

This document exists as supplemental information to the General Motors CORE CRN Requirements. In many cases, this document will outline the general specifications required equipment will need to meet. In other instances, the only approved equipment has been indicated in the manufacturer and model columns. Please make sure you are referencing the most recent version of this information. GM maintains the right to add, delete or modify this list at any time. Participating network members are expected to comply with new requirements. The most recent version can be found at <https://www.genuinegmparts.com>

Category	Specification	Manufacturer	Model	Notes
<i>Required Frame Aligning Equipment / Bench / Rack</i>				
<input type="checkbox"/>	Frame Aligning Equipment / Fixture Bench / Frame Rack	Capable of supporting 7000 lbs. 4 holding points minimum for both unitized bodies and full frame vehicles.	Please reference 'Corvette C8 Required Fixturing Equipment by Manufacturer' for additional details	There are multiple types of benches/racks that are authorized for Corvette C8 repairs. Most require C8 specific holding/fixturing. See C8 required fixturing section for more detailed info.
<input type="checkbox"/>	Measuring System	3D electronic measuring system or fixture bench system, +/- 1 mm accuracy for x,y and z, with current software subscription		For traditional frame racks, 3D electronic measuring system is required. For fixture bench systems utilizing dedicated or universal type fixtures, 3D electronic measuring system is recommended but not required. However, proper photo documentation of vehicle returned to manufacturer's dimensional specifications is required.
<input type="checkbox"/>	Porta Power Set	4 ton required		
<input type="checkbox"/>	Pulling Equipment	Minimum two towers with 10-ton capability each		
<input type="checkbox"/>	Tram Tracking Gauge	Metric scale required		
<i>Required Welding and MIG Brazing Equipment</i>				
<input type="checkbox"/>	Aluminum MIG Welder	208V-240V Pulse MIG Welder, 200 Amp output capability		Must be 5554 alloy, 0.9mm - 1.2mm (.035" - .047") diameter is acceptable
<input type="checkbox"/>	Shielding Gases	Steel Welding - AR/CO2 80/20 % mix MIG Braze - Ar 100% Aluminum MIG - Ar 100%		
<input type="checkbox"/>	Designated equipment to perform test welds/destructive tests	Stand and tools for destructive testing of welds, Stationary vise / Vernier caliper or equivalent, capable of vertical and overhead welding		
<input type="checkbox"/>	MIG Brazing Welder	208V-240V, 180 Amp output capability. May use required steel or aluminum welder with proof of separate and dedicated conductor/torch assembly, drive rolls, and gas for silicon-bronze MIG-brazing.		Must be ER CuSi-A or CuSi-3 alloy, 0.8mm - 0.9mm (.030" - .035") diameter is acceptable
<input type="checkbox"/>	MIG/MAG weld equipment	208V-240V, 180 Amp output capability		Must be ER70S-3 or ER70S-6 alloy, 0.6mm - 0.9mm (.023" - .035") diameter is acceptable
<input type="checkbox"/>	Shunting Clamp			
<input type="checkbox"/>	Squeeze Type Resistance Spot Welding (STRSW) Equipment	STRSW listed in the GM Dealer Equipment website are approved. <b>Please ensure you are also using the approved software ID listed with the STRSW.</b>		Search for 'Spot Welders' at: <a href="http://www.gmdesolutions.com">www.gmdesolutions.com</a>
<i>Expected Welding and MIG Brazing Equipment</i>				
	Auto-dim Welding Helmet	Minimum #11 shade with 3 sensors - one for each MIG/mag welder		
	Welding Blankets	Minimum 2 per MIG/MAG and STRSW machines		
	Welding Respirator	Must meet NIOSH 42 cfr part 84		
	Welding Spark Paper			

