

Audit Review and Evaluations OF

JEMISON METALS

1255 North gate Drive, Sumter, SC 29154

Dates of Audit: 9/9/2021
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: SMT –SRB-001 Red Bud Procedure (Quality Intranet Red Bud computer-no hardcopy present) FOP 081 Inspection REV 1, SMT-SL-001 Slitting procedure (Quality Intranet SLITTER computer-no hardcopy present), FOP-015 REV 1, SMT-CTL-001 Cut to length procedure (Quality Intranet cut to length computer-no hardcopy present) JDM200 Quality Policy Rev-1, 8

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 Current up to date training Matrix listing competency status for all employees interviewed

8.2 Requirements for products and services

K&S Tool PO PX21080635 sent on 8/24/2021, due date 9/7/2021 order acknowledged by Sandi Watkins on 9/1/2021 Sales order 170161-1 entered on 9/1/2021 due 9/7/2021
General Metals PO 25691 sent on 9/7/2021 due date 9/13/2021, Order acknowledged by Donnie Redfern on 9/7/2021, Sales order 170259 -1,2,3 entered 9/7/2021, due 9/13/2021

8.4 Control of externally provided processes, products, and services

Mill coil #647273.000 received on PO SMT-27799-001 for BSH Home Appliances on Receiver 62417 Incoming inspection report MF032 rev 7 not used. Information entered directly into computer program.

8.5-Production & Service Provisions

1st shift:

Production: W/O 82816 Doosan (Stock job) was observed in Production on Cut to length. All checks performed per procedural frequency; material met W/O tolerance requirements. Recorded on FOP 081. Operator Terry Wright

Production: W/O 82691 BSH (Stock job) was observed in Production on Red Bud. All checks performed per procedural frequency; material met W/O tolerance requirements. Recorded on FOP 081. Operator Sam Jackson

Production: W/O 83060 Eaton SMT (Stock job) was observed in Production on Slitter. All checks performed per procedure; material met W/O tolerance requirements. Recorded on FOP 015. Operator Farron Mcleod

2nd shift:

Production: W/O 82817 Doosan (Stock job) was observed in Production on Red Bud. All dimensional checks performed per procedural frequency; Shape checks should have been performed more often per "tight tolerance" Inspection Frequency requirements as described in SMT-SRB-001 (Observation #1); material met W/O tolerance requirements. Recorded on FOP 081. Operator Chris Davis

Shipping: Shipped to customer Eaton Corporation on transfer B/L 116159 (T/O 170274-2) met all standards to ship. Tags scanned at shipping per best practice. Shipped on Jemison owned truck.

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 M50 (Last Calibration 1/8/2021, due 1/8/2022) , Step Gauge ST-4 (Last Calibration 6/21/2021, Due 6/21/2022), Measuring table 63924 (Last Calibration 7/8/2020, Due 4/30/2022) Old calibration sticker still attached 7/8/2020-7/8/2021 (Observation #2), Tape 11-03 (Last calibration 10/2/2020, Due 10/2/2021, Dial Indicator S3 (Last calibration 7/30/2021, Due 7/30/2022).

Standards:

Ruler 135 (Last Cal 7/20/2020, Due 7/20/2025)

Gauge Block .100" Z2714 (Last Cal 12/10/2020, Due 12/10/2025)

8.7 Control of Nonconforming Product

Both sheet and coil nonconforming areas were found to be adequate to current needs. Tag 159701 in coil area: GVC 24 x 3.124" belled edge: assigned to case 21659 dispositioned to devalue.

Tag 153882 in sheet area: GNS 18 x 48" x 105" damaged edge: Disposition to move back into Finished Goods warehouse per Quality Manager.

10.2 Nonconformity and Corrective Action

No current open Corrective Actions to review.

Corrective Actions closed since last audit:

20420 Addressed Observation from previous audit. Opened 1/29/2021, closed 4/26/2021

20478 Eaton Fay Gauge issue. Opened 4/1/2021, closed 4/23/2021

20705 BSH late delivery. Opened 4/1/2021, closed 5/17/2021

10. Improvement

1. Flat Bed truck purchased and used for inter-plant (SMT and SM2) and local deliveries and pick ups.

Observations and findings from previous Internal audit

Observation 1-Delay in auditing and closing Corrective Actions. Addressed in CA 20420

2.0 Overview

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

Sam Jackson-Red Bud Operator Chris Maples-Red Bud Helper Ken Scott- Receiver	Hashim S. Patterson-Material Handler Sandi Watkins-Inside sales Lori Seamon-Logistic Coordinator Dennis Stewart-Maintenance
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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
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2.3 APPROVAL/SIGN-OFF

Report Prepared by Patrick Macias

Date 9/14-16/2021

Nonconforming Corrective Action Report (CAR) for Jemison Metals

CAR #	ISO 9001: 2015 Clause / Sub-Clause	Findings/Requirements	Observation	Minor	Major
NA	8.5.1	Operator failed to meet all sampling frequency requirements.	#1		
NA	7.1.5.2	Out of date Calibration sticker on Measuring table (63924). Sticker removed during audit.	#2		

Training Status Matrix

Employee																			
Dyron Alexander									2										
Dakota Geddings				1					2										
Markus McCutheon									2										
Robert Brown					2	2	1		2			2							
Beverly Clem														3					
Chris Davis	2	1	2	2					2			2							
Nathan Jackson									2	1									
Trelvin Grant		2	2	2		2			2										
Alonzo Graves		1	1	2	2		2		2			2							
David Grimsley									2		2	2							
Michael Harvin		1	1						2										
Marc Harton									2	2	2			2					
Samuel Jackson	2	1	2	2					2										
ROLAND Kennedy	2		2						2		1								
David Macias	1		1		3	2	2		2										
Christopher Maple	2		2	2					2										
Jermaine Kind			1	1		2			2										
Gregory Jones	1			1					2										
Farron Mcleod					3	2	2		2										
Tyrone Dennis					1	1			2										
Anthony Newell									2	1	2								
Henry Jennings									2										
Kenneth Scott									2	3	2								
Marion Sims	1		1	1					2										
Dennis Stewart			1	1					1			1	3						
Thomas Witherspoon									3	2									
Terry Wright		2	2	2					2			2							
Lori Seamon									2	2	2						3		
Donnie Redford																		3	
Patrick Macias		2	1	3	1	3	3	3	3	2	2			3		2	1		
Marion Pitts	3	2	2	3	1	2	2	3	2	1	2	2							
Raymond Charles									2										
Timothy Rodgers									2			2							
Armondo Brown									2										
Sandi Watkins																		3	
Equipment																			
Red Bud Multi Blanking Operator																			
Pro Eco cut to length operator																			
RedBud Helper																			
Cut to length helper																			
Slitter Operator																			
Slitter Helper																			
Slitter Setup																			
Shear Operator																			
Material Handler																			
Receiving																			
Shipping																			
Maint. Helper																			
Maint. Technician																			
Inventory Control																			
Production Planner																			
Inside Sales																			

1 = In Training
2 = Competent & Fully Trained
3 = Trainer



Bill To:
PO Box 2037
Jamestown, NC 27282
PHONE: 336/410-7260 FAX: 336/884-5033

17061
PO Number
PX21080635
Order Date:
08/24/2021

Purchase Order

Ordered From:

Jemison-Demsey Metals
P. O. Box 2153
Department 3137
BIRMINGHAM, AL 35287-3137

Ship To:

K & S Tool & Manufacturing Co.
1247 Elon Place
High Point, NC 27263

Contact Info

Tanner Tapp
Ttapp@jemisonmetals.com

Our Account #	Payment Terms	Discount	Ship Via	Incoterm
1230	Net 30 Days		YOUR TRUCK	K&S Receiving Dock

Ln	Item Number and Description	Rev	Required Date	Quantity Ordered	Unit Cost	Ext Cost
1	089748096HRPO 13 Ga x 48 x 96 HRPO, SHEET 120#s, 34 sheets/skid; 1 skids \$97.38 .0897 (.082 Min.) 13Ga 48 x 96 HRPO Certs Req'd A-1011 ** Must be Skidded, FLAT w/in 1/4", and Clean for laser ** parts: 524190845, 524294007, 55A212178P1, 272A5623MTP1, K68G1A-SB		09/07/2021	4,080.00 LB	\$0.9738	\$3,973.10

PURCHASE ORDER TOTAL

\$3,973.10

Ordered by: David Turner

david.turner@ks-tool.com

(P) (336) 410-7279

(F) (336) 454-1046

PLEASE ACKNOWLEDGE PURCHASE ORDER WITH CONFIRMING PRICE AND DELIVERY.
K & S Tool & Manufacturing Company and its customers reserve the right to verify purchased
product at all vendors' premises.

