

Audit Review and Evaluations of JEMISON METALS

**914 Maero St. NW
Trinity, AL 35673**

Dates of Audit: 9/28/22
Date of Submittal: 11/2/22

Auditors: Rick Rowland – SR VP QA & Engineering

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: GAD009 9.18.17 Rev Level 2 in Receiving, DEC-BB1-CTL 6.26.17 Rev Level 4 at the operator's platform, JDM-VA-0018.31.10 Rev level 0 at operators platform and at packaging computer. JDM200 Quality Policy 7.21.18 Rev-1 posted at bulletin board.

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

Interviewed Greg Chandler and Chris Schimsher, both were able to locate the Jemison Quality Intranet, Quality Policy and Procedures. Chris was able to elaborate on how he contributes to the quality policy by performing his required quality checks.

Additional employees talked to: Blake Key (Shipping), Denise Clayton (Inside Sales), Whitney Windsor (Maintenance), Sarah Singleterry (Purchasing/Materials Mgmt)

Reviewed Training Status Matrix, which had employees clearly identified, Greg and Chris showing both competent and fully trained.

8.2 Requirements for products and services

Contract Review/Order Acknowledgement: Southern Metalcraft issued a consignment release via email (dated Monday 9/19/22 from Greg Williams). Inside Sales (Denise Clayton) confirmed back via email the same day stating delivery by Wednesday 9/29/22.

Purchasing: Tag 853957 on Loading Order GAD 117511 for Southern Metalcraft was reviewed with purchasing. Customer's part was 1/4" nominal thickness 60x120 HRPO A36. This coil was purchased on GAD 22259-001. PO requirements to the mill matched the part spec requirements. PO coil weight range was 41-48k and the actual weight received was 44,620lbs.

8.4 Control of externally provided processes, products and services

Receiving: BOL H576012 (Ty-Dan) was received on receiver# 61320 against Purchase Order GAD-22917 from Nucor Decatur. PO requirements reviewed included: weight,

thickness, grade and width. Details were recorded on GAD009 Revision 2. Mill coil# 4615005.000 was assigned Jemison Tag number ND76651 and placed in location C25R8. The Nucor mill test report was also reviewed to determine a match of gauge, width and grade. All matched the PO requirements. **Observation #1: The coil was weighed and matched the BOL reported weight; however, the weight was not written into the GAD009 form. Receiver says he forgot to write it in. Several other receiving forms were checked and the coil weights were recorded.**

8.5-Production & Service Provisions

Production: Work Order GAD 163324 (JD Stock – internal customer) was in production on the stretch leveler. Production of 9 gauge (.152-162” thick) 61.5” wide Grade 80 material cutting to 2 lengths (157.5” & 205”). Material to be used (from work order): Coil ND76409 was what was used. Requirements such as width, length, thickness, wave/bow/square were checked for each of the 9 bundles produced (2 bundles of 205”, 7 bundles of 157.5”). All checks were in tolerance and documented on DEC-BB1-CTL Rev 4.

Shipping: Southern Metalcraft (Lithonia GA) Sales Order GAD 126914 Lines 1-4 was staged on loading order GAD 117511. Material was pre-staged and identified with colored flags (WELL DONE!). Items were visually verified against the loading order and everything matched.

7.1.3 Infrastructure

Preventive Maintenance: Whitney Windsor provided the following PM evidence:

- Monthly Warehouse PM Checklists (July, August & September 2022) on form SAF072.
- Stretch Leveling Line maintenance is organized by timeframes. 1, 2, 4, 6, 10, 13, 19 and 25 week intervals were reviewed. Most recent dates for each of these timeframes is in the audit notes and met the scheduled requirements of the preventive maintenance plan.

7.1.5 Monitoring and Measuring Resources

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

Receiving:

Micrometer serial#: 011 due 8/24/23, last calibrated 8/24/22.

Tape Measure serial#: T1040 due 2/22/23, last calibrated 2/22/22.

Receiving Scale serial#: HI-02187561 due 11/24/22, last calibrated 8/26/22.

BB1 CTL:

Micrometer serial#: 009 due 4/26/23, last calibrated 4/26/22.

Tape Measure serial#: T208 due 5/19/23, last calibrated 5/19/22.

AGT Thickness serial#: 3305 due 1/18/23, last calibrated 7/18/22.

8.7 Control of Nonconforming Product

The nonconforming area was neat and identified with tags that had descriptions in the comments about the issue. The nonconforming area is at the opposite end of the plant is clearly delineated.

10.2 Nonconformity and Corrective Action

CA 23258, BTB, verified closed on 8/29/22.

CA 22423, Hunter Engineering closed.

CA 22164, Internal Audit OBS#1 from 9/22/21 was closed on 1/26/22.

10. Improvement

Lighting has been upgraded in the plant to LED lights.

A third overhead crane has been added to improve shipping throughput.

2.0 Overview

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

Chris Schimsher – BB1 CTL Operator Blake Key - Shipping Greg Chandler - Receiver	Denise Clayton-Inside sales Justin Pate - Plant Manager Whitney Windsor - Maintenance Sarah Singleterry - Purchasing
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2.2 Audited Requirements

<ul style="list-style-type: none">4 Context of the Organization<ul style="list-style-type: none">4.4 Quality Management System and its processes5 Leadership<ul style="list-style-type: none">5.1 Leadership and commitment<ul style="list-style-type: none">5.1.2 Customer Focus5.2 Policy5.6 Management review6 Planning7 Support<ul style="list-style-type: none">7.1.1 General7.2 Competence<ul style="list-style-type: none">7.1.3 Infrastructure7.1.4 Environment for the operation of processes7.1.5 Monitoring and measuring resources7.5 Documented information	<ul style="list-style-type: none">8 Operation<ul style="list-style-type: none">8.1 Operational planning and control8.2 Requirements for products and services8.3 Design and development of products and services (N/A)8.4 Control of externally provided processes, products and services8.5 Production and service provision8.7 Control of nonconforming outputs9 Performance evaluation<ul style="list-style-type: none">9.1 Monitoring, measurement, analysis and evaluation<ul style="list-style-type: none">9.1.1 General9.1.3 Analysis and evaluation10 Improvement<ul style="list-style-type: none">10.2 Nonconformity and corrective action
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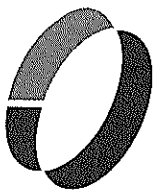
2.3 APPROVAL/SIGN-OFF

Report Prepared by Rick Rowland

Date 11/2/22

Nonconforming Corrective Action Report (CAR) for Jemison
Metals

CAR #	ISO 9001: 2015 Clause / Sub-Clause	Findings/Requirements	Observation	Minor	Major
n/a	8.4	Observation #1: The coil was weighed and matched the BOL reported weight; however, the weight was not written into the GAD009 form. Receiver says he forgot to write it in. Several other receiving forms were checked and the coil weights were recorded.	X		



JEMISON METALS

DATE: 9/28/22

TO: Decatur Internal Audit

Page 1

FROM:

Receiving - Greg Chandler - 20+ years with Jemison ~~Review w/ Purchasing~~

- 0-1" Mic 011 8/4/22 due 8/4/23 PO# GAD-22197 Heil Sheet
- 25' Tape Measure T1040 2/22/22 Receiver# 61320 Nucor Decatur
- HI-02187561 Receiving Scale 8/26/22 ^{due 2/22/23} Master Tag ND 7665 Mill Coil # 4615005.000
- BOL# H576012 Ty-Dan Heat SM 5494 62,099/lbs OBS#1
- .1140 min x 52" HR Location C25 R8 GAD009 9/18/07 Rev.2 Actual Weight
- ASTM A1011 UHSS Grade 100 107.6 Ksi Yield, 114.3 Ksi Tensile, 16.8% Elong.

Production 1st Shift Chris Schimsher ~ 4 yrs w/ Jemison

Work Order # GAD 163324 - JD Stock HS80

- Gauge: .152-.162 Width: 61.5 Mill Edge Lengths 1 157.5" -0, +.5" AGT 3305 7/18/22 due 1/18/23
- Material To be Used: ND 76409 - HS80 92.5 Ksi Yield, 101.8 Tensile Tape Measure 1208 30' 5/19/22 due 5/19/23
- 2 Bundles 10 pcs each 61.5 x 205.00 22.7% Elongation
- 4 Bundles 23 pcs each 61.5 x 157.5 ✓.152 Actual Gauge
- 1 Bundle 1 pc each 61.5 x 157.5 ✓62.1875-62.25 Width Actual
- 10,000 lb Max lift weight. ✓205.187" Length Actual
- 1/2" Wave/Bow Max → < 1/2" Actual ✓157.625" Length Actual

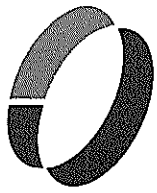
Shipping Blake Key Loading Order GAD 117511

Ship to: Southern Metalcraft, Lithonia GA - Review w/ Sales

- Sales Order 126914 Line 1 2 Skids A1008 CR CS-B 60x120 Tags 462695 462696
- " 126914 Line 2 6 Skids A1011 HRPO CS-B 60x120 Tags 853940, 41, 42, 43, 44 + 46
- " Line 3 1 Skid 1/4" A36 HRPO 60x120 Tag 853957
- " Line 4 1 Skid 7ga A1011 HRPO CS-B 60x120 Tag 835156

* Material Pre-staged + identified with colored flags Nice!

