

Audit Review and Evaluations OF

JEMISON METALS

**188 Enterprise Dr,
Madison Heights, VA 24572**

Dates of Audit: 11/12/2020 and 11/13/2020
Date of Submittal: 11/30/2020

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. **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: LYN-RC-001 Receiving Procedure (Quality Intranet-no hard copy present), LYN-PB-001 Press Brake Procedure (Quality Intranet computer-no hardcopy present), LYN-FAB-002 fabrication First Article Inspection procedure (Quality Intranet-no hard copy present), JDM200 Quality Policy Rev-1, FHR002 Training & Equipment Checklist Plant Employees Rev-8, FHR006 Training & equipment checklist Temporary Staffing checklist Rev-3, LYNN-F-007 Checklist for Press Brake Operator Training Rev-0 GAD059 Rev 0 Press Brake check sheet

7 Support

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

7.2 Competence

Reviewed Nathan Ragland, Amere Pannel, and Lonnie Daye training documents.

Nathan Ragland Amada Safety

Amere Pannel Amada Safety

Lonnie Daye Amada Safety, Laser operator training

8.2 Requirements for products and services

Nordfab PO 8013658-1 10/27/2020-Acknowledged by Paula Loveless 10/27/2020 (S/O 22511-1), PN 17829 (S/O 22511-1)

8.4 Control of externally provided processes, products and services

Mill Coil #880640100G from Metal One received off of PO 4101-1 Receiver 8333 dated 11/11/2020 Bucket GVC C90CDX 21A 60" met all requirements for customer parts in that bucket. Receiver stamped and signed

8.5-Production & Service Provisions

Receiving:

B/L 1241631 (PO LYN 4101) Receiving paperwork signed and dated by Stanley Gallier, Document stamped, filled in, signed and dated, per the receiving procedure. Receiver 8333

Shipping:

B/L 19668 - S/O 22634 shipped 11/12/2020 All tags were matched and all material shipped and was checked off and signed.

Production:

W/O 17829 Nordfab part 8091859 to fulfill S/O 22511-1 on Red Bud. All checks performed and documented by operator per procedure LYN-LRB-001

W/O 17780 HP Fab stock job part F867362GG3, documentation reviewed, GAD 059 filled out incorrectly, Tag number was listed in designated job number location. (Observation #1) Met all requirements of Procedure LYN-PB-001

W/O 17749 HP Fab stock punch job part P113383D documentation reviewed. Met all requirements of Procedure SM2-PC-001

7.1.3 Infrastructure

Preventive Maintenance: Reviewed with Bill Huffman and Justin Riley Schedule calendar for October Internal preventive maintenance reviewed. All schedule maintenance documented as performed for October all documents signed dated and approved.

7.1.5 Monitoring and Measuring Resources

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

Rowe:

Tape 04 due 11/2020

Micrometer 036 due 11/2020

Red Bud:

Tape 01 due 12/20

Joe block 18D07065 due 4/23

Joe Block G0851 due 6/22

8.7 Control of Nonconforming Product

Nonconforming area was well defined and neat. All items identified.

- tags 127041 LSC, Tag 117750 LBR and 113861 LBR reviewed and traced.

10.2 Nonconformity and Corrective Action

CA 17608 and 17543 closed as of 11/3/2020

10. Improvement

New turret punch Laser installation completed and operational. New Turret punch laser combo, add a backup in case of unscheduled down time, and increase versatility of scheduling, as well as add new capability due to the turret punch

Observations and findings from previous internal audit

Observations from previous internal audit:

1. Reviewed: MF1, Scheduled maintenance performed based on calendar. No delays to document
2. Reviewed: OBS 1, All employees interviewed were able to locate and show an understanding of their procedures
3. Reviewed: OBS 2, All micrometer calibrations up to date and no out of date ID's on any tools.

2.0 Overview

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

Rodrick Johnson-Press Brake Operator Mike Brown-Laser operator Lonnie Daye-Laser punch combo operator Stanley Gallier- Receiver Justin Riley-Maintenance	Paula Loveless-Inside sales Bill Huffman-Plant Manager Will Folks –Shipper Zachary Delp-Quality Tech
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2.2 Audited Requirements

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

Report Prepared by Patrick Macias

Date 11/30/2020

Nonconforming Corrective Action Report (CAR) for Jemison Metals

CAR #	ISO 9001: 2015 Clause / Sub-Clause	Findings/Requirements	Observation	Minor	Major
NA	8.1	Form GAD059 Press Brake Check Sheet filled in incorrectly. Job number identification was left off form.	1		

AMADA AMERICA INC.

