

Coil Packaging Specifications (refer to data table for values and dimensions)

SUPPLIER DOCUMENTATION

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

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

SKID REQUIREMENTS

PURPOSE: These requirements 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 must be open for insertion of coil lock pin.
4	SPACERS: Spacers between coils must be at least ___-inch thickness. Refer to data table dimension "J".
5	COIL ID/OD MIN-MAX: Refer to the data table for coil ID max and min, and coil OD max and min, dimensions "A" and "B".
6	SKID HEIGHT MAX: Refer to the data table for max skid height. Skid height to coil OD ratio is 75% or less ($H_s \div OD \leq 0.75$). Dimension "C".
7	NUMBER OF COILS MAX: No more than 12 coils on a skid unless specified in the table. Value "D".
8	TOTAL SKID WEIGHT MAX: Refer to data table for max skid weight, value "G".
9	MAX COIL WEIGHT (when applicable): Refer to data table for max coil weight, value "H".
10	Coil must be centered on the skid.
11	At least one band attached within 1-inch of coil end, unless equipped with a belly band.
12	SKID CONSTRUCTION: Skid construction solid, fastened together securely, no nails/screws protruding.
13	SKID CONSTRUCTION: Skids symmetrical and uniform in width, length, and diagonal.
14	SKID DIMENSIONS: Skids not to exceed ___-inch width, length, or diagonal. Refer to data table, dimension "E"
15	SKID DIMENSIONS: Outside boards must extend beyond the coil OD at least 2-inches each corner, supporting the coil on 4 corners.
16	SKID DIMENSIONS: Skid diagonal must be greater than the coil OD by at least 4-inches.
17	SKID CONSTRUCTION: Two stringers parallel with an outside dimension of min ___ and max ___ apart. Refer to data table, dimension "F"
18	SKID CONSTRUCTION: 4 board min. on skid. Spacing between middle boards, 6-inches min., 12-inches max. Space must be provided for coil lock pin.
19	SKID CONSTRUCTION: Boards equally spaced on the skid.
20	PAYOFF DIRECTION: Stock reel payoff specified as clockwise, CW, or counterclockwise, CCW. Refer to data table, value "I".

Coil Packaging Specifications Data Table

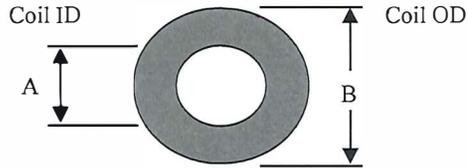
Critical dimensions (units in pounds and inches)	325, 337, 912, 345, 437, 551, 560, 612, 814, 3814	3814C	105, 1212, 15DS, 2012, 1512	510, 512, 1012	551C	551E	3105A, 136-Servo	400, 600, 240-Servo, 337-Servo	10516A	087A	160PD	150PD	250PD
Coil ID min/max (A)	16/20	16/20	16/20	12/20	16/20	16/20	19/22	18/22	18/22	16/20	18/20	16/20	20/24
Coil OD min/max (B)	44/52	50/60	44/52	34/52	44/52	50/60	59/72	59/72	59/72	50/60	50/62	50/62	50/62
Max skid height* (C)	20*	20*	20*	18*	20*	20*	n/a	n/a	n/a	20*	20*	20*	20*
Max number of coils (D)	12	12	12	12	12	12	1	1	1	6	6	6	6
Max skid dimension (E)	56	64	56	51	56	72	76	76	76	77	77	77	77
Skid stringers min-max, outside dim. (F)	24/36	32/44	24/36	24/36	24/36	28/44	24/36	24/36	24/36	24/36	24/36	24/36	24/36
Max total skid weight (G)	3500	5000	3500	3500	5000	7500	6000	10000	6000	6000	8000	6000	10000
Max coil weight (H)	n/a	n/a	n/a	n/a	n/a	n/a	6000	10000	6000	2000	8000	6000	10000
Stock payoff (CW/CCW) (I)	CCW	CCW	CW	CW	CCW	CCW	CCW	CCW	CCW	CCW	CCW	CCW	CCW
Spacer between coils min (J)	0.75	0.75	0.75	0.5	0.75	0.75	n/a	n/a	n/a	1	1	1	1

