

TOYOTA MOTOR MANUFACTURING
NORTH AMERICA

Supplier Packaging Policies & Standards

September 2002

Table of Contents

1. Background.....	2
2. Purpose.....	2
3. Scope.....	2
4. Packaging Operations Manual.....	2
5. Policy.....	3
6. Expectations.....	4
7. Process (Excludes NUMMI & TMMC).....	5
8. Standards.....	6
Appendix A – Tote Standards.....	7
Appendix B – Label Standards.....	9
Appendix C – Rack Standards.....	12

1. Background

Toyota generally requires that all parts shipments to our manufacturing facilities be made using returnable packaging. This packaging includes steel racks, plastic totes and dunnage that may be required to secure and protect the parts within the tote.

Recently, TMMNA has reflected on the total cost of returnable packaging on past vehicle programs. The reflection highlighted 2 main points:

- There are significant cost reduction opportunities available.
- A major portion of the total cost is determined by the procurement activities of our parts suppliers.

As a result, returnable packaging has been identified as a major cost reduction opportunity for you, the supplier, to meet Toyota expectations for total cost reduction. This manual has been developed to help you meet those expectations.

2. Purpose

This manual aims to:

- Communicate TMMNA Returnable Packaging Policy
- Communicate TMMNA Procurement Expectations
- Communicate TMMNA Standards
- Provide a reference

3. Scope

Policy & Expectations	All NAMC's except NUMMI	
Payment Process	TMMAL, TMMBC, TMMK, TMMI, & TMMWV	
Specifications	Racks	All NAMC's
	Labels	All NAMC's
	Totes	All NAMC's (NUMMI has additional types & sizes)

4. Packaging Operations Manual

This document is for Policies and Standards. Each NAMC has its own Pkg Operations Manual to cover Packaging Quality and Operational issues in addition to this document. If you find anything conflicting between this document and the NAMC Pkg Operations Manual's, please contact TMMNA PC for clarification.

5. Policy

TMMNA's policy regarding returnable packaging is outlined in our Terms and Conditions. It has been copied verbatim for your reference.

- Reference Terms and conditions, Section 2.4d

2.4 (d) Packing Requirements

1. Unless otherwise instructed by Toyota Party, all items are to be prepared and packed according to packaging specifications provided by Toyota Party, and are to meet all carriers requirements. The quantity of packaging is determined by Toyota Party, and any additional quantities are Supplier's responsibility.
2. In the event returnable packaging is deemed by Toyota Party to be advisable or necessary for the delivery of items ("Returnable Packaging"), TMMNA shall reimburse Supplier for the acquisition costs of such Returnable Packaging on mutually acceptable terms. The Returnable Packaging shall be the property of Supplier unless otherwise designated by TMMNA. The price for such Returnable Packaging shall be set forth in a separate Purchase Order and paid for in accordance with the general payment terms as set forth in Section 2.3. **Supplier is responsible for cleaning, replacing or repairing any lost or damaged Returnable Packaging.**

6. Expectations

Each and every supplier is expected to:

1. Take full responsibility of their returnable packaging cost and to commit to reducing it significantly.
2. Select the lowest cost option available that will ensure part quality.

Specifically:

Cost Control	<ol style="list-style-type: none"> 1. Reuse obsolete or extra packaging rather than purchase new. 2. Competitively bid at least 3 sources for all packaging unless the source has been pre-determined by Toyota. 3. Consider the total cost of the packaging when making your sourcing decision including freight, labels, kanban holders, etc.
Simple Design	<ol style="list-style-type: none"> 4. Utilize standard tote & rack sizes unless part design or other criteria make impractical. 5. If a non-standard size packaging is approved by Toyota, follow all other standard specifications such as color, stacking feature, etc. 6. Design / redesign packaging to reduce cost. Some items to consider are: <ol style="list-style-type: none"> a. Eliminating or reducing dunnage b. Using alternate, less costly materials c. Increasing box efficiency. d. Simplifying the design for ease of manufacture e. Utilizing same design for each NAMC 1. Target less than 2 hours production per container. <u>(Note: some NAMC's may have lower targets.)</u> 2. Do not exceed a total weight of 15 kg. Per tote including dunnage & parts. <u>(Note: Some NAMC's may have a maximum box weight limit that is less than 15 kg.)</u> 3. During the design phase consider the following options in the sequence shown below. <ol style="list-style-type: none"> a. Option 1: Utilize the most efficient, smallest standard tote first without dunnage. b. Option 2: Utilize the most efficient, smallest standard tote with dunnage c. Option 3: Utilize the most efficient, smallest standard rack without dunnage. Target 48 x 45 footprint. d. Option 4: Utilize the most efficient, smallest standard rack with dunnage. Target 48 x 45 footprint.
Procurement Process	<ol style="list-style-type: none"> 1. Actively seek potential packaging suppliers in order to find the most competitive sources, other than TMMNA sourced packaging (totes) 2. Begin the procurement process (up to the point of ordering) as soon as the packaging has been approved so that the best price can be achieved. 3. Do not place the order until authorization has been received from the NAMC. 4. When a quote is requested by TMMNA, utilize the WARP Returnable Packaging quote form and provide as much detail as possible. 5. Consider lead time when quoting to ensure on time delivery.

