

Audit Review and Evaluations of JEMISON METALS

**3001 Hickory Street
Gadsden, AL 35954**

Dates of Audit: 9/20/22 – 9/21/22
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, JDM200 Quality Policy 7.21.18 Rev-1, GAD-VA-009 5.7.20 Rev 1 at laser, GAD020 1/5/21 Rev 2 at laser, Jemison created part print GFI02 Rev 0. Electronic GAD-VA-008 4.5.19 Rev 0 in shipping.

7 Support

Employees appeared competent and well trained. Adequate resources (gauges, safety equipment, operating equipment, and environment) were observed during the audit with the following observation: **OBS#1 Micrometers, tape measures & calipers could be better organized with additional measuring tools located strategically throughout the plant. It was noted that some operators were sharing measuring tools and would sometimes have to go find measuring tools to perform first piece inspections.**

7.2 Competence

Interviewed Adam Ryan 1st shift in receiving, Kenneth Kuzmicki on 1st shift Laser 5, Bobby Lowe on 2nd shift Laser 3, Jayden Flores on 2nd shift shipping, Phillip Mathis regarding preventive maintenance, Sarah Stanford regarding Purchasing, and Denise Clayton regarding sales. Phillip, Sarah & Denise are all veteran employees and are familiar with the quality policy and their roles. Adam Ryan has been in receiving for approximately 3 months and was previously a laser operator. Adam was familiar with and could pull up the electronic receiving procedure. Kenneth, Bobby, and Jayden each have 1-2 years' experience in their roles and appeared competent with their respective responsibilities.

8.2 Requirements for products and services

Contract Review/Order Acknowledgement: Kirby PO 106505 (copy included in notes) for Part GFI02 (which was audited on laser 5) was received by Denise Clayton, in sales. The PO was acknowledged via email on 8/24/22.

Purchasing: Receiver 61209, material from Phoenix Metals, was reviewed with Purchasing (Sarah Stanford). This material was purchased on PO GAD-22425. This material supports a “spot buy” bucket, which means it is low enough volume that Jemison does not purchase master coil directly from a steel mill. Sarah stated that the size (gauge, width, length) and grade were dictated by the WIP sheet size for the final part.

8.4 Control of externally provided processes, products and services

Receiving: Receiver# 61209 was received in against PO GAD-22425 to Phoenix Metals. 65 pieces of .0747 48x120 material was received and became Jemison Tag 76566, mill tag 2187780.

8.5-Production & Service Provisions

Production:

1st Shift, Laser 5: Work Order GAD 162992, Kirby Building, Part GFI02, Program 32427 was observed. Kenneth Kuzmicki was the operator. First piece inspection was documented (see notes). All measurements except for material thickness were in tolerance. Material thickness was out of tolerance per the JemPrint, but was in tolerance on the work order (from Stelplan). **Minor Finding #1: JemPrint Rev 0 had thickness as .1795-.1955 (fixed same day)**, while the Part spec/Stelplan had .179 +/- .008”

2nd Shift, Laser 3: Work Order GAD 163029, Heil Fab, Part 311-5107-001, Program 31501 was observed. Bobby Lowe was the operator.

Shipping: 2nd shift shipping personnel (Jayden Flores) was interviewed. Jayden has been with Jemison 1.5-2 years. Loading Order 117256 for Bush Hog was being prepared. Line 1 was for part 50080053 calling for Tag 321443 (3pcs) was observed and verified as being staged for 1st shift loading tomorrow.

7.1.3 Infrastructure

Preventive Maintenance: Gadsden is the first Jemison location to implement eMaint maintenance software. Preparations began in Q4 2021 and went live in Q2 2022. Gadsden also went from 2 maintenance technicians to 4 maintenance technicians and represents the significant resource investment to maintain all of the machines and improve uptime.

GL5 (Gadsden Laser 5) weekly PM schedule was reviewed on eMaint. Last completed on 9/20/22 by Logan Shinn. Previous PM dates for GL5 were 9/12/22, 9/8/22 and 9/1/22. The 9/12/22 work order reported Y&Z axis bellows torn and needed replacement. This was reported on 9/14/22 and work order #797 was created to do this replacement and was completed the same day.

eMaint utilizes a schedule and work order system for PM and a work order request and work order system for Maintenance Requests from Operations.