*The max skid height is also limited to the height to width ratio. Skid height to coil OD ratio is 75% or less ($H_s \div OD \leq 0.75$)

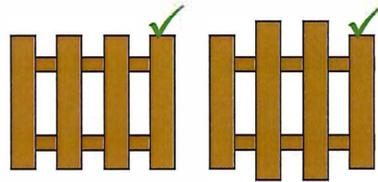
Coil Packaging Specifications Illustrations

(refer to data table for corresponding dimensions and values)

Coil Dimensions (A, B)

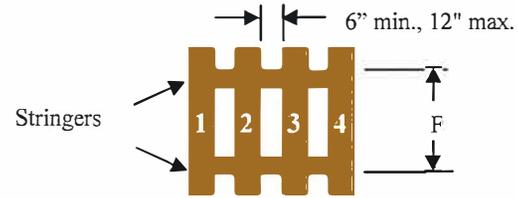


Skid Uniformity



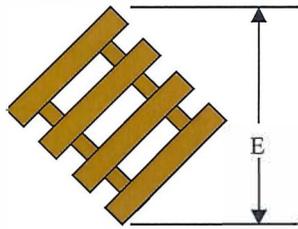
Skids symmetrical and uniform in width, length, and diagonal.

Skid Construction (F)



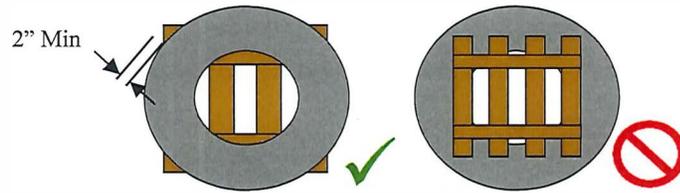
4 boards minimum. 6" min., 12" max. space between middle boards 2 and 3. Two stringers parallel and "F" apart, outside dimension. Skid construction solid, no nails protruding.

Skid Dimension (E)



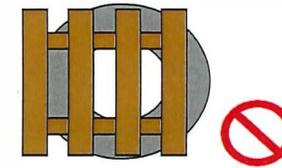
Skids not to exceed "E" in width, length, or diagonal.

Coil Support



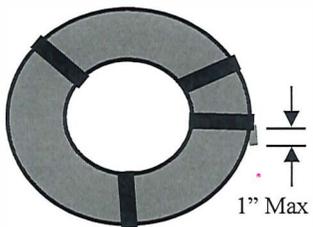
Outside boards extend beyond coil OD at least 2" each corner, supporting the coil on 4 corners. Skid diagonal greater than coil OD by at least 4".

Coil Support



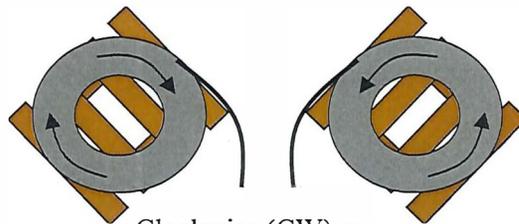
Coil centered on skid.

Coil Banding



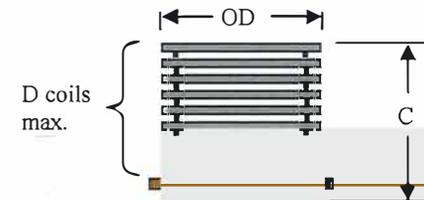
At least one band attached within 1-inch from end (or belly band).

Payoff Direction (I)



Clockwise (CW) or Counterclockwise, (CCW) stock reel payoff, value "I".

Coil Stack Limits (C, D, J)



Max height of skid: C : OD ratio ≤ 0.75
 "D" coils Max. Minimum spacer thickness between coils is dimension "J". No spacer between bottom coil and skid.