

Audit Review and Evaluations OF

JEMISON METALS

**2630 US 15,
Sumter, SC 29154**

Dates of Audit: 9/15 and 10/2/2021

Date of Submittal: 10/18/2021

Auditors: Patrick Macias – Quality Manager-Eastern Division

1.0 Summary

This internal audit review provided an evaluation of Jemison's current level of conformance to the ISO 9001:2015, against the current internal audit schedule. The audit measured how effectively the quality management system is implemented in conformance with the applicable requirements and standards. **Based upon our review, the QMS is effectively implemented.**

Audit Detail/Observations/Findings

7.5 – Documented Information

The following forms and documents were verified during the audit:

SM2-RC-001 Rev0 12/19/19 Receiving Procedure (Quality Intranet-no hard copy present)

SM2-LA-001 Rev 0 12/19/19 Laser Procedure, (Quality Intranet-no hard copy present)

SM2-Fab-001 Rev 0 12/19/19 First Piece Inspection Procedure (Quality Intranet computer-no hardcopy present),

JDM-D-060 Rev 2 9/2/2020 SM2 Press Brake Checklist,

SM2 PB-001 Rev 0 12/19/19 Press Brake Procedure,

JDM 200 Rev 1, 7/21/18 Quality Policy

JDM-F-014 Rev 0, 2/19/21 Laser Production Report

JDM-F-015 Rev 0, 02/19/21 Press Break Production Report

7 Support

Employees appeared competent and well trained. Adequate resources (gauges, safety equipment, operating equipment, and environment) were observed during the audit.

7.2 Competence

Reviewed training documentation:

Current and up to date training matrix

8.2 Requirements for products and services

Blue Bird PO FPL272863-1 due date 11/02/2021 requested on 9/22/2021 order acknowledged by Vickie Fontcuberta 9/22/2021 Sales order SM2-4810-1 entered on 9/23/2021 due 10/29/2021

8.4 Control of externally provided processes, products and services

PO SM2 113-01 for painting and packaging for Eaton part #9550C14H01 and met all requirements for customer part and PO instructions

8.5-Production & Service Provisions

Production:

1st shift

Laser 1: W/O 9786 Trane (S/O 4628-1) Laser documentation reviewed, Part # 436616040120. Jem Print first article completed correctly, doc JDM-F-014 Rev 0 filled in correctly. John Bouyea operator, showed competency on job, located and understood procedure, documentation, and document requirement.

Turret: W/O 9487 Trane (WIP part) Laser Documentation reviewed, Part #W43856609190130 Jem Print first article completed correctly, doc JDM-F-014 Rev 0 filled in correctly. Operator Jackie Miller, showed competency on job, located and understood procedure, documentation, and document requirement.

Brake Press 3 (1st/2nd shift) W/O 9736 Trane (S/O 4644-1) Press Brake Documentation reviewed, Part #436686160110. Jem Print first article completed correctly, doc JDM-F-015 Rev 0 filled in correctly. Operators Travis Harris (1st shift) and Andrew Stewart (2nd Shift), showed competency on job, located and understood procedure, documentation, and documents requirement.

Laser 2: W/O 9688 (1st/2nd shift) Trane (WIP part) Laser Documentation reviewed, Part #W438507080200. Jem Print first article completed correctly, doc JDM-F-014 Rev 0 filled in correctly. Operators Willey Gaymon (1st shift) Corey Prioleau (2nd shift) showed competency on job, located and understood procedure, documentation, and document requirement.

2nd Shift:

Laser 1: W/O 9720 Trane (WIP part) Laser documentation reviewed, Part # W436657500110. Jem Print first article completed correctly, doc JDM-F-014 Rev 0 filled in correctly. William Keith operator, showed competency on job, located and understood procedure, documentation, and document requirement.

Weekend shift:

Brake Press 2 W/O 9645 Trane (S/O 4625-1) Press Brake Documentation reviewed, Part #436664590110. Jem Print first article incomplete, job was started on previous shift and FAI not filled in (Minor #1) (, doc JDM-F-015 Rev 0 filled in correctly. Operators William Keith (trainer) Alfred Carpenter (in training), Jackie Miller (1st shift) showed competency on job, located and understood procedure, and documents requirement. Documentation of FAI inspection missing on Jem Print.

Laser 1: W/O 9932 Trane (WIP part) Laser documentation reviewed, Part # W436617350110B. Jem Print first article completed correctly, doc JDM-F-014 Rev 0 filled in correctly. Rick Vogel operator, showed competency on job, located and understood procedure, documentation, and document requirement.

Shipping:

B/L 2036(S/O 4426, 4689, 4628, 4629) reviewed during shipping. All tags were Matched (scanned). Paperwork was signed and material was loaded on the truck.

PPAP S/O 4849-1 did not show as a PPAP order on shipping board. (OFI)

Preventive Maintenance: Reviewed with Dennis Stewart, Schedule calendar for August reviewed. All schedule maintenance marked as performed. September calendar in progress.

7.1.5 Monitoring and Measuring Resources

The following gauges were verified to be calibrated in compliance with calibration records:

Micrometer:

M4 Calibration date 8/4/2021, due 8/4/2022

Calipers:

C2 Calibration 2/9/2021, due 2/9/2022

C4 Calibration 8/5/2021, due 8/5/2022

Protractor:

P2 Calibration 12/17/2020, due 12/17/2021

8.7 Control of Nonconforming Product

Nonconforming areas were well defined and neat. Traced tags 11730, 11731, (in scrap warehouse, moved from reject 10/1/2021), 11732 (in reject warehouse as of 9/28/2021 on case to devalue)

10.2 Nonconformity and Corrective Action

CA 19039 reviewed, Audited part production and passed 3 times, Jem Print updated for this part. All part spec and Jem print review not completed as of audit date. Jem prints are updated due to need. Case to remain open until all appropriate Jem Prints are updated.

10. Improvement

1. Best project, implementation of Best Operations Module. The initial roll out will improve job time and down time tracking as well as scrap reporting and quality reasons for excess scrap.

2. warehouse camera system installed.

Observations and findings from previous ISO audit

Internal 12/11/2020:

MF-1 Operator did not document first piece inspection-Operator in training repeated this mistake, training operator did not catch the issue. (Minor #1)

MF-2 Press Brake Operator was unable to locate procedure-All operators are able to locate and have acceptable knowledge of procedure.

Registration ISO audit February 2021:

No findings

2.0 Overview

2.1 Personnel Interviewed (Audit evidence found in the Audit Worksheets)

Jackie Miller-Turret Operator Travis Harris-Press Brake Operator Andrew Stewart-Press Brake Operator John Bouyea-Laser Operator William Keith-Laser/press brake Operator	Corey Prioleau-Laser Operator Jeffrey Senn-Shipper Vickie Fontcuberta-Inside Sales Dennis Stewart-Maintenance
--	--

2.2 Audited Requirements

4 Context of the Organization 4.4 Quality Management System and its processes 5 Leadership 5.1 Leadership and commitment 5.1.2 Customer Focus 5.2 Policy 5.6 Management review 6 Planning 7 Support 7.1.1 General 7.2 Competence 7.1.3 Infrastructure 7.1.4 Environment for the operation of processes 7.1.5 Monitoring and measuring resources 7.5 Documented information	8 Operation 8.1 Operational planning and control 8.2 Requirements for products and services 8.3 Design and development of products and services (N/A) 8.4 Control of externally provided processes, products and services 8.5 Production and service provision 8.7 Control of nonconforming outputs 9 Performance evaluation 9.1 Monitoring, measurement, analysis and evaluation 9.1.1 General 9.1.3 Analysis and evaluation 10 Improvement 10.2 Nonconformity and corrective action
--	--

2.3 APPROVAL/SIGN-OFF

Report Prepared by Patrick Macias

Date 10/2/2021

Nonconforming Corrective Action Report (CAR) for Jemison Metals

CAR #	ISO 9001: 2015 Clause / Sub-Clause	Findings/Requirements	Observation	Minor	Major
	8.1	Jem Print First article not filled in.		1	
NA	8.5.2	Instructions to initial back of tag could be documented in procedure.	OFI		
NA	8.2.3.1	PPAP was not visibly a PAPP order on shipping board.	OFI		

Training Status Matrix

<u>Employee</u>									
Andrew Stewart			3						
David Wannamaker	3	3	3	3		1	1		
Eddie Goins	3	1	1	3					
Gregory Bennett			3						
Jackie Miller	2	2	1						
Jeffrey Senn				2	3	3			
John Bouyea	3	1		1					
Rick Vogel	3	1							
Sonny Brown	1	2	1	1					
Tarvis Stewart			3			1			
Travis Harris	2		2						
William Keith	1	1	3						
Willie Gaymon	2		1	1					
Patrick Macias					2	2	3	3	1
Beverly Clem								2	
Hunter Brand		1					3		
Vicki Fontcuberta									3
Dean Burley									3
Bradley Wright	1	1	3	2	2	2	3	2	
<u>Equipment</u>	Fiber Laser Operator	Laser/Punch Operator	Press Brake Operator	Material Handler	Receiving	Shipping	Production Planner	Quality	Inside Sales

1 = In Training

2 = Competent & Fully Trained

3 = Trainer

PURCHASE ORDER

TO:
JEMISON METALS
3800 COLONNADE PARKWAY
BIRMINGHAM, AL 35243
PHONE FAX #

PURCHASE
ORDER NO.
FPL272863



BLUE BIRD BODY COMPANY

All invoices need to be sent to bhag@blue-bird.com

VENDOR CODE: BP0204709 This Purchase Order is subject to the following terms and conditions dated 21 February 2012, Rev 11

DATE	ACCOUNT NO.	PAYMENT TERMS	REQUIRED FOR	DELIVER TO	REQUISITION NO.	REQUISITIONER			
09/22/2021	423510	60 DAYS, 0% 0 DAYS			0				
BILL TO: BLUE BIRD BODY CO P.O. BOX 937 FORT VALLEY GA 31030			SHIP TO: BLUE BIRD SOUTH - BLDG #2 6144 HIGHWAY 341 SOUTH BLDG #2 FORT VALLEY GA 31030			F.O.B. SHIPPING POINT, COLLECT	Please follow Freight Routing Guide		
			TAX INFORMATION: 58-0813156			SPECIAL INSTRUCTIONS:			
ITEM NO.	QUANTITY	UNIT OF MEASURE	BLUE BIRD PART NO.	VENDOR PART NUMBER AND DESCRIPTION		SHIP TO ARRIVE ON	UNIT COST	TOTAL ITEM EXTENDED COST	P R T
1	53	PC	10070570	BLUE BIRD UTILIZES A QUALITY ASSURANCE PROGRAM. SUPPLIER MUST REVIEW AND PROVIDE CURRENT BUY AMERICA AND NAFTA DOCUMENTATION.		11/02/2021	67.3897	3,571.65	
			DRAWING REV. A	PANEL, OSS, 112, 19.75 SKIRT, 20 GA					
2	10	PC	10070648			11/02/2021	31.7147	317.15	
			DRAWING REV. A	PANEL, OSS, 56, REAR, 19.75 SKIRT, LH, 20 GA					
3	10	PC	10070649			11/02/2021	31.7247	317.25	
			DRAWING REV. A	PANEL, OSS, 56, REAR, 19.75 SKIRT, RH, 20 GA					
4	10	PC	10070667			10/19/2021	56.2882	562.88	
			DRAWING REV. A	PANEL, OSS, 91, 19.75 SKIRT, 20 GA					
5	36	PC	10070667			11/02/2021	56.2882	2,026.38	
			DRAWING REV. A	PANEL, OSS, 91, 19.75 SKIRT, 20 GA					
6	16	PC	10070669			11/02/2021	34.4177	550.68	
			DRAWING REV. B	PANEL, OSS, 28, REAR, 19.75 SKIRT, RH, 20 GA					