- ✓ Sales - Southern Metalcraft Consignment Release via Email Dated Monday 9/19/22 From Greg Williams. Denise Clayton Confirmed back via email on same day stating delivery by Wednesday 9/28/22



JEMISON METALS

DATE: 9-28-22

TO: DEC Internal Audit Page 2

FROM:

Preventive Maintenance Whitney

Warehouse Preventive Facility Maintenance Records reviewed (SAF072)
for July / August / Sep 2022 - Check Spare air compressor - Spare Nail Gun
7/15 8/17 9/6 - Inventory of Spare Parts - Chain Saw
- Nails in Wood Area - Vp ender
- Radial Arm Saw - Hand Tools

Line Maintenance 1, 2, 4, 6, 10, 13, 19 + 25 week PM Records

observed. 1 week Uncoiler Camroll Bearing Surfaces Cleaning. 9/19, 9/26

2 week Uncoiler Main Shaft Bearings - Lubricate

4 Week 1 Uncoiler item, 1 Hydraulic Roller Leveler, 1 Hydraulic Shear, 1 Pinch Roll

1 Stretcher, 2 Steering Pinch Roll, 1 Mechanical Shear item. Last Completed 9/12/22

6 Week 6 items Last Completed 9/5/22, previous 7/12/22

10 Week 59 items Last Completed 8/29/22, previous 6/14/22

13 Week 1 item Coil Conveyor Roll Bearings Lubricate. Last Completed 8/1/22

19 Week 16 items Last Completed 9-5-22

25 Week 8 items Last Completed 8/29/22

Purchasing Tag 853957 on Loading Order GAD 117511

1/4" Nom 60X120 A36 HRPO, ND76495 Master Tag purchased for

✓ Southern Metal Craft on PO GAD 22259-001.

✓ PO Rqmts HRPO^{A36} .240" min 60" wide. 41-48K lbs (44,620 Actual)

CA 23258 BTB verified closed on 8/29/22

CA 22423 Hunter Engineering closed.

CA 22164 Internal Audit OBS#1 9/22/21 closed on 1/26/22

INBOUND INSPECTION REPORT

Date:	9-28-22					
P.O Number:	Gad 22197	Type:	HR		Mill Weight:	
Receiver Number:	61320				62,099	
Mill Name:	Nud	BL #			Actual Weight:	
MASTER TAG #:	ND 76657					
Mill TAG #:	4615005.000				Heat #:	SM 5494
COIL INSPECTION INFO :						
	ID	OD	2950		REMARKS:	
WIDTH:	52 1/4	52 1/4				
GAUGE:	.114	.115				
COIL:						
SHEET/PLATE INSPECT. INFO:						
Piece Count:		Gauge:		Width:		Length:
Remarks:						
OTHER INFO						
Comments:						
Physical Conditions:						
Surface/Shape Conditions:						
<div style="display: flex; justify-content: space-between;"> Physicals Required: Yes / No Physicals Received: Yes / No </div>						
Location:	C25 R8			Receiver Name:		

BILL OF LADING # H576012

NUCOR®

VEHICLE #:

NSD TRUCK:

Transworks Load # TC47013655
MODE: COMMON CARRIER
DATE: 09/27/22

NUCOR STEEL DECATUR, LLC
 Telephone 256/301-3500

STRAIGHT BILL OF LADING - SHORT FORM - ORIGINAL - NOT NEGOTIABLE

S
H JEMISON METALS HRB
I 914 MAERO ST
P
T TRINITY
O 256-321-2524 AL 35673

S
O JEMISON METALS
L 3800 COLONNADE PKWY
D STE 250
BIRMINGHAM
T
O AL 35243

Contract Number: ND0015
 Carrier's Name: TY-DAN TRANSPORTATION
 Route:
 Delivering Carrier: TY-DAN TRANSPORTATION
 Consigned To: JEMISON METALS HRB
 TRINITY AL

Received, subject to the classifications and tariffs in effect on the date of issue of the bill of lading.

From: Nucor Steel Decatur, LLC
 At: 4301 Iverson Blvd.
 Trinity, AL 35673

BILL FREIGHT TO: Nucor Steel Decatur, LLC
 4301 Iverson Blvd.
 Trinity, AL 35673

The property described below in apparent good order except as noted (contents and conditions of contents of packages unknown), marked, consigned, and destined as indicated above, 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 the route to said destination. It is mutually agreed, as to each carrier of all or any 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 Uniform 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 the shipment and the said terms and conditions are hereby agreed to by the shipper and accepted for himself and his assigns.
 (Mail or street address of consignee-For purposes of notification only)

THIS BILL FOR DELIVERY PURPOSES ONLY
 REVENUE BILL TO FOLLOW

Subject to Section 7 of Conditions of applicable bill of lading. If this shipment is to be delivered to the consignee without recourse on the consignor, the consignor shall sign the following statement.

The carrier shall not make delivery of this shipment without payment of freight and all other lawful charges.

Signature of Consignor

CHARGES ARE TO BE:
 PREPAID

NO. OF PIECES	DESCRIPTION OF ARTICLES, SPECIAL MARKS, EXCEPTIONS	WEIGHT (LBS)	STCC NO	ROUTE MILES
1	COILED STEEL - HOT ROLLED BAND	62099	33123-32	
	SHEET STEEL IN COILS			
1	TOTAL	62099		1

Advice to Carrier >.300 4 ID 2 OD BANDING

Loading Instructions:

Eye to the side or rear, No Tarp

Door #:

Coil Yard

02578

Shipper's Signature

Carrier's Signature

CONSIGNEE

BAY CY

NUCOR®

VEHICLE #:

NSD Truck:

NUCOR STEEL DECATUR, LLC

Date: 09/27/22

Page: 3

Customer P.O.#: GAD-22197

Loading Order # H576012

Ship To: JEMISON METALS
914 MAERO ST

HRB

Customer Name: JEMISON METALS

Transworks Load # TC47013655

TRINITY

AL

35673

Coil #	Heat	Slab	Coil Location	Actual Weight	Length	Coil #	Heat	Slab	Coil Location	Actual Weight	Length
4615005.000	SM5494	02	D04F0010	62,099lb	2,950ft						

Customer Part #:

Mill Order/Line: 343509 - 1 PRIME

Ordered Size: 0.1140 in MIN X 52.0000 in MIN, MILL

Loading/Packaging:

2 ID 2 OD

Description: HRB, ASTM A1011 UHSS Grade 100 Type 1 MOD 128 max TS

Eye to the side or rear, Bar Coded Tickets, A--HRB and P&O-BARE, No Tarp

Delivery Order No:

Special Instr:

Release Order:

PO Weight (lbs.)

62,099

ADVICE TO SHIPPING:

>.300 4 ID 2 OD BANDING

MELTED AND ROLLED IN THE USA

CUSTOMER



METALLURGICAL TEST REPORT

Nucor Steel Decatur, LLC
4301 Iverson Blvd.
Trinity, AL 35673

Phone: 1-866-825-3239
Email: nsd-mtr-inquiries@nucor.com

Load Number: H576012
Certificate Number: 321349
Date Printed: 09/27/2022 00:47
Total Wgt: 62,099 lbs
Page: 1 of 1

Order Number: 343509 - 0001
Order Dimensions: 0.1140 in MIN X 52.0000 in MIN, MILL
Product: HOT ROLLED BAND COILED STEEL

Customer Name: JEMISON METALS
Address: 3800 COLONNADE PKWY
STE 250
BIRMINGHAM AL 35243

Spec: ASTM A1011 UHSS Grade 100 Type 1 MOD 128 ksi max Tensile
Tensile test per ASTM A370; Fig 3 sheet-type 2" gauge length
%Si meets Galvanized requirements of 0.04% max or 0.15/0.22%

Spec Rev: 18a

Customer PO #: GAD-22197

CHEMISTRY ANALYSIS																			
Coil Num/Wgt	Heat	Slab	C	Mn	P	S	Si	Cu	Sn	Ni	Cr	Mo	Al	N	V	Nb	Ti	B	Ca
4615005.000	SM5494	02	0.05	1.46	0.006	0.001	0.205	0.12	0.004	0.09	0.11	0.10	0.050	0.0060	0.005	0.047	0.098	0.0001	0.0023
62,099 lbs	TUNDISH																		

Test Description	Test Result	Tested Heat / Slab / Gauge(in)	Sample Type	Direction
Yield Strength 0.2% offset	107.6 ksi / 742 MPa	0.1180	ASTM	Long
Tensile Strength	114.3 ksi / 788 MPa	0.1180	ASTM	Long
Total Elongation (2")	16.8 %	0.1180	ASTM	Long

WE HEREBY CERTIFY THE ABOVE IS CORRECT AS CONTAINED IN THE RECORDS OF THE CORPORATION.
MATERIAL ABOVE IS IN COMPLIANCE WITH THE REQUIREMENTS OF THE REFERENCED SPECIFICATION/PRODUCT STANDARDS.
MELTED AND ROLLED IN THE USA. MADE IN THE USA. CERTIFICATE ISSUED IN ACCORDANCE WITH EN 10204 3.1.