SAFETY TRAINING ACKNOWLEDMENT

I, NATHAN ROWLAND, acknowledge that I have undergone training related to Amada equipment including the proper and safe manner by which I and others at our facility will operate the equipment. As a result, I have a clear understanding of the potential hazards and procedures to avoid hazards.

Class taken from Amada instructor: JUDAH WETHERICE

Company Name: JEMISON METALS

Company Location: MADISON HEIGHTS VA

Date: 10/22/19


Signature of student

NATHAN ROWLAND
Print student name

AMADA AMERICA INC.

SAFETY TRAINING ACKNOWLEDGMENT

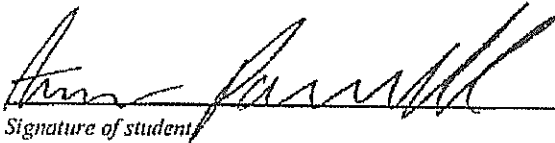
I, America Pennell, acknowledge that I have undergone training related to Amada equipment including the proper and safe manner by which I and others at our facility will operate the equipment. As a result, I have a clear understanding of the potential hazards and procedures to avoid hazards.

Class taken from Amada instructor: Judah Wetherbee

Company Name: Tompson Metals

Company Location: Madison Heights, VA

Date: 10-22-19


Signature of student

America Pennell
Print student name

AMADA AMERICA INC.

SAFETY TRAINING ACKNOWLEDGMENT

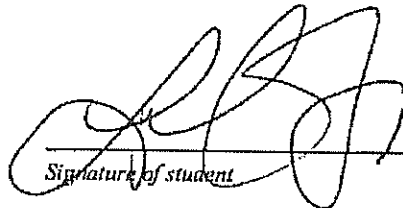
I, Lonnie Dyer Sr, acknowledge that I have undergone training related to Amada equipment including the proper and safe manner by which I and others at our facility will operate the equipment. As a result, I have a clear understanding of the potential hazards and procedures to avoid hazards.

Class taken from Amada Instructor: JUDAH WETHERBEE

Company Name: JEMISON METALS

Company Location: MADISON HEIGHTS, VA

Date: 10-22-19


Signature of student

Lonnie Dyer Sr
Print student name

Checklist for Laser Operator Training

Name LOWNIE DRYE

Payroll# _____

Promotion _____ Cross Training _____ New Hire ✓

Start Date 8/07/18 Completion Date 8/31/18

On the completion of each "Step" the trainer will test the trainee on each topic within the "Step". As each topic is successfully demonstrated and explained by the trainee both the trainer and the trainee will initial the topic to verify acceptance and understanding. Each "step" must be completed before advancing to the next section.

Trainer	Trainee	Step 1
<u>AP/WK</u>	<u>LD</u>	1 Policy and Procedures
<u>AP/WK</u>	<u>LD</u>	2 Personal protective Equipment requirements
<u>AP/WK</u>	<u>LD</u>	3 Housekeeping requirements
<u>AP/WK</u>	<u>LD</u>	4 Identify and utilization of Laser Fabrication tools
<u>AP/WK</u>	<u>LD</u>	5 Basic operation/function of Laser
<u>AP/WK</u>	<u>LD</u>	6 Basic understanding of Laser theory and techniques
<u>AP/WK</u>	<u>LD</u>	7 Laser Procedures/ concerns
<u>AP/WK</u>	<u>LD</u>	8 Proper startup and shutdown procedures
<u>AP/WK</u>	<u>LD</u>	9 LO/TO procedure

AP/WK LD Step 1 Completion Date 8/15/18

Step 2

1

2

3

4

5

6

7

8

List below additional items/ requirements reviewed

Step 2 Completion Date

8/31/18

[illegible]

Purchase order



Contact

Deane Hedrick

Purchase Order

8013658-1

Project

Created Date

10/27/2020

Your ref.

deane.hedrick@nordfab.com

Vendor

800262

Our ref.