Page 1 of 2

CERTIFICATE COPY FURNISHED ON REQUEST

MANDATORY REGULATION NOTICE

STATE LAWS AND THE OSHA HAZARD COMMUNICATION STANDARD (29 CFR 1910.1200) REQUIRE MANUFACTURERS, IMPORTERS, AND DISTRIBUTORS. 1) TO SUPPLY A MATERIAL SAFETY DATA SHEET FOR TOXIC SUBSTANCES AT THE TIME OF THE FIRST SHIPMENT OR ANY CHANGES TO PREVIOUS MATERIAL SAFETY DATA SHEETS. 2) TO LABEL CONTAINERS WITH THE PROPER CHEMICAL NAME AND APPROPRIATE HAZARD WARNING FOR THE SUBSTANCE. SHIPPING INSTRUCTIONS: SHIPMENTS RECEIVED IN ADVANCE OF DATE REQUESTED WITHOUT PRIOR AUTHORIZATION ARE SUBJECT TO RETURN. SHOW PURCHASE ORDER NUMBER, RELEASE NUMBER AND BLUE BIRD PART NUMBER ON ALL CORRESPONDENCE. ATTACH COPY OF PACKING SLIP TO WAY BILL - PACKING SLIP MUST SHOW ORDER NUMBER, RELEASE NUMBER AND OUR PART NUMBER. RETURN ACKNOWLEDGMENT - PAYMENT OF INVOICE WILL BE DELAYED UNLESS CURRENT PRICES ARE ACKNOWLEDGED.

If you have questions concerning price, contact
Purchasing Agent:
YALE HOLTON

ISSUED BY:

TODD BRYAN

INTERNET PRINTED VENDOR COPY

PURCHASE ORDER

TO: JEMISON METALS
3800 COLONNADE PARKWAY
BIRMINGHAM, AL 35243
PHONE FAX #

PURCHASE
ORDER NO. **FPL272863**



BLUE BIRD BODY COMPANY

All invoices need to be sent to bhan@blue-bird.com

VENDOR CODE: BP0204709 This Purchase Order is subject to the following terms and conditions dated 21 February 2012, Rev 11

DATE 09/22/2021	ACCOUNT NO. 423510	PAYMENT TERMS 60 DAYS, 0% 0 DAYS	REQUIRED FOR	DELIVER TO	REQUISITION NO. 0	REQUISITIONER
BILL TO: BLUE BIRD BODY CO P.O. BOX 937 FORT VALLEY GA 31030			SHIP TO: BLUE BIRD SOUTH - BLDG #2 6144 HIGHWAY 341 SOUTH BLDG #2 FORT VALLEY GA 31030			
			F.O.B. SHIPPING POINT, COLLECT		Please follow Freight Routing Guide	
			TAX INFORMATION: 58-0813156		SPECIAL INSTRUCTIONS:	

ITEM NO.	QUANTITY	UNIT OF MEASURE	BLUE BIRD PART NO.	VENDOR PART NUMBER AND DESCRIPTION	SHIP TO ARRIVE ON	UNIT COST	TOTAL ITEM EXTENDED COST	P R T

Page 2 of 2

CERTIFICATE COPY FURNISHED ON REQUEST

If you have questions concerning price, contact Purchasing Agent: YALE HOLTON
ISSUED BY: TODD BRYAN

MANDATORY REGULATION NOTICE
STATE LAWS AND THE OSHA HAZARD COMMUNICATION STANDARD (29 CFR 1910.1200) REQUIRE MANUFACTURERS, IMPORTERS, AND DISTRIBUTORS, 1) TO SUPPLY A MATERIAL SAFETY DATA SHEET FOR TOXIC SUBSTANCES AT THE TIME OF THE FIRST SHIPMENT OR ANY CHANGES TO PREVIOUS MATERIAL SAFETY DATA SHEETS, 2) TO LABEL CONTAINERS WITH THE PROPER CHEMICAL NAME AND APPROPRIATE HAZARD WARNING FOR THE SUBSTANCE. SHIPPING INSTRUCTIONS: SHIPMENTS RECEIVED IN ADVANCE OF DATE REQUESTED WITHOUT PRIOR AUTHORIZATION ARE SUBJECT TO RETURN. SHOW PURCHASE ORDER NUMBER, RELEASE NUMBER AND BLUE BIRD PART NUMBER ON ALL CORRESPONDENCE. ATTACH COPY OF PACKING SLIP TO WAY BILL. PACKING SLIP MUST SHOW ORDER NUMBER, RELEASE NUMBER AND OUR PART NUMBER. RETURN ACKNOWLEDGMENT - PAYMENT OF INVOICE WILL BE DELAYED UNLESS CURRENT PRICES ARE ACKNOWLEDGED.

INTERNET PRINTED VENDOR COPY

From: pmaci	At: SMT	Date: 23Sep21	Time: 15:20
To: bwright	At: SM2		

Type N	BLUE BIRD SM2	Order Item	SO No SM2-	4810-	1
Cus Part Specs: [P]	3554-10070570				
Group PGVS	Pre-paint GVS BLUE BIRD BP2Y100B				
Size 20	.0370 Nom X 51.1392" X 112.8223"				
Grade BB2Y	Width 51.1392"	Length 112.8223"	GaN 0.0370		
Order	53 PCS Msr	2123.55 SFT	Wgt	3209 LBS	
Bal	53 PCS Msr	2123.55 SFT	Wgt	3209 LBS	
Sls Cat/Typ PI-1	Chg Qty Typ T				
Ch Description	PWC	Rate	UM Typ	Quantity	Amount
1 MATERIAL		81.2400	EA E	53 PCS	4305.72

1 *** Net Material ***	81.2400	EA	I	53 PCS	4305.72
	Taxes			Total	4,305.72
Sts ENT 09/23/21	Due 10/29/21	Prn Seq		MPO N WKO Y Upd	Usq Y
Ship Brh SM2	Whs FFG	Source PD	Stk/NST S Org	Due Dt 10/29/21	BKO Sts N
End Use					

1-Res 2-Change 3-Rmks 4-Incm 5-Specs 6-Cost 7-Hdr 8-Total 9-Sts

P U R C H A S E O R D E R

No: SM2-113

Bought By:
Jemison-Demsey, LLC
3800 Colonnade Parkway
Suite 250
Birmingham, AL 35243
Tel: 205 986-6600 Fax: 205 986-6601

Mail To:
Jemison-Demsey, LLC
3800 Colonnade Parkway
Suite 250
Birmingham, AL 35243

Vendor: (5462)
ALPHA POWDER COATING
1425 N PIKE EAST
SUMTER, SC 29153

Ship To: (FFG)
Jemison Fab Finished Goods
2630 Highway 15
Sumter SC 29150-9415

=====

Attn	Terms NET 30 DAYS	P/O Number	Cat	Ordered
		SM2-113	OP	14May20

Freight Ship Via FOB
Customer Pick Up MISC FREIGHT

OUTSIDE PROCESSING	P U R C H A S E O R D E R	VENDOR COPY REPRINT
001 A1011 HRP&O SHEET CS TYPE B TEMP PASS		Due 15May20
.1300 Nom X 4.9403" X 78.6707"		LBS
Processing	0 PCS @	2.9400 /EA
PLEASE POWDER COAT OUR INCOMING MATERIAL		
PER EATON GREY		

PICKLE AND OIL PARTS
GAUGE TOLERANCE: .121 MIN .137 MAX
CSB
25 PIECES PER SKID
part# 6550C14H01

PAINT CODE:
PCST70119
PPG ANSI 61 GRAY HAA POLYESTER

\$ 1.89 POWDER COAT COST
\$ 0.55 PACKAGING

\$2.44 TOTAL PER PIECE

***** Inventory Allocations/Instructions *****

Purchase Order Total LBS
0.00

Buyer: SARAH STANFORD
Page: 1 Last

VENDOR-REPRINT

SM2 978

```

Job Type SHR Process PWC SL1
Metric N Cust
Desc P-2 LYNN 4628-1
Due Date 08Sep21 Whs FFG
Setup 00:00 Run 07:15 Prtd By hunterl

```

PROGRAM: TRANE LYNN - 0923
HUNTER

<<< ORDER SPECIFICATIONS >>>

<<< PROCESSING INSTRUCTIONS >>>

<<< MATERIAL TO BE USED >>>

<<< MATERIAL TO BE SHIPPED >>>

<<< JOB RECAP >>>

	PCS	Weight	Scrap	Scrap %	Unactd Scr %
Material Allocated	60	3,066			
Master Returns					
Returns to Stock					
Work in Process					
Material to be Shipped	300	2,670			
Rejects					

08Sep21 13:52

T A G P I C K I N G L I S T

SM2 9786

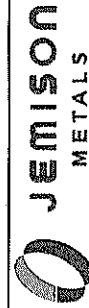
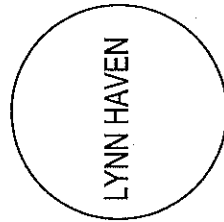
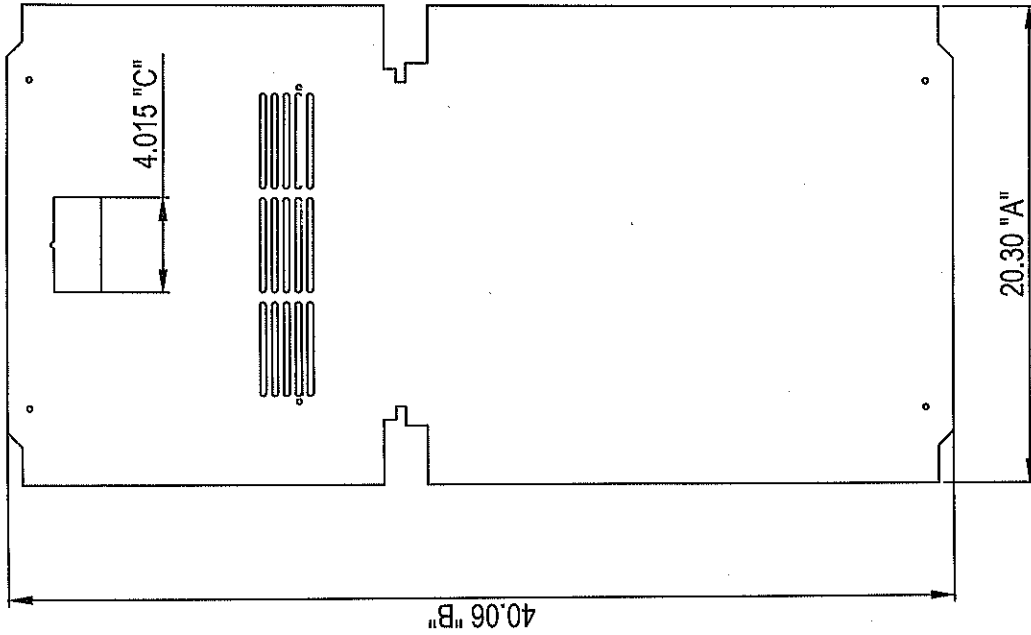
Page: Jemison¹MetalsLast Sumter 2
2630 US Highway 15
Sumter SC 29154