Hector Flores, PLANT METALLURGIST



PRODUCTION REPORT

JOB WORK ORDER NO.	DATE	MACHINE	SHIFT	MASTER COIL NO.	Yield Strength	Hail - Fab		PAGE 1 OF 1	
163324	6-27-22	BD1	3rd/1st	ND76409	92.5	.1570 x 61.5 x			
OPERATOR	RUN HOURS	Purr Msmt(s)	Head Scrap	Tail Scrap	GA MIN	MAX WAVE	MAX SQUARE	KEYED BY	CKD. BY
Lero 1/Chris	5:00A/7:24A		19'	6	.1520	.50			
Minimum Inspection Frequency: 40 min level ok 40 min line backed up (Unless otherwise specified on the Work Order/Part Spec)					GA MAX	MAX BOW			
CHECK PIECE ONCE LINE RUN IS ESTABLISHED + PIECE AT MIDPOINT OF RUN + LAST PIECE OF RUN					.1620	.50			

FINISHED GOODS TAG NO.	PCS Required	PCS Actual	Width Actual	Length Entered	Length Actual	Gauge Actual	Wave/Bow Actual	Square Actual	Weight	Comments
322951	10	10	62.187	205.312	205.187	.150	ok	.062	5574	
952	10	10		1			ok		1	
322944	23	23	62.250	157.75	157.625	.150	ok	.062	9839	
45	23	23					ok			
46	23	23					ok			
47	23	23					ok			
48	23	23					ok			
49	23	23					ok		9839	
50	1	1	62.250	1	157.625	.150	ok		428	

Jemison Metals -- 96 In

Job Work Order: 16337

Customer Name: HEIL Opera

Product: Hot Rolled Steel Sep-27-22 5:45 AM

Average Thickness and Tolerance Data

Target: .1850 Average* 0.1850
Out of Sensor Range 2237 ft

Length 2235 ft
Width 60.000 in
Weight 84562 lbs

Max Thickness is 0.1850 in at 0 ft
Head Scrap 0 ft

Statistical Process Control Data

Upper Control Limit 0.1850 in Up
X Double Bar 0.1850 in R
Lower Control Limit 0.1850 in Lc

CR 1000.0% (Capability Ratio %, 100/Cp)
Cp 999.990 (Process Capability, HiL)
Cpk 999.990 (Capability vs Limits)

Thickness Distribution Relative to the

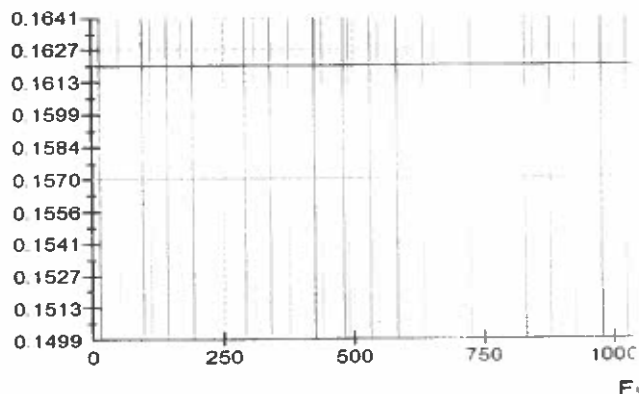
+++ 100.0% ++++++
+0.0100 0.0%
+0.0090 0.0%
+0.0080 0.0%
+0.0070 0.0%
+0.0060 0.0%

-0.0060 0.0%
-0.0070 0.0%
-0.0080 0.0%
-0.0090 0.0%
-0.0100 0.0%
--- 0.0%

0 3 6 9 12 15

0.0% is within ± 0.0020 in of the target
0.0% is within ± 0.0100 in of the target

Thickness vs Leng



Gauge readings provided by Advanced Gauging Technol

h Leveler

076409

Supplier: NID

8.6 min/ run 20.9 min) Shift: 1

Target .1850
Variation .0010
20 in 2235 ft (100.0%)
20 in 0 ft (0.0%)
Max is 0.1850 in at 0 ft
0 ft

0.1620 in

0.1520 in

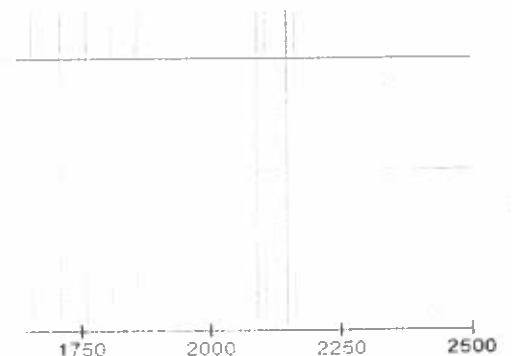
0.822 (Low Limit/Avg)

+++++

30 33 %

in ± 0.0050 in of the target
in ± 0.0200 in of the target

(76409)



Oil 43064 USA Tel (614) 873-6691

27Sep22 06:18

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

GAD 163324

Jemison Metals - Gadsden

3001 Hickory Street

Gadsden, AL 35902

Tel: 800-235-1086 Fax: 205-986-6604

Job Type LEV Process

PWC BB1

Metric N Cust

Desc HEIL FAB 126801

Due Date 23Sep22 Whs DFG

Setup 00:00 Run 01:05 Prtd By decline

<<< JOB SPECIFICATIONS >>>

Group HRS Grade HS80 Gauge 0.1570 (0.1570 to 0.1570) ID 0.0000

<<< ORDER SPECIFICATIONS >>>

W 01 HRS/9E/HS80/61.5000"X205.00/.1570N HSLA GRADE 80
 Ord GAD 126801- 3 Cust JD STOCK - GAD Ga 0.1570 Wth 61.5000 Lth 205.0000
 Part 10/W61.500X205.000 HEIL FAB Ga 0.1570 Wth 61.5000 Lth205.0000
 Ga Rng 0.1520to 0.1620 Pc/Tag 10
 WthTol + 0.9999 - 0.0000 Wt/Skd 10000
 LthTol + 0.5000 - 0.0000 Ty JD0 Pk
 YLD:80000.00 TENS:90000.00 ELONG:18.00
 WAVE:0.00-.50 BOW:0.00-.50

W 02 HRS/9E/HS80/61.5000"X157.50/.1570N HSLA GRADE 80
 Ord GAD 126801- 2 Cust JD STOCK - GAD Ga 0.1570 Wth 61.5000 Lth 157.5000
 Part 10/W61.500X157.500 HEIL FAB Ga 0.1570 Wth 61.5000 Lth157.5000
 Ga Rng 0.1520to 0.1620 Pc/Tag
 WthTol + 0.9999 - 0.0000 Wt/Skd 10000
 LthTol + 0.5000 - 0.0000 Ty JD0 Pk
 YLD:80000.00 TENS:90000.00 ELONG:18.00
 WAVE:0.00-.50 BOW:0.00-.50

<<< PROCESSING INSTRUCTIONS >>>

<Step 1>
 Level To: 61.5000 X 205.0000 20 Pcs 11227 LBS 999 Pcs/Tag
 <Step 2>
 Level To: 61.5000 X 157.5000 139 Pcs 59813 LBS 999 Pcs/Tag

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<HRC/9D/HS80>								
ND76409	DPW	0.1500M	61.5000		1	71040	NUDNM5247	B24R4
Rmks: HEIL - SHEET								
Spec: YLD=<92.5>/TENS=<101.8>/ELONG=<22.7>								
Total:					1	71040		

<<< MATERIAL TO BE SHIPPED >>>

02 Ord GAD 126801- 2 Cust JD STOCK - GAD Part W61.500X157.500 HEIL FAB
 HOT ROLL SHEET HSLA GRADE 80 Pcs/Tg 0 Bal 125 Pcs
 .1570 Nom X 61.5000" X 157.5000" DueDt 25Sep22 53,910 LBS