7. Process

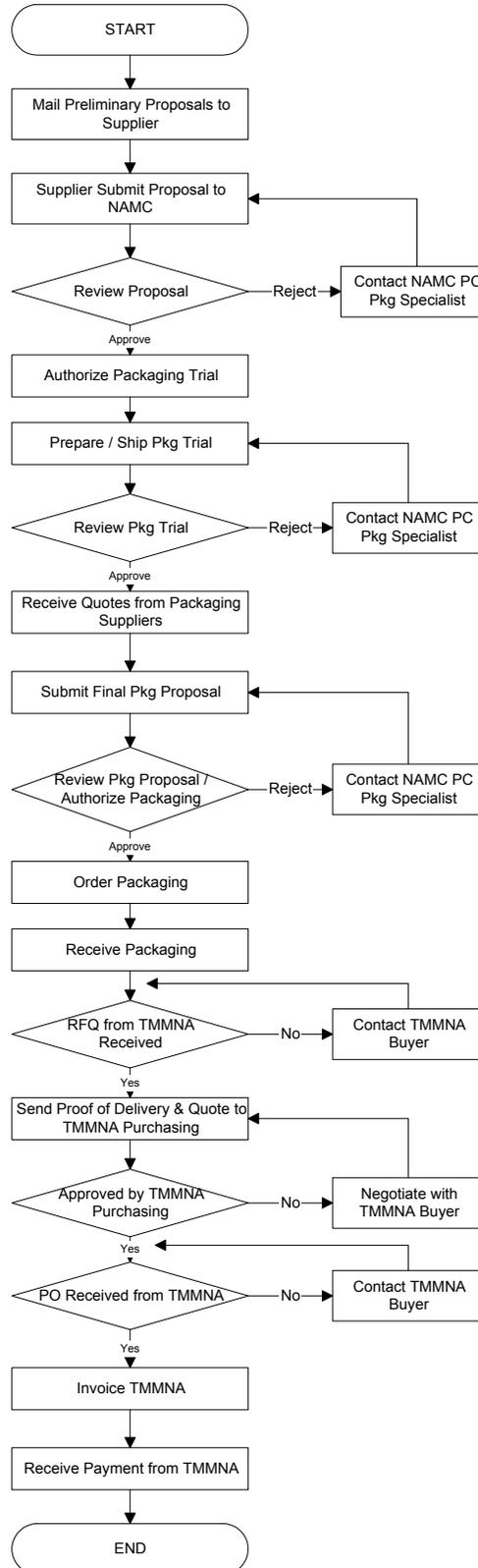
Excludes: NUMMI & TMMC

Responsible Target Timing

General Flow

Note: N = Month of SOP

NAMC PC	N - 14
NAMC PC	N - 14
SUPPLIER	N - 10
NAMC PC	N - 9
NAMC PC	N - 9
SUPPLIER	N - 8
NAMC PC	N - 7
SUPPLIER	N - 6
SUPPLIER	N - 6
NAMC PC	N - 5
SUPPLIER	N - 5
SUPPLIER	N - 2
SUPPLIER	N - 2
NA PURCHASING	N + 2
NA PURCHASING	N + 2
SUPPLIER	N + 3
SUPPLIER	N + 4



8. Standards

In an effort to reduce overall logistics costs, Toyota has implemented standard totes, labeling, and rack specifications.

The standard totes have been in place since 1997. The biggest recent change is the standardization of the color between NAMC's to Charcoal Grey. It does not obsolete any containers of different colors. It is a running change for future orders. This improves efficiency of container manufacturers to reduce lead time and cost.

The container identification standards are important to help improve the visual controls of the container, to improve the return accuracy to our Suppliers. It also improves flexibility for the re-use of containers in the future.