Job Type SHR Process PWC SL1
Metric N Cust
Desc P-2 LYNN 4628-1
Due Date 08Sep21 Whs FFG
Setup 00:00 Run 07:15 Prtd By hunterb

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<PGVS/22/TSG-1>								
23339	FPW	0.0350N	50.0000	106.0000	30	1533	NUB2108752	
23340	FPW	0.0350N	50.0000	106.0000	30	1533	NUB2108752	
Total:					60	3066		

JEMISON REVISION		CUSTOMER REVISION	
REV.	DESCRIPTION	REV.	DESCRIPTION
		H	



CUT/BURNT FIRST ARTICLES		TOLERANCES UNLESS OTHERWISE SPECIFIED	
NOMINAL	TOLERANCE	ACTUAL	LINEAR DECIMAL =
MTL THICKNESS	.0350	.0345	X = +/- .1
TOL "A"	20.30	20.298	XX = +/- .030
TOL "B"	40.06	40.06	XXX = +/- .065
TOL "C"	4.015	4.015	ANGULAR = +/- .2°
		WEIGHT:	
		4.015	

CUSTOMER		INGERSOLL RAND	
TITLE		PANEL MASTER BLANK	
MATERIAL		22GA PGYS TRANE SLATE GRAY	
BY CC	DATE 1/16/20	SHT. 1 of 1	JEMISON REV. 0
PART NO. 438616040120		JEMISON REV. 0	
		JEMISON REV. H	

FABRICATION PRODUCTION REPORT
Laser / Plasma

[illegible]

02Sep21 14:13

J O B W O R K O R D E R

SM2 9688

Jemison Metals - Sumter 2

2630 US Highway 15

Sumter SC 29154

Tel: 803-469-3901 Fax: 803-469-3927

Job Type SHR Process PWC SL2

Metric N Cust

Desc P-2 CLARK 4673-1

Due Date 02Sep21 Whs FPW

Setup 00:00 Run 27:44 Prtd By hunterb

<<< JOB SPECIFICATIONS >>>

Group GVS Grade CB90CD Gauge 0.0960 (0.0960 to 0.0960) ID 0.0000

PROGRAM:TRANE CLARK - 0028

HUNTER

40 X 48 PALLET

<<< ORDER SPECIFICATIONS >>>

W 01 GVS/13/CB90CD/3.8767"X23.02/.0960N

CS-B *90 CT DRY

Part 3488/W438507080200

Ga 0.0960 Wth 3.8767 Lth 23.0232

Ga Rng 0.0920to 0.1000 Pc/Tag 336

WthTol + 0.0300 - 0.0300 Wt/Skd 2500

LthTol + 0.0300 - 0.0300 Ty JD7 Pk

<<< PROCESSING INSTRUCTIONS >>>

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<GVS/13/CB90CD>								
21813	FPW	0.0960N	60.0000	157.5000	9	2309	NUB2109838	F4R7/21
21814	FPW	0.0960N	60.0000	157.5000	7	1796	NUB2109838	F4R7/21
Total:					16	4105		

<<< MATERIAL TO STOCK >>>

Cons Tg

Spc	Prod	Tg	Whs	Ty	Gauge	Width	Length	OD	PCS<Prn>Wt	PCS<Res>Wt
21813										
1	23412		FPW	W	0.0960	3.8767	23.0232		1344	3266

<<< JOB RECAP >>>

	PCS	Weight	Scrap	Scrap %	Unactd	Scr %
Material Allocated	16	4,105				
Master Returns						
Returns to Stock						
Work in Process			1,344		3,266	
Material to be Shipped						
Rejects						
Net Weight to be Produced			1,344		3,266	839 20.44

02Sep21 14:13

T A G P I C K I N G L I S T

SM2 9688

Jemison Metals - Sumter 2
2630 US Highway 15
Sumter SC 29154

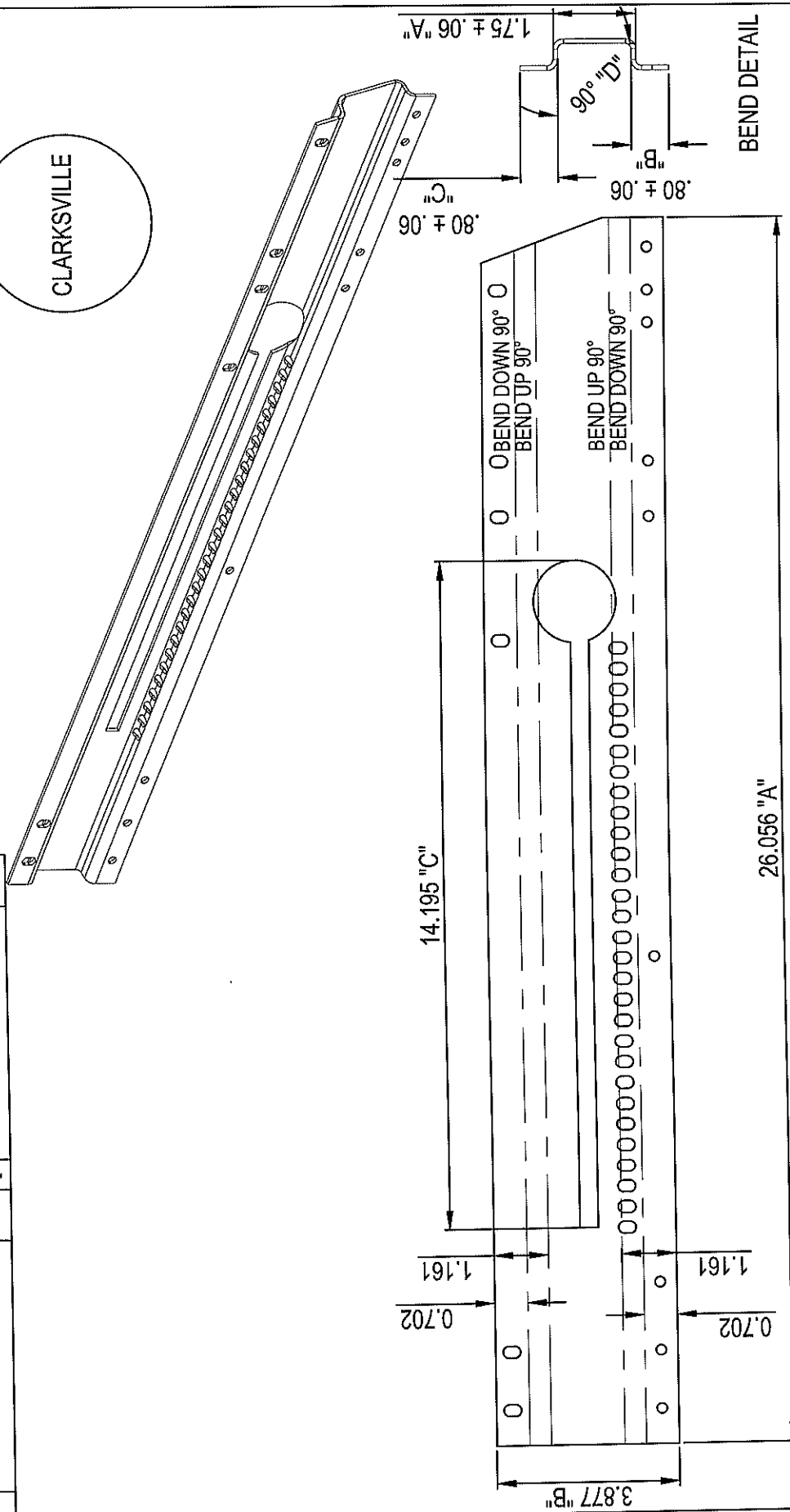
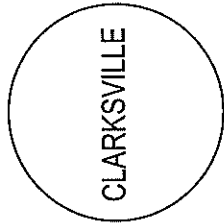
Job Type SHR Process PWC SL2
Metric N Cust
Desc P-2 CLARK 4673-1
Due Date 02Sep21 Whs FPW
Setup 00:00 Run 27:44 Prtd By hunterb

=====

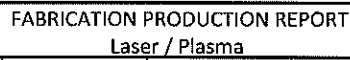
<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<GVS/13/CB90CD>								
21813	FPW	0.0960N	60.0000	157.5000	9	2309	NUB2109838	F4R7/21
21814	FPW	0.0960N	60.0000	157.5000	7	1796	NUB2109838	F4R7/21
Total:					16	4105		

JEMISON REVISION		CUSTOMER REVISION	
REV.	DESCRIPTION	REV.	DESCRIPTION
		F	
			DATE



JEMISON METALS				CUSTOMER			
JEMISON METALS				INGERSOLL RAND			
TOLERANCES UNLESS OTHERWISE SPECIFIED LINEAR DECIMAL = +/- .030 ANGULAR = +/- 3°				MIL SUPPORT IDLER			
MATERIAL 19CA GVS DRY A853				BY CC DATE 1/9/20 SH. 1 OF 1			
PART NO. 438507080200				JEMISON REV. 0			
WEIGHT:				14.16			
BENT/FORMED FIRST ARTICLES		CUT/BURNT FIRST ARTICLES		TOLERANCES UNLESS OTHERWISE SPECIFIED LINEAR DECIMAL = +/- .030 ANGULAR = +/- 3°			
NOMINAL	TOLERANCE	ACTUAL	NOMINAL	TOLERANCE	ACTUAL		
TOL. "A"	1.75	1.69-1.81	.0880	.0820-1.000	9.30		
TOL. "B"	.80	.74-.86	28.056	28.028-28.088	26.150		
TOL. "C"	.80	.74-.86	3.877	3.847-3.907	3.87		
TOL. "D"	90°	87°-93°	14.195	14.185-14.225	14.16		



JDM-F-014 2/19/21 Rev. 0

07Sep21 10:01

J O B W O R K O R D E R

SM2 9736

Jemison Metals - Sumter 2

2530 US Highway 15

Sumter SC 29154

Tel: 803-469-3901 Fax: 803-469-3927

Job Type SHR Process PWC SB1

Metric N Cust

Desc P-2 LYNN 4644-1

Due Date 07Sep21 Whs FFG

Setup 00:00 Run 10:24 Prtd By hunterb

<<< JOB SPECIFICATIONS >>>

Group GVS Grade CB90CD Gauge 0.0355 (0.0355 to 0.0355) ID 0.0000

40 X 48 PALLET

<<< ORDER SPECIFICATIONS >>>

F 01 GVS/22/CB90CD/4.0105"X38.88/.0355N CS-B *90 CT DRY
 Ord SM2 4644- 1 Cust TRANETECH-LYNN Ga 0.0355 Wth 4.0105 Lth 38.8836
 Part 3490/436686160110 Ga 0.0355 Wth 4.0105 Lth 38.8836
 Ga Rng 0.0335to 0.0375 Pc/Tag 208
 WthTol + 0.0300 - 0.0300 Wt/Skd 2500
 LthTol + 0.0300 - 0.0300 Ty JD8 Pk
 PACKAGING INSTRUCTIONS
 1. 40"X48" STANDARD PALLET
 2. SHRINK WRAP PALLET