Deane Hedrick

Fax/Vendor

Vendor address

Jemison Metals
PO Box 2153, Dept 3137
Birmingham, AL 35287
USA

Delivery address

Nordfab LLC
150 Transit Avenue
Thomasville, NC 27360
USA

1 of 3

Forward agent

Freight agreement no.

dELIVER

Goods mark

Mode of delivery

Prepaid

Terms of delivery

Delivered at Place

Terms of payment

60 days net

Item number Vendors item number Configuration	Description	Quantity Unit	Unit price Discount	Line amount USD	Delivery date
5 8091859	Quick-Fit Sleeve Blank Galv 20ga 24in 351M-2400-1NIPPL	50.00 Pcs	22.42	1,121.00	10/28/2020
10 8091864	Quick-Fit Sleeve Blank Galv 22ga 7in 351M-0700-1NIPPL	100.00 Pcs	5.48	548.00	10/28/2020
15 8093342	Clamp Coil Galv 16ga 1.41 350C-1600-01.410	3,000.00 lb	52.00	1,560.00	10/28/2020
20 8093343	Clamp Coil Galv 18ga 1.024 350C-1800-01.024	3,000.00 lb	58.90	1,767.00	10/28/2020
25 8090274	Pipe Blank Galv 20ga 16in 351M-1600-1PM00L	100.00 Pcs	15.16	1,516.00	10/28/2020
30 8090276	Pipe Blank Galv 20ga 18in 351M-1800-1PM00L	100.00 Pcs	17.06	1,706.00	10/28/2020
35 8090282	Pipe Blank Galv 20ga 24in 351M-2400-1PM00L	100.00 Pcs	22.73	2,273.00	10/28/2020
40 8090283	Pipe Blank Galv 22ga 3in 351M-0300-1PM00L	200.00 Pcs	2.40	480.00	10/28/2020
45 8090288	Pipe Blank Galv 22ga 8in 351M-0800-1PM00L	200.00 Pcs	6.03	1,206.00	10/28/2020

Company Name & Address

Nordfab LLC
150 Transit Ave
Thomasville, NC 27360
Federal Tax ID # 56-1230979

Accounts Receivable

Phone +1 336-821-0841
Mail ar@nordfab.com
Web www.nordfab.com

Remit via ACH

Nordfab LLC
Contact Accounts Receivable

Remit Check Via Standard Mail

Nordfab LLC
Lockbox # 777022 7022 Solutions Center
Chicago IL 60677-7000

Remit Check Via Courier

Nordfab LLC
Lockbox # 777022, 350 East Devon Avenue
Itasca IL 60143

Purchase order



Contact
Deane Hedrick

Purchase Order
8013658-1

Project

deane.hedrick@nordfab.com

Created Date
10/27/2020

Your ref.

Vendor
800262

Our ref.
Deane Hedrick

Fax/Vendor

Vendor address
Jemison Metals
PO Box 2153, Dept 3137
Birmingham, AL 35287
USA

Delivery address
Nordfab LLC
150 Transit Avenue
Thomasville, NC 27360
USA

2 of 3

Forward agent

Freight agreement no.
dELIVER

Goods mark

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Prepaid

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Delivered at Place

Terms of payment
60 days net

Item number Vendors item number Configuration	Description	Quantity Unit	Unit price Discount	Line amount USD	Delivery date
50 8090290	Pipe Blank Galv 22ga 10in 351M-1000-1PM00L	200.00 Pcs	7.55	1,510.00	10/28/2020
55 8090291	Pipe Blank Galv 22ga 11in 351M-1100-1PM00L	100.00 Pcs	8.40	840.00	10/28/2020
60 8090292	Pipe Blank Galv 22ga 12in 351M-1200-1PM00L	300.00 Pcs	9.16	2,748.00	10/28/2020
65 8091862	Quick-Fit Sleeve Blank Galv 22ga 5in 351M-0500-1NIPPL	100.00 Pcs	3.94	394.00	10/28/2020
70 8091865	Quick-Fit Sleeve Blank Galv 22ga 8in 351M-0800-1NIPPL	100.00 Pcs	6.23	623.00	10/28/2020
75 8090043	Sheet Galv 20ga 5x10 350M-2000-105100	25.00 Pcs	36.28	907.00	10/28/2020
80 8090045	Sheet Galv 22ga 5x10	25.00 Pcs	32.02	800.50	10/28/2020

