

**Trans-Matic**  
**Raw Material Packaging Specification Details**

**Applies To Presses:**

551F

**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 this section is to ensure that skids and coils operate safely and effectively on the “de-coilers”, and material handling equipment.

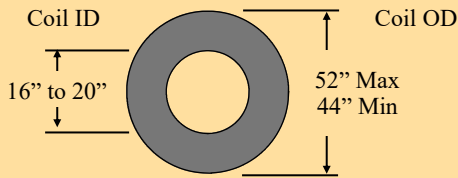
1. Cardboard cores at the option of the supplier.
2. No paper, cardboard or other filler material between coil wraps.
3. 3/4-inch spacers between coils.
4. 16” to 20” Coil ID, 52” Max Coil OD, 44” Min Coil OD.
5. Max skid height is 20”. Height of skid to coil OD ratio  $\leq 0.75$  ( $Hs:OD \leq 0.75$ ).
6. No more than 12 coils on a skid.
7. 5,000 LB Max Skid.
8. Coil must be centered on the skid.
9. At least one band attached within 1-inch of coil end (or belly band).
10. Skid construction solid, fastened together securely, no nails/screws protruding.
11. Skids symmetrical and uniform in width, length, and diagonal.
12. Skids not to exceed 56” in width, length, or diagonal.
13. Outside boards must extend beyond the coil OD at least 2” each corner, supporting the coil on 4 corners.
14. Skid diagonal must be greater than the coil OD by at least 4”.
15. Two stringers parallel and 24” to 36” apart, outside dimension.
16. 4 board minimum on skid.
17. Boards equally spaced on the skid.
18. Stock reel payoff specified as counter-clockwise (CCW)

# Trans-Matic Raw Material Packaging Specification Illustrations

**Applies to Presses:**

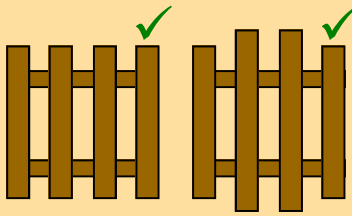
551F

### Coil Dimensions



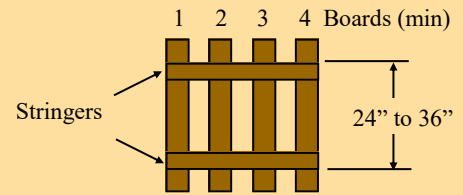
Coil ID, 16'' to 20''  
Coil OD, 52'' maximum.

### Skid Uniformity



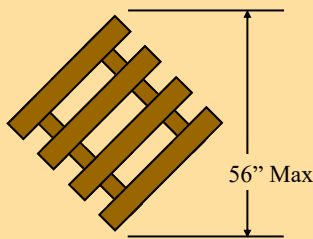
Skids symmetrical and uniform in width, length, and diagonal.

### Skid Construction



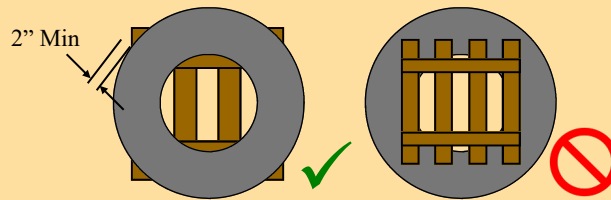
4 boards minimum, evenly spaced. 2 stringers parallel and 24'' to 36'' apart, outside dimension. Skid construction solid, no nails protruding.

### Skid Dimension



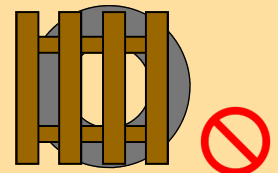
Skids not to exceed 56'' in width, length, or diagonal.

### Coil Support



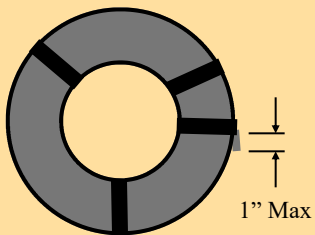
Outside boards extend beyond coil OD at least 2'' each corner, supporting the coil on 4 corners. Skid diagonal greater than coil OD by at least 4''.

### Coil Support



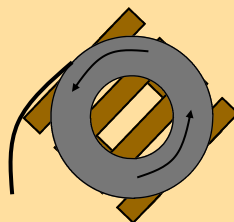
Coil centered on skid.

### Coil Banding



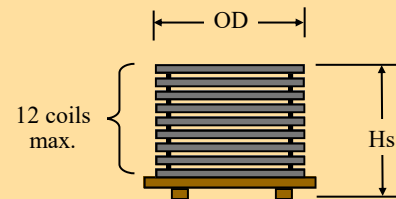
At least one band attached within 1-inch from end (or belly band).

### Payoff Direction



Counterclockwise (CCW) stock reel payoff.

### Coil Stack Limits



Height of skid (Hs): 20'' Max.  
Hs: OD ratio  $\leq 0.75$   
12 coils Max.  
3/4'' spacers between coils.