7.1.5 Monitoring and Measuring Resources

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

Receiving:

25' Tape Measure T3060 calibrated 3/25/22, due 3/25/23

0-1" Micrometer M007 calibrated 5/26/22, due 5/26/23

Scale S/N C007008257, Model TND246, calibrated 8/12/22, due 11/22

Laser 5:

0-1" Mic M003, calibrated 2/17/22, due 2/17/23

12" Caliper C006, calibrated 5/26/22, due 5/26/23

Laser 3:

16' Tape Measure TM014 calibrated 11/19/21, due 11/19/22

0-1" Mic M008, calibrated 11/30/22, due 11/30/23

12" Caliper C005, calibrated 11/20/21, due 11/20/22

8.7 Control of Nonconforming Product

Nonconforming area was well delineated and identified. 3 tags from the non-conforming area were researched. Tag 321916, .056 x 55.00" coil 4,760 lbs dated 9/13/22. This tag was being claimed back to the steel mill. Original coil was overweight causing this part of the slit coil to drag in the slitter. Mill received approval to ship this overweight coil knowing a portion would be claimed. Tags BH46831 (7pcs) & BH46832 (13pcs). These 2 tags were a customer return for 20 pieces over shipped due to a sales error. They will be put back into finished goods pending finalization of the receiver (RMA Case 23870).

10.2 Nonconformity and Corrective Action

External DPPM performance YTD is 2513, which is below the stated goal of <3000DPPM. There was a spike in April (9685) & May (5618). The issue in April was a packaging issue with Daimler trucks, material was ok. The May issue was rolled edges on slit coil for Daimler.

Corrective Action 22126 from internal audit 9/29/21 was closed on 12/10/21.

10. Improvement

Lighting switched to LED to improve visibility, safety and cost.

Implementation of eMaint maintenance software and adding 2 maintenance techs.

2 additional fiber lasers and 2 additional press brakes

Moved away from 24/7 "McDonald's" schedule due to increased machine uptime and able to reduce number of shifts and reduce overtime hours.

2.0 Overview

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

Adam Ryan - Receiving Kenneth Kuzmicki – Laser Bobby Lowe – Laser 2 nd Shift Jayden Flores – Shipping 2 nd Shift	Phillip Mathis – Maintenance Sarah Stanford - Purchasing Denise Clayton – Inside Sales
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2.2 Audited Requirements

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

Report Prepared by 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	7.1.5	OBS#1: Micrometers, tape measures & calipers could be better organized with additional measuring tools located strategically throughout the plant. It was noted that some operators were sharing measuring tools and would sometimes have to go find measuring tools to perform first piece inspections.	X		
1	8.5	Minor Finding #1: JemPrint Rev 0 had thickness as .1795-.1955 (fixed same day), while the Part spec/Stelplan had .179 +/- .008"		X	



JEMISON METALS

DATE: 9/20 Tues.

TO: Internal Audit GAD

FROM:

Adam Ryan - Rcvg March 2022
in Rcvg ~ 3 mos. Previously Laser Operator
Found Rcvg Procedure

Receiver # 61209 on PO GAD 22425 from Phoenix Metals
65 pcs .0747 48X120 Became Tag 76566, Mill Tag 2187780
2 Bundles Both Tag 76566.

Kenneth Kozmicki Laser 5 1st Shift
Job 162992 - Kirby Building
Part GFIO2, Program 32427 ✓
A572 Gr 50

3/25/22 due 3/25/23
✓ Tape Measure - Adam Milwaukee 25'
5/26/22 due 5/26/23
✓ Mic 0-1" GL6 M007 3060
✓ Scale 8/12/22 due 11/22
S/N C007008257
Model IND 246

✓ Tem Print Rev. 0 Cost Rev. .176 Thickness (.1795-.1955) .179 Nom +/- .008
in Steelplan.
✓ 0-1" Mic M003 GL5 2/17/22 due 2/17/23 ~~8.006~~ (7.88-8.12) ★ MF #1 Temprint + Port
Spec didn't Match
- Fixed Same day
✓ 12" Caliper C006 GL5 5/26/22 due 5/26/23 2.444 (2.36-2.50)
7.504 (7.36-7.62)

