to Location	Indicates Ship-to location is Springfield Assembly Plant.
N1*SU**92*12345X1 <small>N/L</small>	Supplier/Manufacturer	The INTERNATIONAL Supplier Code 12345X1.
REF*DK*K999 <small>N/L</small>	Indicates Delivery Dock	Indicates the Delivery Dock is K999 at the Assembly Plant
DTM*002**0700*ES*D8*19990628 <small>N/L</small>	Delivery Date and Optional Time	Requested delivery date is 6/28/1999. Requested delivery time is 07:00 EST
QTY*01*1 <small>N/L</small>	Quantity type	Discrete Quantity of 1 (each of following products) unless otherwise stipulated at the LIN level.
REF*LF*1 <small>N/L</small>	Indicates Assembly Line	Indicates this item used on Assembly Line #1.
LIN**JS*001*RS*5676*PU*6DBB1D8C*J N*608566 <small>N/L</small>	Line Sequence Number, Lineset Number, Module Reference Number (MRN), Job Number.	All discrete part numbers referencing Line Sequence Number 001, Lineset Number 5676, can be referenced by INTERNATIONAL MRN 6DBB1D8C, within Job Number 608566.
LIN**JS*001*RS*5676*BP*1234567F91* JN*608566*LA*5400*CG*326D <small>N/L</small>	Line Sequence Number, Lineset Number, Buyers Part Number, Job Number, Labor Group and Commodity Group.	Line Sequence Number 001, Lineset Number 5676, INTERNATIONAL Part Number is 1234567F91, Job Number 608566, Labor Group 5400 and Commodity Group 326D.



Example of EDI 866 AIAG Formatted Data - LEAN PRODUCTION SEQUENCE

See Implementation Guide for Complete Details

EDI DATA ELEMENT	DATA CONTENT	EXPLANATION
LIN**JS*001*RS*5676*BP*1234578F91* JN*608566*LA*5400 *CG*326D <small>N/L</small>	Line Sequence Number, Lineset Number, Buyers Part Number, Job Number, Labor Group and Commodity Group.	Line Sequence Number 001, Lineset Number 5676, INTERNATIONAL Part Number is 1234578F91, Job Number 608566, Labor Group 5400 and Commodity Group 326D.
LIN**JS*001*RS*5676*BP*1234579F91* JN*608566*LA*5400 *CG*326D <small>N/L</small>	Line Sequence Number, Lineset Number, Buyers Part Number, Job Number, Labor Group and Commodity Group.	Line Sequence Number 001, Lineset Number 5676, INTERNATIONAL Part Number is 1234579F91, Job Number 608566, Labor Group 5400 and Commodity Group 326D.
QTY*01*4 <small>N/L</small>	Quantity Override	Overrides quantity at DTM Level.
DTM*002**1000*ES*D8*19990629 <small>N/L</small>	Delivery Date and Optional Time	Delivery date requested on 6/29/1999. Delivery time is 10:00 EST
QTY*01*1 <small>N/L</small>	Quantity type	Discrete Quantity of 1 (each of following products) unless otherwise stipulated at the LIN level.
REF*LF*1 <small>N/L</small>	Indicates Assembly Line	Indicates this item used on Assembly Line #1.
LIN**JS*002*RS*5677*PU*8BC20C86*J N*608569 <small>N/L</small>	Line Sequence Number, Lineset Number, Module Reference Number, Job Number.	All discrete part numbers referencing Line Sequence Number 002, Lineset Number 5677, can be referenced by INTERNATIONAL MRN 8BC20C86, within Job Number 608569.
LIN**JS*002*RS*5677*BP*1234590F91* JN*608569*LA*5400 *CG*326D <small>N/L</small>	Line Sequence Number, Lineset Number, Buyers Part Number, Job Number, Labor Group and Commodity Group.	Line Sequence Number 002, Lineset Number 5677, INTERNATIONAL Part Number is 1234580F91, Job Number 608569, Labor Group 5400 and Commodity Group 326D.
QTY*01*2 <small>N/L</small>	Quantity Override	Overrides quantity at DTM Level.
LIN**JS*002*RS*5677*BP*1234501F91* JN*608569*LA*5400 *CG*326D <small>N/L</small>	Line Sequence Number, Lineset Number, Buyers Part Number, Job Number, Labor Group and Commodity Group.	Line Sequence Number 002, Lineset Number 5677, INTERNATIONAL Part Number is 1234501F91, Job Number 608569, Labor Group 5400 and Commodity Group 326D.