Sandi Watkins

From: Sandi Watkins
Sent: Wednesday, September 1, 2021 3:53 PM
To: David Turner
Subject: P.O. #PX21080635 CONFIRMATION
Attachments: Xerox Scan_09012021153208.pdf

-----Original Message-----

From: SMTScanner@jemisonmetals.com <SMTScanner@jemisonmetals.com>
Sent: Wednesday, September 1, 2021 3:32 PM
To: Sandi Watkins <SWatkins@JemisonMetals.com>
Subject: Xerox Scan

Please open the scanned attachment

Number of Images: 1
Attachment File Type: PDF

Device Name: VersaLink C405
Device Location:

08Sep21 14:23

S A L E S O R D E R

No: SMT PI-170161

Sold By:

Jemison Metals - Sumter

1255 North Gate Drive

Sumter, SC 29154

Tel: 803-481-0707 Fax: 803-481-0713

Ship From:

Jemison Metals - Sumter

1255 North Gate Drive

Sumter, SC 29154

Sold To: (1230)

K & S Tool & Mfg Co

P O Box 2037

Jamestown, N C 27282

Ship To: (1)

K & S Tool & Mfg Co

1247 Elon Place

High Point, N C 27260

Trm NET 30 DAYS

Frt Included in Price

Slp Sandi Watkins

Con Cham Tally JOE HUGHES

Ord 01Sep21 Due 07Sep21 09/07/21

Via ALL METALS TRAN

FOB DESTINATION

PO/Rel PX21080635

Tel 336-410-7260

Fax 336-884-5033

S A L E S O R D E R - REPRINT

SO No

SMT PI-170161

Test Certs: Chem Y Phys Y 1 Separate copies with shipment, 1 with Invoice

MILL CERTS TO BE SENT WITH ANY CAT MATERIAL THAT

IS SHIPPED TO K&S. ANY PART NUMBERS THAT END IN

1E0166, 1E0357, 1E0170, SHOULD HAVE THE A COPY OF

THE ACTUAL MILL CERT E-MAILED TO K&S.

FAX TO LINDA 336-884-5033

1 A1011 HRP&O SHEET CS-TYPE B

34 PCS

4082 LBS

13GA X 48.0000" X 96.0000"

Part No 089748096HRPO

RESIDUAL STRESS TEST MUST BE DONE! QUALITY OR SUPE

RVISOR MUST SIGN OFF ON THE FIRST 10 PCS.

<<<----- SPECIFICATIONS ----->>>

Ga Tol + 0.0063 - 0.0070 Pc/Tag 34

WthTol + 0.9990 - 0.0000 Wt/Skd

LthTol + 0.1250 - 0.0000 Ty JD4 Pk EDG

WAVE:0.00-.25 BOW:0.00-.25

FLATN:0.00-.25

WIDTH BANDS TO BE OVER SKID AND STEEL, LENGTH

BANDS ONLY TO BE ON STEEL PER CUSTOMER.

SKID SIZE MUST BE 1" LESS THAN SHEET SIZE ON DUAL

DIRECTION SKIDS-MUSTBE ACCESSIBLE BY A FORKLIFT ON

ALL SKIDS AND NO HIGHER THAN 14"

ALL SHEET MUST BE FLAT WITHIN A 1/4" OFF A FLAT

SURFACE CLEAN FOR LASER USE

BOTTOM RUNNER SHOULD BE PARALLEL TO 48" LENGTH

SHEETS MUST BE SAME SIZE AND EVEN ON SKID

MUST BE FREE OF WAVES

GENERAL



METALS, INC.

Precision Metal Fabrication

GENERAL METALS, INC.
P.O. BOX 99
328 EAST MAIN STREET
PINE LEVEL, NC 27568
United States of America
Ph: (919)202-0100

Fax: (919)202-0212

Purchase Order

Number: 25690

Date: 07-Sep-21

To

JEMISON DEMSEY
1255 NORTH GATE DRIVE
SUMTER, SC 29154

Ship To

GENERAL METALS, INC.
P.O. BOX 99
328 EAST MAIN STREET
PINE LEVEL, NC 27568
United States of America

Ph: 803-481-0707

Fax: 803-481-0713

Ph: (919)202-0100

Fax: (919)202-0212

Terms		Ship Via	FOB	Issued By
		VENDOR		JORDAN
Quantity	Description		Unit Price	Amount
60 ea	GZS06048096-ROHS 16 GA GALV 48 X 96 - ROHS Due: 13-Sep-21	GL AC: 410	\$83.03 ea	\$4,151.50
Line: 001	MUST BE ROHS COMPLIANT TRI-V CHEM TREAT - PLEASE PROVIDE ROHS CERT WITH SHIPMENT			
30 ea	GZS060600106 16GA GZS 60 X 106 RoHS Due: 13-Sep-21	GL AC: 410	\$113.48 ea	\$3,404.40
Line: 002	MUST BE ROHS COMPLIANT TRI-V CHEM TREAT - PLEASE PROVIDE ROHS CERT WITH SHIPMENT			
65 ea	HRS12048120 HR STL P&O 11GAX 48 X 120 Due: 13-Sep-21	GL AC: 410	\$171.57 ea	\$11,152.05
Line: 003				
	<p>PURCHASE ORDER NUMBER MUST APPEAR ON ALL INVOICES, PACKING SLIPS, ETC. PLEASE NOTIFY US IMMEDIATELY IF YOU ARE UNABLE TO COMPLETE ORDER BY DATE SPECIFIED.</p> <p>Notice: All rejected materials will be moved to a non-conforming area. The supplier will be contacted and has 30 days to decide disposition. Material and labor cost associated with non-conformance will be passed along to the supplier. If credit or payment method has not been decided within 30 days, GMI will debit the suppliers account or invoice the supplier.</p> <p>ORDERED BY: _____</p> <p>APPROVED BY: _____</p>		Total:	\$18,707.95
<p>CONFIRMED ORDER BY: <i>Dennison</i></p> <p>DATE: 9-7-21</p> <p>THANK YOU</p>				

Electronic Rev 1

08Sep21 13:11

S A L E S O R D E R

No: SMT PI-170275

Sold By:

Ship From:

Jemison Metals - Sumter

Jemison Metals - Sumter

1255 North Gate Drive

1255 North Gate Drive

Sumter, SC 29154

Sumter, SC 29154

Tel: 803-481-0707 Fax: 803-481-0713

Sold To: (2443)

Ship To: (1)

General Metals Inc

General Metals Inc

P O Box 99

328 E Main Street

Pine Level N C 27568

Pine Level N C 27568

Trm NET 90 DAYS

Ord 07Sep21 Due 13Sep21 9-13

Frt Included in Price

Via ALL METALS TRAN

FOB DESTINATION

Slp Donnie Redfern

PO/Rel 25690

Con Chad Carter

Tel 919-202-0100

Fax 919-202-0212

S A L E S O R D E R - REPRINT

SO No

SMT PI-170275

Test Certs: Chem Y Phys N 1 Compliance copies with shipment, 0 with Invoice

1 A 653 GALVANIZED SHEET CS-B *90 CT DRY ROHS 60 PCS 5098 LBS

.0635 Nom X 48.0000" X 96.0000"

Part No GVS 16GA 48X96

<<<----- SPECIFICATIONS ----->>>

Ga Tol + 0.0060 - 0.0060 Pc/Tag

WthTol + 0.1875 - 0.0000 Wt/Skd 5000

LthTol + 0.2500 - 0.0000 Ty JD4 Pk

WAVE:0.00-.12

BOW:0.00-.12

FLATN:0.00-.12

SQUA:0.00-.18

MATERIAL

5,098 LBS @

83.0300 CWT E

4,232.87

Sales Amt

4,232.87 Profit Amt

192.75-G.P%

4.70 N.P%

4.55-

<<<----- INVENTORY RESERVATIONS ----->>>

GVS/16/CB90CD/48.0000"X96.0000"

156773

SFG L5 9/7

60 PCS

4530 LBS

2 A 653 GALVANIZED SHEET CS-B *90 CT DRY ROHS 43 PCS 5043 LBS

.0635 Nom X 60.0000" X 106.0000"

Part No GVS 16GA 60X106

<<<----- SPECIFICATIONS ----->>>

Ga Tol + 0.0060 - 0.0060 Pc/Tag

WthTol + 0.2500 - 0.0000 Wt/Skd 5000

LthTol + 0.2500 - 0.0000 Ty JD4 Pk

WAVE:0.00-.12

BOW:0.00-.12

FLATN:0.00-.12

SQUA:0.00-.25

MATERIAL

43 PCS @

113.4800 PCS E

4,879.64

Sales Amt

4,879.64 Profit Amt

835.69 G.P%

22.13 N.P%

17.13

<<<----- INVENTORY RESERVATIONS ----->>>

GVS/16/CB90CD/60.0000"X106.0000"

157508

SFG

43 PCS

4925 LBS

3 A1011 HRP&O SHEET CS-TYPE B 65 PCS 12862 LBS

.1183 Nom X 48.0000" X 120.0000"

