

Audit Review and Evaluations OF

JEMISON METALS

**8100 Aetna Road
Cleveland, OH 44105**

Dates of Audit: 12/29/2020
Date of Submittal: 12/30/2020

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. This audit was performed virtually reviewing documentation and performing phone interviews. **Based upon our review, the QMS is effectively implemented.**

Audit Detail/Observations/Findings

7.5 – Documentation Requirements

The following forms and documents were verified during the audit: CLV-RC-001 Receiving Procedure (Quality Intranet-no hard copy present) CLV –SL-001 Loopco Procedure (Quality Intranet -no hardcopy present), Quality checklist JDM 13 Rev level 7, JDM-F-001 Mill/Receiving Information Rev-2, JDM200 Quality Policy Rev-1, OJT Group Training form OJT 6.2-4 Rev 5

7 Support

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

7.2 Competence

Reviewed OJT (OJT 6.2-4 Rev 5) forms listed below:

2/10/2020 Inspection of load (Tyrone Vasone, Paul Bouska)

2/10/2020 Job Instructions (Michael Coleman, Darrell Williams)

2/10/2020 Receiving and mill form (Anthony Walton)

8.2 Requirements for products and service

PO UB3579801 sent on 7/24/18 Order acknowledged by Mary-Margaret Brown 11/2/2020 on customer website. Sales order 989060-1 entered on 11/02/2020 due 11/4/2020

8.4 Control of externally provided processes, products, and services

Mill coil #DU22430 received off of PO 27249-01 for Liebert Cols bucket GVC C90CDR 15B 48" met all requirements for customer part in that bucket.

8.5-Production & Service Provisions

Receiving: Was unable to audit receiving in real time. Reviewed receiving paperwork of PO 27249-001 Receiver 52179, B/L 10259669. Receiving paperwork not signed or dated (OBS #1 Paperwork not signed or dated by Jemison personnel), Items 1-5 on CLV-RC-

001 performed by Jemison employee, Item 6 performed by Kathy Manka at time of 2nd receiving

Production: W/O 76253 Vertiv documentation reviewed from Red Bud levelling line. Quality Checklist form JDM 13 completed, all checks performed per procedure, material met W/O tolerance requirements. Operator Michael Coleman.

B/L 126813 (S/O 989060-1) shipped 11/02/2020. Sales order quantity filled from customer PO UB3579801

Preventive Maintenance: Reviewed with Larry Strimple, Schedule calendar for November reviewed. All schedule maintenance marked as performed. December calendar in progress

7.1.5 Monitoring and Measuring Resources

The following gauges were verified to be calibrated in compliance with calibration records: RBI 2: Micrometer ASP016 Last 12/2020 next 1/2021, RBI 2 Caliper 180 last 12/2020 next 1 /2021

8.7 Control of Nonconforming Product

Both sheet and coil nonconforming lists were up to date. Coil area had 2 items awaiting reallocation by material group. Sheet area had seven items.

10.2 Nonconformity and Corrective Action

CA 19818 Reviewed, entered 11/6/2020 Audits not yet performed

10 Continual improvement

Remote controls for two cranes purchased and used to replace pendant controls. Improving, safety, and efficiency.

Observations and findings from previous ISO audit

MF 1, 2 CA 17523 opened 8/2/2019 completed and closed 11/25/2019
OFI calibration records and certificates complete and without alteration.

2.0 Overview

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

<p>Jack Cochran-Operations</p> <p>Larry Strimple-Maintenance</p>	<p>Kathy Manka-Production Planner/Receiver</p> <p>Mary-Margaret Brown-Inside sales</p>
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2.2 Audited Requirements

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

Report Prepared by Patrick Macias

Date 12/30/2020

Nonconforming Corrective Action Report (CAR) for Jemison
Metals

CAR #	ISO 9001: 2015 Clause / Sub-Clause	Findings/Requirements	Observati on	Mino r	Major
NA	8.2	Receiving bill of lading copy from PO 27249-1 not signed or dated by Jemison personnel.	x		

Jemison Metals On-The-Job (OJT) Group Training Form

Continual Learning is key to Continual Improvement in the JDM QMS. This Form recognizes that:

(Attendees):

Print Name	Initial	Print Name	Initial
TYRONE VIGOR	TV		
PAUL BOUSKA	PB		

All Attendees have successfully completed OJT for:

Location: Cleveland

Training Start Date: 2-10-2020 Completion Date: 2-10-2020

Description: Inspection of load

Department: Shipping

Subject: Inspect bundle for no defects and properly packaged

Signature of Trainer: Jack E. Gehring

According to this document, the OJT for these individuals have been trained and have demonstrated sufficient competence to conduct the documented function/task without further instructions. Continued performance evaluation and observation could result in additional training being specified.

Jemison Metals On-The-Job (OJT) Group Training Form

Continual Learning is key to Continual Improvement in the JDM QMS. This Form recognizes that:

(Attendees):

Print Name	Initial	Print Name	Initial
Michael Coleman	M.C.		
Darrell Williams	D.W.		

All Attendees have successfully completed OJT for:

Location: Cleveland

Training Start Date: 2-10-2020 Completion Date: 2-10-2020

Description: Read Job Instructions

Department: CRZ

Subject: Packaging heights and ^{Proper} ~~Skills~~ Skills

Signature of Trainer: Jack E. Gehring

According to this document, the OJT for these individuals have been trained and have demonstrated sufficient competence to conduct the documented function/task without further instructions. Continued performance evaluation and observation could result in additional training being specified.

Jemison Metals On-The-Job (OJT) Group Training Form

Continual Learning is key to Continual Improvement in the JDM QMS. This Form recognizes that:

(Attendees):

Print Name	Initial	Print Name	Initial
Anthony Walton	AW		

All Attendees have successfully completed OJT for:

Location: Cleveland

Training Start Date: 2-10-2020 Completion Date: 2-10-2020

Description: Receiving & Mill Form

Department: Receiving

Subject: Training on how to Properly Fill form out

Signature of Trainer: Jack E. Lock

According to this document, the OJT for these individuals have been trained and have demonstrated sufficient competence to conduct the documented function/task without further instructions. Continued performance evaluation and observation could result in additional training being specified.

Jemison Metals - Cleveland
8100 Aetna Drive
Cleveland, OH 44105

RC 52179 Act Dt 20Aug20 Description Probill Number
By sandyd Ent Dt 20Aug20 NLMK SHARON 10259670

Item	Type	Order Number	Vendor/Customer	Shp Fr	Bill of Lading	U/M
1	P	CLV 27277-C01	833 NLMK		10259670	LBS
GVC/11D/C90CDR					PCS	Quantity
A 653 GALVANIZED COIL CS-B *90 CT DRY ROHS					Coil Lgth	2,098 FT
.1220 Min X 48.0000"					1	43,190 LBS
Tag DU22429 CPW Loc A-17					Pack	43,190 LBS ✓
NLM CSP19A028874						
LIEBERT - COLS					Mat Cst	33.8356 /CWT
					Tot Cst	34.3356 /CWT

Item	1 Totals	Weight	Packing Slip	
PCS				
1		43,190 LBS	Theoretical	43,190 LBS 0 LBS

Item	Type	Order Number	Vendor/Customer	Shp Fr	Bill of Lading	U/M
2	P	CLV 27249-001	833 NLMK		10259670	LBS
GVC/15B/C90CDR					PCS	Quantity
A 653 GALVANIZED COIL CS-B *90 CT DRY ROHS					Coil Lgth	3,831 FT
.0670 Min X 48.0000"					1	42,780 LBS ✓
Tag DU22430 CPW Loc A-17					Pack	42,780 LBS
NLM USHT00056						
LIEBERT - COLS					Mat Cst	34.1882 /CWT
					Tot Cst	34.6882 /CWT

Item	2 Totals	Weight	Packing Slip	
PCS				
1		42,780 LBS	Theoretical	42,780 LBS 0 LBS

Receiver 52179	Total Equivalent Weight	85,970 LBS
	Total Coil Length	5,929 FT

The fiber boxes used for this shipment conform to the specifications set forth in the box maker's certificate thereon and all other requirements of the Consolidated Freight Classification

+Shipper's Imprints in lieu of stamp; not a part of Bill of Lading approved by the Interstate Commerce Commission

STRAIGHT BILL OF LADING - SHORT FORM - Original - Not Negotiable

RECEIVED: subject to the classifications and tariffs in effect on the date of the receipt by the carrier of the property described in the Original Bill of Lading

NAME OF CARRIER P.I. AND I. MOTOR EXPRESS

12:35 Appt 13:29

Shipper's No. 10259670

Carrier's No. 2182

GI PRIME FAR

PAYMENT AUTH # A4105355

At SHARON, PA

AUGUST 19, 2020

From NLMK PENNSYLVANIA

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 the contract as meaning any person or corporation in possession of 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 the route to said destination. It is mutually agreed, as to each carrier of all or any part of said property over all or any portion of said route to destination, and as to 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 Classification 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 motor carrier shipment.