The biggest change to our standard containers is the agreement of rack standards between all NAMC's. The 2 critical points of agreement include the dimensions of the racks, and the stacking points. The reason for standard racks is to reduce overall logistics cost by doing the following:

- a. Improving stack ability of the trailers to increase the cubic efficiency of our routes
- b. Allows for competitive bidding
- c. Facilitates the re-use of racks for future models

Appendix A: Tote, Pallet, & Hot Stamp Standards

Tote Standards:

#	Dimension: In.			Dimension: mm			Labels / Tote	Orbis	Schaefer
	L	W	H	L	W	H			
1	12	15	4	305	381	102	2	NSO 1215-4RQ	AF 1215-04XC
2	12	15	7.5	305	381	191	4	NSO 1215-7RQ	AF 1215-07XC
3	24	15	4	610	381	102	2	NSO 2415-4RQ	AF 2415-04XC
4	24	15	7.5	610	381	191	4	NSO 2415-7RQ	AF 2415-07C
5	24	15	11	610	381	279	4	NSO 2415-11RQ	AF 2415-11XC
6	24	15	14.5	610	381	368	4	SO 2415-14RQ	AF 2415-14C
*7	36	15	4	914	381	102	2	NSOT 3615-4RQ	AF 3615-04CWC
*8	36	15	7.5	914	381	191	4	NSOT 3615-7RQ	AF 3615-07CWC
*9	36	15	11	914	381	279	4	NSOT 3615-11RQ	AF 3615-11CWC
*10	48	15	4	1219	381	102	2	NSOT 4815-4RQ	AF 4815-04CWC
11	48	15	7.5	1219	381	191	4	SO4815-7RQ	AF 4815-07XC
12	48	15	11	1219	381	279	4	SO4815-11RQ	AF 4815-11XC
13	24	22.5	7.5	610	572	191	4	NSO 2422-7RQ	AF 2422-07XC
14	24	22.5	11	610	572	279	4	NSO 2422-11RQ	AF 2422-11C
15	24	22.5	14.5	610	572	368	4	NSO2422-14RQ	AF 2422-14C

* = Cut n weld container, NUMMI does not utilize these sizes

- Container Color: Charcoal Grey (NUMMI Blue)
 - Labels / Tote: See Above. NUMMI: 2
 - Kanban Holders / Tote: 2
 - Hot Stamps:
 - TMMAL, TMMBC, TMMI, TMMK, TMMWV: "TOYOTA SHIPMENT" 1/tote
 - TMMC: "TMMC [TOYOTA]" 2/tote
 - NUMMI: NUMMI Logo, Property of New United Motor Manufacturing, Container Height 2/tote
- NUMMI utilizes additional sizes. Please refer to following page for NUMMI only containers.

Pallet & Top Cap Standards

#	Dimension: In.			Dimension: mm			Orbis	Schaefer
	L	W	H	L	W	H		
Plt Toyota	48.75	45.75	6.8	1238	1162	165	45 x 48-B MI CISF LP (with lip)	AFP 4845 (with lip)
Plt NUMMI	48.75	45.75	6.8	1238	1162	165	45 x 48-C CISF (with lip)	N/A
Top	48.75	45.75	1.5	1238	1162	50	45 x 48 MP-2 Top Cap CISC	AFT4845

- Color: Black
- Hot Stamps: 2. One on each 45" side of pallets & top caps
Hot stamp information is the same as above. The hot stamp is surrounded by a white square that simulates a load stripe. NUMMI has hot stamp "Property of NUMMI" on 48" side.

NUMMI TOTE STANDARDS

NUMMI utilizes TMMNA Standard containers for local California suppliers. The primary containers utilized by NUMMI for most suppliers are listed below.

Orbis FC-4845 Folding Containers

Model	Outside Dimensions			Stack Height	Inside Dimensions		Product Clearance	Collapsed Height	Weight Pounds (Kg)	K.D. Ratio
	Length	Width	Height		Length	Width				
FCSO1215-4	12.0 (305)	15.0 (381)	4.0 (102)	3.6	13.0	9.4	3.0	NA	2.0 (.91)	1:1
FC1215-075	12.0 (305)	15.0 (381)	7.5 (191)	7.2	13.5	10.6	6.8	2.6	3.7 (1.7)	3.1:1
FC1215-089	12.0 (305)	15.0 (381)	8.9 (226)	8.6	13.5	10.6	8.2	3.5	4.0 (1.8)	2.7:1
FC2415-075	24.0 (610)	15.0 (381)	7.5 (191)	7.2	22.5	13.6	6.8	2.6	5.3 (2.4)	3.1:1
FC2415-089	24.0 (610)	15.0 (381)	8.9 (226)	8.6	22.5	13.6	8.2	2.6	6.0 (2.7)	3.7:1
FC2415-111	24.0 (610)	15.0 (381)	11.1 (282)	10.8	22.5	13.6	10.4	2.6	6.7 (3.0)	4.7:1
FC2415-147	24.0 (610)	15.0 (381)	14.7 (373)	14.4	22.5	13.6	14.0	3.5	8.3 (3.8)	4.5:1