W 02 GVS/22/CB90CD/4.0105"X38.88/.0355N CS-B *90 CT DRY
 Part 3490/W436686160110 Ga 0.0355 Wth 4.0105 Lth 38.8836
 Ga Rng 0.0335to 0.0375 Pc/Tag 216
 WthTol + 0.0300 - 0.0300 Wt/Skd 2500
 LthTol + 0.0300 - 0.0300 Ty JD7 Pk

<<< PROCESSING INSTRUCTIONS >>>

<<< MATERIAL TO BE USED >>>

Tag No.	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<GV3/22/CB90CD>								
20243	FPW	0.0355N	4.0105	38.8836	1040	1633	NUB1102681	
Total:					1040	1633		

<<< MATERIAL TO BE SHIPPED >>>

Ord	SM2	4644-	1	Cust	TRANETECH-LYNN	Part	436686160110						
A 653 GALVANIZED SHEET CS-B *90 CT DRY													
							Pcs/Tg	208	Bal	416	Pcs		
							DueDt	22Sep21			653	LBS	
BLOCKOFF; AIRFLOW													
Con	Tag	Whs	Tag	No	Whs	T	Gauge	Width	Length	OD	Pcs	Weight	
20243		FPW	11881		FFG	F	0.0355	4.0105	38.8836		208	327	
			11882		FFG	F	0.0355	4.0105	38.8836		208	327	
Total No Tags 2											416	654	

<<< MATERIAL TO STOCK >>>

Cons	Tg	Sp	Prod	Tg	Whs	Ty	Gauge	Width	Length	OD	PCS<Prn>Wt	PCS<Res>Wt
20243												
2		23455			FPW	W	0.0355	4.0105	38.8836		624	979

<<< JOB RECAP >>>

	PCS	Weight	Scrap	Scrap %	Unactd	Scr %
Material Allocated	1,040	1,633				
Master Returns						

07Sep21 10:01

J O B W O R K O R D E R

SM2 9736

Jemison Metals - Sumter 2

```
=====
Material to be Shipped      416      654
Rejects
Net Weight to be Produced  1,040    1,633
```

07Sep21 10:01

T A G P I C K I N G L I S T

SM2 9736

Jemison Metals - Sumter 2
2630 US Highway 15
Sumter SC 29154

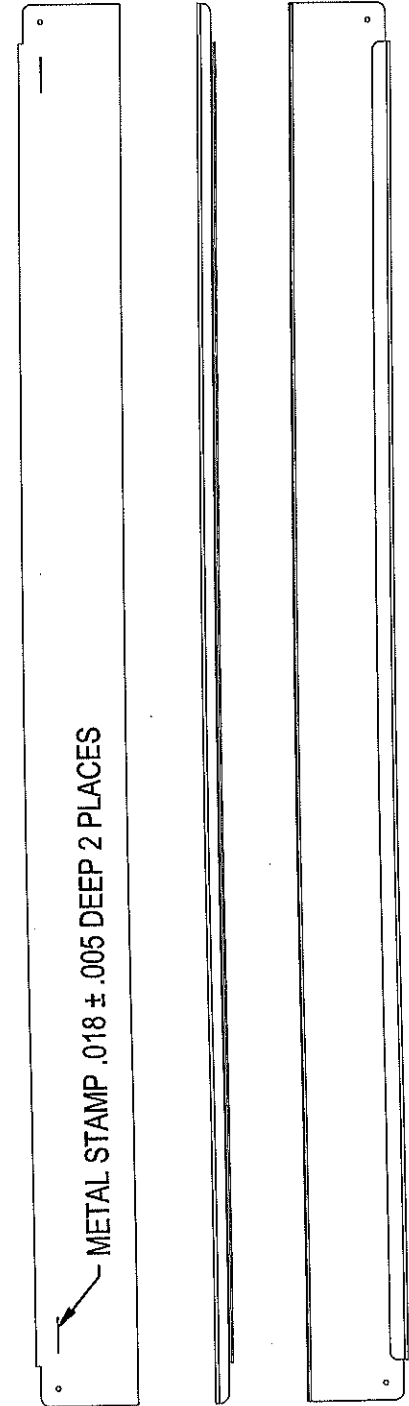
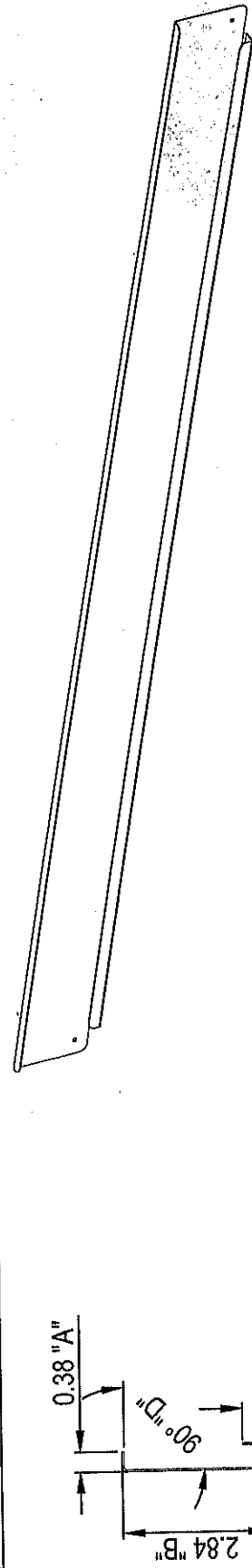
Job Type SHR Process PWC SB1
Metric N Cust
Desc P-2 LYNN 4644-1
Due Date 07Sep21 Whs FFG
Setup 00:00 Run 10:24 Prtd By hunterb

=====

<<< MATERIAL TO BE USED >>>

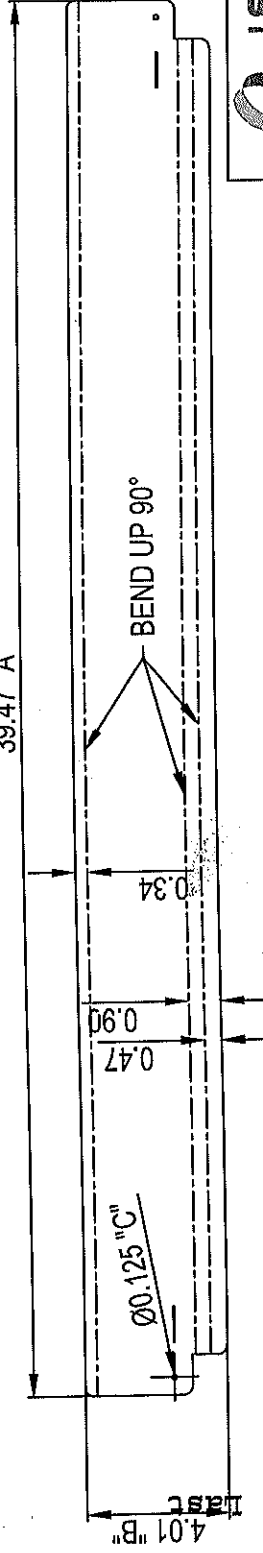
Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<GVS/22/CB90CD>								
20243	FPW	0.0355N	4.0105	38.8836	1040	1633	NUB1102681	
Total:					1040	1633		

JEMISON REVISION		CUSTOMER REVISION	
REV.	DESCRIPTION	REV.	DESCRIPTION
		D	

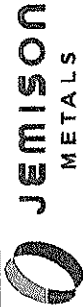


BEND DETAIL

39.47 "A"



FLAT PATTERN

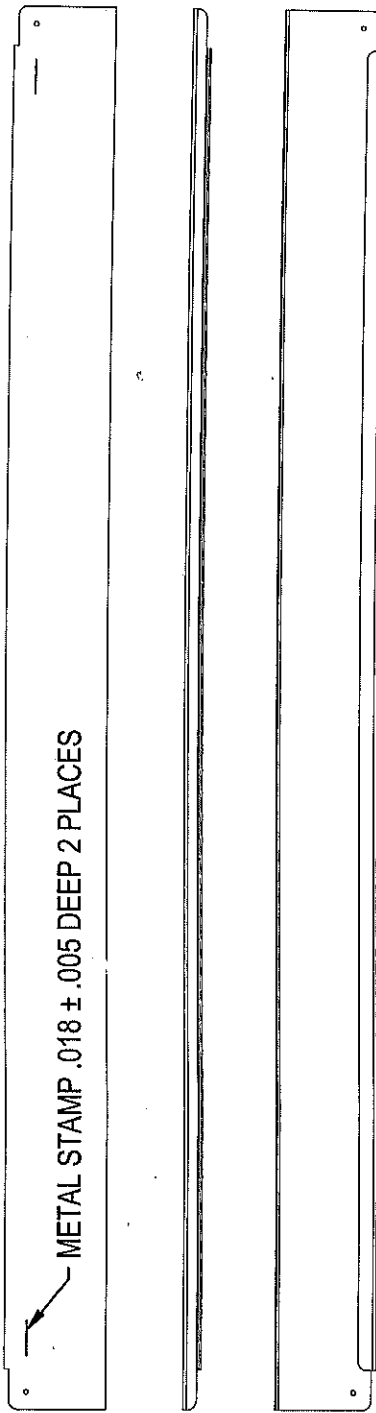
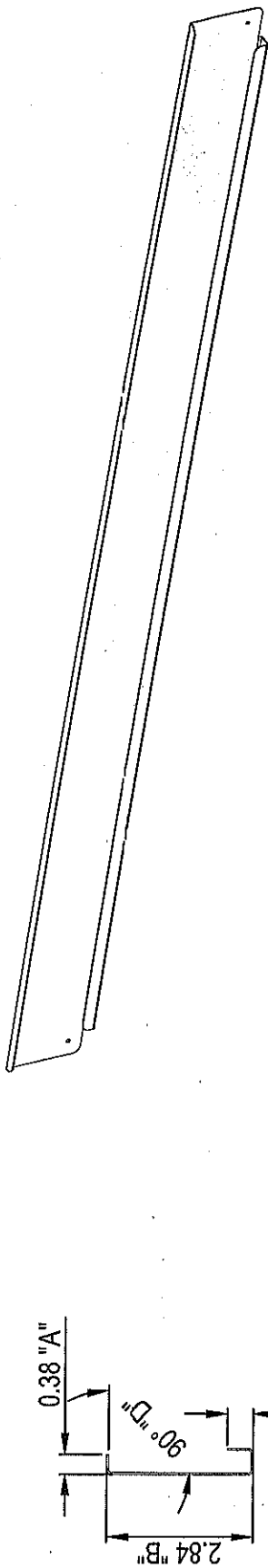


LYNN HAVEN

BENT/FORMED FIRST ARTICLES				CUT/BURNT FIRST ARTICLES				TOLERANCES UNLESS OTHERWISE SPECIFIED			
NOMINAL	TOLERANCE	ACTUAL		NOMINAL	TOLERANCE	ACTUAL		LINEAR DECIMAL =			
TOL "A"	.38	.35-.41		MTL THICKNESS	.0855	.0885-.0875		X = +/-.1			
TOL "B"	2.84	2.81-2.87		TOL "A"	39.47	39.44-39.50		XX = +/-.030			
TOL "C"	.50	.47-.53		TOL "B"	4.01	3.98-4.04		XXX = +/-.005			
TOL "D"	90°	88°-92°		TOL "C"	.125	.120-.130		ANGULAR = +/-.2°			
								WEIGHT:			