Shipper hereby certifies that he is familiar with all the terms and conditions of the said bill of lading, including those on the back thereof, set forth in the classification or 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. Carrier is responsible for tarping of loads.

CONSIGNEE TO JEMISON-DEMSEY, LLC

8100 AETNA ROAD

DESTINATION CLEVELAND

STATE OH, 44105

County

Route TRUCK-EYE TO SIDE (TARP) -- RECV'G HRS 7:00 AM - 2 PM (MON THRU FRI)

***** Chemistry values reported on this document are not to be construed as certified or otherwise guaranteed by the producer *****

DELIVERY # 27234740

CUST PO # CLV-27277

MILL ORDER # 492840

ORDERED SIZE .1220 M X 48.0000 X CPH

ITEM # 60203435

GRADE 1010

MILL EDGE

ASTM ASTM A653

ROHS COMPLIANT

COATING WT NA
G90U

Subject to Section 7 of conditions of applicable bill of lading, if this shipment is to be delivered to the consignee without recourse to 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

NLMK
PENNSYLVANIA

(Signature of Consignor)

Received \$

to apply in prepayment of the charges on the property described hereon.

Agent or Cashier

Per

(The signature here acknowledges only the amount prepaid).

Charges Advanced

\$

Rate per Cwt.

Total Weight

43190

If Charges Are To Be Prepaid Write Here "Prepaid"

Prepay & Add

* 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 a carrier's or shipper's weight.
NOTE: Where the rate is dependent on value, shippers are required to state specifically in writing the agreed or declared value of the property.
The agreed or declared value is hereby
Specifically stated by the shipper to be not exceeding _____ per _____

NLMK PENNSYLVANIA, Shipper

Per DM Eu
Permanent post-office address of shipper,
15 Roemer Boulevard, Farrell, PA 16121

1

Agent, Per

The fiber boxes used for this shipment conform to the specifications set forth in the box maker's certificate thereon and all other requirements of the Consolidated Freight Classification

*Shipper's Imprints in lieu of stamp; not a part of Bill of Lading approved by the Interstate Commerce Commission

STRAIGHT BILL OF LADING - SHORT FORM - Original - Not Negotiable

RECEIVED: subject to the classifications and tariffs in effect on the date of the receipt by the carrier of the property described in the Original Bill of Lading

Shipper's No. **10259669**

NAME OF CARRIER **P.I. AND I. MOTOR EXPRESS**

12:35 Appt 13:29

Carrier's No. **2182**

GI PRIME FAR

PAYMENT AUTH # **A4105355**

At **SHARON, PA**

AUGUST 19, 2020

From **NLMK PENNSYLVANIA**

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 the contract as meaning any person or corporation in possession of 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 the route to said destination. It is mutually agreed, as to each carrier of all or any of said property over all or any portion of said route to destination, and as to 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 Classification 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 motor carrier shipment.

Shipper hereby certifies that he is familiar with all the terms and conditions of the said bill of lading, including those on the back thereof, set forth in the classification or 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. Carrier is responsible for taping of loads.

CONSIGNEE TO **JEMISON-DEMSEY, LLC**

8100 AETNA ROAD

DESTINATION **CLEVELAND**

STATE **OH, 44105**

County

Route **TRUCK-EYE TO SIDE (TARP) -- REC'G HRS 7:00 AM - 2 PM (MON THRU FRI)**

***** Chemistry values reported on this document are not to be construed as certified or otherwise guaranteed by the producer *****

DELIVERY # **26169713**

CUST PO # **CLV-27249**

MILL ORDER # **492001**

ORDERED SIZE **.0670 M X .48.0000 X CCIL**

ITEM # **60702353**

GRADE **1005**

MILL EDGE

ASTM **ASTM A653**

ROHS COMPLIANT

COATING WT **NA**
G900

Subject to Section 7 of conditions of applicable bill of lading, if this shipment is to be delivered to the consignee without recourse to 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.

NLMK PENNSYLVANIA

(Signature of Consignor)

Received \$

to apply in prepayment of the charges on the property described herein.

Agent or Cashier

Per

(The signature here acknowledges only the amount prepaid).

Charges Advanced

\$

Rate per Cwt.

Total Weight

42780

If Charges Are To Be Prepaid Write Here "Prepaid"

Prepay & Add

* 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 a carrier's or shipper's weight.
NOTE: Where the rate is dependent on value, shippers are required to state specifically in writing the agreed or declared value of the property.
The agreed or declared value is hereby
Specifically stated by the shipper to be not exceeding _____ per _____

NLMK PENNSYLVANIA, Shipper

Per

DMU

Permanent post-office address of shipper.

15 Roanoke Boulevard, Farroll, PA 16121

Agent, Per

1

REQUEST FOR INVOICE														
INSTRUCTIONS JEMISON METALS ACKN PO REPT ONLINE AT EPROCUREMENT OR SEND TO LERTPOACK@VERTIV.COM AND COPY PLANNER EMAIL NOTED BELOW ADVANCE SHIP NOTICES CAN BE SENT TO LERTASN@VERTIV.COM			CONSIGNMENT MATERIAL - DO NOT SHIP! - THIS IS NOT A PO! - DO NOT SHIP! - THIS IS NOT A PO! - DO NOT SHIP! - THIS IS NOT A PO! - DO NOT SHIP! - THIS IS NOT A PO! - DO NOT SHIP! - THIS IS NOT A PO! - DO NOT SHIP! - THIS IS NOT A PO! - DO NOT SHIP! - THIS IS NOT A PO!			BILL TO ADDRESS >PREFERRED: SEND INVOICE AS PDF FILE TO VERTIV-NP-INVOICES@DATA-SERV-STL.COM EMAIL CAN HAVE MULTIPLE PDF FILES EACH PDF FILE MUST HAVE ONLY 1 INVOICE >OPTIONAL: SEND VIA US POSTAL SERVICE TO P.O. BOX 8629, ST LOUIS MO 63126 -FAX INVOICES NO LONGER ACCEPTED-			TODAY'S DATE 10/30/2020		OPENED DATE 10/30/2020		VENDOR V00065386	
REF NUMBER UB3579801														
LIEBERT HAS CONSUMED THE FOLLOWING CONSIGNMENT ITEMS IN TH QTY'S NOTED. PLEASE INVOICE LIEBERT FOR THE QTY'S AND PRICES LISTED THESE ITEMS WERE SHIPPED TO LIEBERT PREVIOUSLY PER OUR CONSIGNMENT PROGRAM PLEASE REFERENCE ABOVE REF NUMBER (UB3579801) ON YOUR INVOICE FOR PRICING/PURCHASING QUESTIONS CALL: BOB ROEHRER AT 614 8416981 OR EMAIL BOB.ROEHRER@VERTIV.COM IF YOU NEED ASSISTANCE WITH PORTAL, CONTACT XPO AT VERTIV@XPO.COM IF YOU HAVE RECEIVED THIS ADVISEMENT IN ERROR, PLEASE NOTIFY THE CONTACT PERSON IMMEDIATELY... THANK YOU!														
LINE	SCH#	REQ DATE	CONFIRM?	UOM	CONSUMED	OUR/YOUR PART NBR	DESCRIPTION/MFR#-MFR NAME	ENGINEERING DRAWING / BOM	CONSIGN	UNIT PRICE				
001	00	10/30/2020	N/A	EA	38	RS-5560	STEEL GALV .0680 X 48 X 84 G90 M00001366 BUYER OPTION PER SPE	ES-0011 REV 28 BOM: REV 000002	INVOICE	35.480				
002	00	10/30/2020	N/A	EA	153	RS-7072	STEEL GALV .0340 X 48 X 77 G90 M00001366 BUYER OPTION PER SPE	ES-0011 REV 28 BOM: REV 000000	INVOICE	20.289				
NOTICE: THIS TRANSACTION IS SALES TAX EXEMPT, UPON REQUEST PROPER CERTIFICATION WILL BE PROVIDED. TOTAL IN USD.....										4,452.59				

02Nov20 07:49

S A L E S O R D E R

No: CLV PI-989060

Sold By:

Jemison Metals - Cleveland

8100 Aetna Drive

Cleveland, OH 44105

Tel: 216-271-1500 Fax: 216-271-0013

Ship From:

Jemison Metals - Cleveland

8100 Aetna Drive

Cleveland, OH 44105

Sold To: (6886)

Vertiv Corporation-Columbus

Vertiv Corporation

PO Box 8629

St Louis, MO 63126

Ship To: (1)