Part No HRS125048120

<<<----- SPECIFICATIONS ----->>>

Ga Tol + 0.0132 - 0.0027 Pc/Tag

WthTol + 0.1875 - 0.0000 Wt/Skd 4000

LthTol + 0.1250 - 0.1250 Ty JD3 Pk

WAVE:0.00-.12

FLATN:0.00-.12

MATERIAL

65 PCS @

171.5700 PCS E

11,152.05

Sales Amt

11,152.05 Profit Amt

392.28 G.P%

9.90 N.P%

3.52

<<<----- INVENTORY RESERVATIONS ----->>>

16Aug21 13:27

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

SMT 82816

Jemison Metals - Sumter
1255 North Gate Drive
Sumter, SC 29154

Tel: 803-481-0707 Fax: 803-481-0713

Job Type LEV Process PWC SCT
Metric N Cust
Desc P-1 970466048 DOOSAN
Due Date 16Aug21 Whs SFG
Setup 00:00 Run 03:00 Prtd By rclar

7:49-11:17

11:22-

Bom's Brk / Bom's Downtime

Group GNS Grade CB40NO Gauge 0.0785 (0.0710 to 0.0870) ID 0.0000

<<< ORDER SPECIFICATIONS >>>

F 01 GNS/14/CB40NO/48.0000"X85.00/.0785N CS-B *40 NCT LT OIL
Part 3410/46693343 Ga 0.0785 Wth 48.0000 Lth 85.0000
Ga Rng 0.0710to 0.0870 Pc/Tag 35
WthTol + 0.1875 - 0.0000 Wt/Skd 3255
LthTol + 0.5000 - 0.0000 Ty JD6 Pk EDG
WAVE:0.00-.12 BOW:0.00-.12 FLATN:0.00-.12
SQUA:0.00-.25
EDG Edge Protectors

"PERFORM RESIDUAL STRESS TEST"

F 02 GNS/14/CB40NO/48.0000"X75.00/.0785N CS-B *40 NCT LT OIL
Part 3410/46694088 Ga 0.0785 Wth 48.0000 Lth 75.0000
Ga Rng 0.0710to 0.0870 Pc/Tag 40
WthTol + 0.1875 - 0.0000 Wt/Skd 3283
LthTol + 0.5000 - 0.0000 Ty JD6 Pk EDG
WAVE:0.00-.12 BOW:0.00-.12 FLATN:0.00-.12
SQUA:0.00-.25
EDG Edge Protectors

"PERFORM RESIDUAL STRESS TEST"

<<< PROCESSING INSTRUCTIONS >>>

<Step 1>
Level To: 48.0000 X 85.0000 506 Pcs 46000 LBS 9999 Pcs/Tag
<Step 2>
Level To: 48.0000 X 75.0000 574 Pcs 46000 LBS 9999 Pcs/Tag

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<GNC/14L/CB40NO>								
NB69251	SPW	0.0700M	48.0000		1	46420	NUB1111763	6-D
Rmks: DOOSAN								
NB69244	SPW	0.0700M	48.0000		1	44980	NUB1111769	6-D
Rmks: DOOSAN								

Total: 2 91400

<<< MATERIAL TO STOCK >>>

Cons	Tg	Spc	Prod	Tg	Whs	Ty	Gauge	Width	Length	OD	PCS<Prn>Wt	PCS<Res>Wt
NB69251												
1			157405	SFG	F		0.0785	48.0000	85.0000		35	3179
1			157406	SFG	F		0.0785	48.0000	85.0000		35	3179
1			157407	SFG	F		0.0785	48.0000	85.0000		35	3179
1			157408	SFG	F		0.0785	48.0000	85.0000		35	3179
1			157409	SFG	F		0.0785	48.0000	85.0000		35	3179

16Aug21 13:27

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

SMT 82816

Jemison Metals - Sumter

NB69251

1	157410	SFG F	0.0785	48.0000	85.0000	35	3179
1	157411	SFG F	0.0785	48.0000	85.0000	35	3179
1	157412	SFG F	0.0785	48.0000	85.0000	35	3179
1	157413	SFG F	0.0785	48.0000	85.0000	35	3179
1	157414	SFG F	0.0785	48.0000	85.0000	35	3179
1	157415	SFG F	0.0785	48.0000	85.0000	35	3179
1	157416	SFG F	0.0785	48.0000	85.0000	35	3179
1	157417	SFG F	0.0785	48.0000	85.0000	35	3179
1	157418	SFG F	0.0785	48.0000	85.0000	35	3179
1	157419	SFG F	0.0785	48.0000	85.0000	16	1453

NB69244

2	157420	SFG F	0.0785	48.0000	75.0000	40	3206
2	157421	SFG F	0.0785	48.0000	75.0000	40	3206
2	157422	SFG F	0.0785	48.0000	75.0000	40	3206
2	157423	SFG F	0.0785	48.0000	75.0000	40	3206
2	157424	SFG F	0.0785	48.0000	75.0000	40	3206
2	157425	SFG F	0.0785	48.0000	75.0000	40	3206
2	157426	SFG F	0.0785	48.0000	75.0000	40	3206
2	157427	SFG F	0.0785	48.0000	75.0000	40	3206
2	157428	SFG F	0.0785	48.0000	75.0000	40	3206
2	157429	SFG F	0.0785	48.0000	75.0000	40	3206
2	157430	SFG F	0.0785	48.0000	75.0000	40	3206
2	157431	SFG F	0.0785	48.0000	75.0000	40	3206
2	157432	SFG F	0.0785	48.0000	75.0000	40	3206
2	157433	SFG F	0.0785	48.0000	75.0000	40	3206

Total: 1066 90,843

<<< JOB RECAP >>>

	PCS	Weight	Scrap	Scrap %	Unactd	Scr %
Material Allocated	2	91,400				
Master Returns						
Returns to Stock						
Work in Process						
Material to be Shipped	1,066	90,843				
Rejects						
Net Weight to be Produced	1,066	90,843			557	0.61



Material Inspection Report

LOCATION

Sumter

DATE

9/10/2021

CUSTOMER

DOOSAN

JOB # SMT

82816

Page 1

	Order Dim	Tolerances	Tolerances	Low Limit	High Limit
Gauge	0.078	- 0.007	+ 0.009	0.071	0.087
Width	48.000	- 0.000	+ 0.187	48.000	48.187
Length	85.000	- 0.000	+ 0.500	85.000	85.500

	Set up Target	Side Type	Skid Type Error	Skid Code
Gauge	0.079			0: 2: 3
Width	48.094			
Length	85.250			
		JDOP018	JDOP016	JDOP046
		JDOP014	JDOP034	JDOP032

Finished Goods Tag	157405	409	413	417	557933
Master Coil Number	NB69251	NB69251	NB69251	NB69251	NB69251
Heat					
Enhanced Weight					
Gross Weight	3050	3050	3050	3050	3050
Tare	145	145	145	145	145
Net Weight	2905	2905	2905	2905	2905
Bundle Status					
Good Pcs.	35	35	35	35	35
Scraped Pcs.					
Rockwell					
Gauge Head	E 0.072	0.072	0.072	0.072	0.072
	C 0.072	0.072	0.072	0.072	0.072
	E 0.072	0.072	0.072	0.072	0.072
Body	E				
	C				
	E				
Tail	E				
	C				
	E				
Surface	OK	OK	OK	OK	OK
Width Head	48.043	48.043	48.043	48.043	48.043
Body	48.043	48.043	48.043	48.043	48.043
Tail	48.043	48.043	48.043	48.043	48.043
Shape	LESS.12	LESS.12	LESS.12	LESS.12	LESS.12
Residual Check	LESS.12	LESS.12	LESS.12	LESS.12	LESS.12
Length Head	85.250	85.250	85.250	85.250	85.250
Body	85.250	85.250	85.250	85.250	85.250
Tail	85.250	85.250	85.250	85.250	85.250
Squareness	LESS.12	LESS.12	LESS.12	LESS.12	LESS.12
Camber					
Operator					
Setup Approval					
Run Time	S	F	Down Time	S	F
Total Run Time	0:00	Cost	\$0.00	Cst/Hour	\$400.00
Comments					



Material Inspection Report

LOCATION

Sumter

DATE

9/10/2021

CUSTOMER

0

JOB # SMT

82816

Page 2

	Order Dim		Tolerances		Tolerances		Low Limit		High Limit
Gauge	0.078	-	0.007	+	0.009		0.071		0.087
Width	48.000	-	0.000	+	0.187		48.000		48.187
Length	75.000	-	0.000	+	0.500		75.000		75.500