148

Company Name & Address
Nordfab LLC
150 Transit Ave
Thomasville, NC 27360
Federal Tax ID # 56-1230979

Accounts Receivable
Phone +1 335-821-0841
Mail ar@nordfab.com
Web www.nordfab.com

Remit via ACH
Nordfab LLC
Contact Accounts Receivable

Remit Check Via Standard Mail
Nordfab LLC
Lockbox # 777022 7022 Solutions Center
Chicago IL 60677-7000

Remit Check Via Courier
Nordfab LLC
Lockbox # 777022, 350 East Devon Avenue
Itasca IL 60143

Purchase order

**Contact**

Deane Hedrick

Purchase Order

8013658-1

Project:

deane.hedrick@nordfab.com

Created Date

10/27/2020

Your ref.**Vendor**

800262

Our ref.

Deane Hedrick

Fax/Vendor**Vendor address**Jemison Metals
PO Box 2153, Dept 3137
Birmingham, AL 35287
USA**Delivery address**Nordfab LLC
150 Transit Avenue
Thomasville, NC 27360
USA

3 of 3

Forward agent**Freight agreement no.**

dELIVER

Goods mark**Mode of delivery**

Prepaid

Terms of delivery

Delivered at Place

Terms of payment

60 days net

Item number Vendors item number Configuration	Description	Quantity Unit	Unit price Discount	Line amount USD	Delivery date
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Amount	19,999.50 USD
Misc. charges	0.00
VAT	0.00 USD
Total	19,999.50 USD

Company Name & Address
Nordfab LLC
150 Transit Ave
Thomasville, NC 27360
Federal Tax ID # 56-1230979

Accounts Receivable
Phone +1 336-821-0841
Mail ar@nordfab.com
Web www.nordfab.com

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Contact Accounts Receivable

Remit Check Via Standard Mail
Nordfab LLC
Lockbox # 777022 7022 Solutions Center
Chicago IL 60677-7000

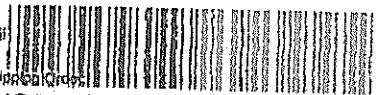
Remit Check Via Courier
Nordfab LLC
Lockbox # 777022, 350 East Devon Avenue
Itasca IL 60143

From: pmaci	At: SMT	Date: 08Dec20	Time: 08:24
To: bwright	At: SM2		

Type N	Purchase Order Item	PO No LYN- 4101- 1
METAL ONE AMERICA-WN		
Group GVC	A 653 GALVANIZED COIL CS-B G90 CT DRY, XS	
Size 21A	.0342 Min X 60.0000"	
Grade C90CDX Width 60.0000"	Length	GaM 0.0342
Order:	PCS Msr:	Wgt: 135000 LBS
Bal :	PCS Msr:	Wgt: LBS
Cst Description	A/V Rate UM	Quantity Ty Amount
M Material	V 39.9000 CWT	P USD

F P/O Frt Cost	A 2.2200 CWT	P	USD
Stk Inq Cost	/CWT A Ex Rt	Bs Crncy Amt	
Stk Inq Y Alloc:			/
For Cus No 3037	Part No	Cus Own N	
Stk Inq Rmks NORDFAB		Upd Usq N	
Source PD	Status ENT	Item Due Date 10/19/20	Rdy Dt 10/19/20
Rolling Wk	Prt Modif Y	Orig Due Date 10/19/20	Complete Y
1-Chng Itm	2-Rmk	3-Cond Cds	4-PO Res 5-Res Incmg 6-Res 7-Hdr 8-Hist

THIS SHIPPING ORDER must be legibly filled in, in ink, in indelible pencil or in Carbon, and retained by the Agent.
RECEIVE, subject to the classifications and lawfully filed tariffs in effect on the date of the issue of this Shipping Order.