Example of EDI 866 AIAG Formatted Data - LEAN PRODUCTION SEQUENCE

See Implementation Guide for Complete Details

EDI DATA ELEMENT	DATA CONTENT	EXPLANATION
LIN**JS*002*RS*5677*BP*1234602F91* JN*608569*LA*5400 *CG*326D <small>N/L</small>	Line Sequence Number, Lineset Number, Buyers Part Number, Job Number, Labor Group and Commodity Group.	Line Sequence Number 002, Lineset Number 5677, INTERNATIONAL Part Number is 1234602F91, Job Number 608569, Labor Group 5400 and Commodity Group 326D.
DTM*002**1000*ES*D8*19990628 <small>N/L</small>	Delivery Date and Optional Time	Delivery date requested on 6/28/1999. Delivery time is 10:00 EST
QTY*01*1 <small>N/L</small>	Quantity type	Discrete Quantity of 1 (each of following products) unless otherwise stipulated at the LIN level.
REF*LF*2 <small>N/L</small>	Indicates Assembly Line	Indicates this item used on Assembly Line #2.
LIN**JS*001*RS*5755*PU*2FF21A2C*J N*608541 <small>N/L</small>	Line Sequence Number, Lineset Number, Module Reference Number, Job Number.	All discrete part numbers referencing Line Sequence Number 002, Lineset Number 5755, can be referenced by INTERNATIONAL MRN 2FF21A2C, within Job Number 608541.
LIN**JS*001*RS*5755*BP*3545450F91* JN*608541*LA*6352 *CG*175A <small>N/L</small>	Line Sequence Number, Lineset Number, Buyers Part Number, Job Number, Labor Group and Commodity Group.	Line Sequence Number 001, Lineset Number 5755, INTERNATIONAL Part Number is 3545450F91, Job Number 608541, Labor Group 6352 and Commodity Group 175A.
LIN**JS*001*RS*5755*BP*3545701F91* JN*608541*LA*6352 *CG*175A <small>N/L</small>	Line Sequence Number, Lineset Number, Buyers Part Number, Job Number, Labor Group and Commodity Group.	Line Sequence Number 001, Lineset Number 5755, INTERNATIONAL Part Number is 3545701F91, Job Number 608541, Labor Group 6352 and Commodity Group 175A.
QTY*01*2 <small>N/L</small>	Quantity Override	Overrides quantity at DTM Level.
CTT*3 <small>N/L</small>	Number of DTM Segments	Total Number of DTM Segments is 3.
SE*31*0001 <small>N/L</small>	Segments Transmitted	31 Segments Transmitted in Transaction 0001.



Day 2 (Second Transmission of an 866) – Assuming that the configurations did not change in any way and no additional lineset was made, this example illustrates what will be transmitted in the EDI-866. Therefore, Figure 1 will become Figure 2.

Figure 2: Existing Lineset Requirements – Day 2

Line	Build Sequence	Lineset Sequence	MRN	Job Number	Quantity
1	001	5676	6DBB1D8C	608566	1
1	002	5677	8BC20C86	608569	1
2	001	5755	2FF21A2C	608541	1

The Quantity field in Figure 2 represents the MRN.