	Set up Target
Gauge	0.079
Width	48.094
Length	75.250

Side Type

Skid Type Error

Skid Code 0 2 3

Finished Goods Tag	157420	424	428	432	557997
Master Coil Number	NB69244	NB69244	NB69244	NB69244	NB69244
Heat					
Enhanced Weight					
Gross Weight	3060	3060	3060	3060	1160
Tare	135	135	135	135	135
Net Weight	2925	2925	2925	2925	1025
Bundle Status					
Good Pcs.	40	40	40	40	14
Scraped Pcs.					
Rockwell					
Gauge Head	E	0.072	0.072	0.072	0.072
	C	0.072	0.072	0.072	0.072
	E	0.072	0.072	0.072	0.072
Body	E				
	C				
	E				
Tail	E				
	C				
	E				
Surface	OK	OK	OK	OK	OK
Width Head	48.043	48.043	48.043	48.043	48.043
Body	48.043	48.043	48.043	48.043	48.043
Tail	48.043	48.043	48.043	48.043	48.043
Shape	LESS.12	LESS.12	LESS.12	LESS.12	LESS.12
Residual Check	LESS.12	LESS.12	LESS.12	LESS.12	LESS.12
Length Head	75.250	75.250	75.250	75.250	75.250
Body	75.250	75.250	75.250	75.250	75.250
Tail	75.250	75.250	75.250	75.250	75.250
Squareness	LESS.12	LESS.12	LESS.12	LESS.12	LESS.12
Camber					
Operator					
Setup Approval					
Run Time	S 12:00 AM	F 12:00 AM	Down Time	S 12:00 AM	F 12:00 AM
Total Run Time	0:00				
Comments					

09Sep21 03:54

J O B W O R K O R D E R
(R E P R I N T)

SMT 82691

Jemison Metals - Sumter
1255 North Gate Drive
Sumter, SC 29154

Tel: 803-481-0707 Fax: 803-481-0713

Job Type LEV Process PWC SRB

Metric N Cust

Desc 170290 BSH

Due Date 03Aug21 Whs SFG

Setup 00:00 Run 02:30 Prtd By marionp

=====
Group GVS <<< JOB SPECIFICATIONS >>>
Grade DD30CD Gauge 0.0396 (0.0356 to 0.0396) ID 0.0000
=====

=====
F 01 GVS/20/DD30CD/24.8000"X29.10/.0396N <<< ORDER SPECIFICATIONS >>>
Part 1795/9000882408 DDS-A *30 CT DRY
Ga Rng 0.0356to 0.0396 Pc/Tag 360 Ga 0.0396 Wth 24.8000 Lth 29.1000
WthTol + 0.0310 - 0.0310 Wt/Skd 3000
LthTol + 0.0320 - 0.0320 Ty JD3 Pk .

F 02 GVS/20/DD30CD/24.8000"X29.10/.0396N DDS-A *30 CT DRY
Ord SMT 170290- 1 Cust BSH-NEW BERN Ga 0.0396 Wth 24.8000 Lth 29.1000
Part 1795/9000882408 Ga 0.0396 Wth 24.8000 Lth 29.1000
TOLERANCES - same as previous Order Item

=====
<<< PROCESSING INSTRUCTIONS >>>
=====

<Step 1>
Level To: 24.8000 X 29.1000 5799 Pcs 47000 LBS 360 Pcs/Tag
=====

=====
<<< MATERIAL TO BE USED >>>
Tag No Whs Gauge Width Length PCS Weight Heat Number Locn
<GVC/20L/DD30CD>
NB68986 SPW 0.0352M 50.1000 1 43080 NUB1110850 8-G
Rmks: BSH HOME APPLIA
Total: 1 43080
=====

=====
<<< MATERIAL TO BE SHIPPED >>>
02 Ord SMT 170290- 1 Cust BSH-NEW BERN Part 9000882408
A 653 GALVANIZED SHEET DDS-A G30 CT DRY Pcs/Tg 360 Bal 3,240 Pcs
20GA X 24.8000" X 29.1000" DueDt 10Sep21 26,889 LBS
Itm Rmks: S REMOVE STOCK TAG AND REPLACE WITH NEW TAGS
WIRE ONE TAG TO SKID AND ONE TAG STAPLE TO SKID
MUST HAVE TAGS ATTACHED TO BOTH SIDES OF SKIDS
=====

CALL FOR AN APPOINTMENT:
CONTACT JOAN MEADOWS
@ 252-672-45912
=====

FORK REAR UNLOAD

RECIEVING HOURS 7 am to 2:30pm

have a new email address for electronic copies of

09Sep21 03:54

J O B W O R K O R D E R
(R E P R I N T)

SMT 82691

Jemison Metals - Sumter

===== material certificates. It is: =====

FDCNb-inspectioncertificates@bshg.com

Please use this address to send all material certs
in the future.

Con Tag	Whs	Tag No	Whs T	Gauge	Width	Length	OD	Pcs	Weight
NB68986	SPW	156033	SFG F	0.0396	24.8000	29.1000		360	2,918
		156034	SFG F	0.0396	24.8000	29.1000		360	2,918
		156035	SFG F	0.0396	24.8000	29.1000		360	2,918
		156036	SFG F	0.0396	24.8000	29.1000		360	2,918
		156037	SFG F	0.0396	24.8000	29.1000		360	2,918
		156038	SFG F	0.0396	24.8000	29.1000		360	2,918
		156039	SFG F	0.0396	24.8000	29.1000		360	2,918
		156040	SFG F	0.0396	24.8000	29.1000		360	2,918
		556832	SFG F	0.0396	24.8000	29.1000		360	2,918
Total	No Tags	9						3240	26,262

<<< MATERIAL TO STOCK >>>

Cons Tg	Spc	Prod Tg	Whs	Ty	Gauge	Width	Length	OD	PCS<Prn>Wt	PCS<Res>Wt
NB68986										
1	556833	SFG F	0.0396	24.8000	29.1000		360	2918		
1	556834	SFG F	0.0396	24.8000	29.1000		360	2918		
1	556835	SFG F	0.0396	24.8000	29.1000		360	2918		
1	556836	SFG F	0.0396	24.8000	29.1000		360	2918		
1	556837	SFG F	0.0396	24.8000	29.1000		360	2918		
1	556838	SFG F	0.0396	24.8000	29.1000		100	810		
1	556839	SFG F	0.0396	24.8000	29.1000		100	810		
Total:								2000	16,210	

<<< JOB RECAP >>>

	PCS	Weight	Scrap	Scrap %	Unactd Scr	%
Material Allocated	1	43,080				
Master Returns						
Returns to Stock						
Work in Process						
Material to be Shipped	5,240	42,472				
Rejects						
Net Weight to be Produced	5,240	42,472			608	1.41

09Sep21 03:54

T A G P I C K I N G L I S T
(R E P R I N T)

SMT 82691

Jemison Metals - Sumter
1255 North Gate Drive
Sumter, SC 29154

Job Type LEV Process PWC SRB
Metric N Cust
Desc 170290 BSH
Due Date 03Aug21 Whs SFG
Setup 00:00 Run 02:30 Prtd By marionp

=====
Tag No Whs Gauge <<< MATERIAL TO BE USED >>>
<GVC/20L/DD30CD> Width Length PCS Weight Heat Number Locn
NB68986 SPW 0.0352M 50.1000 1 43080 NUB1110850 8-G
Rmks: BSH HOME APPLIA
Total: 1 43080



Material Inspection Report

LOCATION

Sumter

DATE

9/10/2021

CUSTOMER

BSH

JOB # SMT

82691

Page 1

	Order Dim	Tolerances	Tolerances	Low Limit	High Limit
Gauge	0.035	-0.001	+0.005	0.036	0.040
Width	24.800	0.031	+0.031	24.769	24.831
Length	29.100	0.032	+0.032	29.068	29.132

	Set up Target	Side Type	Skid Type Error	Skid Code
Gauge	0.038		SOP'S	0.1.1
Width	24.800	JDOP008	JDOP016	
Length	29.100	JDOP014	JDOP032	

Finished Goods Tag	156033	156034	156037	156038	
Master Coil Number	NB68986				
Heat					
Enhanced Weight					
Gross Weight	2700	2700	2700	2700	
Tare	35	35	35	35	
Net Weight	2665	2665	2665	2665	0
Bundle Status					
Good Pcs.	360	360	360	360	
Scraped Pcs.					
Rockwell					
Gauge Head	E 0.036	0.036	0.036	0.036	
	C 0.036	0.036	0.036	0.036	
	E 0.036	0.036	0.036	0.036	
Body	E				
	C				
	E				
Tail	E				
	C				
	E				
Surface	OK	OK			
Width Head	24.811	24.798	24.799	24.809	
Body					
Tail					
Shape	0.000	0.000			
Residual Check					
Length Head	29.124	29.114	29.122	29.113	
Body					
Tail					
Squareness					
Camber					
Operator					
Setup Approval					
Run Time	S	F	Down Time	S	F
Total Run Time	0:00	Cost	\$0.00	Cst/Hour	\$400.00
Comments					



Material Inspection Report

LOCATION

Sumter

DATE

9/10/2021

CUSTOMER

BSH

JOB # SMT

82691

Page 2

	Order Dim		Tolerances		Tolerances		Low Limit		High Limit
Gauge	0.035	-	-0.001	+	0.005		0.036		0.040
Width	24.800	-	0.031	+	0.031		24.769		24.831
Length	29.100	-	0.032	+	0.032		29.068		29.132