01 Ord GAD 126801- 3 Cust JD STOCK - GAD Part W61.500X205.000 HEIL FAB
 HOT ROLL SHEET HSLA GRADE 80 Pcs/Tg 10 Bal 20 Pcs
 .1570 Nom X 61.5000" X 205.0000" DueDt 25Sep22 11,227 LBS

<<< MATERIAL TO STOCK >>>

Cons	Tg	Spc	Prod	Tg	Whs	Ty	Gauge	Width	Length	OD	PCS<Prn>Wt	PCS<Res>Wt
ND76409												
2		322944	DPW	W	0.1570	61.5000	157.5000			23	9919	23 9919

Jemison Metals - Gadsden

ND76409

2	322945	DPW W	0.1570	61.5000	157.5000	23	9919	23	9919
2	322946	DPW W	0.1570	61.5000	157.5000	23	9919	23	9919
2	322947	DPW W	0.1570	61.5000	157.5000	23	9919	23	9919
2	322948	DPW W	0.1570	61.5000	157.5000	23	9919	23	9919
2	322949	DPW W	0.1570	61.5000	157.5000	23	9919	23	9919
2	322950	DPW W	0.1570	61.5000	157.5000	1	431	1	431
1	322951	DPW W	0.1570	61.5000	205.0000	10	5614	10	5614
1	322952	DPW W	0.1570	61.5000	205.0000	10	5614	10	5614
Total:						159	71,173	159	71,173

<<< JOB RECAP >>>

	PCS	Weight	Scrap	Scrap %	Unactd Scr %
Material Allocated	1	71,040			
Master Returns					
Returns to Stock					
Work in Process	159	71,173			
Material to be Shipped					
Rejects					
Net Weight to be Produced	159	71,173			133- 0.19-

27Sep22 06:18

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

GAD 163324

Jemison Metals - Gadsden
3001 Hickory Street
Gadsden, AL 35902

Job Type LEV Process PWC BB1
Metric N Cust
Desc HEIL FAB 126801
Due Date 23Sep22 Whs DFG
Setup 00:00 Run 01:05 Prtd By decline

=====

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<HRC/9D/HS80>								
ND76409	DPW	0.1500M	61.5000		1	71040	NUDNM5247	B24R4
Rmks: HEIL - SHEET								
Spec: YLD=<92.5>/TENS=<101.8>/ELONG=<22.7>								
Total:					1	71040		

LOADING ORDER

No: GAD 117511

Ship From:
Jemison Metals - Gadsden
3001 Hickory Street
Gadsden, AL 35902
Tel: 800-235-1086 Fax: 205-986-6604

Ship Date 28Sep22 at 13:37 From DFG
Probill
Via WALLACE FACTURI
FOB Destination
Frt PREPAID FREIGHT
Route 0- 0 Manifest 46755
Vhcle Trailer
Slp

Ship To: (1)
Southern Metalcraft Inc
2675 Lithonia Ind Blvd
Lithonia GA 30058
Tel: 770-482-2923 Fax: 704-482-6292

Sold To: (3407)
Jemison Metals - Gadsden
3001 Hickory Street
Gadsden, AL 35902

LOADING ORDER

1) Our Order GAD-126914- 1 Your PO #
Part # CR 16GA CS-B 60X120
A1008 COLD ROLLED SHEET CS-TYPE B
.0598 Nom X 60.0000" X 120.0000"

Rel #

Loc	Heat Number	Tag No	Quantity	PCS	Wt LBS
	SM4421	462695	1,600.00 SFT	32	4001
	SM4421	462696	1,600.00 SFT	32	4001
		Total:	3,200.00 SFT	64	8002

2) Our Order GAD-126914- 2 Your PO #
Part # HRPO 11GA CS-B 60X120
A1011 HRP&O SHEET CS-TYPE B
.1196 Nom X 60.0000" X 120.0000"

Rel #

Loc	Heat Number	Tag No	Quantity	PCS	Wt LBS
	NM4838	853940	900.00 SFT	18	4502
	NM4838	853941	900.00 SFT	18	4502
	NM4838	853942	900.00 SFT	18	4502
	NM4838	853943	900.00 SFT	18	4502
	NM4838	853944	800.00 SFT	16	4001
	NM4838	853946	900.00 SFT	18	4502
		Total:	5,300.00 SFT	106	26511

3) Our Order GAD-126914- 3 Your PO #
Part # HRPO 250 60X120
A1011 HRP&O SHEET ASTM A36/A36M
.2500 Nom X 60.0000" X 120.0000"

Rel #

Loc	Heat Number	Tag No	Quantity	PCS	Wt LBS
	SM5380	853957	400.00 SFT	8	4084

BLUE

Robert

-2285
3685
80

Ship From:
Jemison Metals - Gadsden
3001 Hickory Street
Gadsden, AL 35902
Tel: 800-235-1086 Fax: 205-986-6604

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

No: GAD 117511
Ship Date 28Sep22 at 13:37 From DFG
Probill
Via WALLACE FACTURI
FOB Destination
Frt PREPAID FREIGHT
Route 0- 0 Manifest 46755
Vhcle Trailer
Slp
Sold To: (3407)
Jemison Metals - Gadsden

Ship To: (1)
Southern Metalcraft Inc

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

4) Our Order GAD-126914- 4 Your PO #
Part # HRPO 7GA CS-B 60X120
A1011 HRP&O SHEET CS-TYPE B
.1793 Nom X 60.0000" X 120.0000"

Rel #

Loc	Heat Number	Tag No	Quantity	PCS	Wt LBS
	NM1827	✓ 835156-D-7	250.00 SFT	5	1875

TOTAL:	Tags	PCS	LBS
	10	183	40472

Tag/Heat No
853957

*** Physical Analysis ***

SM5380

YLD=<50.0>/TENS=<68.5>/ELONG=<29.2>

Heat Number
NM1827

*** Chemical Analysis ***

NM4838

SM4421

SM5380

C=0.0600 Mn=0.4000 P=0.0090 S=0.0030 Si=0.0210 N=0.0062
Cr=0.0500 Mo=0.0200 Cu=0.1300 Al=0.0330 V=0.0010 Ti=0.0010
Ni=0.0400 Nb=0.0010 Ca=0.0019 Sn=0.0020
C=0.0600 Mn=0.3800 P=0.0040 S=0.0020 Si=0.0220 N=0.0057
Cr=0.0400 Mo=0.0100 Cu=0.1000 Al=0.0290 V=0.0010 Ti=0.0010
Ni=0.0400 Ca=0.0021 B=0.0001
C=<.04> Mn=<.18> P=<.004> S=<.001> Si=<.027> N=<.0048> Cr=<.03>
Mo=<.01> Cu=<.08> Al=<.034> V=<.002> Ti=<.002> Ni=<.02>
Nb=<.001> Ca=<.0023> Sn=<.001> B=<.0001>
C=0.1900 Mn=0.3800 P=0.0050 S=0.0040 Si=0.0180 N=0.0056
Cr=0.0500 Mo=0.0100 Cu=0.1200 Al=0.0280 V=0.0020 Ti=0.0010
Ni=0.0400 Ca=0.0030 Sn=0.0020 B=0.0001

RECEIVING HRS

MONDAY - THURSDAY 8am - 4:30pm EST

FRIDAY 8am - 12pm EST

TRANSFER BILL OF LADING No: GAD 117511

Ship From:
Jemison Metals - Gadsden
3001 Hickory Street
Gadsden, AL 35902
Tel: 800-235-1086 Fax: 205-986-6604

Ship Date 28Sep22 at 7:57 From DFG
Probill
Via WALLACE FACTURI
FOB Destination
Frt PREPAID FREIGHT
Route 0- 0 Manifest 46755
Vhcle Trailer
Slp

Ship To: (1)
Southern Metalcraft Inc
2675 Lithonia Ind Blvd
Lithonia GA 30058
Tel: 770-482-2923 Fax: 704-482-6292

Sold To: (3407)
Jemison Metals - Gadsden
3001 Hickory Street
Gadsden, AL 35902

TRANSFER BILL OF LADING

1) Our Order GAD-126914- 1 Your PO #
Part # CR 16GA CS-B 60X120
A1008 COLD ROLLED SHEET CS-TYPE B
.0598 Nom X 60.0000" X 120.0000"

Rel #

Heat Number	Tag No	Quantity	PCS	Wt LBS
SM4421	462695	1,600.00 SFT	32	4001
SM4421	462696	1,600.00 SFT	32	4001
Total:		3,200.00 SFT	64	8002

2) Our Order GAD-126914- 2 Your PO #
Part # HRPO 11GA CS-B 60X120
A1011 HRP&O SHEET CS-TYPE B
.1196 Nom X 60.0000" X 120.0000"

Rel #

Heat Number	Tag No	Quantity	PCS	Wt LBS
NM4838	853940	900.00 SFT	18	4502
NM4838	853941	900.00 SFT	18	4502
NM4838	853942	900.00 SFT	18	4502
NM4838	853943	900.00 SFT	18	4502
NM4838	853944	800.00 SFT	16	4001
NM4838	853946	900.00 SFT	18	4502
Total:		5,300.00 SFT	106	26511

3) Our Order GAD-126914- 3 Your PO #
Part # HRPO 250 60X120
A1011 HRP&O SHEET ASTM A36/A36M
.2500 Nom X 60.0000" X 120.0000"

Rel #

Heat Number	Tag No	Quantity	PCS	Wt LBS
SM5380	853957	400.00 SFT	8	4084


ROBERT C.

