



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
Required Frame Aligning Equipment / Bench / Rack				
<input type="checkbox"/> Frame Aligning Equipment / Fixture Bench / Frame Rack	Capable of supporting 7000 lbs. 4 holding points minimum for rack system.	Please reference 'Corvette C8 Required Fixturing Equipment by Manf' for additional details		** Dedicated or universal fixturing equipment is required for structural repairs on Corvette C8. Minimum of one bench/rack on site. **
<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 a 3D electronic measuring system is required. For bench systems utilizing dedicated or universal type fixtures a 3D electronic measuring system is recommended but not 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			
Required Welding and MIG Brazing Equipment				
<input type="checkbox"/> Aluminum MIG Welder	208V-240V Pulse Synergic MIG Welder, 200 Amp output capability			
<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 vice / Vernier caliper, 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.			Wire: Er CuSi-a or CuSi-3 .08mm diameter recommended
<input type="checkbox"/> MIG/MAG weld equipment	208V-240V, 180 Amp output capability			ER70S-3
<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. Please ensure you are also using the approved software ID listed with the STRSW.		Search for 'Spot Welders' at:	www.gmdesolutions.com
Expected Welding and MIG Brazing Equipment				
Auto-dim Welding Helmet	Minimum #11 shade with 3 sensors - one for each MiG/mag welder			
Welding Blankets	Minimum 2 per MIG/MAG and stress welding machine			
Welding Respirator	Must meet NIOSH 42 cfr part 84			
Welding Spark Paper				
Required Mechanical Repair Equipment				
<input type="checkbox"/> A/C recovery / recycle / charging station for R134a and R1234YF	Compliant with all current regulations			Or must have access to recovery/recycling service (sublet)
Expected Mechanical Repair Equipment - Unless work is sublet out				
A/C Electronic Leak Detector				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

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Category	Specification	Manufacturer	Model	Notes
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
Wheel Balancer				Or must have access to a wheel balancer (sublet)

Required Collision Repair Equipment

<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"/>	Correct Application equipment for seam sealer/undercoating/corrosion resistance products	See product application guidelines		
<input type="checkbox"/>	Correct Application Equipment for 2-part Adhesives	See product application guidelines		
<input type="checkbox"/>	Glass Removal / Installation Tools and Equipment			Or have access to sublet service provider
<input type="checkbox"/>	Structural Blind Rivet gun	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		

Expected Collision Repair Tools

	Aluminum Repair Hand Tools	Dedicated, stored separately		
	Cavity Wax Gun or Applicator	Aerosol is acceptable - 360 degree spray head with minimum 36" wand, aerosol is acceptable		
	Decal Remover	Eraser wheel type		
	Dent Puller / Stud Welder	Stud and/or washer capable		
	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		

Required General Repair Facility Equipment

<input type="checkbox"/>	Two or Four Post Surface Lift	Minimum 7,000 lb. capacity, two or four post lift		
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Expected General Repair Equipment

	Access to GM OEM Repair Procedures	Technician access to OEM service information - complimentary service express subscription provided		
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Air Compressor	High pressure, high volume, dry and oil free air			
Battery Charger+B78	Charger/booster/ jumper with start and boost capability			
Battery Tester	Or must have access to a battery tester (sublet) - with load testing capability, this may only be sublet if scanning is also sublet to the same provide			
Bench mounted Vice				
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 200 lb./ft) - annual calibration			
Vacuum Cleaner				
Wheel Dollies	Minimum 1500 lb. Capacity (each)			

Required Paint & Refinishing Equipment				
<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	Or equivalent
<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			

Expected Paint & Refinish Equipment				
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 compliant with local regulations - only required where also required by local code.			
Paint station with scales	As required by paint supplier, scale must be capable of interface with mix computer			
Painter suits and protective gear	As specified by refinish maker			
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 pps style cups with written policy for manual gun cleaning			
Spray stand (fender / door)				
Spray stand (hood / trunk)				

Technician Tools				
Expected Technician Tools				

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Category	Specification	Manufacturer	Model	Notes
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)				
Vise grip set				

Personal Protection Equipment (PPE)

Expected Personal Protection Equipment				
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			

Diagnostic Scan

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: <https://www.genuinegmparts.com/pdf/positionstatements/pre-post-scan-collision-vehicles.pdf>
If you sublet your scanning and calibration work out to a 3rd party please ensure that they follow the below protocol.

GM Approved Scan/Calibration Options	Diagnostic Scanning	Company	Model		
<input type="checkbox"/>	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)

This list is subject to change at GM's discretion.



Corvette C8 Required Fixturing Equipment

Updated December 2020
Replaces all previous versions

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
Anchoring & Fixturing	REFERENCE NUMBER
EVO 1 Basic Anchoring System	35413
EVO 2 Extended Anchoring System	35419
EVO3 Universal Fixturing System	35719
3D Electronic Measuring **	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
EQUIPMENT DESCRIPTION	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
3D Electronic Measuring **	

Car Bench International

Frame Benches	REFERENCE NUMBER
Manta*	CBIMANTA
Muraena*	CBIMURAENA
Anchoring & Fixturing	
PACDIMA08 8 point system	minimum 8 required
PACDIMA12 12 point system	12 point optional
C281 Side, Upper	
3D Electronic Measuring **	

Spanesi

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

Chief

Frame Racks	REFERENCE NUMBER
Excelerator	
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	
Anchoring & Fixturing	REFERENCE NUMBER
C8 complete structural holding System (Complete)	CK300036
1-Structural Holding Base w/tool board and ca	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 (minimum of 10 re	502128
3D Electronic Measuring**	

* Minimum of one bench on site

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