

Trans-Matic
DRAFT—Raw Material Packaging Specification Details—DRAFT

Applies To Presses:

551E

Un-coiler dia.: 52”
Un-coiler cap: 7500 LBS

Supplier Documentation:

1. Each coil shipped must be identified with supplier name, master coil number, and purchase order number.
2. Material certification papers required with each shipment.

Trans-Matic Labeling Requirements:

1. Use standard AIAG format or similar.
2. T-M Part Number—plus bar code (P)
3. PO Number—Plus bar code (K)
4. Heat Number—plus bar code (1T)
5. Actual / Net weight—plus bar code (2Q)
6. Supplier Name
7. Date

Trans-Matic Skid Dimensions and Requirements:

PURPOSE: The purpose of these requirements are to ensure that skids and coils operate safely and effectively on “de-coilers”, and are able to be transported safely with material handling equipment.

1. Cardboard cores at the option of the supplier.
2. No paper, cardboard or other filler material between coil wraps.
3. **No excess packaging material in center of coil. Center of coil skid must be opened for insertion of coil lock pin.**
4. 3/4-inch spacers between coils.
5. 16” to 20” Coil ID, **64” Max Coil OD**, 44” Min Coil OD.
6. Max skid height is 20”. **Skid height to coil OD ratio is 75% or less. ($H_s \div OD \leq 0.75$).**
7. No more than 12 coils on a skid.
8. **7500 LB Max Skid.**
9. Coil must be centered on the skid.
10. At least one band attached within 1-inch of coil end (or belly band).
11. Skid construction solid, fastened together securely, no nails/screws protruding.
12. Skids symmetrical and uniform in width, length, and diagonal.
13. Skids not to exceed **68” in width, length, or diagonal.**
14. Outside boards must extend beyond the coil OD at least 2” each corner, supporting the coil on 4 corners.
15. Skid diagonal must be greater than the coil OD by at least 4”.
16. **Two stringers parallel and 30” to 44” apart, outside dimension. No center stringer.**
17. **Four deck board min. on skid. 6” min. spacing in center between deck boards. No center deck board.**
18. Boards equally spaced on the skid.
19. Stock reel payoff specified as counter-clockwise (CCW)

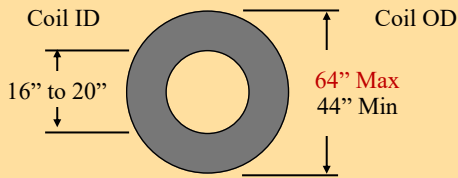
Trans-Matic
DRAFT—Raw Material Packaging Specification Illustrations—DRAFT

Applies to Presses:

551E

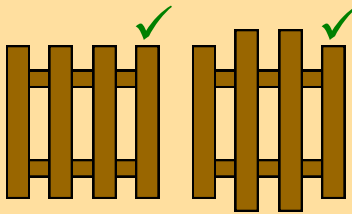
Un-coiler dia.: 52"
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Coil Dimensions



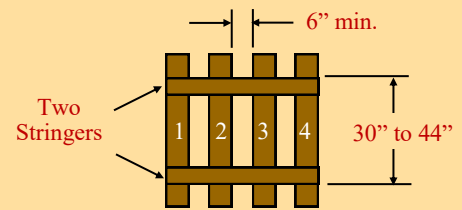
Coil ID, 16" to 20"
 Coil OD, 64" maximum.

Skid Uniformity



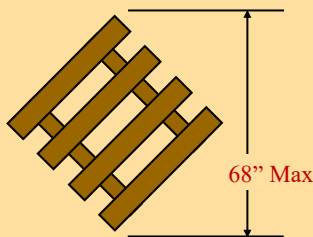
Skids symmetrical and uniform in width, length, and diagonal.

Skid Construction



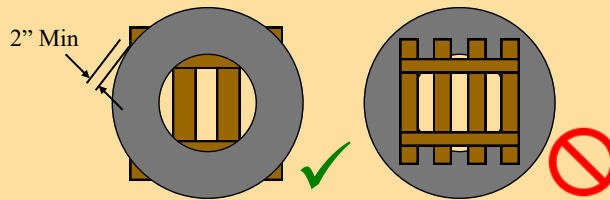
Four deck boards min. 6" min. space in center between deck boards. Two stringers max., parallel and 30" to 44" apart, outside dimension. No center deck board. No center stringer. Solid construction, with no protruding nails or screws.

Skid Dimension



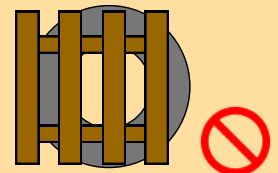
Skids not to exceed 68" in width, length, or diagonal.

Coil Support



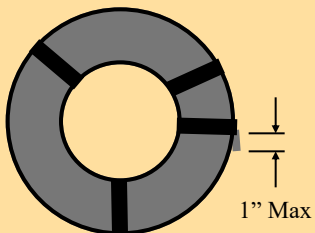
Outside boards extend beyond coil OD at least 2" each corner, supporting the coil on 4 corners. Skid diagonal greater than coil OD by at least 4".

Coil Support



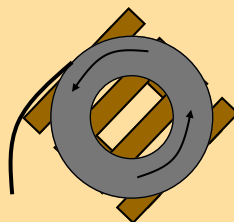
Coil centered on skid.

Coil Banding



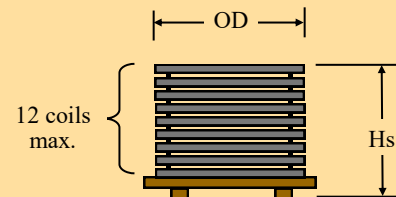
At least one band attached within 1-inch from end (or belly band).

Payoff Direction



Counterclockwise (CCW) stock reel payoff.

Coil Stack Limits



Height of skid (Hs): 20" Max.
 Hs: OD ratio ≤ 0.75
 12 coils Max.
 3/4" spacers between coils.