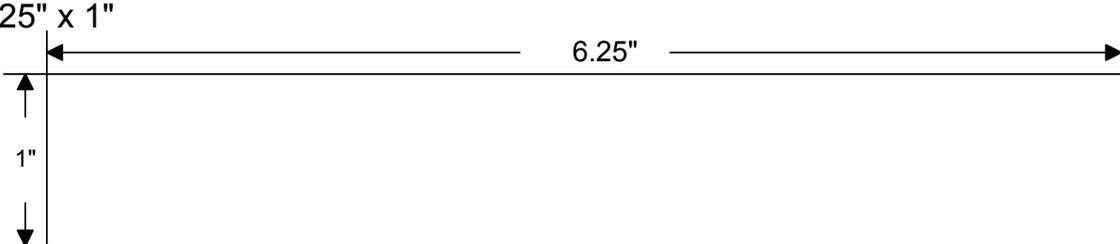
Orbis FC-4845 Folding Containers with Storage Bottom (containers with storage bottoms for custom interiors)

Model	Outside Dimensions			Stack Height	Inside Dimensions		Product Clearance		Collapsed Height	Weight Pounds (Kg)	K.D. Ratio
	Length	Width	Height		Length	Width	Assembled	Collapsed			
FC2415-111-4	24.0 (610)	15.0 (381)	11.1 (282)	10.8	22.5	13.6	10.4	3.6	6.2	7.0 (3.2)	1.8:1
FC2415-147-4	24.0 (610)	15.0 (381)	14.7 (373)	14.4	22.5	13.6	14.0	3.6	6.2	8.5 (3.9)	2.4:1
FC2415-147-7	24.0 (610)	15.0 (381)	14.7 (373)	14.4	22.5	13.6	14.0	7.0	9.8	8.4 (3.8)	1.5:1

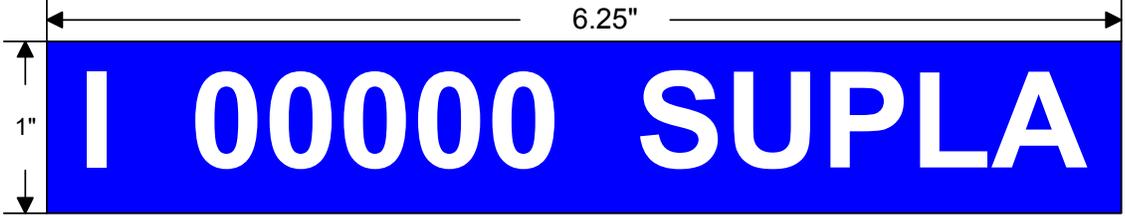
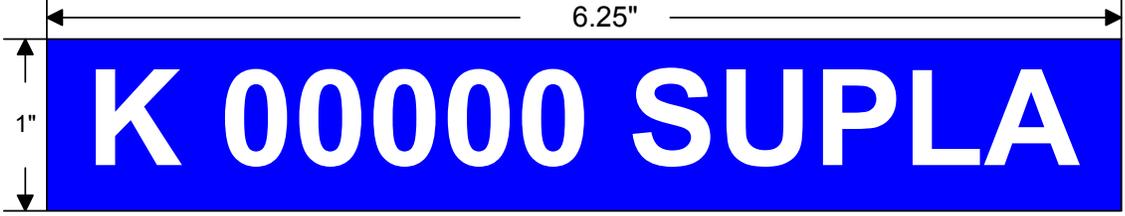
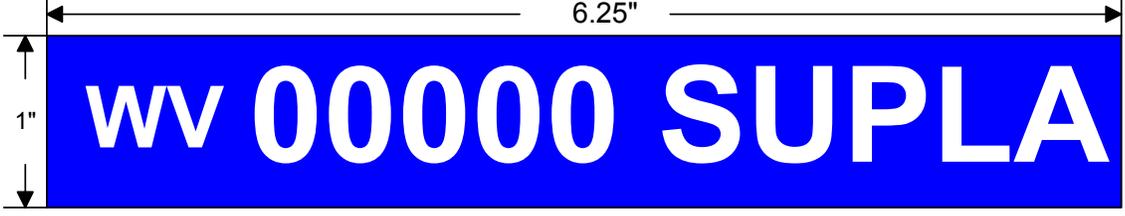
Buckhorn Bi-Color Stack & Nest Containers