SHIPPING/INVOICE NO. 1241631

WHEELING-NIPPON STEEL

DATE SHIPPED 11/10/20

SHIP TO: LOADING NO. MHV-001409
DOCK NO. F22E3

METAL ONE AMERICA, INC./CHI
6250 N. RIVER ROAD
SUITE 2055
ROSEMONT IL 60018

JEMISON METALS/MO ZNC CONTRACT
C/C JEMISON METALS
188 ENTERPRISE DRIVE
MADISON HEIGHTS VA 245722504

WHEELING-NIPPON STEEL, INC.
PENN & MAIN STREETS
P.O. BOX 635
FOLLANSBEE, WV 26037

The property described herein is to be transported by motor vehicle and is subject to the provisions of the Interstate Commerce Act and the regulations of the Interstate Commerce Commission. The carrier, the vessel or the person in possession of the property under the contract of transportation, is not responsible for any loss or damage to the property or for any delay in the delivery of the property, except in cases where the carrier, the vessel or the person in possession of the property is negligent or where the property is damaged by the carrier, the vessel or the person in possession of the property.

W-N MILL ORDER NO.	P.O. NUMBER	LINE	P.O. DATE	RELEASE NUMBER	SHIP MODE
240836	250884		8/22/20		TRUCK
REIGHT PAYMENT	ROUTING				SHIP FROM
PREPAID					FOLLANSBEE, WV 26037
MINIMUM WEIGHT	CARRIER			VEHICLE IDENTIFICATION	
	TRUCKING, INC.				

COILS	LIFTS	BUNDLES	WEIGHT (SUBJECT TO CORRECTION)	
			SKIDS	DUNNAGE
			NET WEIGHT	WRAPPING
			GROSS WEIGHT	
			48763	15
			48775	WM

LINE NO.	PRODUCT SPECIFICATION/DESCRIPTION	P/C	ORDERED WEIGHT	QTY SHIPPED	DELIVERY ALLOWANCE	SHIPPED TO DATE QTY.
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1	GALVANIZED MIN. SPANGLE SHEET IN COIL FORM CSB SAME CTG BOTH SIDES G90 CHEMICAL TREAT NO OILING SKP GAUGE: .0342" MIN WIDTH: 60.0000" NET THEO		68 ST 48763 LBS LBS			
2	LOCATION PACKING# LB KG LB KG FT/SHT M/SHT					
4	880640100G 16306 7396 15775 7156 2251 689 51					
4	880640200G 16416 7446 15886 7206 2277 694 51					
4	880640300G 16041 7276 15523 7041 2225 678 51					

HEAT NO. R05908
C MN P S AL SI TI CU NI CR MC V
.038 .300 .007 .011 .038 .007 .001 .030 .010 .04 .005 .001 .000

*SHIPPING INSTRUCTION
*OHC UNLOAD. REC HRS 7AM-2PM; CONTACT INFORMATION FOR MORE DELIVERY
*434-929-6802 NO FRIDAY OR SATURDAY

11-11-20
Stan Gallier

*SHIPPING INSTRUCTION		*OHC UNLOAD. REC HRS 7AM-2PM; CONTACT INFORMATION FOR MORE DELIVERY	
*434-929-6802 NO FRIDAY OR SATURDAY		*****	
11-11-20		Stan Gallier	
PAGE 1		CUSTOMER NO. 1	
TURN		EMPLOYEE	
B/L NUMBER		NET WEIGHT	
TARE WEIGHT		GROSS WEIGHT	
48763		15	
48775			

CUSTOMER NO.	TURN	EMPLOYEE	B/L NUMBER	NET WEIGHT	TARE WEIGHT	GROSS WEIGHT
1			1101	48763	15	48775
201431			200300			

REFER TO INVOICE NUMBER ON ALL CORRESPONDENCE.
/NI-180

AGENT MUST DETACH AND RETAIN THIS SHIPPING ORDER AND MUST SIGN THE ORIGINAL BILL OF LADING.