TRANSFER BILL OF LADING No: GAD 117511
 Ship From: Jemison Metals - Gadsden Ship Date 28Sep22 at 7:57 From DFG
 3001 Hickory Street Probill
 Gadsden, AL 35902 Via WALLACE FACTURI
 Tel: 800-235-1086 Fax: 205-986-6604 FOB Destination
 Frt PREPAID FREIGHT
 Route 0- 0 Manifest 46755
 Vhcle Trailer
 Slp
 Ship To: (1) Sold To: (3407)
 Southern Metalcraft Inc Jemison Metals - Gadsden

=====

TRANSFER BILL OF LADING

4) Our Order GAD-126914- 4 Your PO #
 Part # HRPO 7GA CS-B 60X120 Rel #
 A1011 HRP&O SHEET CS-TYPE B
 .1793 Nom X 60.0000" X 120.0000"

Heat Number	Tag No	Quantity	PCS	Wt LBS
NM1827	835156	250.00 SFT	5	1875

TOTAL:	Tags	PCS	LBS
	10	183	40472

Tag/Heat No
853957

*** Physical Analysis ***

SM5380

YLD=<50.0>/TENS=<68.5>/ELONG=<29.2>

Heat Number
NM1827

*** Chemical Analysis ***

C=0.0600 Mn=0.4000 P=0.0090 S=0.0030 Si=0.0210 N=0.0062
 Cr=0.0500 Mo=0.0200 Cu=0.1300 Al=0.0330 V=0.0010 Ti=0.0010
 Ni=0.0400 Nb=0.0010 Ca=0.0019 Sn=0.0020

NM4838 C=0.0600 Mn=0.3800 P=0.0040 S=0.0020 Si=0.0220 N=0.0057
 Cr=0.0400 Mo=0.0100 Cu=0.1000 Al=0.0290 V=0.0010 Ti=0.0010
 Ni=0.0400 Ca=0.0021 B=0.0001

SM4421 C=<.04> Mn=<.18> P=<.004> S=<.001> Si=<.027> N=<.0048> Cr=<.03>
 Mo=<.01> Cu=<.08> Al=<.034> V=<.002> Ti=<.002> Ni=<.02>
 Nb=<.001> Ca=<.0023> Sn=<.001> B=<.0001>

SM5380 C=0.1900 Mn=0.3800 P=0.0050 S=0.0040 Si=0.0180 N=0.0056
 Cr=0.0500 Mo=0.0100 Cu=0.1200 Al=0.0280 V=0.0020 Ti=0.0010
 Ni=0.0400 Ca=0.0030 Sn=0.0020 B=0.0001

RECEIVING HRS

MONDAY - THURSDAY 8am - 4:30pm EST

FRIDAY 8am - 12pm EST

JEMISON DEMSEY METALS
WAREHOUSE
PREVENTATIVE FACILITY MAINTENANCE

MONTHLY

initial

WYON

WYw

W/S

www

WYV

WYW

WYU

WYV

CHECK SPARE AIR COMPRESSOR FOR FUNCTION

CHECK INVENTORY OF SPARE PARTS

CHECK NAILS IN WOOD AREA

INSPECT RADIAL ARM SAW FOR FUNCTION

CHECK SPARE NAIL GUN FOR FUNCTION

CHECK CHAIN SAW FOR FUNCTION

CHECK UP ENDER FOR FUNCTION

CHECK HAND TOOLS FOR FUNCTION (BANDERS, CRIMPERS, ETC.)

initial

YEARLY

PHYSICAL INSPECTION OF SUPPORT BEAMS

INSPECT D-BAY CROSS TIES FOR TIGHTNESS

INSPECT LIGHTING

INSPECT EXTERIOR GAS SUPPLY

INSPECT INTERIOR BREAKER BOXES

INSPECT ROOF FOR DAMAGE (WHEN POSSIBLE)

INSPECT SHIPPING DOORS FOR PROPER FUNCTION

VISUAL INSPECTION OF HEATERS

INSPECT DRIVEWAY FOR DAMAGE

INSPECT C- HOOKS AND LIFTING CADIES FOR FUNCTION

TIGHTEN "J" BOLTS ON OVERHEAD CRANES (CRANE RAILS ALL)

INSPECT WALLS FOR DAMAGE OR FAULTS

INSPECT FLOORS FOR DAMAGE

COMMENTS

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print
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MAINTENANCE PERFORMED BY

signature

APPROVED BY

initial

DATE 8-17-22

JEMISON DEMSEY METALS
WAREHOUSE
PREVENTATIVE FACILITY MAINTENANCE

MONTHLY

initial

CHECK SPARE AIR COMPRESSOR FOR FUNCTION

CHECK INVENTORY OF SPARE PARTS

CHECK NAILS IN WOOD AREA

INSPECT RADIAL ARM SAW FOR FUNCTION

CHECK SPARE NAIL GUN FOR FUNCTION

CHECK CHAIN SAW FOR FUNCTION

CHECK UP ENDER FOR FUNCTION

CHECK HAND TOOLS FOR FUNCTION (BANDERS, CRIMPERS, ETC.)

initial

YEARLY

PHYSICAL INSPECTION OF SUPPORT BEAMS

INSPECT D-BAY CROSS TIES FOR TIGHTNESS

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INSPECT EXTERIOR GAS SUPPLY

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VISUAL INSPECTION OF HEATERS

INSPECT DRIVEWAY FOR DAMAGE

INSPECT C- HOOKS AND LIFTING CADIES FOR FUNCTION

TIGHTEN "J" BOLTS ON OVERHEAD CRANES (CRANE RAILS ALL)