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<b>Required Mechanical Repair Equipment</b>				
<input type="checkbox"/>	A/C recovery / recycle / charging station for R134a and R1234YF	Compliant with all current regulations	SAE J2210 OR J2788 compliance label required for R134A. SAE J2843 compliance label required for R1234YF.	Or must have access to recovery/recycling service (sublet). Sublet provider invoice proof required.
<b>Expected Mechanical Repair Equipment - Unless work is sublet out</b>				
	A/C Electronic Leak Detector		SAE J1627 or J2791 compliance label/proof required for R134A. SAE J2913 compliance label/proof for R1234YF.	Or must have access to an electronic a/c leak detector (sublet) - R134A and R1234YF capable
	Coolant Pressure Tester			Manual or electronic test equipment
	Engine Cart			Or must have access to a mobile powertrain dolly
	Engine Hoist			Or must have access to an engine hoist (sublet/rental)
	Tire Changer			Or must have access to a tire changer (sublet)
	Wheel Alignment Measuring System			Or must have access to an alignment measuring system (sublet) - capable of 4 wheel alignment
	Wheel Alignment Rack			Ability to perform and verify four-wheel alignment either in-house or through a sublet provider. Sublet provided invoice proof required.
	Wheel Balancer			Or must have access to a wheel balancer (sublet)
<b>Required Collision Repair Equipment</b>				
<input type="checkbox"/>	Aluminum Work Area (Dedicated)	Minimum: Curtain room 23' length x 12' width x 8' height		
<input type="checkbox"/>	Aluminum Dent Repair Station	Utilize a dent extraction system specifically designed for aluminum		
<input type="checkbox"/>	Aluminum Dust Collection	Dedicated aluminum dust wet mix, dry-pneumatic portable or centrally installed		The aluminum dust collection system must be designed for collecting combustible aluminum dust. Units containing electric motors will generally be wet mix while air powered/pneumatic versions may be dry units. Either type of system may also be centrally installed or portable. Below is a link to the page.
<input type="checkbox"/>	Blind Structural Rivet Gun (BSR)	Electric or pneumatic; capable of pulling 1/4" structural rivets, with a minimum pulling force of 3822 lbf.		
<input type="checkbox"/>	Heat Monitoring System	Temperature crayons, stickers, or non-contact thermometer		
<input type="checkbox"/>	Aluminum Repair Hand Tools	Dedicated, stored separately		
<input type="checkbox"/>	Dent Puller / Stud Welder	Stud and/or washer capable		
<input type="checkbox"/>	Crack and dye, penetrant kit			

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<b>Expected Collision Repair Tools</b>				
Cavity Wax Gun or Applicator	Aerosol is acceptable - 360 degree spray head with minimum 36" wand, <b>aerosol is acceptable</b>			
Decal Remover	Eraser wheel type			
Dry guide coat	Should have at least one in each department			
Heat gun	Temperature and fan control required			
Panel separator/ seam buster	Manual or pneumatic			
Spot Weld Drill / Cutters	6mm, 8mm and 10mm, capable of drilling UHSS			
Correct Application equipment for seam sealer/undercoating/corrosion resistance products	See product application guidelines			
Correct Application Equipment for 2-part Adhesives	See product application guidelines			
Glass Removal / Installation Tools and Equipment				Or have access to sublet service provider
<b>Required General Repair Facility Equipment</b>				
<input type="checkbox"/> Two or Four Post Surface Lift	Minimum 7,000 lb. capacity, two or four post lift			
<b>Expected General Repair Equipment</b>				
Access to GM OEM Repair Procedures	Technician access to OEM service information - complimentary service express subscription provided			
Air Compressor	High pressure, high volume, dry and oil free air			
Battery Charger	Smart Charger capable of monitoring and maintaining dedicated battery voltage.			
Battery Load Tester	with carbon pile load testing capability. Sublet scanning provider must have carbon pile load testing capability.			
Bench mounted Vise				
Electric Extension Power Cord	Minimum 12 awg/ 20 amp with ground prong - should have at least one in each department			
Floor Jack	Minimum 2 1/2 ton lifting capacity, adequate number, capable of lifting low clearance vehicles			
High-pressure Washer				
Jack Stands	Minimum 3 ton capacity (per pair)			
Torque Wrench	Capable of reading in newton meters and pound feet, accurate from 10nm to 272nm (7 lb./ft to 250 lb./ft) - annual calibration recommended			
Vacuum Cleaner				
Wheel Dollies	Minimum 1500 lb. Capacity (each)			