	Set up Target
Gauge	0.035
Width	24.800
Length	29.100

Site Type Skid Type Error

Skid Code	0 1 1
-----------	-------

Finished Goods Tag	556832	556833	556836	556837		
Master Coil Number	NB68986					
Heat						
Enhanced Weight						
Gross Weight	2700	2700	2700	2700		
Tare	35	35	35	35		
Net Weight	2665	2665	2665	2665	0	
Bundle Status						
Good Pcs.	360	360	360	360		
Scraped Pcs.						
Rockwell						
Gauge Head	E	0.037	0.037	0.037	0.037	
	C	0.037	0.037	0.037	0.037	
	E	0.037	0.037	0.037	0.037	
Body	E					
	C					
	E					
Tail	E					
	C					
	E					
Surface	OK	OK	OK	OK		
Width Head	24.790	24.800	24.798	24.811		
Body						
Tail						
Shape	0.000	0.000	0.000	0.000		
Residual Check						
Length Head	29.113	29.115	29.117	29.124		
Body						
Tail						
Squareness						
Camber						
Operator						
Setup Approval						
Run Time	S 12:00 AM	F 12:00 AM	Down Time	S 12:00 AM	F 12:00 AM	
Total Run Time	0:00					
Comments						

08Sep21 12:06

J O B W O R K O R D E R
(R E P R I N T)

SMT 83060

Jemison Metals - Sumter
1255 North Gate Drive
Sumter, SC 29154

Tel: 803-481-0707 Fax: 803-481-0713

Job Type SLT Process PWC SSL
Metric N Cust
Desc EATON WIP .116X59.750
Due Date 08Sep21 Whs SFG
Setup 00:00 Run 01:23 Prtd By rclar

<<< JOB SPECIFICATIONS >>>

Group POC Grade CBTPCE Gauge 0.1160 (0.1090 to 0.1250) ID 20.0000

CHECK BOTTOM SURFACE FOR SCRATCHES

<<< ORDER SPECIFICATIONS >>>

W 01 POC/12F/CBTPCE/59.7500"/.1160N

CSB TP CUT EDGE

Part Ga 0.1160 Wth 59.7500 Lth
Ga Rng 0.1090 to 0.1250 Pc/Tag 1 ID MnOD MxOD MnWgt MxWgt
WthTol + 0.0120 - 0.0000 Wt/Skd 20.00 99.00 25115
LthTol + 0.0000 - 0.0000 Ty J11 Pk .

<<< ARBOR SET UP >>>

1
59.7500

Arbor Recap: 1 X 59.7500

Total Width: 59.7500

<<< PROCESSING INSTRUCTIONS >>>

<Set 1, Step 1> Cut as follows:

1Pcs, 1Pass, Cut Full, Run @ Pos 1- 1, To OD, Lgth, PIW

Use Tags:

71927 SPW 0.1080M 60.2500

ID Wdth OD Wdth
60.2500 0.0000

<<< MATERIAL TO BE USED >>>

Tag No Whs Gauge Width Length PCS Weight Heat Number Locn

<POC/12F/CSBTP>

71927 SPW 0.1080M 60.2500 1 45635 MTL2121135 1B

Rmks: EATON INDUSTRIE

Total: 1 45635

<<< MATERIAL TO STOCK >>>

Cons Tg Spc Prod Tg Whs Ty Gauge Width Length OD PCS<Prn>Wt PCS<Res>Wt
71927 557897 SPW W 0.1160 59.7500 1919 F 61.64 1 45256 1 45256

<<< JOB RECAP >>>

PCS Weight Scrap Scrap % Unactd Scr %

Material Allocated 1 45,635

Master Returns

Returns to Stock

Work in Process 1 45,256

Material to be Shipped

Rejects

Net Weight to be Produced 1 45,256

379 0.83

08Sep21 12:06

T A G P I C K I N G L I S T
(R E P R I N T)

SMT 83060

Jemison Metals - Sumter
1255 North Gate Drive
Sumter, SC 29154

Job Type SLT Process PWC SSL
Metric N Cust
Desc EATON WIP .116X59.750
Due Date 08Sep21 Whs SFG
Setup 00:00 Run 01:23 Prtd By rclar

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
71927	SPW	0.1080M	60.2500		1	45635	MTL2121135	1B
Rmks: EATON INDUSTRIE								
Total:					1	45635		



Manual Inspection Report

FOA013 Retention Codes

JDO1905 JDO1906

JDO1907 JDO1909

Date: 9/10/2021

Job # SMT	83060	Page #	1	Machine	Shifter	CQ	HS	10038	
Location	Summer	Operator	FM	Target	0.11700	0.01700	0.00320	0.02900	
Gauge Spec	0.11600	Limits	0.10900						
Cut	Set Up	Actual	Cut	Set Up	Actual	Cut	Set Up	Actual	Cut
1	59.780	59.750	6			16			21
2			7			17			22
3			8			18			23
4			9			19			24
5			10			20			25

Set Up Comments:

	Coll #	Olsen	Rb	Gauge					Camber	Linear Ft	Burr Hgt	Good PC	Bad PC	Comment	
				Head	1/4	Center	3/4	Tail							
1	71927			E 0.11400	0.11600	0.11600	0.11600	0.11600							
				C 0.11600	0.11500	0.11500	0.11500	0.11500							
				E 0.11500	0.11400	0.11400	0.11400	0.11400							
2				E											
				C											
				E											
3				E											
				C											
				E											
4				E											
				C											
				E											
5				E											
				C											
				E											
Start Time		Stop Time		Start Time		Stop Time		Total Down Time	0:40	Total Run Time	0:00	Cut/Hour	Cost	\$550.00	\$8.00
Comment															

09Sep21 13:31

J O B W O R K O R D E R
(R E P R I N T)

SMT 82817

Jemison Metals - Sumter
1255 North Gate Drive
Sumter, SC 29154

Tel: 803-481-0707 Fax: 803-481-0713

Job Type LEV Process PWC SRB
Metric N Cust
Desc P-1 54495148 DOOSAN
Due Date 16Aug21 Whs SFG
Setup 00:00 Run 02:15 Prtd By marionp

<<< JOB SPECIFICATIONS >>>

Group GNS Grade CB40NO Gauge 0.0785 (0.0710 to 0.0870) ID 0.0000

<<< ORDER SPECIFICATIONS >>>

F 01 GNS/14/CB40NO/48.0000"X96.00/.0785N CS-B *40 NCT LT OIL
Part 3410/54495148 Ga 0.0785 Wth 48.0000 Lth 96.0000
Ga Rng 0.0710to 0.0870 Pc/Tag 30
WthTol + 0.1875 - 0.0000 Wt/Skd 3151
LthTol + 0.5000 - 0.0000 Ty JD6 Pk EDG
WAVE:0.00-.12 BOW:0.00-.12 FLATN:0.00-.12
SQUA:0.00-.25
EDG Edge Protectors

"PERFORM RESIDUAL STRESS TEST"

F 02 GNS/14/CB40NO/48.0000"X96.00/.0785N CS-B *40 NCT LT OIL
Ord SMT 170064- 1 Cust DOOSAN Ga 0.0785 Wth 48.0000 Lth 96.0000
Part 3410/54495148 Ga 0.0785 Wth 48.0000 Lth 96.0000
TOLERANCES - same as previous Order Item
WAVE:0.00-.12 BOW:0.00-.12 FLATN:0.00-.12
SQUA:0.00-.25
EDG Edge Protectors

"PERFORM RESIDUAL STRESS TEST"

F 03 GNS/14/CB40NO/48.0000"X96.00/.0785N CS-B *40 NCT LT OIL
Ord SMT 170100- 1 Cust DOOSAN Ga 0.0785 Wth 48.0000 Lth 96.0000
Part 3410/54495148 Ga 0.0785 Wth 48.0000 Lth 96.0000
Ga Rng 0.0710to 0.0870 Pc/Tag 29
WthTol + 0.1875 - 0.0000 Wt/Skd 3151
LthTol + 0.5000 - 0.0000 Ty JD6 Pk EDG
WAVE:0.00-.12 BOW:0.00-.12 FLATN:0.00-.12
SQUA:0.00-.25
EDG Edge Protectors

"PERFORM RESIDUAL STRESS TEST"

F 04 GNS/14/CB40NO/48.0000"X96.00/.0785N CS-B *40 NCT LT OIL
Ord SMT 169835- 1 Cust DOOSAN Ga 0.0785 Wth 48.0000 Lth 96.0000
Part 3410/54495148 Ga 0.0785 Wth 48.0000 Lth 96.0000
TOLERANCES - same as previous Order Item
WAVE:0.00-.12 BOW:0.00-.12 FLATN:0.00-.12
SQUA:0.00-.25
EDG Edge Protectors