OBS #1

had to go
to Laser 2
to get
Calipers

Bobby Lowe - 2nd Shift Laser 3 ~ 2 yrs

Revision A

163029 Getting Ready to Run Hal Fab 10/31-5107-001 Program 31501

usc Tag 322425 1/4" 5550 62.5 x 90" 3 pcs. No Tem Print → Christine
Length 26.50" (26.5 +/- .06), .235" thick (.235-.265), 2.00" width (2.00 +/- .03)

✓ 0-1" Mic M008, GL3 11/30/22 due 11/30/23
✓ TM 014 11/19/21 due 11/19/22
✓ 16' Tape 11/20/21 due 11/20/22
✓ 12" Caliper C005 GL2

Jayden Flores 2nd Shift Shipping 1.5 - 2 yrs.

Loading Order 117256 Bush Hog Line1 50080053 Part #

Tag 321443 3 pcs. ✓ Staging for 1st Shift.



JEMISON METALS

DATE: 9/21 Wed,

TO: Day 2 Internal Audit GAD

FROM:

Preventive Maintenance

G-LS Weekly PM Schedule

Last Completed 9/20/22 by Logan Shinn

Previous Dates: 9/12/22, 9/8/22, 9/1/22.

Gadsden is the first location to implement eMaint. Software. Prep began Q4 2021 + went Live in Q2 2022. Also went from 2 maint. personnel to 4.

9/12/22 work order reported 4+2 axis bellows torn + needed replaced. Reported on 9/14/22 WO# 797 created to do this replacement. Completed same day.

Sales - Kirby GFIO2 from Laser 5 Denise Clayton Inside Sales

PO# 106505 emailed on 8/23/22. Acknowledged on 8/24/22

~~Due~~
Purchasing - Sarah Stanford via email Re: Phoenix Metals reviewed at receiving Receiver# 61209 PO GAD 22425

Bucket is a spot buy bucket due to low volume. Size + grade dictated by WIP sheet size, although had to buy a longer length due to availability.

Non Conforming Area - Well delineated & Identified

Tag 321916 in GRJ overweight coil in GMC .056 x 55.00 Coil Grade SS55. 4,670 lbs. Tag date 9/13/22. Mill shipped coil over PO. Weight. Coordinated with mill to scrap a portion of coil prior to running. This weight (Linear footage) would cause some material to bottom out in slitter looping pit. Tags BH 46831 (7 pcs) + BH 46832 (13 pcs). Customer return for 20 pc. overshipment due to sales error. In GRJ pending receiver + Return. pMA Case# 23870

CA 22126 from internal audit 9/29/21. Closed on 12/10/21

PURCHASE ORDER

PO Number: PO106505 ✓

Date: 8/23/2022



PO Box 390 Portland TN 37148

J0044

Vendor: JEMISON METALS

P.O. BOX 2153

DEPARTMENT 3137

BIRMINGHAM, AL 35287-3137

This PO number must appear on all packages, invoices and packing lists.

Receiving Hours are M-F 6:00 AM - 2:00 PM
For Steel Receiving Appointments call 615-745-6095

Email Invoices to ap@kirbybuildingsystems.com

Ship To: KIRBY BUILDING SYSTEMS

124 KIRBY DRIVE

PORTLAND, TN 37148

Contact: 615-325-4165

Buyer		Payment Terms		Job Number		Job Name	
Jaska Ward		NET 30					
Line	Item Number Description	Required Date	Qty Ordered	U/M	Unit Price	Extended Price	
1	GF102 ✓ WELDED FLUSH INSET GIRT CLIP 1300-03 INVENTORY - STEEL - STRUCTURAL	9/6/2022	4,000	EA	\$6.25	\$25,000.00	

ORDER TOTAL \$25,000.00

Jaska Ward

Authorized Signature

Sales Tax Exempt No. SR KH 101-049183

Notice: OSHA from OMB NO. 44-R1387 Material Safety Data Sheet is Required for all pertinent Material(s) ordered on this Purchase Order.

By acceptance and acknowledgement of this order, vendor agrees to furnish materials and/or services in accordance with all terms on the obverse and final page.