In these examples, the configurations consist of only 3 feature part numbers for two jobs and 2 features for one job. In the Day 1 example, the character count was 987. For Day 2, the character count is 458. The reduction in characters is approximately 64%

The character reduction from Day 1 to Day 2 will be a function of the number of features within a configuration. For instance, a configuration of 9 features for the first two jobs and 8 features for the last job would have transmitted approximately 2,103 characters on Day 1, assuming no override quantity lines other than what was originally illustrated. Day 2 would have been 458. The reduction in characters is approximately 78%



Example of EDI 866 AIAG Formatted Data - Day 2 - Lean Production Sequence -- EDI-866

See Implementation Guide for Complete Details

EDI DATA ELEMENT	DATA CONTENT	EXPLANATION
ST*866*0001 _{N/L}	ANSI Transaction set 866 Transaction ID number 0002	ANSI transaction set 866, transaction ID Number 0001
BSS*05*R2617*19990623*DL*19990624*19990731*002ASM12345X1990627**** A _{N/L}	Replacement Document R2617 Dated 6/23/1999, Delivery Based Horizon from 6/24/1999 to 7/31/1999, Release Number 002ASM12345X1990627, Actual discrete quantities.	Replacement Document R2617, Dated 6/23/1999, Delivery Based Horizon from 6/24/1999 to 7/31/1999, Release Number 002ASM12345X1990627, Actual Discreet Quantities
UIT*PC _{N/L}	Unit of Measure	Indicates that Unit of Measure is pieces.
N1*ST**92*002ASM _{N/L}	Ship to Location	Indicates Ship-to location is Springfield Assembly Plant.
N1*SU**92*12345X1 _{N/L}	Supplier/Manufacturer	The INTERNATIONAL Supplier Code 12345X1.
REF*DK*K999 _{N/L}	Indicates Delivery Dock	Indicates the Delivery Dock is K999 at the Assembly Plant
DTM*002**0700*ES*D8*19990628 _{N/L}	Delivery Date and Optional Time	Requested delivery date is 6/28/1999. Requested delivery time is 07:00 EST
QTY*01*1 _{N/L}	Quantity type	Discrete Quantity of 1 (each of following products) unless otherwise stipulated at the LIN level.
REF*LF*1 _{N/L}	Indicates Assembly Line	Indicates this item used on Assembly Line #1.
LIN**JS*001*RS*5676*PU*6DBB1D8C*J N*608566 _{N/L}	Line Sequence Number, Lineset Number, Module Reference Number (MRN), Job Number.	All discrete part numbers referencing Line Sequence Number 001, Lineset Number 5676, can be referenced by INTERNATIONAL MRN 6DBB1D8C, within Job Number 608566.
DTM*002**1000*ES*D8*19990629 _{N/L}	Delivery Date and Optional Time	Delivery date requested on 6/29/1999. Delivery time is 10:00 EST



Example of EDI 866 AIAG Formatted Data - Day 2 - Lean Production Sequence -- EDI-866

See Implementation Guide for Complete Details

EDI DATA ELEMENT	DATA CONTENT	EXPLANATION
QTY*01*1 _{N/L}	Quantity type	Discrete Quantity of 1 (each of following products) unless otherwise stipulated at the LIN level.
REF*LF*1 _{N/L}	Indicates Assembly Line	Indicates this item used on Assembly Line #1.
LIN**JS*002*RS*5677*PU*8BC20C86*J N*608569 _{N/L}	Line Sequence Number, Lineset Number, Module Reference Number, Job Number.	All discrete part numbers referencing Line Sequence Number 002, Lineset Number 5677, can be referenced by INTERNATIONAL MRN 8BC20C86, within Job Number 608569.
DTM*002**1000*ES*D8*19990628 _{N/L}	Delivery Date and Optional Time	Delivery date requested on 6/28/1999. Delivery time is 10:00 EST
QTY*01*1 _{N/L}	Quantity type	Discrete Quantity of 1 (each of following products) unless otherwise stipulated at the LIN level.
REF*LF*2 _{N/L}	Indicates Assembly Line	Indicates this item used on Assembly Line #2.
LIN**JS*001*RS*5755*PU*2FF21A2C*J N*608541 _{N/L}	Line Sequence Number, Lineset Number, Module Reference Number, Job Number.	All discrete part numbers referencing Line Sequence Number 002, Lineset Number 5755, can be referenced by INTERNATIONAL MRN 2FF21A2C, within Job Number 608541.
CTT*3 _{N/L}	Number of DTM Segments	Total Number of DTM Segments is 3.
SE*20*0001 _{N/L}	Segments Transmitted	20 Segments Transmitted in Transaction 0001.