"PERFORM RESIDUAL STRESS TEST"

<<< PROCESSING INSTRUCTIONS >>>

<Step 1>
Level To: 48.0000 X 96.0000 429 Pcs 44000 LBS 30 Pcs/Tag

09Sep21 13:31

J O B W O R K O R D E R
(R E P R I N T)

SM

Jemison Metals - Sumter

=====

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<<< MATERIAL TO BE USED >>>								
<GNC/14L/CB40NO>								
ND69105	SPW	0.0700M	48.0000		1	44840	NUDNL4195	6-E
Rmks: DOOSAN								

Total: 1 44840

=====

04 Ord SMT 169835- 1 Cust DOOSAN Part 54495148

A 653 GALVANNEALED SHEET CS-B A40 NCT LT OIL Pcs/Tg 29 Bal 30 Pcs

14GA X 48.0000" X 96.0000" DueDt 10Sep21 3,148 LBS

Itm Rmks: S RECEIVING HOURS 6:00AM - 2:00PM MONDAY - FRIDAY

DOOSAN BAR CODE LABELS AND PACKING SLIP BUT BE PUT

WITH OUR BOLLS- SEE LORI FOR DETAILS

MAKE AN APPOINTMENT WITH DOOSAN BEFORE SHIPPING

SHIPPING CONTACT IS: stareceive@doosan.com OR

FLARECEIVE@doosan.com or 704-883-3993

Con Tag	Whs	Tag No	Whs T	Gauge	Width	Length	OD	Pcs	Weight
ND69105	SPW	157445	SFG F	0.0785	48.0000	96.0000		30	3,078

02 Ord SMT 170064- 1 Cust DOOSAN Part 54495148

A 653 GALVANNEALED SHEET CS-B A40 NCT LT OIL Pcs/Tg 30 Bal 300 Pcs

14GA X 48.0000" X 96.0000" DueDt 10Sep21 31,510 LBS

Itm Rmks: S RECEIVING HOURS 6:00AM - 2:00PM MONDAY - FRIDAY

DOOSAN BAR CODE LABELS AND PACKING SLIP BUT BE PUT

WITH OUR BOLLS- SEE LORI FOR DETAILS

MAKE AN APPOINTMENT WITH DOOSAN BEFORE SHIPPING

SHIPPING CONTACT IS: stareceive@doosan.com OR

FLARECEIVE@doosan.com or 704-883-3993

Con Tag	Whs	Tag No	Whs T	Gauge	Width	Length	OD	Pcs	Weight
		157435	SFG F	0.0785	48.0000	96.0000		30	3,078
		157436	SFG F	0.0785	48.0000	96.0000		30	3,078
		157437	SFG F	0.0785	48.0000	96.0000		30	3,078
		157438	SFG F	0.0785	48.0000	96.0000		30	3,078
		157439	SFG F	0.0785	48.0000	96.0000		30	3,078
		157440	SFG F	0.0785	48.0000	96.0000		30	3,078
		157441	SFG F	0.0785	48.0000	96.0000		30	3,078
		157442	SFG F	0.0785	48.0000	96.0000		30	3,078
		157443	SFG F	0.0785	48.0000	96.0000		30	3,078
		157444	SFG F	0.0785	48.0000	96.0000		30	3,078
Total	No Tags	10						300	30,780

03 Ord SMT 170100- 1 Cust DOOSAN Part 54495148

A 653 GALVANNEALED SHEET CS-B A40 NCT LT OIL Pcs/Tg 29 Bal 354 Pcs

14GA X 48.0000" X 96.0000" DueDt 22Sep21 37,183 LBS

Itm Rmks: S RECEIVING HOURS 6:00AM - 2:00PM MONDAY - FRIDAY

DOOSAN BAR CODE LABELS AND PACKING SLIP BUT BE PUT

WITH OUR BOLLS- SEE LORI FOR DETAILS

09Sep21 13:31

J O B W O R K O R D E R
(R E P R I N T)

SMT 82817

Jemison Metals - Sumter

=====

MAKE AN APPOINTMENT WITH DOOSAN BEFORE SHIPPING
SHIPPING CONTACT IS: stareceive@doosan.com OR
FLARECEIVE@doosan.com or 704-883-3993

Con Tag	Whs	Tag No	Whs	T	Gauge	Width	Length	OD	Pcs	Weight
		157446	SFG	F	0.0785	48.0000	96.0000		30	3,078
		157447	SFG	F	0.0785	48.0000	96.0000		30	3,078
		157448	SFG	F	0.0785	48.0000	96.0000		30	3,078
		557237	SFG	F	0.0785	48.0000	96.0000		30	3,078
Total	No Tags	4							14	1,436
									104	10,670

=====

<<< JOB RECAP >>>

	PCS	Weight	Scrap	Scrap %	Unactd	Scr %
Material Allocated	1	44,840				
Master Returns						
Returns to Stock						
Work in Process						
Material to be Shipped	434	44,528				
Rejects						
Net Weight to be Produced	434	44,528			312	0.70

09Sep21 13:31

T A G P I C K I N G L I S T
(R E P R I N T)

SMT 82817

Jemison Metals - Sumter
1255 North Gate Drive
Sumter, SC 29154

Job Type LEV Process PWC SRB
Metric N Cust
Desc P-1 54495148 DOOSAN
Due Date 16Aug21 Whs SFG
Setup 00:00 Run 02:15 Prtd By marionp
=====

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<GNC/14L/CB40NO>								
ND69105	SPW	0.0700M	48.0000		1	44840	NUDNL4195	6-E
		Rmks: DOOSAN						
				Total:	1	44840		



Material Inspection Report

LOCATION

Sumter

DATE

9/10/2021

CUSTOMER

DOOSAN

JOB # SMT

82817

Page 1

	Order Dim		Tolerances		Tolerances		Low Limit		High Limit
Gauge	0.070	-	-0.001	+	0.017		0.071		0.087
Width	48.000	-	0.000	+	0.187		48.000		48.187
Length	96.000	-	0.000	+	0.500		96.000		96.500

	Set up Target		Skid Type		Skid Type Error		Skid Code		0 2 3
Gauge	0.079								
Width	48.094								
Length	96.250								

JNOP008	JNOP016	JNOP046
JNOP014	JNOP034	JNOP032

Finished Goods Tag	157435	157440	157445			
Master Coil Number	ND69105					
Heat						
Enhanced Weight						
Gross Weight	2950	2950	2950	1650		
Tare	130	130	130	130		
Net Weight	2820	2820	2820	1520	0	
Bundle Status						
Good Pcs.	30	30	30	16		
Scraped Pcs.						
Rockwell						
Gauge Head	E 0.072	0.071	0.072			
	C 0.072	0.073	0.073			
	E 0.070	0.072	0.072			
Body	E					
	C					
	E					
Tail	E					
	C					
	E					
Surface	OK					
Width Head	48.067	48.058	48.065			
Body						
Tail						
Shape	0.000					
Residual Check						
Length Head	96.060	96.060	96.060			
Body						
Tail						
Squareness	.03					
Camber						
Operator	CD					
Setup Approval						
Run Time	S	F	Down Time	S	F	
Total Run Time	0:00	Cost	\$0.00	Cst/Hour	\$400.00	
Comments						

Jemison Metals - Sumter
1255 North Gate Drive
Sumter, SC 29154

RC 62417 Act Dt 09Sep21 Description Probill Number
By kens Ent Dt 09Sep21 NUB 1580962

Item Type Order Number Vendor/Customer Shp Fr Bill of Lading U/M
1 P SMT 27799-001 35 NUCOR BERKELEY 1580962 LBS
PCS Quantity
GVC/20L/DD30CD Other Tag Ref: 647273.000 Coil Lgth 7,094 FT
A 653 GALVANIZED COIL DDS-A *30 CT DRY 1 42,420 LBS
.0352 Min X 48.1380" Pack 42,420 LBS
Tag NB69498 SPW Loc 4-E NUB 2114231

BSH HOME APPLIA
Width ID 48.5000" Gauge ID 0.0352" Diameter ID 24.0000"
0.0352" 68.0000"

Item 1 Totals
PCS Weight Packing Slip 42,420 LBS
1 42,420 LBS Theoretical 0 LBS

Receiver 62417 Total Equivalent Weight 42,420 LBS
Total Coil Length 7,094 FT

STRAIGHT BILL OF LADING - SHORT FORM

ORIGINAL - NOT NEGOTIABLE

RECEIVED, subject to the classifications and tariffs in effect on the date of the issue of this Bill of Lading.

FROM: NUCOR STEEL BERKELEY

TELEPHONE: 843/336-6000

AT: 1455 Hagan Avenue
Huger, SC 29450

DATE 9/09/21

BILL OF LADING NO. 1580962

PAGE : 1

Subject to Section 7 of the terms and conditions of this 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 may decline to make delivery of this shipment without payment of freight and all other lawful charges.