Vertiv Corporation

1050 Dearborn Drive

Columbus, OH 43085

Trm NET 90 DAYS

Frt PREPAID FREIGHT

Slp Mary Margaret Brown

Con

Ord 30Oct20 Due 04Nov20 BILLING

Via MISC FREIGHT

FOB DESTINATION

PO/Rel UB3579801

Tel 614-888-0246 Fax 614-841-6882

S A L E S O R D E R

SO No

CLV PI-989060

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

1 Galvanized Sheet G90-U CS ROHS COMPLIANT 38 PCS 3159 LBS
14GA GALV 48(+.187/-0) X 84(+.500/-0)
Part No RS-5560

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

Ga Tol + 0.0030 - 0.0030 Pc/Tag 50

WthTol + 0.1870 - 0.0000 Wt/Skd 42C0

LthTol + 0.5000 - 0.0000 Ty JD7 Pk

WAVE:0.00-3.00

FLATN:0.00-.12

CAMB:0.00-.25

SQUA:0.00-.12

MATERIAL

38 PCS @

43.9800 PCS E

1,671.24

Sales Amt

1,671.24 Profit Amt

380.48 G.P%

32.50 N.P%

22.77

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

GVS/15C/CB90CD/48.0000"X84.0000"

LC68919 CLC

38 PCS 2965 LBS

TAGS MUST BE STAPLED TO THE SKID

MATERIAL MUST BE CAPABLE OF BEING BENT AT ROOM
TEMPERATURE IN ANY DIRECTION THROUGH 180 DEGREES
(FLAT ON ITSELF) WITHOUT CRACKING

END USE - FABRICATED PARTS

OVERHEAD CRANE UNLOAD

TAG THEO @ 83.13#/PC

ALL SKIDS 48" AND WIDER WITH 1 X 6 BOARDS MUST

HAVE 3 RUNNERS

2 GALVANIZED SHEET CS G90 153 PCS 5912 LBS
.0340 Min X 48.0000" X 77.0000"
Part No RS-7072

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

Ga Tol + 0.0020 - 0.0020 Pc/Tag 153

WthTol + 0.2500 - 0.0000 Wt/Skd 5950

LthTol + 0.7500 - 0.0000 Ty JD7 Pk

WAVE:0.00-3.00

FLATN:0.00-.12

CAMB:0.00-.31

02Nov20 07:49

S A L E S O R D E R

No: CLV PI-989060

Sold By:

Jemison Metals - Cleveland

8100 Aetna Drive

Cleveland, OH 44105

Tel: 216-271-1500 Fax: 216-271-0013

Ship From:

Jemison Metals - Cleveland

8100 Aetna Drive

Cleveland, OH 44105

Sold To: (6886)

Vertiv Corporation-Columbus

Ship To: (1)

Vertiv Corporation

S A L E S O R D E R

SO No

CLV PI-989060

SQUA:0.00-.12

MATERIAL

153 PCS @

21.4600 PCS E

3,283.38

Sales Amt

3,283.38 Profit Amt

408.21 G.P% 23.56 N.P% 12.43

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

GVS/21A/CB90CD/48.0000"X77.0000"

LC68802 CLC

153 PCS 5463 LBS

TAGS MUST BE STAPLED TO THE SKID

TOP BOARDS MUST BE 2 X 4'S

MATERIAL MUST BE CAPABLE OF BEING BENT AT ROOM
TEMPERATURE IN ANY DIRECTION THROUGH 180 DEGREES
(FLAT ON ITSELF) WITHOUT CRACKING

END USE - FABRICATED PARTS

OVERHEAD CRANE UNLOAD

TAG THEO @ 38.64¢/PC

ALL SKIDS 48" AND WIDER MUST

HAVE 3 RUNNERS

RECEIVING HOURS:

EFFECTIVE 2/27/12

1ST SHIFT - 6:30 AM - 2:00 PM MON-FRI

3RD SHIFT - 10:30 PM - 6:30 AM SUN - THURS

OVERHEAD CRANE UNLOAD

NEVER SHIP UNLESS ORDER IS COMPLETE - NO SHORTAGES

SKIDS WILL BE RETURNED TO US

Order Totals:

2 Items

9071 LBS

Sales Amt

4,954.62 Profit Amt

788.69 G.P% 26.58 N.P% 15.92

03Sep20 07:48

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

CLV 76253

Jemison Metals - Cleveland

8100 Acuna Drive

Cleveland, OH 44105

Tel: 216-271-1500 Fax: 216-271-0013

Job Type LEV Process

PWC CR2

Metric N Cust

Desc 988149 VERTIV

Due Date 08Sep20 Whs Clg

Setup 00:00 Run 01:30 Prtd By kathym

<<< JOB SPECIFICATIONS >>>

Group GVS Grade CB90CD Gauge 0.0710 (0.0680 to 0.0740) ID 0.0000

<<< ORDER SPECIFICATIONS >>>

F 01 GVS/15C/CB90CD/48.0000"X84.00/.0710N CS-B *90 CT DRY
Ord Clv 988149- 3 Cust VERTIV - COLS Ga 0.0710 Wth 48.0000 Lth 84.0000
Part 6886/RS-5560 Ga 0.0710 Wth 48.0000 Lth 84.0000
Ga Rng 0.0680to 0.0740 Pc/Tag 50
Wth/Pol + 0.1870 + 0.0000 Wt/Skd 4200
Lth/Pol + 0.5000 + 0.0000 Ty JD/ Pk
WAVE:0.00-3.00 FLATN:0.00-.12 CAMB:0.00-.25
SQUA:0.00-.12

48.25
OK per
Randy

TAGS MUST BE STAPLED TO THE SKID

MATERIAL MUST BE CAPABLE OF BEING BENT AT ROOM
TEMPERATURE IN ANY DIRECTION THROUGH 180 DEGREES
(FLAT ON ITSELF) WITHOUT CRACKING

END USE - FABRICATED PARTS

OVERHEAD CRANE UNLOAD

TAG THEO @ 83.13#/PC

ALL SKIDS 48" AND WIDER WITH 1 X 6 BOARDS MUST
HAVE 3 RUNNERS

F 02 GVS/15C/CB90CD/48.0000"X84.00/.0710N CS-B *90 CT DRY
Part 6886/RS-5560 Ga 0.0710 Wth 48.0000 Lth 84.0000
TOLERANCES - same as previous Order Item
WAVE:0.00-3.00 FLATN:0.00-.12 CAMB:0.00-.25
SQUA:0.00-.12

TAGS MUST BE STAPLED TO THE SKID

MATERIAL MUST BE CAPABLE OF BEING BENT AT ROOM
TEMPERATURE IN ANY DIRECTION THROUGH 180 DEGREES
(FLAT ON ITSELF) WITHOUT CRACKING

END USE - FABRICATED PARTS

OVERHEAD CRANE UNLOAD

TAG THEO @ 83.13#/PC

ALL SKIDS 48" AND WIDER WITH 1 X 6 BOARDS MUST
HAVE 3 RUNNERS

03Sep20 07:48

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

CLV 76253

Jemison Metals - Cleveland

<<< PROCESSING INSTRUCTIONS >>>

<Step 1>

Level To: 48.0000 X 84.0000 300 Pcs 24356 LBS 9999 Pcs/Tag

<<< MATERIAL TO BE USED >>>

Tag No Whs Gauge Width Length PCS Weight Heat Number Locn

<GVC/15B/C90CDR>

DU22430 CPW 0.0670M 48.0000 1 42780 NLMUSHT00056 A-17

Rmks: 1.111BERT - COLS

Total: 1 42780

<<< MATERIAL TO BE SHIPPED >>>

01 Ord CLV 988149- 3 Cust VERTIV - COLS Part RS-5560

Galvanized Sheet G90-U CS ROHS COMPLIANT Pcs/Tg 50 Bal 300 Pcs

14GA GALV 48(+.187/-0) X 84(+.500/-0) DucDt 09Sep20 24,941 LBS

QB3570200-028

Item Rmks: S *****

RECEIVING HOURS:

EFFECTIVE 2/27/12

1ST SHIPT - 6:30 AM - 2:00 PM MON-FRI

3RD SHIPT - 10:30 PM - 6:30 AM SUN - THURS

OVERHEAD CRANE UNLOAD

NEVER SHIP UNLESS ORDER IS COMPLETE - NO SHORTAGES

SKIDS WILL BE RETURNED TO US

Con Tag	Whs	Tag No	Whs T	Gauge	Width	Length	OD	Pcs	Weight
DU22430	CPW	LC65586	CFG F	0.0710	48.0000	84.0000		50	4,059
		LC65587	CFG F	0.0710	48.0000	84.0000		50	4,059
		LC65588	CFG F	0.0710	48.0000	84.0000		50	4,059
		LC65589	CFG F	0.0710	48.0000	84.0000		50	4,059
		LC65590	CFG F	0.0710	48.0000	84.0000		50	4,059
		LC65591	CFG F	0.0710	48.0000	84.0000		50	4,059
Total	No Tags	6						300	24,354