INSPECT WALLS FOR DAMAGE OR FAULTS

INSPECT FLOORS FOR DAMAGE

COMMENTS

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print
```

MAINTENANCE, PERFORMED BY

signature

APPROVED BY

initial

DATE 9-6-22

Location	Item	Hours	Weeks	Type	Details	Comments
Uncoiler	Camroll bearing surfaces	80	1	Clean	2 rails each unit	clean debris around and on top of rail
DUE DATES (WEEK OF)	Completed Initials/DATE	Comments				
January 3, 2022						
January 10, 2022						
January 17, 2022						
January 24, 2022						
January 31, 2022						
February 7, 2022						
February 14, 2022						
February 21, 2022						
February 28, 2022						
March 7, 2022						
March 14, 2022						
March 21, 2022						
March 28, 2022						
April 4, 2022						
April 11, 2022						
April 18, 2022						
April 25, 2022						
May 2, 2022						
May 9, 2022						
May 16, 2022						
May 23, 2022						
May 30, 2022						
June 6, 2022	<i>WYD 6-10-22</i>					
June 13, 2022	<i>WYD 6-13-22</i>					
June 20, 2022	<i>WYD</i>					
June 27, 2022	<i>WYD - 27-22</i>					

Location	Item	Hours	Weeks	Type	Details	Comments
Uncoller	Camroll bearing surfaces	80	1	Clean	2 rails each unit	clean debris around and on top of rail
DUE DATES (WEEK OF)	Completed Initials/DATE	Comments				
July 4, 2022	WYW 7-8-22					
July 11, 2022	WYW 7-11-22					
July 18, 2022	WYW 7-18-22					
July 25, 2022	WYW 7-25-22					
August 1, 2022	WYW 8-1-22					
August 8, 2022	WYW 8-8-22					
August 15, 2022	WYW 8-22-22					
August 22, 2022	WYW 8-22-22					
August 29, 2022	WYW 8-29-22					
September 5, 2022	WYW 9-5-22					
September 12, 2022	WYW 9-12-22					
September 19, 2022	WYW 9-19-22					
September 26, 2022	WYW 9-26-22					
October 3, 2022	WYW					
October 10, 2022	WYW					
October 17, 2022	WYW					
October 24, 2022	WYW					
October 31, 2022	WYW					
November 7, 2022	WYW					
November 14, 2022	WYW					
November 21, 2022	WYW					
November 28, 2022	WYW					
December 5, 2022	WYW					
December 12, 2022	WYW					
December 19, 2022	WYW					
December 26, 2022	WYW					
January 2, 2023	WYW					

WEEKLY

Location	Item	Hours	Weeks	Type	Details	Comments
Uncoiler	Main shaft bearings	150	2	Lubricate-Mobil EP2 grease	2 points each unit	Clean debris and old grease. Rotate shaft slowly while greasing.

DUE DATES (WEEK OF)	Completed Initials/DATE	Comments
January 3, 2022		
January 10, 2022		
January 17, 2022		
January 24, 2022		
January 31, 2022		
February 7, 2022		
February 14, 2022		
February 21, 2022		
February 28, 2022		
March 7, 2022		
March 14, 2022		
March 21, 2022		
March 28, 2022		
April 4, 2022		
April 11, 2022		
April 18, 2022		
April 25, 2022		
May 2, 2022		
May 9, 2022		

Location	Item	Hours	Weeks	Type	Details	Comments
Uncoiler	Main shaft bearings	150	2	Lubricate-Mobil EP2 grease	2 points each unit	Clean debris and old grease. Rotate shaft slowly while greasing.
DUE DATES (WEEK OF)						
May 16, 2022	Completed Initials/DATE					Comments
May 23, 2022						
May 30, 2022						
June 6, 2022	WYW 6-10-22					
June 13, 2022	WYW 6-18-22					
June 20, 2022	WYW					
June 27, 2022	WYW 6-27-22					
July 4, 2022	WYW 7-7-22					
July 11, 2022	WYW 7-11-22					
July 18, 2022	WYW 7-18-22					
July 25, 2022	WYW 7-22-22					
August 1, 2022	WYW 8-1-22					
August 8, 2022	WYW 8-8-22					
August 15, 2022	WYW 8-15-22					
August 22, 2022	WYW 8-22-22					
August 29, 2022	WYW 8-29-22					
September 5, 2022	WYW 9-5-22					
September 12, 2022	WYW 9-12-22					
September 19, 2022	WYW 9-19-22					

EVERY 2 WEEKS

Location	Item	Hours	Weeks	Type	Details	Comments
Uncoiler	Drive motor	300	4	Clean or replace air filter	1 each unit	
Hydraulic Roller Leveler	Pinch roll bearings	300	4	Lubricate-Mobil EP2 grease	2 points - 2 locations	Clean debris and old grease in area. Grease and wipe off excess grease.
Hydraulic Shear	Drive motor	300	4	Clean or replace air filter	1 motor	
Pinch roll	Cooling unit	300	4	Replace filters		
2400 Ton Stretcher	Drive motor	300	4	Clean or replace filter	1 unit	
Steering Pinch Roll	Cooling unit	300	4	Replace filters		
Steering Pinch Roll	Drive motor	300	4	Clean or replace filter	1 motor	
Mechanical Shear	Drive motor	300	4	Clean or replace filter	1 motor	

DUE DATES (WEEK OF)	Completed Initials/DATE	Comments
January 3, 2022		
January 31, 2022		
February 28, 2022		
March 28, 2022		
April 25, 2022		
May 23, 2022		
June 20, 2022	MPW / 6-18-22	
July 18, 2022	MPW 7-12-22	
August 15, 2022	MPW - 8-15-22	
September 12, 2022	MPW - 9-12-22	
October 10, 2022		
November 7, 2022		
December 5, 2022		
January 2, 2023		

Location	Item	Hours	Weeks	Type	Details	Comments
Uncoiler	Camroll bearings	500	6	Lubricate-Mobil EP2 grease	3 points - 2 locations 2 units	Clean debris and old grease.
Uncoiler	Camroll bearing surfaces	500	6	Clean	4 points each unit	Pull surface wipers clean and install.
Snubber & Processor Roll	Roll drive chain	500	6	Lubricate-Mobil EP2 grease	1 chain	Clean debris from and around chain. Brush with grease.
Pinch roll	Upper and lower bearings	500	6	Lubricate-Mobil EP2 grease	2 points - 2 locations	Clean debris and old grease around bearing. Grease and wipe off excess.
Pinch roll	Shaft frame ways	500	6	Lubricate-Mobil EP2 grease	2 points - 2 locations	Clean debris and old grease in area. Grease and wipe off excess grease.
Steering Pinch Roll	Upper and lower pinch rolls	500	6	Lubricate-Mobil EP2 grease	2 points - 2 locations	Clean debris and old grease in area. Grease and wipe off excess grease.
DUE DATES (WEEK OF)						
March 21, 2022	Completed Initials/DATE					Comments
May 2, 2022						
June 13, 2022	<i>WPN 6-14-22</i>					
July 25, 2022	<i>WPN 7-17-22</i>					
September 5, 2022	<i>WPN 9-5-22</i>					
October 17, 2022						
November 28, 2022						
January 9, 2023						
February 20, 2023						
April 3, 2023						

EVERY 6 WEEKS

Location	Item	Hours	Weeks	Type	Details	Comments
Coil Car	Drive wheel chain	750	10	Lubricate-Mobil EP2 grease	1 chain	Clean debris from and around chain. Brush with grease.
Coil Car	Driven wheel chain	750	10	Lubricate-Mobil EP2 grease	1 chain	Clean debris from and around chain. Brush with grease.
Coil Car	Lift guide bearing blocks	750	10	Lubricate-Mobil EP2 grease	1 point - 4 locations	Clean debris and old grease around blocks. Grease and wipe off excess grease.
Coil Car	Lift guide Camroll Bearings	750	10	Lubricate-Mobil EP2 grease	1 point - 4 locations	Clean debris and old grease around camroll. Grease and wipe off excess grease.
Coil Car	Driven Wheel Chain Tensioner	750	10	Lubricate-Mobil EP2 grease	1 point	Clean debris and old grease. Grease and wipe off excess grease.
Coil Car	Drive Roll Pillow Block Bearings	750	10	Lubricate-Mobil EP2 grease	2 points- 12 locations	Clean debris and old grease. Grease and wipe off excess grease.
Coil Conveyor	Chains	750	10	Lubricate-Mobil EP2 grease	38 front side-19 back side	Clean debris from and around chain. Brush with grease.
Uncoiler	Ram slides	750	10	Clean	2 rams	Clean all slide surfaces
DUE DATES (WEEK OF)						
Completed Initials/DATE						
January 31, 2022						
April 11, 2022						
June 20, 2022	WJW - 6-14-22					
August 29, 2022	WJW - 8-29-22					
November 7, 2022						
January 16, 2023						

Location	Item	Hours	Weeks	Type	Details	Comments
Snubber & Processor Roll	roll pillow block bearings	750	10	Lubricate-Mobil EP2 grease	1 point - 2 locations	Clean debris and old grease around blocks. Grease and wipe off excess grease.
Snubber & Processor Roll	Liner guide bearing blocks Op side	750	10	Lubricate-Mobil EP2 grease	2 points - 2 locations	Clean debris and old grease around blocks. Grease and wipe off excess grease.
Snubber & Processor Roll	Liner guide bearing blocks Dry side	750	10	Lubricate-Mobil EP2 grease	2 points - 2 locations	Clean debris and old grease around blocks. Grease and wipe off excess grease.
Snubber & Processor Roll	Back-up roll bearings	750	10	Lubricate-Mobil EP2 grease	2 points - 2 locations	Clean debris and old grease around blocks. Grease and wipe off excess grease.
Snubber & Processor Roll	Work roll bearing blocks	750	10	Lubricate-Mobil EP2 grease	1 point - 2 locations	Clean debris and old grease around blocks. Grease and wipe off excess grease.
