

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

## **Applies To Presses:**

3105A

136 Servo

## **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. No more than one coil per skid.
4. 19” to 22” Coil ID, 72” Max Coil OD, 59” Min Coil OD.
5. Coil must be as close to OD Max as possible without going over max weight.
6. Max skid height is 20”. Height of skid to coil OD ratio  $\leq 0.75$  (Hs:OD  $\leq 0.75$ ).
7. 6000 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 76” 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)

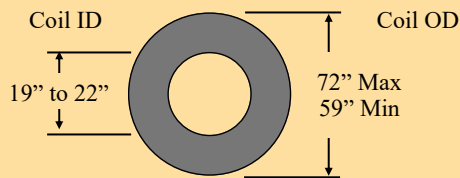
**Trans-Matic**  
**Raw Material Packaging Specification Illustrations**

**Applies to Presses:**

3105A

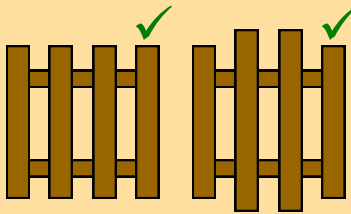
136 Servo

**Coil Dimensions**



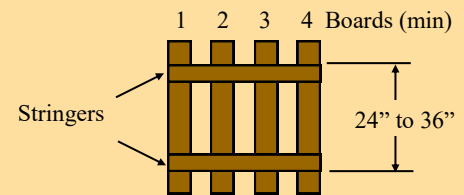
Coil ID, 19" to 22"  
Coil OD, 72" maximum.

**Skid Uniformity**



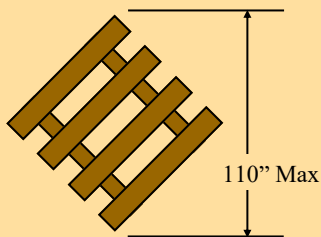
Skids symmetrical and uniform in width, length, and diagonal.

**Skid Construction**



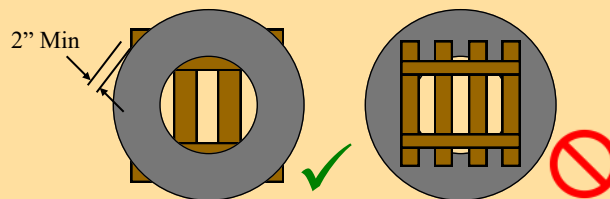
4 boards minimum, evenly spaced. 2 stringers parallel and 24" to 36" apart, outside dimension. Skid construction solid, no nails protruding.

**Skid Dimension**



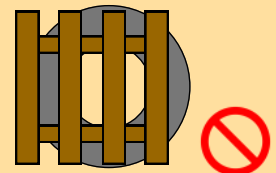
Skids not to exceed 110" in width, length, or diagonal.

**Coil Support**



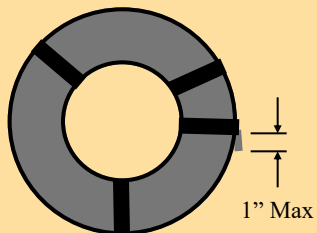
Outside boards extend beyond coil OD at least 2" each corner, supporting the coil on 4 corners. Skid diagonal greater than coil OD by at least 4".

**Coil Support**



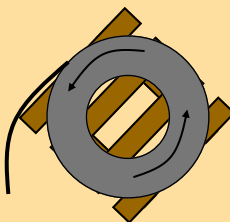
Coil centered on skid.

**Coil Banding**



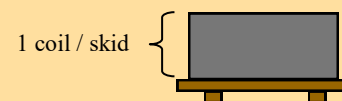
At least one band attached within 1-inch from end (or belly band).

**Payoff Direction**



Counterclockwise (CCW) stock reel payoff.

**Coil Stack Limits**



One coil / skid