<<< MATERIAL TO STOCK >>>

Cons Tg

Sp	Prod	Tg	Whs	Ty	Gauge	Width	Length	OD	PCS<Prn>WL	PCS<Res>WL
DU22430										
2	265593	CFG F	0.0710	48.0000	84.0000		50	4059		
2	265594	CFG F	0.0710	48.0000	84.0000		50	4059		
2	265595	CFG F	0.0710	48.0000	84.0000		50	4059		
2	265596	CFG F	0.0710	48.0000	84.0000		50	4059		
2	265597	CFG F	0.0710	48.0000	84.0000		19	1543		
Total:							219	17,779		

<<< JOB RECAP >>>

	PCS	Weight	Scrap	Scrap %	Unactd Scr %
Material Allocated	1	42,780			
Master Returns					
Returns to Stock					
Work in Process					

03Sep20 07:48

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

CIN 76253

Jemison Metals - Cleveland

=====

Material to be Shipped	519	42,133		
Rejects				
Net Weight to be Produced	519	42,133	647	1.51

START TIME: _____ STOP TIME: _____

03Sep20 07:48

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

CIV 76253

Jemison Metals - Cleveland
8100 Aetna Drive
Cleveland, OH 44105

Job Type LEV Process PWC CR2
Metric N Cust
Desc 988149 VERTTV
Due Date 08Sep20 Whs CFG
Setup 00:00 Run 01:30 Prtd By kathym

=====

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<GVC/15B/C90CDR>								
DU22430	CPW	0.0670M	48.0000		1	42780	NIMUSHT00056	A-17
Rmks: LIEBERT - COLS				Total:	1	42780		

AGT400 Coil Summary Report

Jemison Metals -- 75 Inch Red Bud CTL Line

Work Order: 76253 Coil Number: DU22430

Customer Name: VERTIV Heat Number: NLMUSHT00056 Vendor: NLMK

Product: G90 Galvanized Sep-10-20 7:11 AM to 8:05 AM (clock 54.1 min/ run 31.9 min) Shift: 1

Average Thickness and Tolerance Data

Target	Average*	68.0 mil	Average - Target	-2.5500 mil (-3.59%)
			Standard Deviation*	0.4300 mil (0.61%)
Length	3781 ft	Above High Limit	74.0 mil	0 ft (0.0%)
Width	48.250 in	In Tolerance		
Weight	42562 lbs	Below Low Limit	68.0 mil	565 ft (14.7%)
Max Thickness	69.6 mil at 3462 ft	Min Thickness	67.0 mil at 3692 ft	
Head Scrap	21 ft	Tail Scrap	24 ft	

Statistical Process Control Data

CR	43.0%	(Capability Ratio %, 100/CP)		
CP	2.326	(Process Capability, HiLim-LoLim/6*Sigma)		
CPK	0.349	(Capability vs Limits)	TMW Ratio	0.993 (Low Limit/Avg)

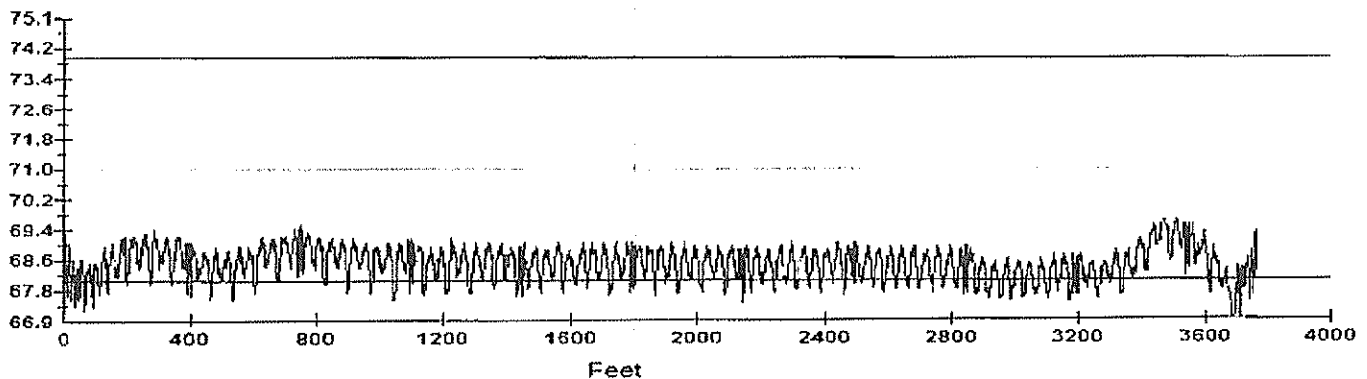
Thickness Distribution Relative to the Target

+++	0.0%
+10.0	0.0%
+ 9.0	0.0%
+ 8.0	0.0%
+ 7.0	0.0%
+ 6.0	0.0%
+ 5.0	0.0%
+ 4.0	0.0%
+ 3.0	0.0%
+ 2.0	0.0%
+ 1.0	0.0%
0.0	0.0%
- 1.0	0.0%
- 2.0	0.0%
- 3.0	0.0%
- 4.0	14.7%
- 5.0	0.0%
- 6.0	0.0%
- 7.0	0.0%
- 8.0	0.0%
- 9.0	0.0%
-10.0	0.0%
---	0.0%

0 3 6 9 12 15 18 21 24 27 30 33 %

10.0% is within ± 2.0000 mil of the target 100.0% is within ± 5.0000 mil of the target
100.0% is within ± 10.0000 mil of the target 100.0% is within ± 20.0000 mil of the target

Thickness vs Length (Coil Number DU22430)



Gauge readings provided by Advanced Gauging Technologies, L.L.C. Plain City, OH 43064 USA Tel: (614) 873-6691

Johnson Metals - Cleveland

20Aug20

JU22430

Loc: A-17
Std:
Whts: CPW

653 GALVANIZED COIL CS-B *90 CT
DRY ROHS

0670 Min X 48.0000"

1 PCS 42,780 LBS

Receiving Info

Applier NLMK (# 833) Mst Prn
Jpl Tag 8008919 By sandy
J 27249-001 RC 52179-002 Job 0 LBS

< Qty 42,780 LBS Th Qty 0 LBS

Specifications

Heat No : NLM USHT0056
Spec :

Condition :
Tolerance Min: 0.0000 Max : 0.0000
Width Min: .0000 Max : .0000
Length Min: .0000 Max : .0000
D: 0D: 3831 FT Typ:A

Chemistry : C=0.0500 Mn=0.2300 P=0.0120 S=0.0030
Si=0.0010 N=0.0040 Cr=0.0370 Mo=0.0030
Cu=0.0150 Al=0.0350 V=0.0020 Ti=0.0020
Ni=0.0300 Nb=0.0020 Ca=0.0002 Sn=0.0010
Remarks : LIEBERT - COLS



JU22430

Quality Checklist

Date: 9/10/20 Customer: Vertiv

Work Order #: 76253

Machine #: CR2

Master Tag #: B422430 Tag Weight: 42.780

Type: SVC 90

Ordered RB:

Gauge Tolerance				Width Tol:	Length Tol:	Square Tol:	Flatness Tol:	Inspected By (Initials):		Date
Skid Tag #	Edge	Gauge Crown	Edge	Width	Length	Square	Flatness			
068-074				48 +1870-0	84 +50-0	12	12			
0685586	0685	0685	068	48.25	84.062	062	<12	MC	EB	9/10/20
Last piece of 1st bundle	0685	0685	068	48.25	84.062	062	<12	MC	EB	9/10/20

Skid Tag #	Edge	Gauge Crown	Edge	Width	Length	Square	Flatness	Inspected By (Initials):		Date
0685588	0685	0685	068	48.25	84.062	062	<12	MC	EB	9/10/20
0685590	0685	0685	068	48.25	84.062	062	<12	MC	EB	9/10/20
0685591	0685	0685	068	48.25	84.062	062	<12	MC	EB	9/10/20
0685594	0685	0685	068	48.25	84.062	062	<12	MC	EB	9/10/20

Skid Tag #	Edge	Gauge Crown	Edge	Width	Length	Square	Flatness	Inspected By (Initials):		Date
0685597	0685	0685	068	48.25	84.062	062	<12	MC	EB	9/10/20
Last piece of last bundle	0685	0685	068	48.25	84.062	093	<12	MC	EB	

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

No: CLV 126813

Ship From:
Jemison Metals - Cleveland
8100 Aetna Drive
Cleveland, OH 44105
Tel: 216-271-1500 Fax: 216-271-0013

Ship Date 02Nov20 at 13:31 From CFG
Probill
Via MISC FREIGHT
FOB DESTINATION
Frt PREFAID FREIGHT
Route 290- 0 Manifest
Vncle Trailer
Slp Mary Margaret Brown
Sold To: (6886)
Vertiv Corporation-Columbus
Vertiv Corporation
PO Box 8629
St Louis, MO 63126

Ship To: (1)
Vertiv Corporation
1050 Dearborn Drive
Columbus, OH 43085
Tel: 614-888-0246 Fax: 614-841-6882