DUE DATES (WEEK OF)						
Completed Initials/DATE						
January 31, 2022						
April 11, 2022						
June 20, 2022	WJW - 6-14-22					
August 29, 2022	WJW - 8-29-22					
November 7, 2022						
January 16, 2023						

EVERY 10 WEEKS

Location	Item	Hours	Weeks	Type	Details	Comments
Hydraulic Roller Leveler	Sludge conveyor	750	10	Lubricate-Mobil EP2 grease	2 points - 2 locations	Clean debris and old grease on bearing blocks. Adjust to run straight.
Hydraulic Roller Leveler	Housing guides	750	10	Lubricate-Dow 321 dry film	32 locations	Clean debris and old grease on guides. Coat sides with grease.
Hydraulic Roller Leveler	Upper back-up roll housing large	750	10	Lubricate-Mobil EP2 grease	90 points	Clean debris and old grease on rolls. Grease and wipe off excess grease.
Hydraulic Roller Leveler	Lower back-up roll housing large	750	10	Lubricate-Mobil EP2 grease	108 points	Clean debris and old grease on rolls. Grease and wipe off excess grease.
Hydraulic Roller Leveler	Upper back-up roll housing small	750	10	Lubricate-Mobil EP2 grease	54 points	Clean debris and old grease on rolls. Grease and wipe off excess grease.
Hydraulic Roller Leveler	Lower back-up roll housing small	750	10	Lubricate-Mobil EP2 grease	54 points	Clean debris and old grease on rolls. Grease and wipe off excess grease.
Hydraulic Roller Leveler	Position sensor	750	10	Lubricate-Mobil EP2 grease	14 points	Clean debris and old grease in area. Grease and wipe off excess grease.
Hydraulic Roller Leveler	Upper light rolls	750	10	Lubricate-Mobil EP2 grease	3 points each end	Clean debris and old grease in area. Grease and wipe off excess grease.
Hydraulic Roller Leveler	Lower light rolls	750	10	Lubricate-Mobil EP2 grease	3 points each end	Clean debris and old grease in area. Grease and wipe off excess grease.
Hydraulic Roller Leveler	Upper heavy rolls	750	10	Lubricate-Mobil EP2 grease	5 points each end	Clean debris and old grease in area. Grease and wipe off excess grease.
Hydraulic Roller Leveler	Lower heavy rolls	750	10	Lubricate-Mobil EP2 grease	6 points each end	Clean debris and old grease in area. Grease and wipe off excess grease.
Hydraulic Roller Leveler	Driven splines	750	10	Lubricate-Mobil EP2 grease	17 points	Clean splines and brush with grease.
Hydraulic Roller Leveler Drive Unit	Drive shafts	750	10	Lubricate-Mobil EP2 grease	1 point each end-18 ea.	Clean debris and old grease each end. Grease and wipe off excess grease.
Hydraulic Shear	Rod ends	750	10	Lubricate-Mobil EP2 grease	1 point - 2 locations	Clean debris and old grease in area. Grease and wipe off excess grease.
Hydraulic Shear	Carroll upper	750	10	Lubricate-Mobil EP2 grease	1 point - 4 locations	Clean debris and old grease in area. Grease and wipe off excess grease.
Hydraulic Shear	Carroll lower	750	10	Lubricate-Mobil EP2 grease	1 point - 2 locations	Clean debris and old grease in area. Grease and wipe off excess grease.
Hydraulic Shear	Eccentric bracket	750	10	Lubricate-Mobil EP2 grease	1 point - 4 locations	Clean debris and old grease in area. Grease and wipe off excess grease.
Hydraulic Shear	Pivot pin	750	10	Lubricate-Mobil EP2 grease	1 point - 2 locations	Clean debris and old grease in area. Grease and wipe off excess grease.
Hydraulic Shear	Link	750	10	Lubricate-Mobil EP2 grease	2 points - 2 locations	Clean debris and old grease in area. Grease and wipe off excess grease.
Hydraulic Shear	Strip clamp	750	10	Lubricate-Mobil EP2 grease	1 point - 2 locations	Clean debris and old grease in area. Grease and wipe off excess grease.
DUE DATES (WEEK OF)		Completed Initials/DATE		Comments		
January 31, 2022						
April 11, 2022						
June 20, 2022		JTW 6-14-22				
August 29, 2022		JTW-8-25-22				
November 7, 2022						
January 16, 2023						

1/1/2018

EVERY 10 WEEKS

Location	Item	Hours	Weeks	Type	Details	Comments
Scrap Bucket	Wheels	750	10	Lubricate-Mobil EP2 grease	4 locations	Clean debris and old grease in area. Grease and wipe off excess grease.
Squaring Guide	Cylinder rod bearing	750	10	Lubricate-Mobil EP2 grease	1 point - 2 locations	Clean debris and old grease in area. Grease and wipe off excess grease.
Squaring Guide	Cylinder cap mount	750	10	Lubricate-Mobil EP2 grease	1 point - 2 locations	Clean debris and old grease in area. Grease and wipe off excess grease.
2400 Ton Stretcher	Feed rolls	750	10	Lubricate-Mobil EP2 grease	1 point each end-4 rolls	Clean debris and old grease in area. Grease and wipe off excess.
2400 Ton Stretcher	Conveyor rolls	750	10	Lubricate-Mobil EP2 grease	1 point each end-54 rolls	Clean debris and old grease in area. Grease and wipe off excess.
2400 Ton Stretcher	Camrol enter	750	10	Lubricate-Mobil EP2 grease	1 point - 159 camrols	Clean debris and old grease in area. Grease and wipe off excess.
2400 Ton Stretcher	Camrol exit	750	10	Lubricate-Mobil EP2 grease	1 point - 119 camrols	Clean debris and old grease in area. Grease and wipe off excess.
2400 Ton Stretcher	Stretcher base feed end	750	10	Lubricate-Mobil EP2 grease	3 points - 2 locations	Clean debris and old grease on all flat ways.
2400 Ton Stretcher	Stretcher base operator end	750	10	Lubricate-Mobil EP2 grease	2 points - 2 locations	Clean debris and old grease on all flat ways.
Brush Roller Scale Collector	LM guide bearings	750	10	Lubricate-Mobil EP2 grease	1 point - 4 locations	Clean debris and old grease in area. Grease and wipe off excess grease.
Brush Roller Scale Collector	Arbor pillow block bearings	750	10	Lubricate-Mobil EP2 grease	1 point - 4 locations	Clean debris and old grease in area. Grease and wipe off excess grease.
Brush Roller Scale Collector	Roll engagement hand wheel	750	10	Lubricate-Mobil EP2 grease	1 point - 2 locations	Clean debris and old grease in area. Grease with brush.
Mechanical Shear	Coupling connecting electric	750	10	Replace grease-Mobil EP2	1 unit	Pull fill plug and drain plug. Pump grease in top until clean grease comes out bottom.
Mechanical Shear	Drive motor coupling	750	10	Replace grease-Mobil EP2	1 unit	Pull fill plug and drain plug. Pump grease in top until clean grease comes out bottom.
Measuring Wheel Arrangement	Measurement wheel bearing	750	10	Lubricate-Mobil EP2 grease	1 point	Clean debris and old grease from bearing. Grease and wipe off excess grease.
DUE DATES (WEEK OF)						
January 31, 2022	Completed Initials/DATE					Comments
April 11, 2022						
June 20, 2022	WFW - 6-14-22					
August 29, 2022	WFW - 8-29-22					
November 7, 2022						
January 16, 2023						

Location	Item	Hours	Weeks	Type	Details	Comments
Heavy Duty Plate Stacker	Trunion Blocks	750	10	Lubricate-Mobil EP2 grease	1 point - 20 locations	Clean debris and old grease from block. Grease and wipe off excess grease.
Heavy Duty Plate Stacker	Drop arms	750	10	Lubricate-Mobil EP2 grease	2 points 10 locations	Clean debris and old grease from arms. Grease and wipe off excess grease. Arms must be in down position.
Heavy Duty Plate Stacker	Idle sprocket	750	10	Lubricate-Mobil EP2 grease	1 point - 2 locations	Clean debris and old grease from sprockets. Grease and wipe off excess grease.
Heavy Duty Plate Stacker	Drive chains	750	10	Lubricate-Mobil EP2 grease	4 chains	Clean debris and old grease from chains. Brush with grease.
Heavy Duty Plate Stacker	Chain take up bearings	750	10	Lubricate-Mobil EP2 grease	1 point - 4 locations	Clean debris and old grease from area. Grease and wipe off excess grease.
Heavy Duty Plate Stacker	Clevis	750	10	Lubricate-Mobil EP2 grease	1 point - 10 locations	Clean debris and old grease from area. Grease and wipe off excess grease.
Heavy Duty Plate Stacker	Clevis bracket	750	10	Lubricate-Mobil EP2 grease	2 points 10 locations	Clean debris and old grease from area. Grease and wipe off excess grease.
Heavy Duty Plate Stacker	Slide base assembly - 4 units	750	10	Lubricate-Mobil EP2 grease	4 points - 4 locations	Clean debris and old grease from area. Grease and wipe off excess grease.
Auto Pack Receiving Table	Base rollers	750	10	Clean rollers and plates		Clean debris around and on plates and rollers.