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

Prepaid

(Signature of Consignor)

The property described below 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 word carrier being understood throughout this contract as meaning any person or corporation in possession of the property under the contract) agrees to carry to its usual place of delivery at said destination, if on its route, otherwise to deliver to another carrier on route to said destination. It is mutually agreed that every service to be performed hereunder shall be subject to all the terms and conditions of this bill of lading. THIS BILL OF LADING IS NOT SUBJECT TO ANY CLASSIFICATION OR TARIFFS, WHETHER INDIVIDUALLY DETERMINED OR FILED WITH ANY FEDERAL OR STATE REGULATORY AGENCY, EXCEPT AS SPECIFICALLY AGREED TO IN WRITING BY THE SHIPPER AND CARRIER.

SHIP JEMISON DEMSEY METALS
TO: 7 1255 NORTH GATE DRIVE
SUMTER, SC 29150

SOLD JEMISON DEMSEY LLC DBA
105 JEMISON METALS
TO: 3800 COLONNADE PKWY STE 250
BIRMINGHAM AL 35243 0000

ROUTE

CARRIER TRUCK MILES 00088
O&I TRANSPORT

CAR OR
VEHICLE NO. 100124

Load 1774178 Ticket...: 2930519

Contract: COLLECT

Trailer Number

Gross Wt.: 71,340.00

COIL NBR	PO# /HEAT-SEQ#	PRODUCT (inches)	CALC LB	ORDER/LINE	WEIGHT
----------	----------------	------------------	---------	------------	--------

647273.000	SMT-27799	.0352 MIN X 48.1380 MIN	7094	519458-1	42,420.00
		ASTM A653 / DDS TYPE A / 20		Due 9/18/21	
G30	2114231-6	GALVANIZED	.0352X48.138G30	Dry/CHM	

Melted and Manufactured In the USA.

Total Pounds 42,420.00

(in percent)

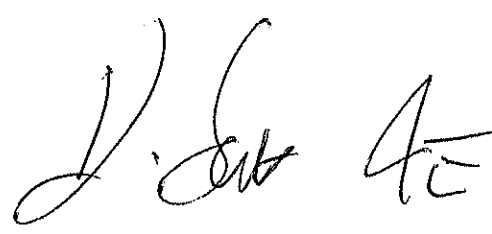
Heat	C	Mn	P	S	Si	Cu	Ni	Cr	Mo	Sn	Al	V	Nb	N	Ti	B	Ca
2114231	.003	.05	.008	.003	.04	.07	.03	.03	.01	.004	.036	.003	.000	.005	.073	.000	.002

TARP ALL LOADS

Ship-To Contact: Lori Seamon, Ship-To Phone#: 8032727325

M-F (NoApptReq) | M-Th (7AM 3:30PM) | F (7AM 2PM) | Sa-Su (Closed)

Load Created by: JLM



4850 24/68

If the shipment moves between two ports by a carrier by water, the law requires that the bill of lading shall state whether it is "carrier's weight" or "shipper's weight".
The agreed-on declared value of the property is hereby specifically stated by the shipper to be not exceeding _____ per _____.
Shipper hereby certifies that he is familiar with all the terms and conditions of this bill of lading, including those on the back hereof, and the said terms and conditions are hereby agreed to by the shipper and accepted for itself and its assigns.

NUCOR STEEL BERKELEY

1455 Hagan Avenue
Huger, SC 29450

Permanent post office address of shipper

833637

SHIPPER'S
SIGNATURE: 

JOSHUA R HOLMES

CARRIER'S
SIGNATURE: _____

Carrier acknowledges receipt of property described above in good order and condition.
(This Bill of Lading is to be signed by the shipper and agent of the carrier (issuing company))

TRANSFER BILL OF LADING No: SMT 116159
 Ship From: Jemison Metals - Sumter
 1255 North Gate Drive
 Sumter, SC 29154
 Tel: 803-481-0707 Fax: 803-481-0713
 Ship To: (1)
 Eaton Corporation
 845 CORPORATE CIRCLE
 SUMTER, SC 29154
 Tel: 803-481-3131 Fax: 803-481-6632
 Ship Date 09Sep21 at 10:16 From SFG
 Probill
 Via BEST WAY
 FOB DESTINATION
 Frt PREPAID FREIGHT
 Route 1- 0 Manifest 43432
 Vhcle Trailer
 Slp
 Sold To: (1530)
 Jemison Metals - Sumter
 1255 North Gate Drive
 Sumter, SC 29154

Con Jeffrey Bays

Tel 803-481-3131 Fax 803-481-6632

TRANSFER BILL OF LADING

1) Our Order SMT-170274- 2 Your PO #

Part # 10102HBWSE

Rel #

A1008 COLD ROLLED SHEET CS-TYPE B

.0580 Nom X 60.0000" X 96.0000"

Heat Number	Tag No	Quantity	PCS	Net Wt	Gr LBS
2113724	159492	2,000.00 SFT	50	4851	4911
2113724	159493	2,000.00 SFT	50	4851	4911
2113724	159494	2,000.00 SFT	50	4851	4911
Total:		6,000.00 SFT	150	14553	14733

TOTAL:	Tags	PCS	Net Wt	Gr LBS
	3	150	14553	14733

Heat Number

2113724

*** Chemical Analysis ***

C=<.05> Mn=<.26> P=<.011> S=<.004> Si=<.02> N=<.006> Cr=<.03>

Mo=<.01> Cu=<.09> Al=<.039> V=<.001> Ti=<.001> Ni=<.03>

Nb=<.001> Ca=<.002> Sn=<.004> B=<.000>

PROTECT FROM WEATHER / ALL LOADS MUST BE TARPED

Page: 1 Last

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 word carrier being understood throughout this contract meaning any person or corporation in possession under the contract) agrees 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 all property said property 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 set forth (1 in Official, Southern, Western, and Illinois Freight Classifications 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 read 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.		CARRIER <i>Truck</i>		FREIGHT Prepaid <input type="checkbox"/> Collect <input type="checkbox"/>	
SIGNATURE OF CONSIGNOR <i>[Signature]</i>		AGENT PER (Driver's Signature) <i>[Signature]</i>		DATE Sept 9	
If charges are to be prepaid write or stamp here, "To be Prepaid."		RECEIVED \$		AGENT OR CASHIER (The signature here acknowledges only the amount prepaid.) \$	

L O A D I N G O R D E R

Ship From:
Jemison Metals - Sumter
1255 North Gate Drive
Sumter, SC 29154
Tel: 803-481-0707 Fax: 803-481-0713

No: SMT 116159
Ship Date 09Sep21 at 4:34 From SFG
Probill
Via BEST WAY
FOB DESTINATION
Frt PREPAID FREIGHT
Route 1- 0 Manifest 43432
Vhcle Trailer
Slp
Sold To: (1530)
Jemison Metals - Sumter
1255 North Gate Drive
Sumter, SC 29154

Ship To: (1)
Eaton Corporation
845 CORPORATE CIRCLE
SUMTER, SC 29154
Tel: 803-481-3131 Fax: 803-481-6632

Con Jeffrey Bays

Tel 803-481-3131 Fax 803-481-6632

L O A D I N G O R D E R

1) Our Order SMT-170274- 2 Your PO #
Part # 10102HBWSE Rel #

A1008 COLD ROLLED SHEET CS-TYPE B
.0580 Nom X 60.0000" X 96.0000"

Loc	Heat Number	Tag No	Quantity	PCS	Net Wt	Gr LBS
<i>Just Ram.</i>	2113724	159492	2,000.00 SFT	50	4851	4911
	2113724	159493	2,000.00 SFT	50	4851	4911
	2113724	159494	2,000.00 SFT	50	4851	4911
	Total:		6,000.00 SFT	150	14553	14733

TOTAL:	Tags	PCS	Net Wt	Gr LBS
	3	150	14553	14733

Heat Number
2113724

*** Chemical Analysis ***
C=<.05> Mn=<.26> P=<.011> S=<.004> Si=<.02> N=<.006> Cr=<.03>
Mo=<.01> Cu=<.09> Al=<.039> V=<.001> Ti=<.001> Ni=<.03>
Nb=<.001> Ca=<.002> Sn=<.004> B=<.000>

PROTECT FROM WEATHER / ALL LOADS MUST BE TARPED

07Sep21 14:31 T R A N S F E R S H I P P I N G O R D E R No: SMT TR-170274
 Transferred From: Branch:
 Jemison Metals - Sumter Jemison Metals - Sumter
 1255 North Gate Drive 1255 North Gate Drive
 Sumter, SC 29154 Sumter, SC 29154
 Tel: 803-481-0707 Fax: 803-481-0713

Sold To: (SMT)
 Jemison Metals - Sumter
 1255 North Gate Drive
 Sumter, SC 29154

Ship To: (1)
 Eaton Corporation
 845 CORPORATE CIRCLE
 SUMTER, SC 29154
 Tel: 803-481-3131 Fax: 803-481-6632