Con

Tel 614-888-0246 Fax 614-841-6882

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

1) Our Order CLV-989060- 1 Your PO # UB3579801
Part # RS-5560 Rel #

Galvanized Sheet G90-U CS RCHS COMPLIANT
14GA GALV 48(+.187/-0) X 84(+.500/-0)

Heat Number	Tag No	Quantity	PCS	Wt LBS
USHT00056	LC68919		38	3159

2) Our Order CLV-989060- 2 Your PO # UB3579801
Part # RS-7072 Rel #

GALVANIZED SHEET CS G90
.0340 Min X 48.0000" X 77.0000"

Heat Number	Tag No	Quantity	PCS	Wt LBS
CSP19A026186	LC68802		153	5912

TOTAL:	Tags	PCS	LBS
	2	191	9071

Heat Number
CSP19A026186

*** Chemical Analysis ***

C=0.0300 Mn=0.2500 P=0.0130 S=0.0080 Si=0.0300 N=0.0040
Cr=0.0200 Cu=0.0400 Al=0.0370 Ti=0.0020 Ni=0.0100 Sn=0.0020
B=0.0002

USHT00056

C=0.0500 Mn=0.2300 P=0.0120 S=0.0090 Si=0.0010 N=0.0040
Cr=0.0370 Mo=0.0030 Cu=0.0160 Al=0.0360 V=0.0020 Ti=0.0020
Ni=0.0300 Nb=0.0020 Ca=0.0002 Sn=0.0010 B=0.0002

RECEIVING HOURS:

Page: 1Continued

B I L L O F L A D I N G		No: CLV 126813
Ship From:	Jemison Metals - Cleveland	Ship Date 02Nov20 at 13:31 From CFG
	8100 Aetna Drive	Probill
	Cleveland, OH 44105	Via MISC FREIGHT
Tel: 216-271-1500	Fax: 216-271-0013	FOB DESTINATION
		Frt PREPAID FREIGHT
		Route 290- 0 Manifest
		Vhcle Trailer
		Slp Mary Margaret Brown
Ship To: (1)	Vertiv Corporation	Sold To: (6886)
Con		Vertiv Corporation-Columbus
		Tel 614-888-0246 Fax 614-841-6882

=====

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

EFFECTIVE 2/27/12

1ST SHIFT - 6:30 AM - 2:00 PM MON-FRI

3RD SHIFT - 10:30 PM - 6:30 AM SUN - THURS

OVERHEAD CRANE UNLOAD

NEVER SHIP UNLESS ORDER IS COMPLETE - NO SHORTAGES

SKIDS WILL BE RETURNED TO US

>>PROTECT FROM WEATHER / ALL LOADS TO BE TARPED<<

ALL TIMES NOTED ARE CENTRAL STANDARD TIME

CALIBRATION/ VERIFICATION SHEET

Jenison
METALS

INSTRUMENT
CALIBRATED/ VERIFIED: Caliper
*indicate appropriate action(s)

INSTRUMENT ID# 180

AS FOUND PHYSICAL GOOD
CONDITION:

ACTION TAKEN: 3-MONTH CHECK

STANDARD SERIAL #:	KNOWN VALUE:	AS FOUND READINGS:	VERIFICATION
<u>1</u>	<u>1.000</u>	<u>1.000</u>	<u>1.000</u>
<u>12</u>	<u>12.000</u>	<u>12.000</u>	<u>12.000</u>
<u>24</u>	<u>24.000</u>	<u>24.000</u>	<u>24.000</u>
<u>090051</u>	<u>3.000</u>	<u>3.000</u>	<u>3.000</u>
<u>050300</u>	<u>3.250</u>	<u>3.250</u>	<u>3.250</u>
<u>090337</u>	<u>3.500</u>	<u>3.500</u>	<u>3.500</u>

TEMPERATURE: Ambient

HUMIDITY: Ambient

VERIFIED BY L. Stringle

DATE: 12-2020

ISSUED TO: RBI 2

DUE DATE 3-21

Allowable Deviation:
Calipers = $\pm .001$ "
Micrometers = $\pm .001$ "
Tape Measure = $\pm .03125$ "

Extra Caliper Measurements where applicable
*inside
**depth
***step

CALIBRATION/ VERIFICATION SHEET

JENKINSON
METALS

INSTRUMENT
CALIBRATED/ VERIFIED: Micrometer
*indicate appropriate action(s)

INSTRUMENT ID# ASP016

AS FOUND PHYSICAL Good
CONDITION:

ACTION TAKEN: MONTHLY CHECK

STANDARD
SERIAL #:

KNOWN VALUE:

AS FOUND READINGS:

VERIFICATION

980157

.100

.100

.100

970914

.500

.500

.500

TEMPERATURE: Ambient

HUMIDITY: Ambient

VERIFIED BY C. Strimple

DATE: 12-2020

ISSUED TO: RBI 2

DUE DATE 1-2021

Allowable Deviation:

Calipers = $\pm .001"$

Micrometers = $\pm .001"$

Depth Measure = $\pm .03125"$

Extra Caliper Measurements where applicable

"Inside

"depth

"step

MAINTENANCE 01 REV.03 11/ Nov-17

JEMISON METALS
MANLIFT SAFETY INSPECTION CHECKLIST
MONTHLY INSPECTIONS

CHECKLIST ;	MONTH <u>Nov</u>	YEAR <u>2020</u>	<u>GOOD</u>	<u>NEEDS REPAIR</u>
RAILS			<u>✓</u>	<u> </u>
RAIL SUPPORTS			<u>✓</u>	<u> </u>
ROLLERS, SLIDES			<u>✓</u>	<u> </u>
BELTS , BELT TENSION			<u>✓</u>	<u> </u>
HANDHOLDS AND FASTENINGS			<u>✓</u>	<u> </u>
FLOOR LANDING			<u>✓</u>	<u> </u>
GUARDRAILS			<u>✓</u>	<u> </u>
LUBRICATION			<u>✓</u>	<u> </u>
SAFETY SWITCHES			<u>✓</u>	<u> </u>
WARNINGS LABELS AND LIGHTS			<u>✓</u>	<u> </u>
DRIVE PULLEY			<u>✓</u>	<u> </u>
MOTOR			<u>✓</u>	<u> </u>
DRIVE MECHANISM			<u>✓</u>	<u> </u>
DRIVE WHEELS OR TRACTION			<u>✓</u>	<u> </u>
ELECTRICAL SWITCHES			<u>✓</u>	<u> </u>
EXIT DOOR			<u>✓</u>	<u> </u>
EMERGENCY STOPS			<u>✓</u>	<u> </u>
MAXIMUM RATED LOAD SIGN			<u>✓</u>	<u> </u>
COMMENTS	<u> </u>			<u> </u>
	<u> </u>			<u> </u>
	<u> </u>			<u> </u>
	<u> </u>			<u> </u>

MAINTENANCE PERFORMED BY

R. LADON

APPROVED BY

11-2020

JEMISON METALS
US INDUSTRIAL MACHINERY SHEAR
MODEL # US 1025 CNC PSS
SERIAL # J2 005-151

GREASE CONVEYOR BEARINGS	<u>✓</u>
CHECK HYDRAULIC FLUID IN RESERVOIR	<u>✓</u>
GREASE ALL GREASE POINTS ON SHEAR	<u>✓</u>
INSPECT SAFETY GUARDS	<u>✓</u>
CHECK FOR OIL AND AIR LEAKS	<u>✓</u>
CHECK FOOT PEDALS	<u>✓</u>
CHECK ELECTRICAL CONNECTIONS	<u>✓</u>
CHECK CLUTCH AND BRAKE	<u>✓</u>

MAINTENANCE BY B. LADON

APPROVED BY ME

DATE 11-2020

COMMENTS _____

11/16/2017

RBI 2
PREVENTATIVE MAINTENANCE

page1-3

SECTION ONE
POWER UNIT

	CHECK
CHECK HYDRAULIC OIL LEVELS	<u>✓</u>
CHECK THAT PRESSURE EQUALS LABEL	<u>✓</u>
CHECK IF COOLER & BLOWER ARE CLEAN AND WORKING	<u>✓</u>
CHECK OIL FILTER PRESSURE GAUGE, CHANGE FILTER AS NEEDED	<u>✓</u>
CHECK ACCUMULATOR CHARGE PRESSURE & RECHARGE IF NEEDED (900 PSI)	<u>✓</u>

COIL STAGE AND LIFT

GREASE AXEL BEARINGS AND VERTICAL GIBBS	<u>✓</u>
OIL CHAIN	<u>✓</u>
CHECK CHAIN TENSION	<u>✓</u>

REEL

GREASE MANDREL WHILE EXPANDING AND CONTRACTING	<u>✓</u>
CHECK THAT GREASE IS SEEN AT SHOE SLIDES	<u>✓</u>
OIL CHAINS	<u>✓</u>
CHECK CHAIN TENSION	<u>✓</u>
CHECK BRAKE SHOES FOR WEAR	<u>✓</u>
GREASE MANDREL BEARINGS	<u>✓</u>
GREASE TRAVERSING BASE AXLES	<u>✓</u>
CHECK CHAIN TENSION TRAVERSING BASE	<u>✓</u>