Rick Rowland

From: Denise Clayton
Sent: Wednesday, September 21, 2022 8:57 AM
To: Rick Rowland
Subject: FW: PO106505
Attachments: PO106505.pdf

See attached po and confirmation back. Let me know if you need anything else, Thanks

Denise Clayton | Inside Sales Representative Jemison Metals
3001 Hickory St.
Gadsden, AL 35904
Direct / M (256) 393-3868
F (205) 449-9941
dclayton@jemisonmetals.com

Informed when we buy.
Transparent when we sell.

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

From: Ward, Jaska (KBS) <jaska.ward@kirbybuildingsystems.com>
Sent: Wednesday, August 24, 2022 10:21 AM
To: Denise Clayton <dclayton@jemisonmetals.com>
Subject: RE: PO106505

Thank you!

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

From: Denise Clayton <dclayton@jemisonmetals.com>
Sent: Wednesday, August 24, 2022 10:18 AM
To: Ward, Jaska (KBS) <jaska.ward@kirbybuildingsystems.com>
Subject: [EXT] RE: PO106505

*Acknowledged Next day
via email.*

This message came from outside of Nucor.

Good morning, confirming receipt of PO, and will advise on ready date. Thanks

Denise Clayton | Inside Sales Representative Jemison Metals
3001 Hickory St.
Gadsden, AL 35904
Direct / M (256) 393-3868
F (205) 449-9941
dclayton@jemisonmetals.com

Informed when we buy.
Transparent when we sell.

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

From: Ward, Jaska (KBS) <jaska.ward@kirbybuildingsystems.com>
Sent: Tuesday, August 23, 2022 4:27 PM
To: Denise Clayton <dclayton@jemisonmetals.com>
Subject: PO106505

Denise,

Please see attached PO106505. ✓

Thanks,

Jaska Ward
Buyer

Kirby Building Systems
124 Kirby Drive . Portland, TN 37148
Phone: 615.745.6022
Jaska.Ward@kirbybuildingsystems.com

ALL INVOICES MUST BE SENT TO AP@KIRBYBUILDINGSYSTEMS.COM

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Work Order

WO No.: 837
WO Date: 09/19/2022
WO Time: 01:08:21

Project #:
Sched. Date:

Est. Hours: 2.00

Asset ID: LASER_05_TR
Asset Description: LASER Cutter 5 - TruLASER 3040 / TruDis

Department: PRODUCTION
Site: Gadsden

Request #:
Requested By: P.M. Schedule

Assign To Type: Technician
Assign To:

Jemison Metals (Logan Shinn)

Open / History: H
Job Status: Completed
WO Type: PM
Problem Type:
Completed Date: 09/20/2022
Downtime: 0.50

Building: Plant 1
Floor: BAY 2 MD

Req. Telephone:
Req. E-mail:

Perform For Type: Employee
Perform For: Jemison
Metals
(Phillip
Mathis)

Brief Description: WEEKLY PM SCHEDULE- TRUMPF

Work Description: 1. BLOW OUT OR REPLACE BOTH CHILLER FILTERS 2. CHECK WATER LEVELS ON BOTH THE CHILLER CABINET AND THE RESONATOR CABINET 3. CHECK THE HYDRAULIC OIL LEVEL FOR THE PALLET CHANGER 4. CHECK TO MAKE SURE BOTH LUBES, THE GREASE AND OIL, CONTAINERS ARE AT GOOD LEVELS SO THAT THEY WILL NOT RUN OUT BEFORE THE NEXT CHECK IS DONE. 5. CHECK TO MAKE SURE FLOOR PLATES ARE IN PLACE FOR SAFETY 6. CHECK TO MAKE SURE ALL COVERS ARE IN PLACE ON THE ENCLOSURE. ALSO THAT THE TOP DOOR AND FRONT DOOR, ALSO THE PALLET DOOR WORKS PROPERLY AND THE MACHINE WILL NOT OPERATE IF ONE IS OPEN. 7. CHECK TO MAKE SURE THERE IS NO DAMAGE TO ANY OF THE CONDUIT, PIPING AND FAN CORDS THAT ARE USED IN THE AREA. AS TO LEAVE ANY UNSAFE CONDITION OR LEAKS. 8. VISUALLY CHECK TO MAKE SURE THERE ARE NO PREVENTABLE TRIP HAZARDS THAT CAN BE CORRECTED BY HOUSEKEEPING OR REARRANGE OF WORK MATERIAL. 9. VISUALLY CHECK BELLOWS FOR TEARS OR CRACKS

Insp. Round WO#:

Comments: Scheduled PM check was completed.