Jemison Metals - Lynchburg
188 Enterprise Drive
Madison Hts, VA 24572

RC	8333	Act Dt 11Nov20	Description	Probill Number	
By lyn1		Ent Dt 11Nov20	COIL	1241631	
Item	Type	Order Number	Vendor/Customer	Shp Fr Bill of Lading	U/M
1	P	LYN 4101-001	2040 METAL ONE-WN	1241631	LBS
GVC/21A/C90CDX			Other Tag Ref: 880640100G	PCS	Quantity
A 653 GALVANIZED COIL CS-B G90 CT DRY, XS				Coil Lgth	2,335 FT
.0342 Min X 60.0000"				1	16,306 LBS
Tag NI12277 LPW Loc			MTL R05908	Pack	16,306 LBS
				Theo	16,306 LBS
NORDFAB					
GVC/21A/C90CDX			Other Tag Ref: 880640200G	Coil Lgth	2,351 FT
A 653 GALVANIZED COIL CS-B G90 CT DRY, XS				1	16,416 LBS
.0342 Min X 60.0000"				Pack	16,416 LBS
Tag NI12278 LPW Loc			MTL R05908	Theo	16,416 LBS
NORDFAB					
GVC/21A/C90CDX			Other Tag Ref: 880640300G	Coil Lgth	2,297 FT
A 653 GALVANIZED COIL CS-B G90 CT DRY, XS				1	16,041 LBS
.0342 Min X 60.0000"				Pack	16,041 LBS
Tag NI12279 LPW Loc			MTL R05908	Theo	16,041 LBS
NORDFAB					
Item	1 Totals		Weight	Packing Slip	
PCS			48,763 LBS	Theoretical	48,763 LBS
3					48,763 LBS
Receiver	8333	Total Equivalent Weight		48,763 LBS	
		Total Coil Length		6,983 FT	

13Nov20 13:03

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

LYN 17829

Jemison Metals - Lynchburg
188 Enterprise Drive
Madison Hts, VA 24572
Tel: 434-929-6802 Fax: 434-929-4335

Job Type LEV Process PWC LRB
Metric N Cust
Desc P-1 NORDFAB 22511-1
Due Date 13Nov20 Whs LFG
Setup 00:00 Run 01:01 Prtd By lunsfor

<<< JOB SPECIFICATIONS >>>

Group GVS Grade CB90CD Gauge 0.0386 (0.0346 to 0.0426) ID 0.0000

<<< ORDER SPECIFICATIONS >>>

F 01 GVS/20L/CB90CD/60.0000"X75.59/.0386N CS-B *90 CT DRY
Ord LYN 22511- 1 Cust NORDFAB Ga 0.0386 Wth 60.0000 Lth 75.5937
Part 3037/8091859 Ga 0.0386 Wth 60.0000 Lth 75.5937
Ga Rng 0.0346to 0.0426 Pc/Tag 50
WthTol + 0.2500 - 0.0000 Wt/Skd
LthTol + 0.0200 - 0.0200 Ty JD5 Pk
SQUA:0.00-.08

***COIL INCOMING ***

MATERIAL TO BE EXTRA SMOOTH - *****

CSB, G90, CTD, XS

TOL BURR - <10% THICKNESS
TOL SQ - +/- .03943

EXTRA SMOOTH
SURFACE CRITICAL - NO RUST, DENTS, SCRATCHES, BLEM
ISHES
STACKING MUST BE SQUARE - <1/16" DEVIATION
EDGE CRITICAL - INSPECT FOR DAMAGE
OAK PALLETES ONLY
RUNNERS LONG DIMENSION OF MATERIAL
DECK BOARDS SHORT DIMENSIONS OF MATERIAL
3RD RUNNER REQUIRED FOR LENGTHS OVER 36"
* UPDATE MARCH 2018 - PAPER TOP AND BOTTOM /TOP PA
PER TO OVERHANG AND COVER SIDES OF MATERIAL*
FULL EDGE PROTECTION

SIGNATURES

OPERATOR_____

SUPERVISOR_____

BOTTOM SIDE CRITICAL

Fill out form JDM-F-009 for each skid.

A1 and A2 measurements to be measured off of a str
aight edge with feeler gauges.

13Nov20 13:03

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

LYN 17829

Jemison Metals - Lynchburg

B1 Measurement to be measured using the dial indicator.