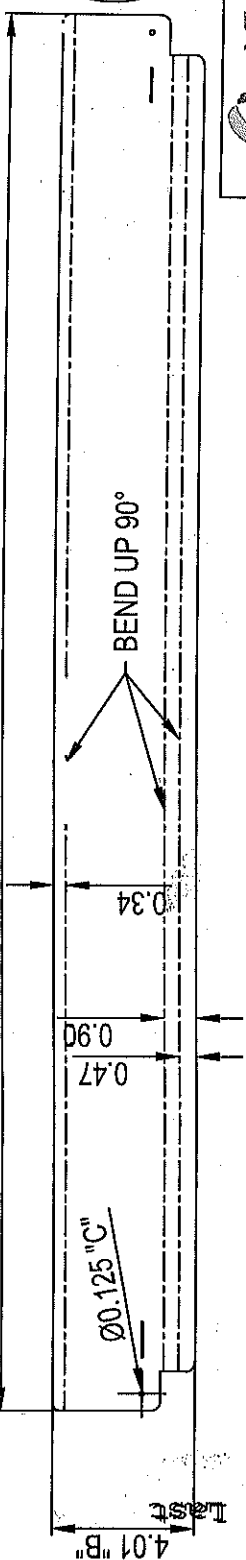
CUSTOMER: INGERSOLL RAND			
TITLE: BLOCKOFF AIRFLOW			
MATERIAL: 22GA GVS A653			
BY CC	DATE 1/20/20	SHT. 1 OF 1	JEMISON REV. 0
PART NO. 436886160110			CUST. REV. D

JEMISON REVISION		CUSTOMER REVISION	
REV.	DESCRIPTION	REV.	DATE
		D	



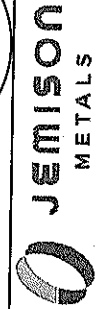
BEND DETAIL

39.47 "A"



BEND UP 90°

FLAT PATTERN



CUSTOMER	INGERSOLL RAND
TITLE	BLACKOFF AIRFLOW
MATERIAL	22GA GYS A653
BY CC	DATE 1/20/20
PART NO. 438886160110	SHT. 1 OF 1
JEMISON REV. 0	CUST. REV. D

BENT/FORMED FIRST ARTICLES				CUT/BURNT FIRST ARTICLES				TOLERANCES UNLESS OTHERWISE SPECIFIED	
A3	NOMINAL	TOLERANCE	ACTUAL	NOMINAL	TOLERANCE	ACTUAL		LINEAR DECIMAL =	
TOL "A"	.38	.35-.41	.364	.0355	.0355-.0375			X = +/-.1	
TOL "B"	2.84	2.81-2.87	2.84	39.47	39.44-39.50			XX = +/-.030	
TOL "C"	.50	.47-.53	.502	4.01	3.98-4.04			XXX = +/-.005	
TOL "D"	90°	88°-92°	90°	.125	.120-.130			ANGULAR = +/-.2°	
								WEIGHT:	

LYNN HAVEN

NOTES:

1. MATERIAL: 0.035/0.0352
MINIMIZED STAINLESS ZINC-COATED
COMMERCIAL STEEL CHEMICALLY TREATED
COATING DESIGNATION G90-U
SEE ENGINEERING SPECIFICATION FOR DETAILS
2. ALL BENDS WITH .060 INSIDE RADIUS
UNLESS OTHERWISE SPECIFIED

UNLESS OTHERWISE SPECIFIED ALL
DIMENSIONS ARE IN INCHES.

FINISH ✓
HOLE DIA = $\frac{1}{16}$
ANGLES = $\pm 2^\circ$
CONFORMS TO ASME Y14.5M-1994.

THIS DRAWING IS PROPRIETARY AND SHALL NOT BE COPIED OR ITS
CONTENT DISCLOSED TO OUTSIDE PARTIES WITHOUT THE WRITTEN
CONSENT OF TRANE

DRAWN BY: C. MENHENNETT © TRANE DATE: 09-10-2013

DO NOT SCALE PRINT

THIRD ANGLE PROJECTION

43668616

BLOCKOFF
AIRFLOW

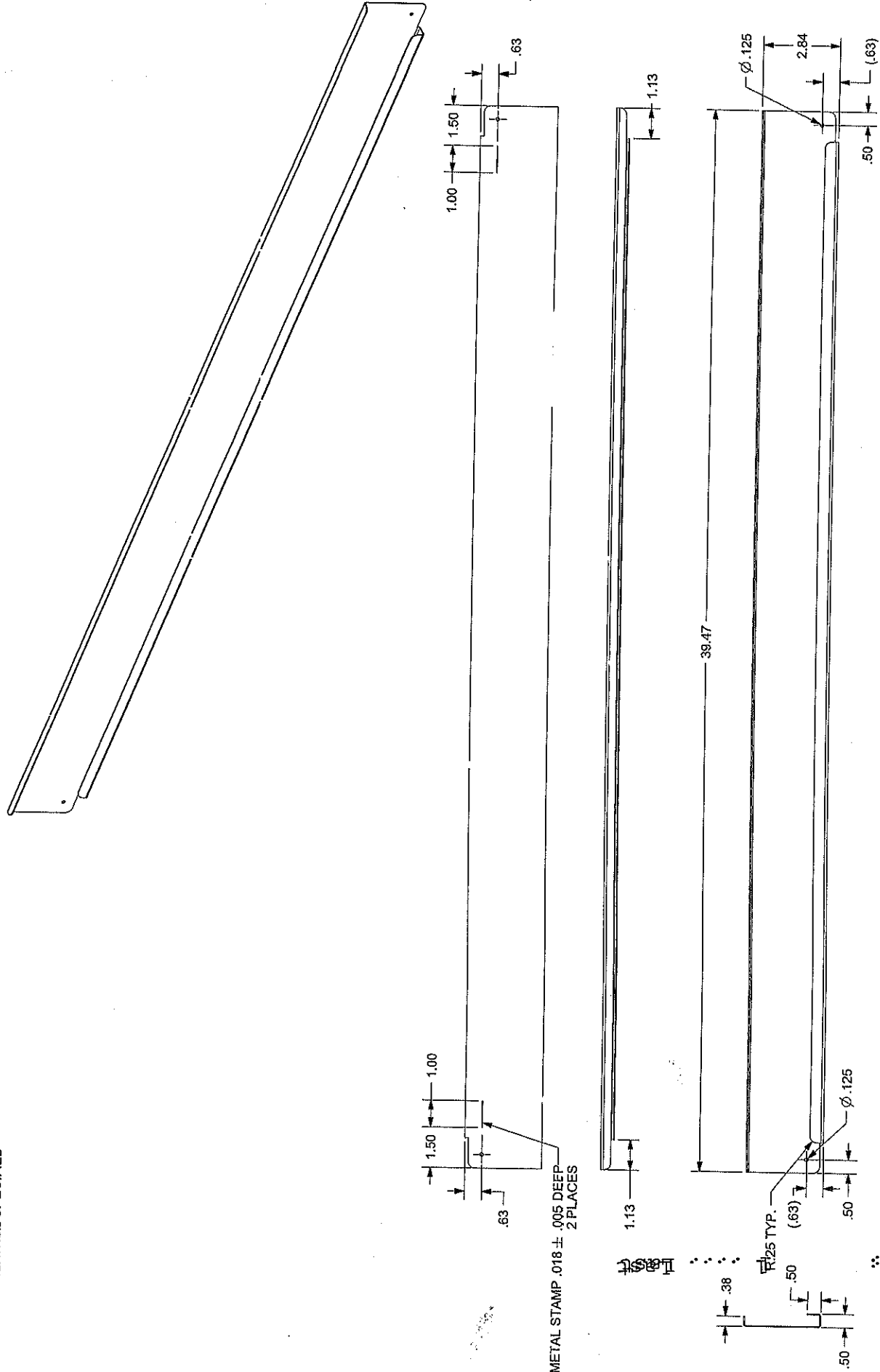
SHEET
1 OF 1

D

C

B

A



1

2

3

4

SM2 Press Brake Checksheet

Job Number: 500 9736 Operator Name: Travis Harris / Andrew
 Part Number: 4311-8011 Date: 9/15/21

Check all Formed Dimensions on Jem print and part orientation based on customer drawing on 1st, 5th, 10th, 20th, ongoing at 20 piece intervals, and last piece of the job. The operator will initial both boxes to indicate pass.

Frequency	Pass/Fail	Orientation	Frequency	Pass/Fail	Orientation	Frequency	Pass/Fail	Orientation
1st Piece	Pass	TH	660			1360		
5th	Pass	TH	680			1380		
10th	Pass	TH	700			1400		
20	Pass	TH	720			1420		
40	Pass	TH	740			1440		
60	Pass	TH	760			1460		
80	Pass	TH	780			1480		
100	Pass	TH	800			1500		
120	Pass	TH	820			1520		
140	Pass	TH	840			1540		
160	Pass	TH	860			1560		
180	Pass	TH	880			1580		
200	Pass	TH	900			1600		
220	Pass	TH	920			1620		
240	Pass	TH	940			1640		
260	Pass	AGS	960			1660		
280	Pass	AGS	980			1680		
300	Pass	AGS	1000			1700		
320	Pass	AGS	1020			1720		
340	Pass	AGS	1040			1740		
360	Pass	AGS	1060			1760		
380	Pass	AGS	1080			1780		
400	Pass	AGS	1100			1800		
420	Pass	AGS	1120			1820		
440	Pass	AGS	1140			1840		
460	Pass	AGS	1160			1860		
480			1180			1880		
500			1200			1900		
520			1220			1920		
540			1240			1940		
560			1260			1960		
580			1280			1980		
600			1300			2000		
620			1320			2020		
640			1340			2040		

24Aug21 07:48

J O B W O R K O R D E R

SM2 9487

Jemison Metals - Sumter 2
 2630 US Highway 15
 Sumter SC 29154
 Tel: 803-469-3901 Fax: 803-469-3927

Job Type SHR Process PWC SP1
 Metric N Cust
 Desc P-2 LYNN 4514-3
 Due Date 24Aug21 Whs FPW
 Setup 00:00 Run 02:52 Prtd By hunterb

<<< JOB SPECIFICATIONS >>>

Group GVS Grade CB90CD Gauge 0.0355 (0.0355 to 0.0355) ID 0.0000

40 X 48 PALLET

<<< ORDER SPECIFICATIONS >>>

W 01 GVS/22/CB90CD/16.5083"X17.68/.0355N CS-B *90 CT DRY
 Part 3490/W436609190130 Ga 0.0355 Wth 16.5083 Lth 17.6893
 Ga Rng 0.0335to 0.0375 Pc/Tag 126
 WthTol + 0.0300 - 0.0300 Wt/Skd 2500
 LthTol + 0.0300 - 0.0300 Ty JD7 Pk

<<< PROCESSING INSTRUCTIONS >>>

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<GVS/22/CB90CD>								
4483	FPW	0.0355N	54.0000	120.0000	14	851	NUB1918497	E5L 7/5
Total:					14	851		

<<< MATERIAL TO STOCK >>>

Cons Tg	Spc	Prod	Tg	Whs	Ty	Gauge	Width	Length	OD	PCS<Prn>Wt	PCS<Res>Wt
4483											
1	23157	FPW	W			0.0355	16.5083	17.6893		252	741

<<< JOB RECAP >>>

	PCS	Weight	Scrap	Scrap %	Unactd	Scr %
Material Allocated	14	851				
Master Returns						
Returns to Stock						
Work in Process	252	741				
Material to be Shipped						
Rejects						
Net Weight to be Produced	252	741			110	12.93