Work Order Charges

Tranid	Category	WoContactid	Tran date	Qty	Unitcost	Extcost	Comment	Sub Category	Acct_no
6FL0147Y6	Technician	837 LSHINN - Logan Shinn	09/20/2022	0.50	37.00	18.50			
Sub				0.50		18.50			
Total				0.50		18.50			

Employee Comments

Employee 1:

Employee 2:

Employee 3:

Employee 4:

Employee 5:

Work Order Charges

Tranid	Category	WoContactid	Tran date	Qty	Unitcost	Extcost	Comment	Sub Category	Acct_no
6FL0147Y6	Technician	837 LSHINN - Logan Shinn	09/20/2022	0.50	37.00	18.50			
Sub				0.50		18.50			
Total				0.50		18.50			

Work Order

WO No.: 724
WO Date: 09/12/2022
WO Time: 01:08:24

Open / History: H
Job Status: Completed
WO Type: PM
Problem Type:
Completed Date: 09/14/2022
Downtime: 0.50

Project #:
Sched. Date:

Est. Hours: 2.00

Asset ID: LASER_Q5_TR
Asset Description: LASER Cutter 5 - TruLASER 3040 / TruDis

Department:
Site: Gadsden

Request #:
Requested By: P.M. Schedule

Assign To Type: Technician
Assign To:

Jemison Metals (Logan Shinn)

Building: Plant 1
Floor:

Req. Telephone:
Req. E-mail:

Perform For Type: Employee
Perform For: Jemison
Metals
(Phillip
Mathis)

Brief Description: WEEKLY PM SCHEDULE- TRUMPF

Work Description: 1. BLOW OUT OR REPLACE BOTH CHILLER FILTERS 2. CHECK WATER LEVELS ON BOTH THE CHILLER CABINET AND THE RESONATOR CABINET 3. CHECK THE HYDRAULIC OIL LEVEL FOR THE PALLET CHANGER 4. CHECK TO MAKE SURE BOTH LUBES, THE GREASE AND OIL, CONTAINERS ARE AT GOOD LEVELS SO THAT THEY WILL NOT RUN OUT BEFORE THE NEXT CHECK IS DONE. 5. CHECK TO MAKE SURE FLOOR PLATES ARE IN PLACE FOR SAFETY 6. CHECK TO MAKE SURE ALL COVERS ARE IN PLACE ON THE ENCLOSURE. ALSO THAT THE TOP DOOR AND FRONT DOOR, ALSO THE PALLET DOOR WORKS PROPERLY AND THE MACHINE WILL NOT OPERATE IF ONE IS OPEN. 7. CHECK TO MAKE SURE THERE IS NO DAMAGE TO ANY OF THE CONDUIT, PIPING AND FAN CORDS THAT ARE USED IN THE AREA. AS TO LEAVE ANY UNSAFE CONDITION OR LEAKS. 8. VISUALLY CHECK TO MAKE SURE THERE ARE NO PREVENTABLE TRIP HAZARDS THAT CAN BE CORRECTED BY HOUSEKEEPING OR REARRANGE OF WORK MATERIAL. 9. VISUALLY CHECK BELLOWS FOR TEARS OR CRACKS

Insp. Round WO#:

Comments: Scheduled PM was completed. Both Y-axis bellows and Z-axis bellows are torn and need to be replaced.