Rsn Stock Transfer Ord 07Sep21 Due 08Sep21 09-08 Rt 001-000
 Frt PREPAID FREIGHT Via ALL METALS TRAN FOB DESTINATION

T R A N S F E R S H I P P I N G O R D E R TO No SMT TR-170274
 Test Certs: Chem-Y Phys-Y 1 Original copies with Shipment, 0 with Invoice

1 A1011 HRP&O SHEET CSB TP CUT EDGE 145 PCS 21573 LBS
 .1000 Nom X 54.5000" X 94.0000"
 Part No 10101ACJDB - 54.50X94

Shipped: Pcs
 <<<----- INVENTORY RESERVATIONS ----->>>
 POS/13E/CBTPCE/54.5000"X94.0000" 157719 SFG 32 PCS 4485 LBS
 POS/13E/CBTPCE/54.5000"X94.0000" 157720 SFG 32 PCS 4485 LBS
 POS/13E/CBTPCE/54.5000"X94.0000" 157721 SFG 32 PCS 4485 LBS
 POS/13E/CBTPCE/54.5000"X94.0000" 557767 SFG 30 PCS 4335 LBS
 POS/13E/CBTPCE/54.5000"X94.0000" 155781 SFG B8 8/26 19 PCS 2665 LBS

2 A1008 COLD ROLLED SHEET CS-TYPE B 160 PCS 15523 LBS
 .0580 Nom X 60.0000" X 96.0000"
 Part No 10102HBWSE 09Sep21

Shipped: Pcs
 <<<----- INVENTORY RESERVATIONS ----->>>
 CRS/16L/CSB/60.0000"X96.0000" 159183 SFG 50 PCS 4737 LBS
 CRS/16L/CSB/60.0000"X96.0000" 159184 SFG 50 PCS 4737 LBS
 CRS/16L/CSB/60.0000"X96.0000" 159440 SFG 50 PCS 4737 LBS

3 A 653 GALVANIZED SHEET CS-B *40 NCT LT OIL 102 PCS 17233 LBS
 .1010 Nom X 60.0000" X 96.0000"
 Part No 10102LM90Q

Shipped: Pcs
 <<<----- INVENTORY RESERVATIONS ----->>>
 GVS/13/CB40NO/60.0000"X96.0000" 154778 SFG B8 8/26 34 PCS 5300 LBS
 GVS/13/CB40NO/60.0000"X96.0000" 154779 SFG B8 8/26 34 PCS 5300 LBS
 GVS/13/CB40NO/60.0000"X96.0000" 154780 SFG B8 8/26 34 PCS 5300 LBS

FORK REAR UNLOAD

=====

all steel trucks must DELIVER no later than 3:30
 on Friday, Saturday, and Sunday.

The cut off Mon.- Thurs. is our normal 10:30 pm

=====

PROTECT FROM WEATHER / ALL LOADS MUST BE TARPED

Order Totals: 3 Items 54329 LBS



Corrective Action Report

Case#	20420	Date Created	1/29/2021
Branch	SMT	Created By	Patrick Macias
Assigned Responsibility	Quality	Customer	-----
Internal/External	Internal		
Has finished goods inventory been checked for the same issue?			N/A

Problem Description:
(Who, What, Where, When)

CA 18690, 7 month lapse between entering of CA and first audit of CA.

Root Cause Of Issue:
(Why)

Corrective action not reviewed on timely basis

Interim Responsible	Patrick Macias	Implementation Date:	1/29/2021
All open CA's to be reviewed monthly by Quality department.			
Plan:			

Permanent Responsible	Patrick Macias	Implementation Date:	1/29/2021
Scheduled review with Eastern Division quality personnel last Friday every month.			
Plan:			

Material Disposition	-----		
Audit Date 1	2/26/2021	Outcome 1	Pass
Audit Date 2	3/26/2021	Outcome 1	Pass
Audit Date 3	4/23/2021	Outcome 1	Pass
Follow Up:			

Elevate to risks and opportunities document: No
Change required to QMS (Forms/Procedures etc): No

2/26/2021 meeting reviewed CAs 20418, 20419, 20420 recorded cases reviewed on meeting.

3/26/2021 meeting reviewed and instigated action where necessary on the following cases: 19039, 19818, 20418, 20419, 20420, 20757

Notes from 4/23/2021 call:

Case/action

19039-updated prints for four parts documented on case

19818-Three audits completed

20420-updated third audit with this meeting

20443-Beverly to review jobs for notes per CA

20705-Patrick to review with Lori and audit by 4/30

20757-Patrick to complete first audit by 4/30

20852-Patrick to complete first audit no later than 5/7

4/26/21 Closed. RR

Complete

Yes Closed

Yes

JDM 200 10-09-13 Revision 2

Continue



Corrective Action Report

Case#	20705	Date Created	4/1/2021
Branch	SMT	Created By	Patrick Macias
Assigned Responsibility	Operations	Customer	BSH-NEW BERN
Internal/External	External		

Has finished goods inventory been checked for the same issue? N/A

Problem Description:
(Who, What, Where, When)

Delay in delivery of blank 9000882413, causing Built In Oven lines to shut down, 3/10/21 - 6 hrs on 2nd shift, 8 hrs 1st shift, 3/11/2021

Root Cause Of Issue:
(Why)

Process: Loading orders are created for sales order(s) for each location to be delivered. Loading orders are grouped together for each truck load and entered onto a truck manifest. Loading orders are loaded into an envelope and placed into shipping area for truck loading. If loads are changed, loading orders are pulled from the floor, manifest are updated, and loading orders are put into envelope and returned to the floor. After truck is loaded envelope and tags are returned to Logistics Coordinator to check tags against loading order in tag scan process confirming all material listed on loading order is loaded on truck

Failures:

1. Load was changed due to production requirements.
2. Manifest changed.
3. Loading order was mislaid when order was changed and did not make it back to the floor in the envelope.
4. Root issue: Manifest not reviewed to confirm all listed loading orders were loaded on truck.

Interim Responsible	Lori Seamon	Implementation Date:	3/18/2021
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Plan:

Manifest to be printed and accompany loading orders, to be used to confirm all loading orders are loaded on assigned truck

Permanent Responsible	Lori seamon	Implementation Date:	3/18/2021
------------------------------	-------------	-----------------------------	-----------

Plan:

Loading order to be checked by Logistic Coordinator or designee at time of tag scan function to confirm all assigned loading orders are loaded on the assigned truck

Material Disposition -----

Audit Date 1	5/6/2021	Outcome 1	Pass
Audit Date 2	5/13/2021	Outcome 1	Pass
Audit Date 3	5/17/2021	Outcome 1	Pass

Elevate to risks and opportunities document: No
Change required to QMS (Forms/Procedures etc): No
first verification to be performed by 4/30/21

Follow Up:

5/06/2021 Eaton B/L 114275 reviewed. Lori Seamon Logistic Coordinator performed check
5/13/2021 ABB Selmer B/L 114392 reviewed. Marc Harton Logistic Coordinator back up performed check.
5/17/2021 Altec B/L 114415 reviewed. Lori Seamon Logistic Coordinator performed check.

Complete**Yes Closed****Yes****JDM 200 10-09-13 Revision 2**

Continue



Corrective Action Report

Case#	20478	Date Created	4/1/2021
Branch	SMT	Created By	Patrick Macias
Assigned Responsibility	Operations	Customer	EATON-FAY
Internal/External	External		
Has finished goods inventory been checked for the same issue?			Yes

Problem Description:
(Who, What, Where, When)

Eaton Fay part the thickness is under the specified range of 6271A07H13 .072-.076 use a .068 min coil did not make the min requirement tried coils. Pick up coils .

Root Cause Of Issue:
(Why)

1. Part was not awarded to Jemison by Eaton.
2. Eaton spot ordered part, to alleviate inventory issue and issued a PO to Jemison.
3. PO was for 14 gauge without specifics on gauge.
4. Failure: Jemison did not receive specific gauge information from customer.

Interim Responsible	Donnie Redfern	Implementation Date:	4/1/2021
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Plan:

No spot orders to be accepted without specific information/drawing for Eaton parts.

Permanent Responsible	Patrick Macias	Implementation Date:	4/1/2021
------------------------------	----------------	-----------------------------	----------

Plan:

Jemison will require all future spot buy items to be accompanied by part specifications to confirm internal specifications match customer requirements.
 All spot orders submitted without specs will be put on hold until the customer specs are reviewed by quality and confirmation of correct internal spec.

Material Disposition	----		
Audit Date 1	----	Outcome 1	----
Audit Date 2	----	Outcome 1	----
Audit Date 3	----	Outcome 1	----

Follow Up:

Elevate to risks and opportunities document: No
 Change required to QMS (Forms/Procedures etc): No
 4/23/21 Closed. RR

Complete

Yes **Closed**

Yes

JDM 200 10-09-13 Revision 2

Continue