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<b>Required Paint &amp; Refinishing Equipment</b>				
<input type="checkbox"/>	Paint booth / Paint forced curing system	Meets the specifications of utilized GM approved refinish system		
<input type="checkbox"/>	Paint mil Spec Gauge	A paint gauge capable of accurately measuring paint film thickness on non-metal substrates which is nondestructive to the paint film.	Defelsko	200b1-e Positector
<input type="checkbox"/>	Paint System	Utilize a GM approved refinishing system as outlined in GMW15406 globally approved refinish materials and provide proof of product training		
<b>Expected Paint &amp; Refinish Equipment</b>				
	Compressor Air dryer			Refrigerant type, desiccant type or membrane type acceptable
	Bumper stand			
	Cart for masking paper			
	Color formula data+B9	Computerized, Capable of VOC tracking		
	Dedicated mix room	Must have exhaust system and spill containment compliant with federal, state and local regulations		
	Paint station with scales	Scale must be capable of interface with mix computer		
	Painter suits and protective gear	Appropriate PPE Required		
	Polishing set	Adequate number of buffers/polishers - eclectic or pneumatic acceptable		
	Spray gun (for base coat)	Capable of high transfer efficiency, must meet local regulations		
	Spray gun (for clear coat)	Capable of high transfer efficiency, must meet local regulations		
	Spray gun (for primer)	Capable of high transfer efficiency, must meet local regulations		
	Spray gun washer	Enclosed system or disposable pps style cups with written policy for manual gun cleaning		
	Spray stand (fender / door)			
	Spray stand (hood / trunk)			
<b>Technician Tools</b>				
<b>Expected Technician Tools</b>				
	Air duster gun	OSHA approved		
	Body hammer assortment			
	Chisels			
	Clip remover			
	Disk grinder			
	Dolly assortment			
	Dual action sander (random orbital sander)			
	General hand tool set			
	Hand drill (pneumatic or electric)			
	Hand saw (pneumatic or electric)			
	Metric measuring tape (convex)	Metric scale required		
	Pneumatic / electric impact gun			
	Pneumatic / electric ratchet			
	Punch tool set with centering punch			
	Rubber hammer			
	Spoon			
	Storage for removed parts (cart, box)			
	Mechanical Locking Pliers (Vise grip)			

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Category	Specification	Manufacturer	Model	Notes	
<b>Personal Protection Equipment (PPE)</b>					
<b>Expected Personal Protection Equipment</b>					
Dust masks	Dust/mist mask				
Eye and face protection	Safety goggles / Safety glasses / Face shield Glasses must meet ansi z87.1+.				
Hand protection/gloves	Abrasion resistant Chemical resistant Work gloves				
Hearing protection	Ear plugs / Ear muffs				
Paint suit	One-piece hooded				
Respirators	Fresh air supplied for painting Osha certified for all others				
<b>Diagnostic Scan</b>					
<b>Not all scan tools or software read all DTC codes. Please refer to GM's Position Statement on scanning and tools GM supports found here: <a href="https://www.genuinegmparts.com/pdf/positionstatements/pre-post-scan-collision-vehicles.pdf">https://www.genuinegmparts.com/pdf/positionstatements/pre-post-scan-collision-vehicles.pdf</a></b>					
<b>If you sublet your scanning and calibration work out to a 3rd party please ensure that they follow the below protocol.</b>					
<input type="checkbox"/>	<b>GM Approved Scan/Calibration Options</b>	<b>Diagnostic Scanning</b>	<b>Company</b>	<b>Model</b>	
	Diagnostic Scan Tool that can capture diagnostic trouble codes (DTC)	Utilizing the Multiple Diagnostic Interface 2 (MDI-2) or any SAE J2534 compliant device.	General Motors	Global Diagnostic System 2 (GDS2) or Tech2Win	Runs GDS2 locally (on a computer on-site with the vehicle)
	Diagnostic Scan Tool that can capture diagnostic trouble codes (DTC)	Utilizing the Multiple Diagnostic Interface 2 (MDI-2) or any SAE J2534 compliant device.	AirPro Diagnostics	Utilizes GDS2 and/or Tech2Win	Runs GDS2 locally (on a computer on-site with the vehicle)
	Diagnostic Scan Tool that can capture diagnostic trouble codes (DTC)	Utilizing the Multiple Diagnostic Interface 2 (MDI-2) or any SAE J2534 compliant device.	Drew Tech	Utilizes GDS2 and/or Tech2Win	Runs GDS2 locally (on a computer on-site with the vehicle)
	Diagnostic Scan Tool that can capture diagnostic trouble codes (DTC)	Utilizing the Multiple Diagnostic Interface 2 (MDI-2) or any SAE J2534 compliant device.	Mitchell Diagnostics	MD-OEM using GDS2 and/or Tech2Win	Runs GDS2 locally (on a computer on-site with the vehicle)
	Communication Interface Device that can capture diagnostic trouble codes (DTC)	Utilizing the Multiple Diagnostic Interface 2 (MDI-2).	asTech	Utilizes GDS2 and/or Tech2Win	Runs GDS2 and/or Tech2Win remotely (on computer in asTech® data center)
<b>This list is subject to change at GM's discretion.</b>					
<b>C8 Required Equipment</b>					
	C8 Countersink Cutter Kit			<a href="https://gmdesolutions.com/item-detail.aspx?itemid=125340490&amp;type=equipment">https://gmdesolutions.com/item-detail.aspx?itemid=125340490&amp;type=equipment</a>	