Work Order Charges

Transid	Category	WoContactid	Trandate	Qty	Unitcost	Extcost	Comment	Sub Category	Acct no
6FF12L4CD	Technician	724 LSHINN Logan Shinn	09/14/2022	0.50	37.00	18.50			
Sub				0.50		18.50			
Total				0.50		18.50			

Employee Comments

Employee 1:

Employee 2:

Employee 3:

Employee 4:

Employee 5:

Work Order Charges

Transid	Category	WoContactid	Trandate	Qty	Unitcost	Extcost	Comment	Sub Category	Acct no
6FF12L4CD	Technician	724 LSHINN Logan Shinn	09/14/2022	0.50	37.00	18.50			
Sub				0.50		18.50			
Total				0.50		18.50			

Work Order

WO No.: 797
 WO Date: 09/14/2022
 WO Time: 05:56:26 PM
 Project #:
 Sched. Date: 09/30/2022
 Est. Hours: 2.00

Open / History: H
 Job Status: Completed
 WO Type: REACTIVE
 Problem Type: MECHANICAL
 Completed Date: 09/14/2022
 Downtime: 0.00

Asset ID: LASER_05_TR
 Asset Description: LASER Cutter 5 - TruLASER 3040 / TruDis
 Department: PRODUCTION
 Site: GADSDEN

Building: PLANT 1
 Floor:

Request #: 00180
 Requested By: LOGAN SHINN

Req. Telephone: 256-549-5546
 Req. E-mail: pmathis@jemisonmetals.com

Assign To Type: Technician
 Assign To: Jemison Metals (Chris Ellis)

Perform For Type: Employee
 Perform For: Jemison Metals (Phillip Mathis)

Brief Description: BELLOWS NEED REPLACED
 Work Description: Both Y-axis bellows and Z-axis bellows are torn and need to be replaced. [NOTED ON LOGAN'S PM]

Insp. Round WO#:

Comments: CHRIS- WILL YOU LET ME KNOW IF LOGAN HAS BEEN TRAINED ON HOW TO REPLACE THESE BELLOWS? I'D ASSIGN IT TO HIM BUT I WASN'T SURE ... UPDATE 9/19/2022 Sorry, the y bellows has been replaced but it seems that we have no z bellows on hand. They may be on back order. What does the inventory reflect and I'll update the wo. PHILLIP - WE SHOW 2 IN INVENTORY, CHRIS WILL VERIFY. IF NOT ON HAND WE WILL NEED TO ORDER

I found 2 bellows for the Z axis. 1 was use for this W/O, 2 Y bellows were used for this W/O as well. Cost for parts unknown to me, labor 2hrs.

Work Order Charges

Tranid	Category	WoContactId	TranDate	Qty	Unitcost	Extcost	Comment	Sub Category	Acct no
Parts									
6FK0MXH2A	Parts	797	TRUMPF1931838 - BELLOWS, FOLDING Y AXIS	09/19/2022	1.00	2,042.00	2,042.00	Part	
6FK0N85CM	Parts	797	1595345 - Bellows Z Axis	09/19/2022	1.00	678.90	678.90	Part	
Sub				2		2720.90			
Technician									
6FL0J3QAZ	Technician	797	C.ELLIS - Chris Ellis	09/20/2022	2.00	37.00	74.00		
Sub				2.00		74.00			
Total				4.00		2,794.90			

Employee Comments

Employee 1:

Employee 2:

Employee 3:

Employee 4:

Employee 5:

Work Order Charges

Tranid	Category	WoContactId	TranDate	Qty	Unitcost	Extcost	Comment	Sub Category	Acct no
Parts									
6FK0MXH2A	Parts	797	TRUMPF1931838 - BELLOWS, FOLDING Y AXIS	09/19/2022	1.00	2,042.00	2,042.00	Part	
6FK0N85CM	Parts	797	1595345 - Bellows Z Axis	09/19/2022	1.00	678.90	678.90	Part	
Sub				2		2720.90			
Technician									
6FL0J3QAZ	Technician	797	C.ELLIS - Chris Ellis	09/20/2022	2.00	37.00	74.00		
Sub				2.00		74.00			
Total				4.00		2,794.90			

Employee Comments

Employee 1:

Employee 2:

Employee 3:

Employee 4:

Employee 5:

Work Order

WO No.: 673
 WO Date: 09/08/2022
 WO Time: 01:08:23

Project #:
 Sched. Date:

Est. Hours: 2.00

Asset ID: LASER_05_TR
 Asset Description: LASER Cutter 5 - TruLASER 3040 / TruDis