24Aug21 07:48

T A G P I C K I N G L I S T

SM2 9487

Jemison Metals - Sumter 2
2630 US Highway 15
Sumter SC 29154

Job Type SHR Process PWC SP1
Metric N Cust
Desc P-2 LYNN 4514-3
Due Date 24Aug21 Whs FPW
Setup 00:00 Run 02:52 Prtd By hunterb
=====

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<GVS/22/CB90CD>								
4483	FPW	0.0355N	54.0000	120.0000	14	851	NUB1918497	ESL 7/5
Total:					14	851		

Rev. 0

07Sep21 08:50

J O B W O R K O R D E R

SM2 9720

Jemison Metals - Sumter 2
Page:2630 US1Highway

Sumter SC 29154

Tel: 803-469-3901 Fax: 803-469-3927

Job Type SHR Process PWC SL2

Metric N Cust

Desc P-2 LYNN 4632-7,4637-2

Due Date 07Sep21 Whs FPW

Setup 00:00 Run 03:03 Prtd By hunterb

<<< JOB SPECIFICATIONS >>>

Group PGVS Grade TSG-1 Gauge 0.0350 (0.0350 to 0.0350) ID 0.0000

PROGRAM:TRANE LYNN - 0949

HUNTER

40 X 48 PALLET

<<< ORDER SPECIFICATIONS >>>

W 01 PGVS/22/TSG-1/13.1915"X47.19/.0350N

TRANE SLATE GRAY 1SD

Part 3490/W436657500110

Ga 0.0350 Wth 13.1915 Lth 47.1976

Ga Rng 0.0330to 0.0370 Pc/Tag 120

WthTol + 0.0300 - 0.0300 Wt/Skd 2500

LthTol + 0.0300 - 0.0300 Ty JD7 Pk

<<< PROCESSING INSTRUCTIONS >>>

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<PGVS/22/TSG-1>								
21624	FPW	0.0350N	60.0000	98.0000	56	3253	NUB1109652	
22007	FPW	0.0350N	60.0000	98.0000	5	286	NUB1109652	
Total:					61	3539		

<<< MATERIAL TO STOCK >>>

Cons Tg

Spc	Prod	Tg	Whs	Ty	Gauge	Width	Length	OD	PCS<Prn>Wt	PCS<Res>Wt
21624										
1	23446		FPW	W	0.0350	13.1915	47.1976		488	3016

<<< JOB RECAP >>>

	PCS	Weight	Scrap	Scrap %	Unactd	Scr %
Material Allocated	61	3,539				
Master Returns						
Returns to Stock						
Work in Process	488	3,016				
Material to be Shipped						
Rejects						
Net Weight to be Produced	488	3,016			523	14.78

Continued

322 976 52.9955 0.8100 0.0460 FFG F 11838

07Sep21 08:50

T A G P I C K I N G L I S T

SM2 9720

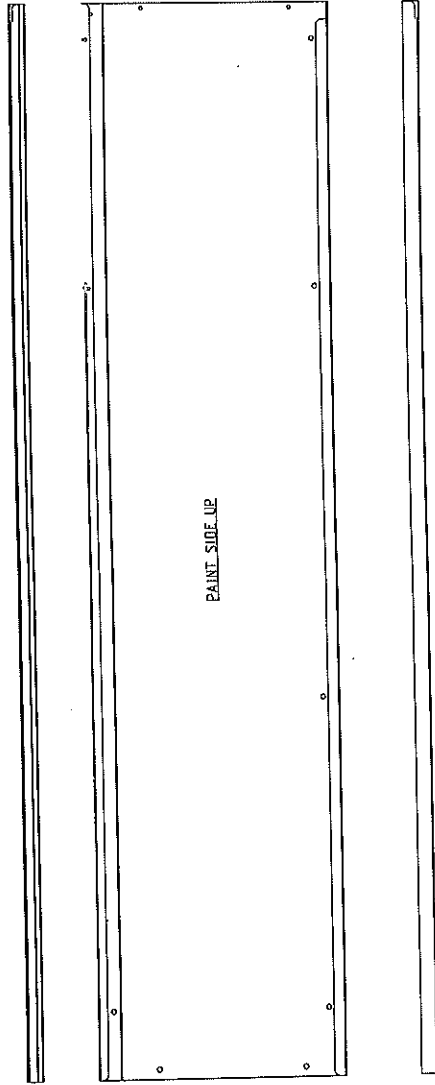
Page: Jemison Metals Co Sumter 2
2530 US Highway 15
Sumter SC 29154

Job Type SHR Process PWC SL2
Metric N Cust
Desc P-2 LYNN 4632-7,4637-2
Due Date 07Sep21 Whs FPW
Setup 00:00 Run 03:03 Prtd By hunterb

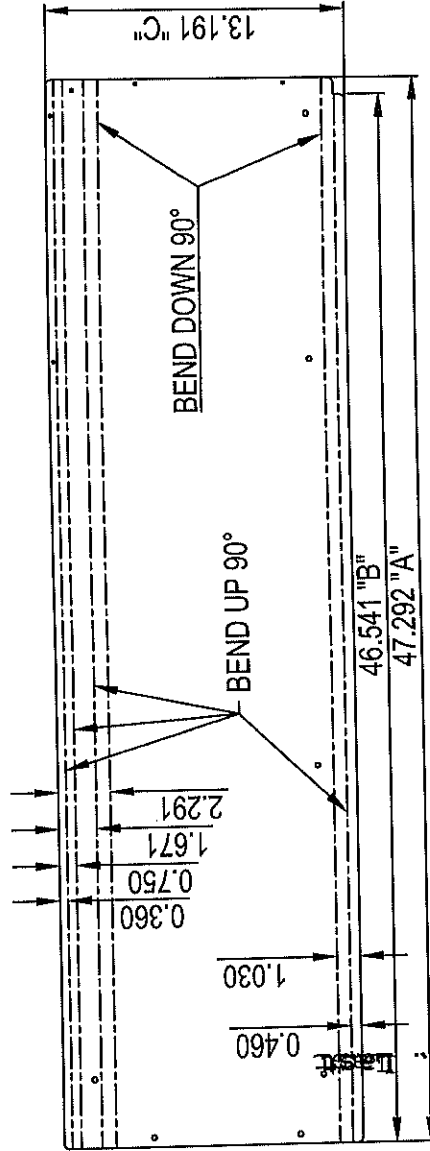
<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<PGVS/22/TSG-1>								
21624	FPW	0.0350N	60.0000	98.0000	56	3253	NUB1109652	
22037	FPW	0.0350N	60.0000	98.0000	5	286	NUB1109652	
Total:					61	3539		

JEMISON REVISION		CUSTOMER REVISION	
REV.	DESCRIPTION	REV.	DESCRIPTION
		E	



BEND DETAIL



FLAT PATTERN

BENT/FORMED FIRST ARTICLES		CUT/BURNT FIRST ARTICLES		TOLERANCES UNLESS OTHERWISE SPECIFIED	
NOMINAL	TOLERANCE	NOMINAL	TOLERANCE	LINEAR DECIMAL =	ANGULAR =
TOL. "A"	9.950	.0355	.0355-.0875	X = +/- .1	ANGULAR = +/- 2°
TOL. "B"	.500	47.292	47.277-47.307	XX = +/- .030	
TOL. "C"	1.000	46.541	46.526-46.556	XXX = +/- .015	
TOL. "D"	90°	13.191	13.176-13.208		
				WEIGHT:	



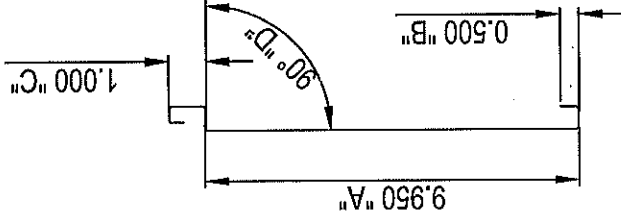
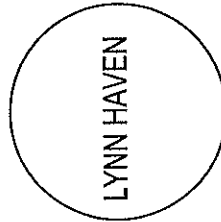
CUSTOMER: INGERSOLL RAND

TITLE: POST ECONOMIZER CONNECTING

MATERIAL: 22GA PGVS PAINTED SLATE GRAY

BY CC DATE 1/20/20 SPT. 1 OF 1

PART NO. 496657500110 JEMISON REV. 0 (CUST. REV. E



B I L L O F L A D I N G

No: SM2 2036

Ship From:
Jemison Metals - Sumter 2
2630 US Highway 15
Sumter SC 29154
Tel: 803-469-3901 Fax: 803-469-3927

Ship Date 15Sep21 at 12:07 From FFG
Probill
Via CP
FOB Shipping Point
Frt Customer Pick U
Route 0- 0 Manifest
Vhcle Trailer
Slp Dean Burley
Sold To: (3490)
Trane Technologies Company LLC
Lynn Haven FL

Ship To: (1)
Trane Technologies-Lynn Haven
7701 Commerce Blvd
Advantage Relocation
Port of Panama City Dist Center
Panama City FL 32404
Tel: Fax:

B I L L O F L A D I N G

1) Our Order SM2- 4426- 1 Your PO # 30154777
Part # 436657790120 Rel #
Pre-paint GVS TRANE SLATE GRAY 1SD
.0350 Nom X 7.4372" X 47.2774"

Heat Number	Tag No	Quantity	PCS	Wt LBS
2107694	10961		84	291
2107694	10962		84	291
2107694	10963		93	322
	Total:		261	904

3) Our Order SM2- 4689- 1 Your PO # 30130544-727
Part # 436665860110 Rel #
A 653 GALVANIZED SHEET CS-B *90 CT DRY
BRACKET; ELECTRIC HEAT SUPPORT

Heat Number	Tag No	Quantity	PCS	Wt LBS
2102810	12076		190	156
2102810	12077		162	133
	Total:		352	289

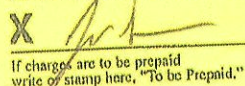
4) Our Order SM2- 4626- 6 Your PO # 30130544-689
Part # 436618180110B Rel #
Pre-paint GVS TRANE SLATE GRAY 1SD
PANEL; REAR FILLER 68IN OD COIL

Heat Number	Tag No	Quantity	PCS	Wt LBS
1102265	11689		288	766
1102265	11690		288	766
1102265	11691		288	766
1102265	11692		209	556
	Total:		1073	2854

ALL LOADS MUST BE TARPED By signing below you acknowledge you have read and understand that this load must be tarped prior to leaving the premises.
The property described above, in apparent good order, except as noted (contents and condition of contents of packages unknown), marked, consigned, and destined as indicated below, which said carrier the worst carrier being understood throughout this contract, is hereby sold, property or any portion of said route to the consignee, and on each party at any time interested in all or any of said property, that every service to be performed hereunder shall be subject to all the terms and conditions of the Uniform Domestic Straight Bill of Lading, and the carrier, Southern Western, and its agents, shall be held harmless in effect on the date hereof if this is a rail or a water shipment, or (2) in the applicable motor carrier classification or tariff if this is a carrier shipment.
Shipper hereby certifies that he is familiar with all terms and conditions of the said bill of lading including those on the back thereof, set forth in the classification of tariff which governs the transportation of this shipment, and the said terms and conditions are hereby agreed to by the shipper and accepted for himself and his assignees.

Subject to Section 7 of conditions of applicable bill of lading, if this shipment is to be delivered to the consignee without recourse on the consignor, the consignor shall sign the following statement:
The carrier shall not make delivery of this shipment without payment of freight and all other lawful charges.