Day 3 (Third Transmission of an 866) – Assuming that the one of the configurations changed and no additional lineset was made, this example illustrates what will be transmitted in the EDI-866. Therefore, Figure 2 will become Figure 3.

Figure 3: Existing Lineset Requirements – Day 3

Line	Build Sequence	Lineset Sequence	MRN	Job Number	Part Number	Quantity	Quantity	Labor Group	Commodity Group
1	001	5676	6DBB1D8C	608566		1			
1	002	5677	9AB22C38	608569	1234590F9 1		1	5400	326D
					1234501F9 2		1	5400	326D
					1234602F9 1		1	5400	326D
2	001	5755	2FF21A2C	608541		1			

Where the configuration is not transmitted, the MRN is represented by a quantity of 1. However, the set of part content forming the changed configuration assumes an MRN of 1, with applicable part quantities for the associated features.

Note that Job Number 608569 now requires a new MRN of 9AB22C38 consisting of 1 each of 1234590F91 (which was previously a quantity of 2), 1234501F92 (which was previously 1234501F91) and 1234602F91.

**In the Day 1 example, the character count was 987.
 For Day 2, the character count was 458.
 For Day 3, the character count is 644.**



Example of EDI 866 AIAG Formatted Data - Day 3 - Lean Production Sequence -- EDI-866

See Implementation Guide for Complete Details

EDI DATA ELEMENT	DATA CONTENT	EXPLANATION
ST*866*0001 _{N/L}	ANSI Transaction set 866 Transaction ID number 0002	ANSI transaction set 866, transaction ID Number 0001
BSS*05*R2617*19990624*DL*19990625*19990731*002ASM12345X1990627**** A _{N/L}	Replacement Document R2617 Dated 6/24/1999, Delivery Based Horizon from 6/25/1999 to 7/31/1999, Release Number 002ASM12345X1990627, Actual discrete quantities.	Replacement Document R2617, Dated 6/24/1999, Delivery Based Horizon from 6/25/1999 to 7/31/1999, Release Number 002ASM12345X1990627, Actual Discreet Quantities
UIT*PC _{N/L}	Unit of Measure	Indicates that Unit of Measure is pieces.
N1*ST**92*002ASM _{N/L}	Ship to Location	Indicates Ship-to location is Springfield Assembly Plant.
N1*SU**92*12345X1 _{N/L}	Supplier/Manufacturer	The INTERNATIONAL Supplier Code 12345X1.
REF*DK*K999 _{N/L}	Indicates Delivery Dock	Indicates the Delivery Dock is K999 at the Assembly Plant
DTM*002**0700*ES*D8*19990628 _{N/L}	Delivery Date and Optional Time	Requested delivery date is 6/28/1999. Requested delivery time is 07:00 EST
QTY*01*1 _{N/L}	Quantity type	Discrete Quantity of 1 (each of following products) unless otherwise stipulated at the LIN level.
REF*LF*1 _{N/L}	Indicates Assembly Line	Indicates this item used on Assembly Line #1.
LIN**JS*001*RS*5676*PU*6DBB1D8C*J N*608566 _{N/L}	Line Sequence Number, Lineset Number, Module Reference Number (MRN), Job Number.	All discrete part numbers referencing Line Sequence Number 001, Lineset Number 5676, can be referenced by INTERNATIONAL MRN 6DBB1D8C, within Job Number 608566.
DTM*002**1000*ES*D8*19990629 _{N/L}	Delivery Date and Optional Time	Delivery date requested on 6/29/1999. Delivery time is 10:00 EST