TIGHTEN ALL BOLTS IF FOUND TO BE LOOSE
CHECK HYDRAULIC FITTINGS AND CLAMPS FOR TIGHTNESS

COMMENTS (PRINT)

TECH PERFORMING TASKS B. LADO

DATE 11-20-20

APPROVED BY [Signature]

***** ELECTRICAL SWITCHGEAR TO BE INSPECTED *****
ANNUAL

BREAKERS SHOULD BE OPENED AND CLOSED SEVERAL TIMES MANUALLY
ENCLOSURES SHOULD BE OPENED FOR CLEANING AND TIGHTENING OF ALL CONNECTIONS
FOR FUSED SWITCHES A THERMOGRAPHIC INSPECTION WITH INSPECTION OF BLADE
BARRIERS AND BOLTS FOR TIGHTNESS
A THERMOGRAPHIC INSPECTION TO BE PERFORMED EVERY THREE YEARS

PREVENTATIVE MAINTENANCESECTION TWOPEELER BREAKER

GREASE GAUGING ROLLS
 CLEAN AND OIL LEAD SCREWS
 OIL SLIDES

CHECKPINCH ROLLS

GREASE ROLLS

MOTOR GRIP FEED

CHECK ACCUMULATOR PRESSURE RECHARGE IF NEEDED (900 PSI)
 CHECK AIR FILTER (MAKE SURE IT IS DRAINED)
 CHECK THAT FEED CYCLE, STRAIGHTENER LIGHTS WORK
 GREASE DUAL MOTOR CLUTCH AND BEARING
 CLEAN AND OIL ALL GUIDES, SCREWS AND SHAFTS
 GREASE DRIVE SHAFTS
 OIL CHAINS
 CHECK CHAIN TENSION
 CHECK LENGTH ADJUSTMENT WITH STANDARD
 CHECK DRIVE BELT TENSION
 TIGHTEN ALL LOOSE BOLTS, TIGHTEN HYDRAULIC HOSE CLAMPS

SLITTER HEAD

GREASE SLITTER ARBOR BEARINGS
 GREASE DRIVE SHAFT BEARINGS
 GREASE KNIFE BACK UP BEARINGS
 GREASE LEAD SCREW THRU-JST BEARINGS
 CLEAN , OIL UPPER AND LOWER KNIFE BACKUP GIBBS
 CLEAN , OIL GAGE LOCATORS AND LEAD SCREW

SCRAP WINDERS

REMOVE ALL EXCESS SCRAP ON WINDER
 GREASE BEARINGS
 OIL TRAVERSING ARM SLIDES
 OIL PIVOT POINTS

COMMENTS (PRINT)

TECH PERFORMING TASKS

DATE 1/20/20

APPROVED BY

R. LADDAW

W

PREVENTIVE MAINTENANCE

SECTION THREE

SHEAR

OIL GIBBS
GREASE PINCH ROLL BEARINGS
CHECK PINCH ROLL SPRINGS
CHECK PINCH ROLL CHAIN TENSION
GREASE SWIVEL BASE

CHECK

✓
✓
✓
✓
✓

STRIP STACKER

CLEAN AND OIL DIVIDER GIBBS
CLEAN OIL , AND ADJUST POWER LEAD SCREWS AND ARM SLIDES

✓
✓

STACK TABLE

GREASE BEARINGS

✓

VOSS

GREASE JACKS
INSPECT DRIVE SHAFTS FOR BROKEN SHAFTS
INSPECT ROLLS FOR WEAR
INSPECT GEAR BOX, SEMI ANNUALLY

✓
✓
✓
✓

ROLLOUT

CLEAN AND OIL CENTER SLIDE, SHAFTS, AND SCREWS
CHECK CHAIN TENSION

TIGHTEN ALL LOOSE BOLTS
TIGHTEN ALL HYDRAULIC CLAMPS AND FITTINGS

✓
✓

✓
✓

COMMENTS (PRINT)

TECH PERFORMING TASKS

B. Ladd

DATE

11/20/20

APPROVED BY

W

***** ANNUAL GEAR BOX INSPECTION TO INCLUDE- OIL VISCOSITY, ACID CONTENT, ELEMENTAL WEAR METALS FERROGRAPHY AND MOISTURE

BANDING LINE
PREVENTATIVE MAINTENANCE

SECTION ONE

DISASSEMBLE SEALER MECHANISM
REMOVE ALL DIRT FROM UPPER AND LOWER GUIDE BLOCKS
LUBRICATE GUIDE SLOTS IN GUIDE BLOCKS
CLEAN ALL PARTS AND INSPECT
ASSEMBLE THE SEALER MECHANISM
CLEAN TEETH OF THE TRACTION WHEEL
CHECK OIL LEVEL
GREASE ALL GREASE FITTINGS
GREASE TURNSTILE
CHECK TURNSTILE LIGHTS / HORN
CHECK TIME DELAY FOR FUNCTION
INSPECT UP ENDER FOR PROPER FUNCTION
GREASE UP ENDER
CLEAN UP ENDER AREA
INSPECT BANDING TABLE FOR PROPER FUNCTION
GREASE BANDING TABLE
CLEAN BANDING TABLE / AREA
INSPECT AIR FILTER , REGULATOR, LUBRICATOR (DRAIN WATER)
INSPECT HYDRAULIC UNIT (FLUID LEVEL)
CLEAN POWER UNIT / AREA

CHECK

COMMENTS (print)

TECH PERFORMING TASKS

DATE _____

APPROVED BY

TIGHTEN ALL LOOSE BOLTS
TIGHTEN ALL HYDRAULIC FITTINGS AND CLAMPS

ELECTRICAL SWITCH GEAR TO BE INSPECTED

TO INCLUDE- TIGHTEN ALL WIRE CONNECTIONS, CHECK BLADE SEPARATORS, BLADE ALIGNMENT, CHECK BOLTED CONNECTIONS FOR TIGHTNESS AND RE-TORQUE AS NEEDED , CHECK FUSE HOLDERS FOR CORROSION AND TIGHTNESS, VACUUM CABINET AND DIELECTRIC GREASE AS NEEDED
A THERMOGRAPHIC INSPECTION TO BE PREFORMED EVERY THREE YEARS

PREVENTATIVE MAINTENANCESECTION ONEPOWER UNITCHECK

CHECK HYDRAULIC OIL LEVEL
 CHECK THAT PRESSURE EQUALS LABEL
 CHECK IF COOLER AND BLOWER ARE CLEAN AND WORKING
 CHECK OIL FILTER PRESSURE GAUGE, FILTER
 CHECK ACCUMULATOR CHARGE AND RECHARGE IF NEEDED
 900 PSI

✓
 ✓
 ✓
 ✓
 ✓

REEL

GREASE MANDREL
 CHECK THAT GREASE IS SEEN ON SHOE SLIDES
 OIL CHAIN
 CHECK CHAIN TENSION
 CHECK BRAKE PADS
 GREASE MANDREL BEARINGS
 GREASE TRAVERSING BASE AXLES
 CHECK CHAIN TENSION TRAVERSING BASE

✓
 ✓
 ✓
 ✓
 ✓
 ✓
 ✓

PEELER BREAKER

GREASE GAUGING ROLLS
 CLEAN AND OIL LEAD SCREWS
 OIL SLIDES
 TIGHTEN ALL LOOSE BOLTS
 TIGHTEN ALL HYDRAULIC CLAMPS AND FITTINGS

✓
 ✓
 ✓
 ✓

COMMENTS (PRINT)

TECH PERFORMING TASK

B. LADDAW

DATE

11-2020

APPROVED BY

MELECTRICAL SWITCH GEAR TO BE INSPECTED

TO INCLUDE - TIGHTEN ALL WIRE CONNECTIONS, CHECK BLADE SEPARATORS, BLADE ALIGNMENT, CHECK
 BOLTED CONNECTIONS FOR TIGHTNESS AND RE-TORQUE AS NEEDED, CHECK FUSE HOLDERS FOR
 CORROSION AND TIGHTNESS, VACUUM CABINET AND DIELECTRIC GREASE AS NEEDED
 A THERMOGRAPHIC INSPECTION TO BE PERFORMED EVERY THREE YEARS