Department:
 Site: Gadsden

Request #:
 Requested By: P.M. Schedule

Assign To Type: Technician
 Assign To:

Jemison Metals (Logan Shinn)

Brief Description: WEEKLY PM SCHEDULE- TRUMPF

Work Description: 1. BLOW OUT OR REPLACE BOTH CHILLER FILTERS 2. CHECK WATER LEVELS ON BOTH THE CHILLER CABINET AND THE RESONATOR CABINET 3. CHECK THE HYDRAULIC OIL LEVEL FOR THE PALLET CHANGER 4. CHECK TO MAKE SURE BOTH LUBES, THE GREASE AND OIL, CONTAINERS ARE AT GOOD LEVELS SO THAT THEY WILL NOT RUN OUT BEFORE THE NEXT CHECK IS DONE. 5. CHECK TO MAKE SURE FLOOR PLATES ARE IN-PLACE FOR SAFETY 6. CHECK TO MAKE SURE ALL COVERS ARE IN PLACE ON THE ENCLOSURE. ALSO THAT THE TOP DOOR AND FRONT DOOR, ALSO THE PALLET DOOR WORKS PROPERLY AND THE MACHINE WILL NOT OPERATE IF ONE IS OPEN. 7. CHECK TO MAKE SURE THERE IS NO DAMAGE TO ANY OF THE CONDUIT, PIPING AND FAN CORDS THAT ARE USED IN THE AREA. AS TO LEAVE ANY UNSAFE CONDITION OR LEAKS. 8. VISUALLY CHECK TO MAKE SURE THERE ARE NO PREVENTABLE TRIP HAZARDS THAT CAN BE CORRECTED BY HOUSEKEEPING OR REARRANGE OF WORK MATERIAL. 9. VISUALLY CHECK BELLOWS FOR TEARS OR CRACKS

Comments: Scheduled PM check was complete.

Open / History: H
 Job Status: Completed
 WO Type: PM
 Problem Type:
 Completed Date: 09/08/2022
 Downtime: 0.50

Building: Plant 1
 Floor:

Req. Telephone:
 Req. E-mail:

Perform For Type: Employee
 Perform For: Jemison
 Metals
 (Phillip
 Mathis)

Insp. Round WO#:

Work Order Charges

Tranid	Category	WoContactid	TranDate	Qty	Unitcost	Extcost	Comment	Sub-Category	Acct no
Technician									
6F9129V5Z	Technician	673 L.SHINN - Logan Shinn	09/08/2022	0.50	37.00	18.50			
Sub				0.50		18.50			
Total				0.50		18.50			

Employee Comments

Employee 1:

Employee 2:

Employee 3:

Employee 4:

Employee 5:

Work Order Charges

Tranid	Category	WoContactid	TranDate	Qty	Unitcost	Extcost	Comment	Sub-Category	Acct no
Technician									
6F9129V5Z	Technician	673 L.SHINN - Logan Shinn	09/08/2022	0.50	37.00	18.50			
Sub				0.50		18.50			
Total				0.50		18.50			

Work Order

WO No: 589

WO Date: 09/01/2022

WO Time: 01:08:19

Project #:

Sched. Date:

Est. Hours: 2.00

Asset ID: LASER_05_TR

Asset Description: LASER Cutter 5 - TruLASER 3040 / TruDis

Department:

Site: Gadsden

Request #:

Requested By: P.M. Schedule

Assign To Type: Technician

Assign To:

Jemison Metals (Logan Shinn)

Open / History: H

Job Status: Completed

WO Type: PM

Problem Type:

Completed Date: 09/01/2022

Downtime: 0.50

Building: Plant 1

Floor:

Req. Telephone:

Req. E-mail:

Perform For Type: Employee

Perform For: Jemison

Metals

(Phillip

Mathis)