Model	Outside Dimensions			Inside Dimensions		Storage Bottom Height	Weight Pounds (Kg)	K.D. Ratio
	Length	Width	Height	Length	Width			
BC24229	24.0 (610)	22.5 (572)	9.0 (229)	21.8	20.5	4.5	7.1 (3.2)	2:1
BC242211	24.0 (610)	22.5 (572)	11.0 (279)	21.8	20.5	5.5	7.6 (3.4)	2:1

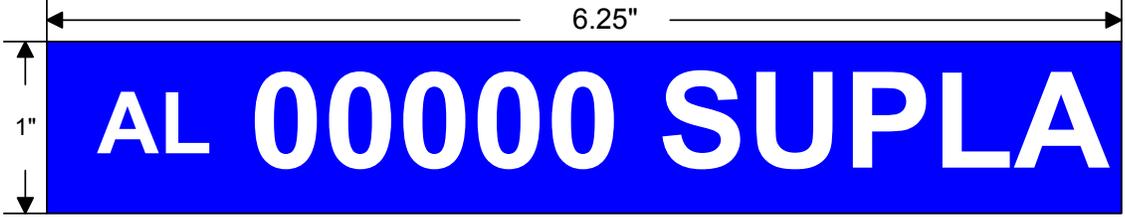
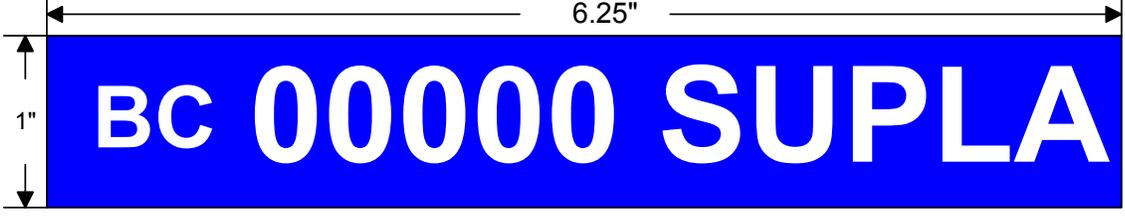
Appendix B: Container Identification

Item	Container ID Label Specifications																																																										
Dimension	 <p>6.25" x 1"</p> <p>6.25"</p> <p>1"</p>																																																										
Location	1) Stack Only Totes: 4 sides, except 12" x 15" x 4" - 2 sides sides 2) Nesting Totes: 4 sides 3) KD Totes (NUMMI): 2 sides																																																										
Colors	<table border="1"> <thead> <tr> <th>#</th> <th>Label Color</th> <th>Font Color</th> <th>Cross Dock (NA Network)</th> <th>Consolidation Center (NUMMI NETWORK)</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>Blue</td> <td>Process Blue</td> <td>White</td> <td>GCD</td> <td>Detroit</td> </tr> <tr> <td>2</td> <td>Red</td> <td>Red 187</td> <td>White</td> <td>RCD</td> <td>Southern California</td> </tr> <tr> <td>3</td> <td>Green</td> <td>Green 354</td> <td>White</td> <td>BCD</td> <td>Northern California</td> </tr> <tr> <td>4</td> <td>Orange</td> <td>Orange 144</td> <td>Black</td> <td>KCD</td> <td>El Paso</td> </tr> <tr> <td>5</td> <td>Purple</td> <td>Pantone Purple</td> <td>White</td> <td>OCD</td> <td></td> </tr> <tr> <td>6</td> <td>Yellow</td> <td>Pantone Yellow</td> <td>Black</td> <td>MCD</td> <td>MCD</td> </tr> <tr> <td>7</td> <td>Pink</td> <td>Pantone 223C</td> <td>Black</td> <td>Direct</td> <td></td> </tr> <tr> <td>8</td> <td>White</td> <td></td> <td>Black</td> <td></td> <td>Chicago</td> </tr> </tbody> </table>	#	Label Color	Font Color	Cross Dock (NA Network)	Consolidation Center (NUMMI NETWORK)	1	Blue	Process Blue	White	GCD	Detroit	2	Red	Red 187	White	RCD	Southern California	3	Green	Green 354	White	BCD	Northern California	4	Orange	Orange 144	Black	KCD	El Paso	5	Purple	Pantone Purple	White	OCD		6	Yellow	Pantone Yellow	Black	MCD	MCD	7	Pink	Pantone 223C	Black	Direct		8	White		Black		Chicago					
#	Label Color	Font Color	Cross Dock (NA Network)	Consolidation Center (NUMMI NETWORK)																																																							
1	Blue	Process Blue	White	GCD	Detroit																																																						
2	Red	Red 187	White	RCD	Southern California																																																						
3	Green	Green 354	White	BCD	Northern California																																																						
4	Orange	Orange 144	Black	KCD	El Paso																																																						
5	Purple	Pantone Purple	White	OCD																																																							
6	Yellow	Pantone Yellow	Black	MCD	MCD																																																						
7	Pink	Pantone 223C	Black	Direct																																																							
8	White		Black		Chicago																																																						
<p>Direct & Cross dock label:</p> <p>Some suppliers ship to 1 NAMC through both a cross dock and direct. In this case, the top half of the label is the color of the cross dock, the bottom half of the label is Pink 223c to reflect direct. Font color is always black.</p> 																																																											
Layout	See pages 2 & 3 for each NAMC's label layout.																																																										