Roller Leveler Cartridge Support	Idle sprocket	750	10	Lubricate-Mobil EP2 grease	1 location	Clean debris and old grease from sprocket. Grease and wipe off excess grease.
Roller Leveler Cartridge Support	Chain	750	10	Lubricate-Mobil EP2 grease	1 chain	Clean debris and old grease from chain. Brush with grease.
Comments						
DUE DATES (WEEK OF)	Completed Initials/DATE					
January 31, 2022						
April 11, 2022						
June 20, 2022	WYW 6-14-22					
August 29, 2022	WYW 8-29-22					
November 7, 2022						
January 16, 2023						

Location	Item	Hours	Weeks	Type	Details	Comments
Coil Conveyor	Roll Bearings	1,000	13	Dow Molykote G4700 grease	120 locations	

DUE DATES (WEEK OF)	Completed Initials/DATE	Comments
May 2, 2022		
August 1, 2022	8-1-22	
October 31, 2022		
January 30, 2023		
May 1, 2023		

Location	Item	Hours	Weeks	Type	Details	Comments
Squaring Guide	Cylinder rod bearing	1,500	19	Lubricate-Mobil EP2 grease	1 point - 2 locations	Clean debris and old grease each end. Grease and wipe off excess grease.
Squaring Guide	Cylinder cap mount bearing	1,500	19	Lubricate-Mobil EP2 grease	1 point - 2 locations	Clean debris and old grease each end. Grease and wipe off excess grease.
Thickness Measurement System	Idle conveyor rolls	1,500	19	Lubricate-Mobil EP2 grease	4 points each end	Clean debris and old grease in area. Grease and wipe off excess grease.
Mechanical Shear	Electric cylinder	1,500	19	Lubricate-Mobil EP2 grease	3 points - 2 locations	Clean debris and old grease in area. Grease and wipe off excess grease.
Mechanical Shear	Guiding stationary camrolls	1,500	19	Lubricate-Mobil EP2 grease	3 points - 2 locations	Clean debris and old grease in area. Grease and wipe off excess grease.
Mechanical Shear	Eccentric arm/camfollower	1,500	19	Lubricate-Mobil EP2 grease	2 points - 2 locations	Clean debris and old grease in area. Grease and wipe off excess grease.
Mechanical Shear	Lift bar wear bars	1,500	19	Lubricate-Mobil EP2 grease	1 point - 2 locations	Clean debris and old grease in area. Grease and wipe off excess grease.
Mechanical Shear	Knife holder moving camrolls	1,500	19	Lubricate-Mobil EP2 grease	2 points - 2 locations	Clean debris and old grease in area. Grease and wipe off excess grease.
Mechanical Shear	Cartridge tray flange bearings	1,500	19	Lubricate-Mobil EP2 grease	10 points	Clean debris and old grease in area. Grease and wipe off excess grease.
Mechanical Shear	Cartridge tray chain	1,500	19	Lubricate-Mobil EP2 grease	2 chains	Clean debris and old grease on chain. Brush on grease.
Heavy Duty Plate Stacker	Bearing blocks	1,500	19	Lubricate-Mobil EP2 grease	1 point - 4 locations	Clean debris and old grease from bearings. Grease and wipe off excess grease.
Heavy Duty Plate Stacker	End cam roll	1,500	19	Lubricate-Mobil EP2 grease	1 point - 2 locations	Clean debris and old grease from area. Grease and wipe off excess grease.
Heavy Duty Plate Stacker	End stop hinge assembly	1,500	19	Lubricate-Mobil EP2 grease	1 point - 2 locations	Clean debris and old grease from area. Grease and wipe off excess grease.
Heavy Duty Plate Stacker	Cam rolls	1,500	19	Lubricate-Mobil EP2 grease	1 point - 100 locations	Clean debris and old grease from rolls. Grease and wipe off excess grease.
Auto Pack Receiving Table	Roll drive connecting chains	1,500	19	Lubricate-Mobil EP2 grease	20 chains 2 conveyors	Clean debris and old grease from chains. Brush with grease.
Run out Conveyor	Chain	1,500	19	Lubricate - machine oil	21 chains - 3 conveyors	Clean debris from chains. Brush with oil.

DUE DATES (WEEK OF)	Completed Initials/DATE	Comments
April 25, 2022		
September 5, 2022	9-5-22 <i>WJW</i>	
January 16, 2023		
May 29, 2023		

Location	Item	Hours	Weeks	Type	Details	Comments
Uncoiler	Motor reducer	2,000	25	Change oil-VG220 Mobil SHC	1 each unit	Drain oil and clean area. Refill with oil. 5.2 gal.
Snubber & Processor Roll	Motor reducer	2,000	25	Change oil-VG220 Mobil	1 unit	Drain oil and clean area. Fill with oil. .4 gal.
Hydraulic Roller Leveler Drive Unit	Pinch roll gearbox	2,000	25	Change oil-VG220 Mobil gear	2 units	Drain oil and clean gearbox. Refill with oil. 1.2 gal.
Hydraulic Roller Leveler Drive Unit	Light roll gearbox	2,000	25	Change oil-VG220 Mobil gear	6 units	Drain oil and clean gearbox. Refill with oil. .1 gal.
Hydraulic Roller Leveler Drive Unit	heavy roll gearbox	2,000	25	Change oil-VG220 Mobil gear	10 units	Drain oil and clean gearbox. Refill with oil. .7 gal
Pinch roll	Motor reducer	2,000	25	Change oil-VG220 Mobil	1 unit	Drain oil and clean reducer. Refill with oil. 2.5 gal
Steering Pinch Roll	Drive reducer	2,000	25	Change oil-VG220 Mobil	1 unit	Drain oil and clean reducer. Fill with oil. 2.4 gal
Mechanical Shear	Shear drive reducer	2,000	25	Change oil-VG220 Mobil	1 unit	Drain oil and clean reducer. Fill with oil. 2.4 gal.

DUE DATES (WEEK OF)	Completed Initials/DATE	Comments
March 7, 2022		
August 29, 2022	8-29-22 WPH	
February 20, 2023		

Location	Item	Hours	Weeks	Type	Details	Comments
Uncoiler	Main shaft coupling	3,000	38	Change grease-Mobil EP2	1 unit	Pull fill plug and drain plug. Pump grease in top until clean comes out bottom.
Uncoiler	Motor coupling	3,000	38	Change grease-Mobil EP2	1 unit	Pull fill plug and drain plug. Pump grease in top until clean comes out bottom.
Hydraulic Roller Leveler Drive Unit	Light roll coupling	3,000	38	Change grease-Mobil EP2	2 units	Pull fill plug and drain plug. Pump grease in top until clean comes out bottom.
Hydraulic Roller Leveler Drive Unit	Heavy roll coupling	3,000	38	Change grease-Mobil EP2	6 units	Pull fill plug and drain plug. Pump grease in top until clean comes out bottom.
Pinch roll	Main shaft coupling	3,000	38	Replace grease-Mobil EP2	1 unit	Pull fill plug and drain plug. Pump grease in top until clean grease comes out bottom
Pinch roll	Motor coupling	3,000	38	Replace grease-Mobil EP2	1 unit	Pull fill plug and drain plug. Pump grease in top until clean grease comes out bottom
Steering Pinch Roll	Motor coupling	3,000	38	Replace grease-Mobil EP2	1 unit	Pull fill plug and drain plug. Pump grease in top until clean grease comes out bottom.
Steering Pinch Roll	Drive coupling	3,000	38	Replace grease-Mobil EP2	1 unit	Pull fill plug and drain plug. Pump grease in top until clean grease comes out bottom.

DUE DATES (WEEK OF)	Completed Initials/DATE	Comments
April 4, 2022		
December 26, 2022		
September 18, 2023		

Location	Item	Hours	Weeks	Type	Details	Comments
Coil Car	Hydraulic unit	4,000	50	Change oil & filter		Drain oil and clean area around unit. Replace filter and refill oil.
Coil Car	Hydraulic pump motor	4,000	50	Lubricate-Mobil EP2 grease	1 motor	1 pump of grease at each location
Uncoiler	Drive motor	4,000	50	Lubricate-Mobil EP2 grease	1 each unit	1 pump of grease at each location.
Hydraulic Roller Leveler Drive Unit	Drive motors	4,000	50	Lubricate-Mobil EP2 grease	18 motors	One pump of grease at each location.
Hydraulic Shear	Drive motor	4,000	50	Lubricate-Mobil EP2 grease	1 motor	One pump of grease at each location.
Pinch roll	Drive motor	4,000	50	Lubricate-Mobil EP2 grease	1 motor	One pump of grease at each location.
Brush Roller Scale Collector	Drive motors	4,000	50	Lubricate-Mobil EP2 grease	2 motors	One pump of grease at each location.
Steering Pinch Roll	Drive motor	4,000	50	Lubricate-Mobil EP2 grease	1 motor	One pump of grease at each location.
Mechanical Shear	Electric cylinder motor	4,000	50	Lubricate-Mobil EP2 grease	1 motor	One pump of grease at each location.
Mechanical Shear	Drive motor	4,000	50	Lubricate-Mobil EP2 grease	1 motor	One pump of grease at each location.

DUE DATES (WEEK OF)	Completed Initials/DATE	Comments
March 7, 2022		
February 20, 2023		
February 5, 2024		

Location	Item	Hours	Weeks	Type	Details	Comments
Roller Leveler Cartridge Support	Gear reducer	10,000	126	Change oil-VG220 Mobil	1 gearbox	Drain oil and clean gearbox. Fill with oil.

DUE DATES (WEEK OF)	Completed Initials/DATE	Comments
5/30/2022		
10/28/2024		
March 29, 2027		

EVERY 126 WEEKS