Example of EDI 866 AIAG Formatted Data - Day 3 - Lean Production Sequence -- EDI-866

See Implementation Guide for Complete Details

EDI DATA ELEMENT	DATA CONTENT	EXPLANATION
QTY*01*1 _{N/L}	Quantity type	Discrete Quantity of 1 (each of following products) unless otherwise stipulated at the LIN level.
REF*LF*1 _{N/L}	Indicates Assembly Line	Indicates this item used on Assembly Line #1.
LIN**JS*002*RS*5677*PU*9AB22C38*J N*608569 _{N/L}	Line Sequence Number, Lineset Number, Module Reference Number, Job Number.	All discrete part numbers referencing Line Sequence Number 002, Lineset Number 5677, can be referenced by INTERNATIONAL MRN 9AB22C38, within Job Number 608569.
LIN**JS*002*RS*5677*BP*1234590F91* JN*608569*LA*5400 *CG*326D _{N/L}	Line Sequence Number, Lineset Number, Buyers Part Number, Job Number, Labor Group and Commodity Group.	Line Sequence Number 002, Lineset Number 5677, INTERNATIONAL Part Number is 1234580F91, Job Number 608569, Labor Group 5400 and Commodity Group 326D.
LIN**JS*002*RS*5677*BP*1234501F92* JN*608569*LA*5400 *CG*326D _{N/L}	Line Sequence Number, Lineset Number, Buyers Part Number, Job Number, Labor Group and Commodity Group.	Line Sequence Number 002, Lineset Number 5677, INTERNATIONAL Part Number is 1234501F91, Job Number 608569, Labor Group 5400 and Commodity Group 326D.
LIN**JS*002*RS*5677*BP*1234602F91* JN*608569*LA*5400 *CG*326D _{N/L}	Line Sequence Number, Lineset Number, Buyers Part Number, Job Number, Labor Group and Commodity Group.	Line Sequence Number 002, Lineset Number 5677, INTERNATIONAL Part Number is 1234602F91, Job Number 608569, Labor Group 5400 and Commodity Group 326D.
DTM*002**1000*ES*D8*19990628 _{N/L}	Delivery Date and Optional Time	Delivery date requested on 6/28/1999. Delivery time is 10:00 EST
QTY*01*1 _{N/L}	Quantity type	Discrete Quantity of 1 (each of following products) unless otherwise stipulated at the LIN level.
REF*LF*2 _{N/L}	Indicates Assembly Line	Indicates this item used on Assembly Line #2.



Example of EDI 866 AIAG Formatted Data - Day 3 - Lean Production Sequence -- EDI-866

See Implementation Guide for Complete Details

EDI DATA ELEMENT	DATA CONTENT	EXPLANATION
LIN**JS*001*RS*5755*PU*2FF21A2C*J N*608541 <small>NL</small>	Line Sequence Number, Lineset Number, Module Reference Number, Job Number.	All discrete part numbers referencing Line Sequence Number 002, Lineset Number 5755, can be referenced by INTERNATIONAL MRN 2FF21A2C, within Job Number 608541.
CTT*3 <small>NL</small>	Number of DTM Segments	Total Number of DTM Seqments is 3.
SE*23*0001 <small>NL</small>	Segments Transmitted	23 Segments Transmitted in Transaction 0001.