Container Identification Continued

NAMC	LABEL LAYOUT
TMMI	 <p>All Fonts: 56 point Arial Bold; NAMC Code, Supplier Code; TLMS Code</p>
TMMK	 <p>All Fonts: 56 point Arial Bold; NAMC Code, Supplier Code, TLMS Code</p>
TMMWV	 <p>NAMC Code: 36 point font; Supplier Code: 56 point font; TLMS Code: 56 point font; All Arial Bold</p>
TMMC	 <p>NAMC Code: 36 point font; Supplier Code: 56 point font; TLMS Code: 56 point font; Cross dock: 20 point font; All Arial Bold</p>

Container Identification Continued

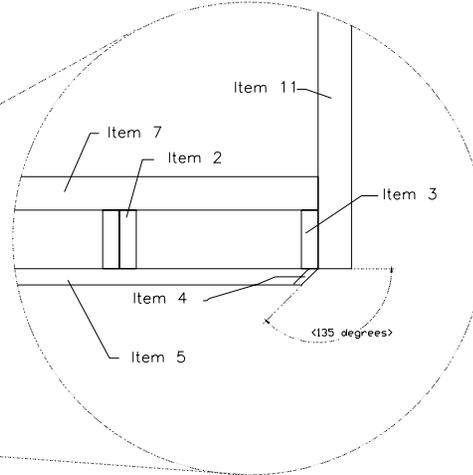
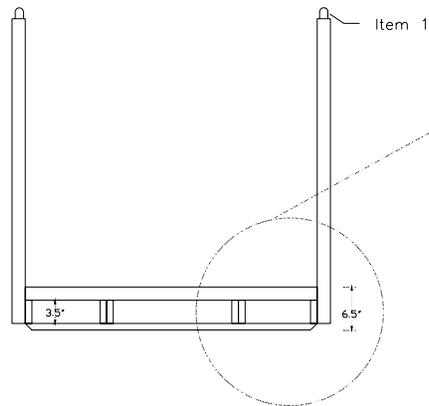
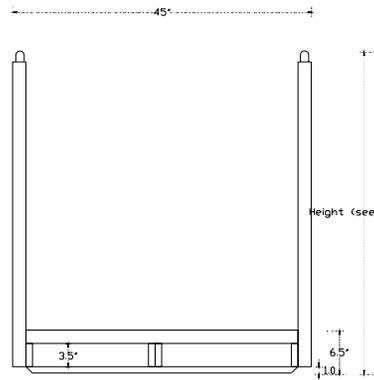
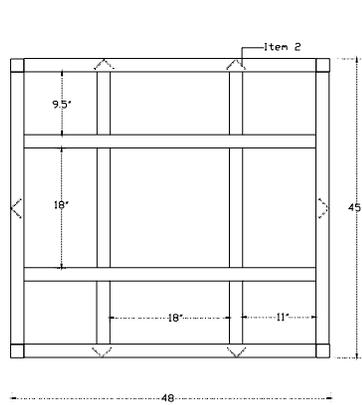
NAMC	LABEL LAYOUT
TMMAL	 <p>NAMC Code: 36 point font; Supplier Code: 56 point font; TLMS Code: 56 point font; All Arial Bold</p>
NUMMI	 <p>TLMS CODE: 49 pt font; Supplier Code: 19 point font; Supplier Name 29 point font; City/State: 29 point font; All Arial Bold</p>
TMMBC	 <p>NAMC Code: 36 point font; Supplier Code: 56 point font; TLMS Code: 56 point font; All Arial Bold</p>