SIGNATURE OF CONSIGNOR

X 

DATE

01/15/21

RECEIVED

\$

To apply in payment of the charges on the property described hereon.

CARRIER

AGENT PER (Driver's Signature)

X

AGENT OR CASHIER

(The signature here acknowledges only the amount prepaid.)

FREIGHT

Prepaid ☐
Collect ☐

DATE

CHARGES ADVANCE

\$

B I L L O F L A D I N G

No: SM2 2036

Ship From:
Jemison Metals - Sumter 2
2630 US Highway 15
Sumter SC 29154
Tel: 803-469-3901 Fax: 803-469-3927

Ship Date 15Sep21 at 12:07 From FFG
Probill
Via CP
FOB Shipping Point
Frt Customer Pick U
Route 0- 0 Manifest
Vhcle Trailer
Slp Dean Burley
Sold To: (3490)
Trane Technologies Company LLC

Ship To: (1)
Trane Technologies-Lynn Haven

B I L L O F L A D I N G

5) Our Order SM2- 4628- 1 Your PO # 30130543-143
Part # 436616040120 Rel #
Pre-paint GVS TRANE SLATE GRAY 1SD
PANEL; MASTER BLANK

Heat Number	Tag No	Quantity	PCS	Wt LBS
2108752	12079		100	390
2108752	12080		100	390
2108752	12081		100	390
Total:			300	2570

6) Our Order SM2- 4629- 7 Your PO # 30130544-690
Part # 436613630110 Rel #
A 653 GALVANIZED SHEET CS-B *90 CT DRY
ANGLE; TOGGLE LOCK

Heat Number	Tag No	Quantity	PCS	Wt LBS
1110430	11777		1072	1715

Tags	PCS	LBS
13	3058	8432

ALL LOADS MUST BE TARPED By signing below you acknowledge you have read and understand that this load must tarped prior to leaving the premises.
The property described above, in apparent good order, except as noted (contents and condition of contents of packages unknown), marked, consigned, and delivered as indicated below, which said carrier (the word carrier being understood throughout this contract meaning any person or corporation in possession under the contract to carry to its usual place of delivery at said destination, if on its route, otherwise to deliver to another carrier on the route to said destination. It is mutually agreed as to each carrier of it) is being carried over or any portion of said route to destination, and as each party at any time interested in all or any of said property, that every service to be performed hereunder shall be subject to all the terms and conditions of the Uniform Domestic Straight Bill of Lading (as published by the National Motor Freight Classification Board) and all applicable motor carrier regulations in effect on the date hereof if this is a rail or a rail-water shipment, or (2) in the applicable motor carrier classification or tariff if this is a carrier shipment. The shipper hereby certifies that he is familiar with all terms and conditions of the said bill of lading including those on the back thereof, set forth in the classification of tariff which governs the transportation of this shipment, and the said terms and conditions are hereby agreed to by the shipper and accepted for himself and his assigns.

Subject to Section 7 of conditions of applicable bill of lading, if this shipment is to be delivered to the consignee without recourse on the consignor, the consignor shall sign the following statement:
The carrier shall not make delivery of this shipment without payment of freight and all other lawful charges.

SIGNATURE OF CONSIGNOR

DATE

9/15/21

If charges are to be prepaid write or stamp here, "To be Prepaid."

RECEIVED
\$

To apply in payment of the charges on the property described hereon.

CARRIER

AGENT PER (Driver's Signature)

AGENT OF CASHIER

(The signature here acknowledges only the amount prepaid.)

FREIGHT

Prepaid ☐
Collect ☐

DATE

CHARGES ADVANCE

\$

Straight bill of lading form Original not Negotiable										
Bill of Lading Number 2IN0272871				Freight Terms COLLECT						
Pickup Stop: 1/1 JEMISON METALS - SUMTER 2630 US-15 SUMTER, SC, 29154			Shipper: Trane Technologies C/O US Bank Dept TRA P.O. Box 3001 Naperville, IL 60566-7001			Planned Ship Date 15-SEP-21				
Delivery Stop Information										
Stop 2		TRANE - CO 7701 B 7701 B COMMERCE BLVD PANAMA CITY, FL, 32404, USA			PCS: 30		WGT: 27000		SCAC Code: SXCR Trailer Number: Seal Code: PRO Number: TRIP Number: 2IN0272871 Tour ID: Tour Sequence#: Oversized Dim: Special Instruction: DIRECT LOAD NO LTL	
Emergency Contact :					Reg.No.					
QTY	TYPE	HM	DESCRIPTION	WEIGHT	NMFC	COD Amount 0 Remit COD to shipper COD Fee paid by consignee PCS: 30 WGT: 27000				
2	PALLET_N O_STACK		AIR CONDITIONING OR HEATING PARTS, SUBASSEMBLIES OR MATERIAL	1800	50					
28	PALLET_N O_STACK		AIR CONDITIONING OR HEATING PARTS, SUBASSEMBLIES OR MATERIAL	25200	50					
						RECEIVED, subject to individually determined rates or contracts that have been agreed upon in writing between the carrier and shipper, if applicable, otherwise to the rates, classifications and rules that have been established by the carrier and are available to the shipper, on request, and to all applicable state and federal regulations.				
SHIPPER CERTIFICATION/DATE I hereby declare that the contents of this consignment are fully and accurately described above by proper shipping name and are classified, packed, marked and labeled, and are in all respects in proper condition for transport by rail, highway, water according to applicable international and national government regulations. (Signature) 9/15/21 (Date)				Trailer Loaded Freight Counted ☐ By Shipper ☐ By Driver ☐ By Shipper ☐ By Driver / Pallets said to contain ☐ By Driver/pieces			CARRIER SIGNATURE/ PICKUP DATE & TIME Carrier acknowledges receipt of packages and required placards. Carrier certifies emergency response information was made available and/or carrier has the DOT emergency response guidebook or equivalent documentation in the vehicle. Property described above is received in good order, except as noted. (Signature) (Date)			

Loading Details:

TRIP Number	Pickup Stop No	Activity	Pieces to Load	Weight of Load	Volume of Load	Loading Length Allowed
IRE/NAM/INB. 2IN0272871	1	P	30	27000 LB	1134.38 CU FT	52.5 FT

01Sep21 12:25

J O B W O R K O R D E R

SM2

Jemison Metals - Sumter 2

2630 US Highway 15

Sumter SC 29154

Tel: 803-469-3901 Fax: 803-469-3927

Job Type SHR Process PWC SB1

Metric N Cust

Desc P-2 LYNN 4625-4

Due Date 01Sep21 Whs FFG

Setup 00:00 Run 08:00 Prtd By hunter

<<< JOB SPECIFICATIONS >>>

Group GVS Grade CB90CD Gauge 0.0355 (0.0355 to 0.0355) ID 0.0000

44.5 X 48 CHEP CONTAINERS

<<< ORDER SPECIFICATIONS >>>

F 01 GVS/22/CB90CD/21.3602"X44.17/.0355N CS-B *90 CT DRY
 Ord SM2 4625- 4 Cust TRANETECH-LYNN Ga 0.0355 Wth 21.3602 Lth 44.175
 Part 3490/436664590110 Ga 0.0355 Wth 21.3602 Lth 44.1757
 Ga Rng 0.0335to 0.0375 Pc/Tag 76
 WthTol + 0.0300 - 0.0300 Wt/Skd 2500
 LthTol + 0.0300 - 0.0300 Ty CHP Pk

PACKAGING INSTRUCTIONS

1. 44.5"X48" CHEP

<<< PROCESSING INSTRUCTIONS >>>

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<GVS/22/CB90CD>								
23363	FPW	0.0355N	21.3602	44.1757	240	2280	NUB1107920	
Total:					240	2280		

<<< MATERIAL TO BE SHIPPED >>>

01 Ord	SM2	4625-	4 Cust	TRANETECH-LYNN	Part	436664590110				
A 653 GALVANIZED SHEET CS-B *90 CT DRY							Pcs/Tg	76	Bal	228 Pcs
PANEL; VESTIBULE							DueDt	15Sep21		2,166 LBS
Con Tag	Whs	Tag No	Whs T	Gauge	Width	Length	OD	Pcs	Weight	
23363	FPW	11638	FFG F	0.0355	21.3602	44.1757		76	722	
		11639	FFG F	0.0355	21.3602	44.1757		76	722	
		11640	FFG F	0.0355	21.3602	44.1757		88	836	
Total No Tags 3								240	2,280	

<<< JOB RECAP >>>

	PCS	Weight	Scrap	Scrap %	Unactd Scr %
Material Allocated	240	2,280			
Master Returns					
Returns to Stock					
Work in Process					
Material to be Shipped	240	2,280			
Rejects					
Net Weight to be Produced	240	2,280			

01Sep21 12:25

T A G P I C K I N G L I S T

SM2 964

Jemison Metals - Sumter 2
2630 US Highway 15
Sumter SC 29154

Job Type SHR Process PWC SB1
Metric N Cust
Desc P-2 LYNN 4625-4
Due Date 01Sep21 Whs FFG
Setup 00:00 Run 08:00 Prtd By hunter

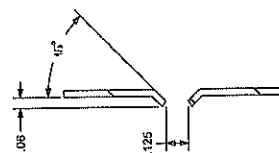
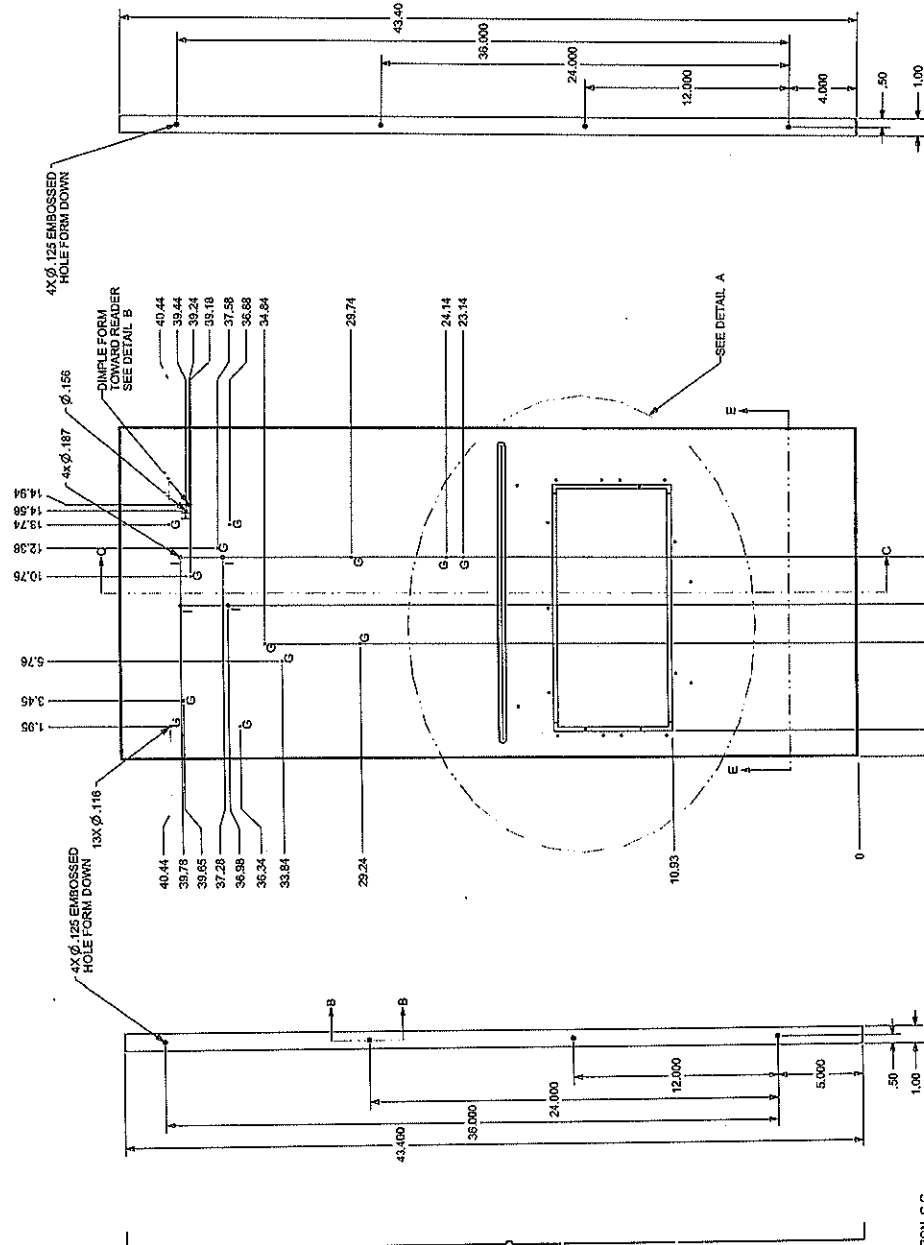
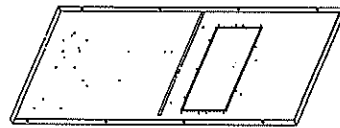
=====