Brief Description: WEEKLY PM SCHEDULE- TRUMPF

Work Description: 1. BLOW OUT OR REPLACE BOTH CHILLER FILTERS 2. CHECK WATER LEVELS ON BOTH THE CHILLER CABINET AND THE RESONATOR CABINET 3. CHECK THE HYDRAULIC OIL LEVEL FOR THE PALLET CHANGER 4. CHECK TO MAKE SURE BOTH LUBES, THE GREASE AND OIL, CONTAINERS ARE AT GOOD LEVELS SO THAT THEY WILL NOT RUN OUT BEFORE THE NEXT CHECK IS DONE. 5. CHECK TO MAKE SURE FLOOR PLATES ARE IN PLACE FOR SAFETY 6. CHECK TO MAKE SURE ALL COVERS ARE IN PLACE ON THE ENCLOSURE. ALSO THAT THE TOP DOOR AND FRONT DOOR, ALSO THE PALLET DOOR WORKS PROPERLY AND THE MACHINE WILL NOT OPERATE IF ONE IS OPEN. 7. CHECK TO MAKE SURE THERE IS NO DAMAGE TO ANY OF THE CONDUIT, PIPING AND FAN CORDS THAT ARE USED IN THE AREA. AS TO LEAVE ANY UNSAFE CONDITION OR LEAKS. 8. VISUALLY CHECK TO MAKE SURE THERE ARE NO PREVENTABLE TRIP HAZARDS THAT CAN BE CORRECTED BY HOUSEKEEPING OR REARRANGE OF WORK MATERIAL. 9. VISUALLY CHECK BELLOWS FOR TEARS OR CRACKS

Insp. Round WO#:

Comments: Scheduled PM check was completed.

Work Order Charges

TranId	Category	Wo	ContactId	TranDate	Qty	UnitCost	ExtCost	Comment	Sub Category	Acct no
6F700634Y	Technician	589	L SHINN - Logan Shinn	09/06/2022	0.25	37.00	9.25			
Sub					0.25		9.25			
Total					0.25		9.25			

Employee Comments

Employee 1:

Employee 2:

Employee 3:

Employee 4:

Employee 5:

Work Order Charges

Rick Rowland

From: Sarah Stanford
Sent: Wednesday, September 21, 2022 2:35 PM
To: Rick Rowland
Subject: RE: PO GAD 22425-1 14ga CR 48x120 for Bluebird

Yes sir it is a spot buy bucket due to usage. ✓

2. sorry yes I was looking at the wrong bucket – that is the only size we could find from Phoenix. ✓

Sarah Stanford Adams | Materials Supply Chain Manager

Jemison Metals

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Birmingham, AL 35243
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sstanford@jemisonmetals.com

2020 AMM Service Center of the Year

2018 AMM Service Center of the Year

2015 AMM Service Center of the Year

2016 S&P Platts Global Service Center of the Year

From: Rick Rowland <rrowland@JemisonMetals.com>
Sent: Wednesday, September 21, 2022 11:39 AM
To: Sarah Stanford <SStanford@JemisonMetals.com>
Subject: RE: PO GAD 22425-1 14ga CR 48x120 for Bluebird

Follow-up questions below.

From: Sarah Stanford <SStanford@JemisonMetals.com>
Sent: Wednesday, September 21, 2022 10:15 AM
To: Rick Rowland <rrowland@JemisonMetals.com>
Subject: RE: PO GAD 22425-1 14ga CR 48x120 for Bluebird

1. I Purchased based on need per the bucket we needed to buy to be able to cover orders in October/November. Am I correct in assuming this is a spot buy only bucket due to the low volume? ✓
2. I knew group/size/grade/width/length based on the requisition and part specs from the wip part. Sarah, the WIP size in that bucket is 48 x 96, but we ordered 48x120. The requisition doesn't list length. So how/why did we order 120" long? ✓

Sarah Stanford Adams | Materials Supply Chain Manager

Jemison Metals

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From: Rick Rowland <rrowland@JemisonMetals.com>
Sent: Wednesday, September 21, 2022 8:49 AM
To: Sarah Stanford <SStanford@JemisonMetals.com>
Subject: PO GAD 22425-1 14ga CR 48x120 for Bluebird

Sarah,

I'm performing the annual internal audit for GAD. At receiving, this material was being received in during the audit.

Can you tell me:

1. What told you that you needed to purchase this material?
2. How did you know what type (group/size/grade/width/length) to purchase?

I likely know these answers, but as part of the audit, I need purchasing to tell me so I can document.

Thanks

Rick Rowland | SR VP Quality & Engineering, Metallurgical Engineer
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