Appendix C: Rack Standards

Item	Detail																																																							
Footprint	<p>The 13 footprints shaded box's & denoted with "0" are standard sizes. Always specify 45" x 48" footprint as first choice.</p> <table border="1" data-bbox="350 554 1511 856"> <thead> <tr> <th colspan="2" data-bbox="350 554 570 638">Standard Rack Footprints</th> <th colspan="9" data-bbox="570 554 1511 590">Length</th> </tr> <tr> <th colspan="2" data-bbox="350 638 570 701"></th> <th data-bbox="570 590 667 638">30" (762mm)</th> <th data-bbox="667 590 764 638">45" (1143mm)</th> <th data-bbox="764 590 862 638">60" (1524mm)</th> <th data-bbox="862 590 959 638">75" (1905mm)</th> <th data-bbox="959 590 1057 638">90" (2286mm)</th> <th data-bbox="1057 590 1154 638">105" (2667mm)</th> <th data-bbox="1154 590 1252 638">120" (3048mm)</th> <th data-bbox="1252 590 1349 638">150" (3810mm)</th> <th data-bbox="1349 590 1446 638">180" (4572mm)</th> </tr> </thead> <tbody> <tr> <td data-bbox="350 638 456 701">W i d t h</td> <td data-bbox="456 638 570 701">32" (813mm)</td> <td data-bbox="570 638 667 701">0</td> <td data-bbox="667 638 764 701"></td> <td data-bbox="764 638 862 701"></td> <td data-bbox="862 638 959 701"></td> <td data-bbox="959 638 1057 701"></td> <td data-bbox="1057 638 1154 701"></td> <td data-bbox="1154 638 1252 701"></td> <td data-bbox="1252 638 1349 701"></td> <td data-bbox="1349 638 1446 701"></td> </tr> <tr> <td></td> <td data-bbox="456 701 570 764">48" (1219mm)</td> <td data-bbox="570 701 667 764">0</td> <td data-bbox="667 701 764 764">0</td> <td data-bbox="764 701 862 764">0</td> <td data-bbox="862 701 959 764">0</td> <td data-bbox="959 701 1057 764">0</td> <td data-bbox="1057 701 1154 764">0</td> <td data-bbox="1154 701 1252 764">0</td> <td data-bbox="1252 701 1349 764">0</td> <td data-bbox="1349 701 1446 764">0</td> </tr> <tr> <td></td> <td data-bbox="456 764 570 827">96" (2438mm)</td> <td data-bbox="570 764 667 827"></td> <td data-bbox="667 764 764 827"></td> <td data-bbox="764 764 862 827">0</td> <td data-bbox="862 764 959 827">0</td> <td data-bbox="959 764 1057 827"></td> <td data-bbox="1057 764 1154 827">0</td> <td data-bbox="1154 764 1252 827"></td> <td data-bbox="1252 764 1349 827"></td> <td data-bbox="1349 764 1446 827"></td> </tr> </tbody> </table> <p data-bbox="350 827 922 856">Note: 45 x 48 footprint should always be first choice</p>	Standard Rack Footprints		Length											30" (762mm)	45" (1143mm)	60" (1524mm)	75" (1905mm)	90" (2286mm)	105" (2667mm)	120" (3048mm)	150" (3810mm)	180" (4572mm)	W i d t h	32" (813mm)	0										48" (1219mm)	0	0	0	0	0	0	0	0	0		96" (2438mm)			0	0		0			
	Standard Rack Footprints		Length																																																					
			30" (762mm)	45" (1143mm)	60" (1524mm)	75" (1905mm)	90" (2286mm)	105" (2667mm)	120" (3048mm)	150" (3810mm)	180" (4572mm)																																													
	W i d t h	32" (813mm)	0																																																					
	48" (1219mm)	0	0	0	0	0	0	0	0	0																																														
	96" (2438mm)			0	0		0																																																	
Height	<p>The height is based on a trailer opening of 98" tall. It takes into consideration 1.75" of nesting for the stacking cap, and 1" of nesting for the recessed bottom.</p> <table border="1" data-bbox="1146 926 1528 1171"> <thead> <tr> <th data-bbox="1146 926 1263 989">Stack Height</th> <th data-bbox="1263 926 1382 989">Height (in)</th> <th data-bbox="1382 926 1528 989">Height (mm)</th> </tr> </thead> <tbody> <tr> <td data-bbox="1146 989 1263 1020">1</td> <td data-bbox="1263 989 1382 1020">98.0</td> <td data-bbox="1382 989 1528 1020">2489</td> </tr> <tr> <td data-bbox="1146 1020 1263 1052">2</td> <td data-bbox="1263 1020 1382 1052">50.0</td> <td data-bbox="1382 1020 1528 1052">1270</td> </tr> <tr> <td data-bbox="1146 1052 1263 1083">3</td> <td data-bbox="1263 1052 1382 1083">34.0</td> <td data-bbox="1382 1052 1528 1083">864</td> </tr> <tr> <td data-bbox="1146 1083 1263 1115">4</td> <td data-bbox="1263 1083 1382 1115">26.5</td> <td data-bbox="1382 1083 1528 1115">673</td> </tr> <tr> <td data-bbox="1146 1115 1263 1146">5</td> <td data-bbox="1263 1115 1382 1146">21.5</td> <td data-bbox="1382 1115 1528 1146">546</td> </tr> <tr> <td data-bbox="1146 1146 1263 1178">6</td> <td data-bbox="1263 1146 1382 1178">18.5</td> <td data-bbox="1382 1146 1528 1178">470</td> </tr> </tbody> </table>	Stack Height	Height (in)	Height (mm)	1	98.0	2489	2	50.0	1270	3	34.0	864	4	26.5	673	5	21.5	546	6	18.5	470																																		
Stack Height	Height (in)	Height (mm)																																																						
1	98.0	2489																																																						
2	50.0	1270																																																						
3	34.0	864																																																						
4	26.5	673																																																						
5	21.5	546																																																						
6	18.5	470																																																						
Color	<p>All NAMC's except NUMMI: Light Grey NUMMI: Blue <u>Paint Type:</u> ESD</p>																																																							
Rack ID	<p><u>ID Color:</u> Black, NUMMI Color: White <u>Size:</u> 1.5" (38mm) Block Capitals Font <u>Information:</u> TOYOTA or NUMMI, NAMC Code, Supplier Code, TLMS Code <u>ID Location:</u> All 4 sides of the base. <u>Sequential Number:</u> All racks must be sequentially numbered. Two digit year code preceding the number. Located on the corner post.</p>																																																							
Stacking Caps	<p>Pin Post Design: Livonia Tool, 1738 B Stacking Cap location: Top, Recessed Bottom (1", 25 mm)</p>																																																							
Rack Frame	<p>Frame: 2" x 2" 11 gauge Steel</p>																																																							