RBI 1
PREVENTATIVE MAINTENANCE

MAINTENANCE 01 REV.3 11/16/2017

SECTION TWO
STRAIGHTENED

CHECK

GREASE ROLLS
GREASE PINCH ROLL BACKUP ROLLS
GREASE GAUGING ROLLS
OIL CHAINS
CHECK CHAIN TENSION

✓
✓
✓
✓
✓

EDGE TRIMMER

GREASE SPINDLE BEARINGS
OIL CHAINS
CHECK CHAIN TENSION

✓
✓
✓

STRETCHER LEVELER

GREASE RAM GIBBS
GREASE GIBBS ON STRETCH CYLINDERS
GREASE WHEEL BEARINGS

✓
✓
✓

GRIP FEED

CHECK ACCUMULATOR CHARGE PRESSURE (900 PSI)
FILL AIR LUBRICATOR
CHECK AIR FILTER (MAKE SURE IT IS DRAINED)
CLEAN AND OIL ALL GUIDES, SCREWS, AND SHAFTS
GREASE DRIVE SHAFTS
OIL CHAINS
CHECK CHAIN TENSION
CHECK LENGTH WITH STANDARD
CHECK FEED MOTOR COUPLING ON DRIVE AND LUBE

✓
✓
✓
✓
✓
✓
✓
✓
✓

TIGHTEN ALL LOOSE BOLTS
TIGHTEN ALL HYDRAULIC CLAMPS AND FITTINGS

✓

COMMENTS (PRINT)

TECH PERFORMING TASKS

DATE 11-26-20

APPROVED BY

B. Ladd
[Signature]

PREVENTATIVE MAINTENANCESECTION THREESHEAR

OIL GIBBS

CHECK

STRIP STACKER

CLEAN AND OIL DIVIDER GIBBS

CLEAN, OIL AND ADJUST POWER LEAD SCREWS

OIL ARM SLIDES

STACK TABLE

GREASE BEARINGS

ROLLOUTCLEAN AND OIL CENTER SLIDE, SHAFTS AND SCREWS
CHECK CHAIN TENSIONSLITTER HEAD

GREASE SLITTER ARBOR BEARINGS

GREASE DRIVE SHAFT BEARINGS

GREASE KNIFE BACKUP ROLLER BEARINGS

GREASE LEAD SCREW THRUST BEARINGS

CLEAN AND OIL UPPER AND LOWER BACKUP GIBBS

SCRAP WINDERS

REMOVE ALL EXCESS SCRAP ON WINDERS

GREASE BEARINGS

OIL PIVOT POINTS

COMMENTS (PRINT)

TECH PERFORMING TASKS

DATE

11/20/20

APPROVED BY

TIGHTEN ALL LOOSE BOLTS

TIGHTEN ALL HYDRAULIC CLAMPS AND FITTINGS

AIR COMPRESSOR
PREVENTATIVE MAINTENANCE

SECTION ONE

CHECK DISCHARGE PUMP FROM HOLDING TANK
DRAIN WATER FROM HOLDING TANK
CHECK AIR FILTER
CHECK SEPARATOR FOR OIL
CHECK SEPARATOR.
MAKE SURE THAT AIR COMPRESSOR CYCLES OFF OF 120 PSI

CHECK

✓
✓
✓
✓
✓
✓

IF NEEDED

CHANGE AIR FILTER
CHANGE SEPARATOR
CHANGE COMPRESSOR OIL
CHANGE OIL FILTER
REMOVE AND CLEAN RADIATOR
CLEAN AIR COMPRESSOR

✓
✓
✓
✓
✓
✓

SECTION TWO

CHECK SUMP PRESSURE
CHECK LINE PRESSURE
CHECK LINE DISCHARGE FOR PRESSURE
DRAIN 55 GALLON DISCHARGE DRUM

✓
✓
✓
✓

COMMENTS

print

TECH PERFORMING TASKS

R. Ladd

DATE

11-2020

APPROVED BY

[Signature]

***** REMOVE RUST BUILDUP FROM ALL PUMPS AND DISCHARGE LINES

✓

ELECTRIC SWITCH GEAR TO BE INSPECTED

TO INCLUDE- TIGHTEN ALL WIRE CONNECTIONS, CHECK BLADE SEPERATORS ,BLADE ALIGNMENT CHECK BOLTED CONNECTIONS FOR TIGHTNESS AND RE-TORQUE AS NEEDED, CHECK FUSE HOLDERS FOR CORROSION AND TIGHTNESS, VACUUM CABINET AND DIELECTRIC GREASE AS NEEDED
A THERMOGRAPHIC INSPECTION TO BE PREFORMED EVERY THREE YEARS

PAXSON
PREVENTATIVE MAINTENANCE

SECTION ONE

COIL CAR

CHECK FLUID LEVEL
INSPECT FOR FLUID LEAKS
INSPECT FOR PROPER FUNCTION
INSPECT ELECTRICAL WIRING
INSPECT ELECTRICAL WIRING TAKE-UP
GREASE COIL CAR

CHECK

✓
✓
✓
✓
✓

UNCOILER

INSPECT FOR PROPER FUNCTION
CHECK FOR HYDRAULIC LEAKS
GREASE UNCOILER
CHECK WATER LEVEL IN BRAKE

✓
✓
✓
✓

SHEAR

INSPECT FOR PROPER FUNCTION
GREASE ENTRANCE ROLL
GREASE SHEAR
INSPECT FOR LEAKS

✓
✓
✓
✓

SLITTER

GREASE SLITTER
LUBRICATE SLITTER DRIVE
CHECK SLITTER TOLERANCES
INSPECT SLITTER ENTRANCE TABLE

✓
✓
✓
✓

PIT THREAD TABLE

INSPECT FOR PROPER FUNCTION
INSPECT LIFT MOUNT AND PINS
LUBRICATE

✓
✓
✓

TIGHTEN ALL LOOSE BOLTS

TIGHTEN ALL HYDRAULIC CLAMPS AND FITTINGS

COMMENTS (PRINT)

TECH PERFORMING TASKS

R. LADDA

DATE

11-2020

APPROVED BY

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ANNUAL GEAR BOX INSPECTION TO INCLUDE

OIL VISCOSITY, ACID CONTENT, ELEMENTAL WEAR METALS, FERROGRAPHY AND MOISTURE

**PAXSON
PREVENTATIVE MAINTENANCE**

<u>SECTION TWO</u>	<u>CHECK</u>
<u>TENSION STAND</u>	
INSPECT FOR PROPER FUNCTION	<u>✓</u>
INSPECT AIR BAG	<u>✓</u>
LUBRICATE	<u>✓</u>
GREASE TENSION STAND EXIT ROLL	<u>✓</u>
<u>OVERARM</u>	
INSPECT FOR PROPER FUNCTION	<u>✓</u>
LUBRICATE	<u>✓</u>
<u>RECOILER</u>	
INSPECT FOR PROPER FUNCTION	<u>✓</u>
CHECK FOR LEAKS	<u>✓</u>
CLEAN AIR INTAKE FOR RECOILER MOTOR	<u>✓</u>
GREASE RECOILER	<u>✓</u>
INSPECT MOTOR AND COUPLING	<u>✓</u>
<u>ENTER / EXIT POWER UNIT</u>	
INSPECT FOR LEAKS	<u>✓</u>
CHECK PRESSURE SETTING (1200 - 1500 PSI)	<u>✓</u>
CHECK FILTER	<u>✓</u>
CHECK FLUID LEVELS	<u>✓</u>
<u>EDGE GUIDE</u>	
CHECK FOR PROPER FUNCTION	<u>✓</u>
LUBRICATE GUIDE BAR	<u>✓</u>
CLEAN LENS ON LIGHT / REPLACE PLEXIGLAS	<u>✓</u>
TIGHTEN ALL LOOSE BOLTS	
TIGHTEN ALL HYDRAULIC FITTINGS AND CLAMPS	<u>✓</u>
COMMENTS (PRINT)	

TECH PERFORMING TASKS R. LADON
 DATE 11-20-20 APPROVED BY [Signature] APPROVED BY [Signature]

ELECTRICAL CABINET INSPECTIONS

TO INCLUDE- TIGHTEN ALL WIRE CONNECTIONS, CHECK BLADE BARRIERS, BLADE ALIGNMENT, CHECK BOLTED CONNECTIONS FOR TIGHTNESS AND RE-TORQUE AS NEEDED. CHECK FUSE HOLDERS FOR CORROSION AND TIGHTNESS. VACUUM CABINET AND DIELECTRIC GREASE AS NEEDED
 A THERMOGRAPHIC INSPECTION TO BE PREFORMED EVERY THREE YEARS

LOOPCO
PREVENTATIVE MAINTENANCE

SECTION ONE

ENTER / EXIT COIL CAR

CHECK FLUID LEVEL
INSPECT FOR HYDRAULIC LEAKS
INSPECT FOR PROPER FUNCTION
INSPECT ELECTRICAL WIRING
INSPECT CHAIN TENSION
INSPECT HYDRAULIC IN/ OUT MOTOR MOUNTING BOLTS
GREASE COIL CAR
LUBE CHAIN

CHECK

✓
✓
✓
✓
✓
✓
✓

UNCOILER

INSPECT FOR PROPER FUNCTION
CHECK FOR HYDRAULIC LEAKS
DRAIN AIR LINES OF WATER
GREASE UNCOILER
CHECK WATER LEVEL OF BRAKE

