



Coiled-In-Reject for RV Filon® Bulk Coils

When Crane Composites products are produced in continuous coils, it is inevitable that there may be some coiled-in reject. The following policy addresses this issue.

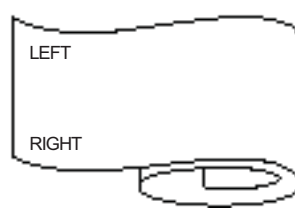
1. A bulk coil is defined as any panel 100 feet or longer.
2. No marked defect areas are allowed in the first or last 35 feet of a bulk coil. There must be a minimum of 35 feet between marked defects.
3. A continuous coil up to and including 500 feet in length can contain up to 6 reject areas. A coil over 500 feet and up to and including 700 feet may contain up to 8 reject areas.
4. The reject material will be credited on the invoice at time of shipment.
5. To assist customers in locating bulk reject areas, a Defect Coil Map is attached to each coil that leaves the manufacturing facility and one edge of the coil is marked with arrow labels to identify problem areas. Every attempt is made to identify all defect areas. Reject areas within 5 feet of reach will be marked and mapped as one reject area.
6. If an extensive area of reject is being generated as the coil is being made, this area will be cut out, leaving two panel ends butted together, creating a splice/cut. A maximum of two splices/cuts are allowed per coil, and each splice/cut will be counted as one defect. After a splice/cut is made, no marked defects are allowed in the next 35 feet of material.
7. The line inspectors will note on the Defect Coil Map the location and duration (in linear feet) of defective material along with an identifying code of the type of reject. One copy will be included in the shipping label pocket for the customer.
8. Crane Composites recommends that all material be inspected prior to lamination or use. Reimbursement for non Crane Composites material that is lost, or extra costs incurred due to installation of reject material is not within the Coiled-In-Reject Policy.

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DEFECT COIL MAP

DEFECT NO.	1	2	3	4	5	6	7	8	9	10
FT. FROM CORE										
LGTH OF DEFECT	+	+	+	+	+	+	+	+	+	+
DEFECT CODE										

TOTAL "B" GRADE
 Z

TOTAL FEET	
TOTAL "B" GRADE	
TOTAL "A" GRADE	

DEFECT CODES:
 A - AIR
 B - DIRT
 C - MAT CHUNK
 R - RESIN STARVATION
 S - LONG STRAND
 W - WRINKLE

CUSTOMER		
TYPE	WIDTH	SHIFT
WO#	TICKET#	
DATE / /	COLOR	
INSPECTOR	COIL NO.	

CRANE COMPOSITES, INC.
 8500 C. POST RD.
 JONESBORO, AR 74201

DEFECT COIL MAP INCLUDED WITH EACH COIL

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Crane Composites is the manufacturer of Noble, Filon and a variety of other fiberglass reinforced plastic (frp) composite panels. Crane Composites has over 55 years of experience and is the recognized industry leader in frp applications.

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