Rack Standards continued

Item	Detail
Kanban Holders	<p>Kanban holders on 2 adjacent sides located near corner post. Holders must be visible.</p> <p>Contact specific NAMC to confirm location and specification for kanban holder.</p>
Bottom Strap	<p>4 way entry Opening Clearance: 3.5" (89mm) 1" x 2" (25mm x 51mm) bottom strap. Located around the perimeter of the base.</p>
Walk In Feature	<p>Walk in design should target an 18" width and a depth of 1/2 the distance into the rack.</p>
Knock Down Design	<p>Current Standard: Pin on the bottom. Working to develop a design with the pin on the top</p>



HEIGHTS (OD of Rack Height)

Stack Height	Height (in)	Height (mm)
1	98"	2489
2	50.0"	1270
3	34.0"	864
4	26.5"	673
5	21.5"	546
6	18.5"	470

NOTES: Grind all sharp corners
Complete Welds Around all items
Grind welds flush in stacking areas

12	1	Paint	ESD Light Grey
11	4	2" x 2" 11 ga.	OD Height minus 2.9"
10	4	2" x 2" 11 ga.	9.5" Length
9	2	2" x 2" 11 ga	18" Length
8	2	2" x 2" 11 ga	41" Length
7	4	2" x 2" 11 ga	44" Length
6	2	1" x 2" 11 ga.	41" Length
5	2	1" x 2" 11 ga.	44" Length
4	8	1/4" Plate	1" x 2"
3	8	1" x 2" 11 ga.	3.5" Length
2	6	3/16" Ang.	2" x 2" x 3.5" 3/16" Angle
1	4	Purch.	Livonia Tool 1738B Stacking Cap

ITEM NO.	QTY.	MATERIAL	SIZE/DESCRIPTION
BILL OF MATERIALS			
		45" x 48" Rack Base	
<small>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE (MILLIMETERS) FRACTIONS DECIMALS ANGLES ±1/16 .xxx±.1 ±1 .xxx±.01</small>			
<small>THIS DESIGN IS THE PROPERTY OF TOYOTA MOTOR MANUFACTURING NORTH AMERICA, INC. IT IS PROHIBITED TO REPRODUCE OR TRANSMIT IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.</small>			
<small>CHECKED BY:</small> T. Ballard	<small>DATE:</small> 9/20/02	<small>DWG NO.:</small> TMMNA.PK-RO001	<small>REV</small>
<small>SCALE</small>		<small>SHEET 1 OF 1</small>	