✓
✓
✓
✓
✓

SHEAR

INSPECT FOR PROPER FUNCTION
GREASE ENTRANCE ROLLS
INSPECT ELECTRIC EYE (CLEAN LENS)
GREASE SHEAR

✓
✓
✓
✓

SLITTER

GREASE SLITTER
LUBRICATE GEARS
CHECK SLITTER TOLERANCES EVERY 6 MONTHS

✓
✓
✓

TIGHTEN ALL LOOSE BOLTS

TIGHTEN ALL HYDRAULIC FITTINGS AND CLAMPS

COMMENTS (PRINT)

TECH PERFORMING TASKS

DATE 11/20/20

APPROVED BY

R. Ladouceur

***** INSPECTION OF ALL ELECTRICAL CABINETS TO INCLUDE - TIGHTEN ALL WIRE CONNECTIONS . CHECK BLADE SEPARATORS, BLADE ALIGNMENT, CHECK BOLTED CONNECTIONS FOR TIGHTNESS AND RE-TORQUE AS NEEDED, CHECK FUSE HOLDERS FOR CORROSION AND TIGHTNESS. VACUUM CABINET AND DIELECTRIC GREASE AS NEEDED

GEAR BOX INSPECTION -

TO INCLUDE- OIL VISCOSITY, ACID CONTENT, ELEMENTAL WEAR METALS, FERROGRAPHY AND MOISTURE

ELECTRICAL

A THERMOGRAPHIC INSPECTION TO BE DONE EVERY THREE YEARS

LOOPCO
PREVENTATIVE MAINTENANCE

SECTION TWO

PIT THREAD TABLE

INSPECT FOR PROPER FUNCTION
INSPECT FOR CYLINDER MOUNT PINS & BOLTS
LUBRICATE

CHECK

TENSION STAND

INSPECT FOR PROPER FUNCTION
CHECK AIR VALVE FOR TIGHTNESS
CHECK FOR LEAKS
GREASE TENSION STAND EXIT ROLLER

OVERARM

INSPECT FOR PROPER FUNCTION
CHECK BOLT FOR TIGHTNESS
GREASE OVERARM

RECOILER

INSPECT DRIVE MOTOR
INSPECT FOR PROPER FUNCTION
CHECK FOR LEAKS
INSPECT BRAKE
INSPECT MOTOR COUPLING
GREASE RECOILER

..... CHECK OIL FOR VISCOSITY, ACID CONTENT, WEAR METALS- ANNUALL
..... INSPECT GEAR BOX , SEMI ANNUALLY

ENTER / EXIT POWER UNITS

INSPECT FOR LEAKS
INSPECT PRESSURE SETTING
CHECK OIL LEVELS
GREASE MOTORS

GAUGER

INSPECT FOR PROPER FUNCTION
GREASE GAUGER
INSPECT MAGNET
INSPECT FOR WORKING LIGHTS
INSPECT PHYSICAL CONDITION
INSPECT LABELING

COMMENTS (PRINT)

TECH PERFORMING TASKS

DATE 162020

APPROVED BY

R. LADON

[Signature]

CRANE MAINTENANCE REPORT

Monthly Inspection Report

Model Demas Location B-Bay Serial # 94-179
 Date 11/2/2020 Capacity 25-Ton

CONDITION CODES

A=Very Good B=Good C=Acceptable D=Fair(inspect & review periodically)
 E= Poor (repairs required) F=Further inspection required X=Unsafe (tagout)

RUNWAY:

Rail	<u>B</u>
J Bolts	<u>B</u>
End Stops	<u>B</u>
Splice Plates	<u>B</u>

General:

Floor Disconnect	<u>B</u>
Warning Labels	<u>B</u>
Load Marking	<u>B</u>
Control Labels	<u>B</u>
Pend. Cable	<u>B</u>
Conductors	<u>B</u>
Warning Devices	<u>B</u>

Brake Aerial Displacement KBA, KBF, SBA, KBS, SBS

71, 80, 90	.059 min.	.117 max.
100, 112	.070 min.	.136 max.
125, 140	.078 min.	.156 max.
160, 180, 200, 225	.089 min.	.175 max.

CRANE: KBA 125 Motor Type

Wheel	<u>B</u>
Bridge Brakes	<u>W 093 / E 093</u>
MCR	<u>B</u>
Collectors	<u>B</u>
Bumpers	<u>B</u>
Guarding	<u>B</u>
Cab	<u>B</u>

Brake Aerial Displacement KBH, KBF

71, 80, 90	.060 min.	.120 max.
100, 112	.070 min.	.140 max.
125, 140	.080 min.	.160 max.
160, 180, 200, 225	.090 min.	.180 max.

TROLLEY:

KBA 112 Motor Type

Shaft	<u>B</u>
Frame	<u>B</u>
Brakes	<u>093</u>
Stops	<u>B</u>
Wheels	<u>D</u>

Brake Aerial Displacement
 KMH .070 min. - 138 max.
 KMF (80-90) .060 min. .118 max.
 KMF (100) .070 min. .137 max.

MF056

REV 3 Date June 6, 2001

CRANE MAINTENANCE REPORT

Monthly Inspection Report

Model Demas Location B-Bay Serial # 90-274
 Date 11-26-00 Capacity 10-TB

CONDITION CODES

A= Very Good B=Good C=Acceptable D=Fair(inspect & review periodically)
 E= Poor (repairs required) F=Further inspection required X=Unsafe (tagout)

RUNWAY:

Rail	<u>B</u>
J Bolts	<u>D</u>
End Stops	<u>B</u>
Splice Plates	<u>D</u>

General:

Floor Disconnect	<u>B</u>
Warning Labels	<u>B</u>
Load Marking	<u>B</u>
Control Labels	<u>B</u>
Pend. Cable	<u>B</u>
Conductors	<u>B</u>
Warning Devices	<u>B</u>

Brake Aerial Displacement KBA, KBF, SBA, KBS, SBS

71, 80, 90	.059 min.	.117 max.
100, 112	.070 min.	.136 max.
125, 140	.078 min.	.156 max.
160, 180, 200, 225	.089 min.	.175 max.

CRANE: KBA 90 Motor Type

Wheel	
Bridge Brakes	<u>W 093 / E 093</u>
MCR	<u>B</u>
Collectors	<u>B</u>
Bumpers	<u>B</u>
Guarding	<u>B</u>
Cab	<u>B</u>

Brake Aerial Displacement KBH, KBF

71, 80, 90	.060 min.	.120 max.
100, 112	.070 min.	.140 max.
125, 140	.080 min.	.160 max.
160, 180, 200, 225	.090 min.	.180 max.

TROLLEY:

KBF 90
Motor Type

Shaft	<u>B</u>
Frame	<u>B</u>
Brakes	<u>093</u>
Stops	<u>B</u>
Wheels	<u>B</u>

Brake Aerial Displacement
 KMH .070 min. - 138 max.
 KMF (80-90) .060 min. .118 max.
 KMF (100) .070 min. .137 max.

MF056

REV 3 Date June 6, 2001

CRANE MAINTENANCE REPORT

Monthly Inspection Report

Model Demas Location C-BAY Serial # 8262
 Date 11-20-00 Capacity 5-TON

CONDITION CODES

A= Very Good B=Good C=Acceptable D=Fair(inspect & review periodically)
 E= Poor (repairs required) F=Further inspection required X=Unsafe (tagout)

RUNWAY:

Rail	<u>B</u>
J Bolts	<u>B</u>
End Stops	<u>B</u>
Splice Plates	<u>B</u>

General:

Floor Disconnect	<u>B</u>
Warning Labels	<u>B</u>
Load Marking	<u>B</u>
Control Labels	<u>B</u>
Pend. Cable	<u>B</u>
Conductors	<u>B</u>
Warning Devices	<u>B</u>

Brake Atrial Displacement KBA, KBF, SBA, KBS, SBS

71, 80, 90	.059 min	.117 max
100, 112	.070 min	.136 max
125, 140	.078 min	.156 max
160, 180, 200, 225	.089 min	.175 max

CRANE:
KBH 80
 Motor Type

Wheel	<u>B</u>
Bridge Brakes	<u>W 093 / E 093</u>
MCR	<u>B</u>
Collectors	<u>B</u>
Bumpers	<u>B</u>
Guarding	<u>B</u>
Cab	<u>N/A</u>

Brake Atrial Displacement KBH, KBF

71, 80, 90	.060 min	.120 max
100, 112	.070 min	.140 max
125, 140	.080 min	.160 max
160, 180, 200, 225	.090 min	.180 max

TROLLEY:

KB471
 Motor Type

Shaft	<u>B</u>
Frame	<u>B</u>
Brakes	<u>093</u>
Stops	<u>B</u>
Wheels	<u>B</u>

Brake Atrial Displacement
 KMH .070 min - 138 max
 KMF (80-90) .060 min .118 max
 KMF (100) .070 min .137 max

MF056

REV 3 Date June 6, 2001