<<< MATERIAL TO BE USED >>>

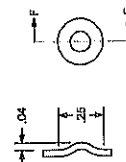
Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<GVS/22/CB90CD>								
23363	FPW	0.0355N	21.3602	44.1757	240	2280	NUB1107920	
Total:					240	2280		

43666459		SHEET 1 OF 2	
PANEL VESTIBULE			
TRANE THESE DRAWINGS ARE PRELIMINARY AND SHALL NOT BE USED FOR CONSTRUCTION WITHOUT THE WRITTEN CONSENT OF TRANE DRAWN BY: LESTER CHECKED BY: [] DATE: 01-04-08 THIS ANGLE PROJECTION DO NOT SCALE PRINT UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES FINISH: [] ANGLE: 45° HOLE DIA: .125 CONFORMS TO ASME Y14.5M-1994			

1. MATERIAL: 0.0355 / 0.0352 MINIMIZED SPANGLER ZINC-COATED COMMERCIAL STEEL CHEMICALLY TREATED TO PREVENT CORROSION. SEE ENGINEERING SPECIFICATION FOR DETAILS.
2. ALL BENDS WITH .050 INSIDE RADIUS UNLESS OTHERWISE SPECIFIED.



SECTION B-B



SECTION F-F

DETAIL B

SECTION C-C

SECTION E-E

SM2 Press Brake Checksheet

Job Number: sm2 9645

Operator Name: JM

Part Number: 4366-6459
Last

Date: 9/24/21

Page

Check all Formed Dimensions on Jem print and part orientation based on customer drawing on 1st, 5th, 10th, 20th, ongoing at 20 piece intervals, and last piece of the job. The operator will initial both boxes to indicate pass.

Frequency	Pass/Fail	Orientation	Frequency	Pass/Fail	Orientation	Frequency	Pass/Fail	Orientation
1st Piece	✓	JM	660			1360		
5th	✓	JM	680			1380		
10th	✓	JM	700			1400		
20	✓	JM	720			1420		
40	✓	WG	740			1440		
60	✓	JM	760			1460		
80	✓	JM	780			1480		
100	Pass	AC	800			1500		
120	Pass	AC	820			1520		
140	Pass	AC	840			1540		
160	Pass	AC	860			1560		
180	Pass	AC	880			1580		
200	Pass	AC	900			1600		
220	Pass	AC	920			1620		
240			940			1640		
260			960			1660		
280			980			1680		
300			1000			1700		
320			1020			1720		
340			1040			1740		
360			1060			1760		
380			1080			1780		
400			1100			1800		
420			1120			1820		
440			1140			1840		
460			1160			1860		
480			1180			1880		
500			1200			1900		
520			1220			1920		
540			1240			1940		
560			1260			1960		
580			1280			1980		
600			1300			2000		
620			1320			2020		
640			1340			2040		

17Sep21 07:56

J O B W O R K O R D E R

SM2 9932

Jemison Metals - Sumter 2

2630 US Highway 15

Sumter SC 29154

Tel: 803-469-3901 Fax: 803-469-3927

Job Type SHR Process PWC SL1

Metric N Cust

Desc P-2 LYNN 4636-6

Due Date 17Sep21 Whs FPW

Setup 00:00 Run 06:36 Prtd By hunterk

<<< JOB SPECIFICATIONS >>>

Group PGVS Grade TSG-1 Gauge 0.0350 (0.0350 to 0.0350) ID 0.0000

PROGRAM:TRANE LYNN - 0107

HUNTER

40 X 48 PALLET

<<< ORDER SPECIFICATIONS >>>

W 01 PGVS/22/TSG-1/21.0120"X21.09/.0350N

TRANE SLATE GRAY 1SD

Part 3490/W436617350110B

Ga 0.0350 Wth 21.0120 Lth 21.0965

Ga Rng 0.0330to 0.0370 Pc/Tag 380

WthTol + 0.0300 - 0.0300 Wt/Skd 2500

LthTol + 0.0300 - 0.0300 Ty JD7 Pk

<<< PROCESSING INSTRUCTIONS >>>

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<PGVS/22/TSG-1>								
23586	FPW	0.0350N	43.0000	117.0000	51	2454	NUB2109208	
23587	FPW	0.0350N	43.0000	117.0000	21	1011	NUB2109208	
Total:					72	3465		

<<< MATERIAL TO STOCK >>>

Cons Tg

Spc	Prod	Tg	Whs	Ty	Gauge	Width	Length	OD	PCS<Prn>Wt	PCS<Res>Wt
23586										
1	23758		FPW	W	0.0350	21.0120	21.0965		720	3168

<<< JOB RECAP >>>

	PCS	Weight	Scrap	Scrap %	Unactd	Scr %
Material Allocated	72	3,465				
Master Returns						
Returns to Stock						
Work in Process	720	3,168				
Material to be Shipped						
Rejects						
Net Weight to be Produced	720	3,168			297	8.57

17Sep21 07:56

T A G P I C K I N G L I S T

SM2 993

Jemison Metals - Sumter 2
2630 US Highway 15
Sumter SC 29154

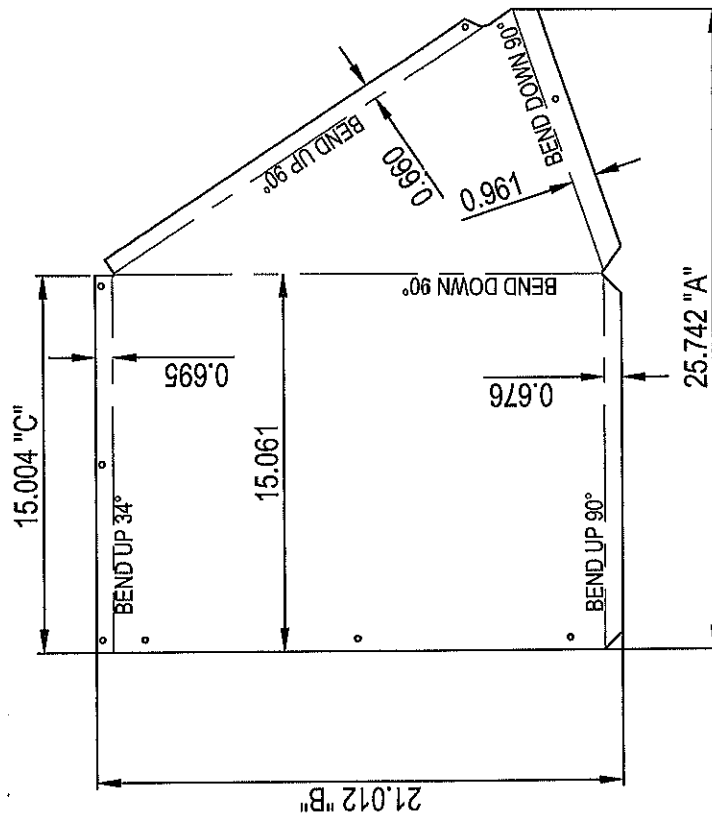
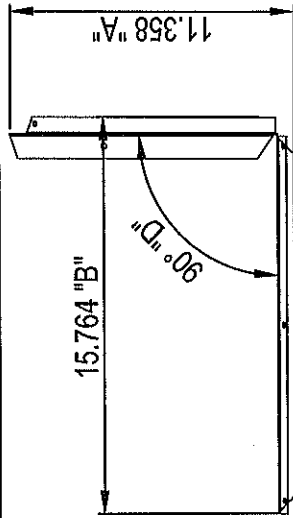
Job Type SHR Process PWC SL1
Metric N Cust
Desc P-2 LYNN 4636-6
Due Date 17Sep21 Whs FPW
Setup 00:00 Run 06:36 Prtd By hunter

=====

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<PGVS/22/TSG-1>								
23586	FPW	0.0350N	43.0000	117.0000	51	2454	NUB2109208	
23587	FPW	0.0350N	43.0000	117.0000	21	1011	NUB2109208	
Total:					72	3465		

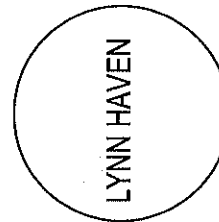
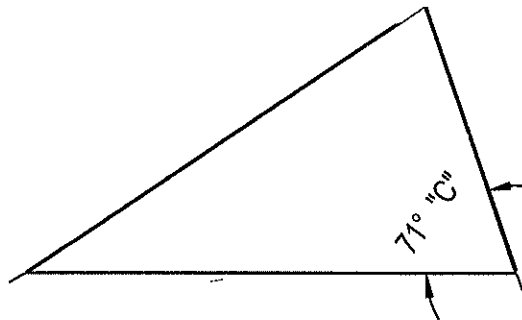
JEMISON REVISION		CUSTOMER REVISION	
REV.	DESCRIPTION	REV.	DESCRIPTION
		C	



FLAT PATTERN

BENT/FORMED FIRST ARTICLES		CUT/BURNT FIRST ARTICLES		TOLERANCES UNLESS OTHERWISE SPECIFIED	
NOMINAL	TOLERANCE	ACTUAL	NOMINAL	TOLERANCE	ACTUAL
TOL "A"	11.358	11.358-11.363	0.060	0.030-0.070	0.0350
TOL "B"	15.764	15.759-15.769	25.742	25.737-25.747	25.742
TOL "C"	71°	68°-73°	21.012	21.007-21.017	21.011
TOL "D"	90°	88°-92°	15.004	14.999-15.009	15.005

BEND DETAIL



CUSTOMER	INGERSOLL RAND
TITLE	SHIELD RAIN RH
MATERIAL	22GA PGVS TRANE SLATE GRAY
BY CC	DATE 1/11/20
PART NO.436817350110	SHT. 1 OF 1
JEMISON REV. 0	CUST. REV. C