LEAN 866 PRODUCTION SEQUENCE DATA NOTES:

- 1) The **Lean Production Sequence -- EDI-866** Transaction Set (Version 004010) will be used ONLY by selected Suppliers to identify component requirements in actual production build sequence communicating “Production Linking” requirements which identify multiple part numbers linked to specific assembly lines, sequence number and job number.
- 2) The Lean Process is designed to diminish the volume of data transmitted to/from Suppliers by direct association of the configuration content with the Module Reference Number.
- 3) The part content of a configuration will always be transmitted the FIRST time it is associated with a Job Number. Thereafter, only the MRN will be transmitted with the associated Job Number information.
 - a) New lineset will always contain the discrete part content of a configuration along with the associated Job and MRN information.
 - b) When the part **content** of a set of features or grouping of discrete part numbers linked to a Job Number does not change, the Lean 866 Process will not restate the redundant information.
 - c) The first time a the part content is associated with the Job Number, the MRN and all associated parts will be transmitted in the 866 data along with relevant requirements dates and parameters.
 - d) This set of discrete parts/features forms the configuration.
 - i) Note that within a configuration, a discrete feature can be required multiple times.
 - ii) Attribute Part Numbers are typically suffixed by "F91", "F92", "F93" and so on.
 - iii) Attribute Parts cannot stand alone as purchased finished commodities.
 - e) ABR Commodities are not defined by top-level part numbers, but are grouped as a configuration specific to a job number.
 - i) The Module Reference Number is not maintained in INTERNATIONAL's Bill of Material.
 - ii) The Module Reference Number is a system-generated number, unique to the grouping of attributes that form a configuration specific to a Job Number.
 - (1) Any change to the attribute content of the specified job number will cause a new Module Reference Number to be generated.
 - (2) Any change to the requirement quantity of a particular attribute, of a specified job number, will cause a new Module Reference Number to be generated.
 - (3) It is possible that the Sequence Number and/or Lineset Number could change without changing the MRN or restating the configuration details.
 - (4) The same MRN will be assigned to multiple jobs with identical configurations. Do not create a one-to-one relationship between the Job Number and the MRN.
 - (5) Another way to describe the MRN might be like a "Version Number".
- 4) It is necessary to store this information for future reference because the discrete part content forming the configuration will not be transmitted on the second occurrence of a Job Number if no change occurs to the configuration.
- 5) Ship Notices must be transmitted from the Supplier at the Job Level only, with the associated MRN regardless of whether or not that Supplier participates in the Lean Process.



International Truck and Engine Corporation
Business Process Guide – Lean Production Sequence -- EDI-866

- a) The Module Reference Number must be transmitted along with the specific Job Number and applicable quantities. Please refer to the 856 Business Process Guide for detailed explanations, available on INTERNATIONAL's website: www.internationalsupplier.com.
 - i) INTERNATIONAL will explode the content of the Module Reference Number contained in the 856 data to ascertain the applicable attribute content specific to the job number.
 - ii) The attribute content will be applicably aggregated and the Receipt Record will be used to create the ERS Record forwarded to INTERNATIONAL FINANCE for the payment process.
- b) Suppliers shipping ABR commodities to the Escobedo Assembly Plant will be expected to utilize the Module Reference Number in their Customs Invoices and/or applicable paperwork accompanying the load to facilitate border crossing processes.
 - i) These Suppliers will be expected to transmit "Job Level" 856 ASN's.
 - ii) Suppliers must explode the content of the Module Reference Number to aggregate the attributes within their own applications to generate their Invoices.
- 6) The human readable verbiage "ABR Assembly" contained on the ABR Part Label, must be replaced with the Module Reference Number. Please refer to the D-13 Packaging Guide for additional information.



4. Definition of Terms

Plant Code	002ASM	--	Springfield Assembly Plant
	005	--	Cab Assembly Stamping
	009	--	Conway Bus Plant
	011	--	Blue Diamond Truck
	014	--	Tulsa Bus Plant
	020	--	Chatham Assembly Plant
	062	--	Garland Assembly Plant
	065	--	Escobedo Assembly Plant
	078	--	PEC Facility
	xxxxxxx	--	Designated Remote Receiving Location

5. INTERNATIONAL Specific Codes

There are no INTERNATIONAL specific codes for this transaction set.

6. Conformance Testing Procedures

Upon readiness INTERNATIONAL will transmit an actual transaction set of the supplier's related schedule.