Signifies Audit Item

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Car-O-Liner

Frame Benches	REFERENCE NUMBER
BenchRack 4200*	NA-34573-KIT
BenchRack 5000*	NA-34639-KIT
BenchRack 5500*	NA-34640-KIT
BenchRack 6300*	NA-33907-KIT
Quick 42*	46642
<b>Anchoring &amp; Fixturing</b>	
REFERENCE NUMBER	
EVO 1 Basic Anchoring System	35413
EVO 2 Extended Anchoring System	35419
EVO3 Universal Fixturing System	35719
EVO 630mm tower ( 2 req'd)	35067
B248 anchoring plate (4 req'd)	30638
B333 fixture (4 req'd)	30641
<b>3D Electronic Measuring **</b>	
REFERENCE NUMBER	
Car-O-Tronic Vision2 X3	46733

Celette

Frame Benches	REFERENCE NUMBER
Sevenne, Sevenne XL*	N/A
Griffon, Griffon XL*	N/A
Rhone, Rhone XL*	N/A
Smart Rhone*	N/A
<b>EQUIPMENT DESCRIPTION</b>	
REFERENCE NUMBER	
Crossmembers (set of 6)	955A.9412
22 MZ Towers (with pins)	MZ450.010
MZ Trolley	MZ450.907
MZ Plus kit	MZ2500.000
Cameleon Premium	CAM02.162
Cameleon Side Body kit	CAM04.032
Additional Straight Cross Member	955A908
<b>3D Electronic Measuring **</b>	

Car Bench International

Frame Benches	REFERENCE NUMBER
Manta*	CBIMANTA
Manta XL 5.2 meters	
Muraena*	CBIMURAENA
<b>Anchoring &amp; Fixturing</b>	
PACDIMA08 8 point system	minimum 8 required
PACDIMA12 12 point system	12 point optional
C281 Side,Upper	
<b>3D Electronic Measuring **</b>	

Spanesi

Frame Benches	REFERENCE NUMBER
106 Bench*	5MTR
106 EXT Bench*	6MTR
<b>Anchoring &amp; Fixturing</b>	
Superstar Universal Fixturing	N/A
<b>3D Electronic Measuring**</b>	

Chief

Frame Racks	REFERENCE NUMBER
Excelsator	
EZ Liner, Standard, S21/S21M	
18' Impulse, or Impulse Tilt	
20' Impulse or Impulse Tilt	
18' Impulse VHT	
20' Impulse VHT	
18' or 20' E-VHT	
Goliath	
Fuzion	
Titan-360 21 series	
<b>Anchoring &amp; Fixturing</b>	
REFERENCE NUMBER	
C8 complete structural holding System (Complete) or	CK300036
1-Structural Holding Base w/tool board and cart	CK300021
1-GM Base w/tool chest	CK300037
1-Corvette C8 w/ tool chest	CK300038
1-Upper Body Structural Holding	CK300039
Additional Bases if needed (minumum of 10 required)	502128
<b>3D Electronic Measuring**</b>	

\* Minimum of one bench on site

\*\*3D Measuring system Accuracy +/- 1mm Current model year software Pre/post measure documentation