All other measurements to be performed and recorded based on standard practice

Please see Bill Huffman if there are any questions

*****NEW REC HOURS 6AM TO 11AM*****

F 02 GVS/20L/CB90CD/60.0000"X43.85/.0386N CS-B *90 CT DRY
Part 3037/8090272 Ga 0.0386 Wth 60.0000 Lth 43.8593
Ga Rng 0.0346to 0.0426 Pc/Tag 100
WthTol + 0.2500 - 0.0000 Wt/Skd
LthTol + 0.0200 - 0.0200 Ty JD5 Pk
SQUA:0.00-.08
MATERIAL TO BE EXTRA SMOOTH - *****

CSB, G90, CTD, XS

TOL BURR - <10% THICKNESS
TOL SQ - +/- .03943

EXTRA SMOOTH
SURFACE CRITICAL - NO RUST, DENTS, SCRATCHES, BLEMISHES
STACKING MUST BE SQUARE - <1/16" DEVIATION
EDGE CRITICAL - INSPECT FOR DAMAGE
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RUNNERS LONG DIMENSION OF MATERIAL
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PER TO OVERHANG AND COVER SIDES OF MATERIAL*
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SIGNATURES

OPERATOR _____

SUPERVISOR _____

BOTTOM SIDE CRITICAL

Fill out form JDM-F-009 for each skid.

A1 and A2 measurements to be measured off of a straight edge with feeler gauges.

B1 Measurement to be measured using the dial indicator.

All other measurements to be performed and recorded

13Nov20 13:03

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

LYN 17829

Jemison Metals - Lynchburg

d based on standard practice

Please see Bill Huffman if there are any questions

<<< PROCESSING INSTRUCTIONS >>>

<Step 1>	Level To:	60.0000 X	75.5937	50	Pcs	2483	LBS	50	Pcs/Tag
<Step 2>	Level To:	60.0000 X	43.8593	500	Pcs	14404	LBS	100	Pcs/Tag

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<GVC/21A/C90CDX>								
NI12277	LPW	0.0342M	60.0000		1	16306	MTLR05908	
Rmks: NORDFAB								

Total: 1 16306

<<< MATERIAL TO BE SHIPPED >>>

01 Ord LYN 22511-	1 Cust NORDFAB	Part 8091859						
A 653 GALVANIZED SHEET CS-B *90 CTD 24" NIPPL	Pcs/Tg	50	Bal	50	Pcs			
20 GA X 60.0000" X 75.5937"	DueDt	30Oct20		2,543	LBS			
Itm Rmks: S								

REC HOURS 8AM TO 11 AM

FORKLIFT SIDE UNLOAD

Con Tag	Whs	Tag No	Whs T	Gauge	Width	Length	OD	Pcs	Weight
NI12277	LPW	128302	LFG F	0.0386	60.0000	75.5937		50	2,259

<<< MATERIAL TO STOCK >>>

Cons Tg	Spc	Prod Tg	Whs Ty	Gauge	Width	Length	OD	PCS<Prn>Wt	PCS<Res>Wt
NI12277									
2	40981	LFG F	0.0386	60.0000	43.8593		100	2621	
2	40982	LFG F	0.0386	60.0000	43.8593		100	2621	
2	40983	LFG F	0.0386	60.0000	43.8593		100	2621	
2	40984	LFG F	0.0386	60.0000	43.8593		100	2621	
2	40985	LFG F	0.0386	60.0000	43.8593		100	2621	
Total:								500	13,105

<<< JOB RECAP >>>

Material	PCS	Weight	Scrap	Scrap %	Unactd Scr %
Material Allocated	1	16,306			
Master Returns					
Returns to Stock					
Work in Process					
Material to be Shipped	550	15,364			
Rejects					
Net Weight to be Produced	550	15,364			
			942	5.78	

13Nov20 13:03

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

LYN 17829

Jemison Metals - Lynchburg
188 Enterprise Drive
Madison Hts, VA 24572

Job Type LEV Process PWC LRB
Metric N Cust
Desc P-1 NORDFAB 22511-1
Due Date 13Nov20 Whs LFG
Setup 00:00 Run 01:01 Prtd By lunsfor

=====

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<<< MATERIAL TO BE USED >>>								
<GVC/21A/C90CDX>								
NI12277	LPW	0.0342M	60.0000		1	16306	MTLR05908	
Rmks: NORDFAB								
Total:					1	16306		

13Nov20 13:00

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

LYN 17780

Jemison Metals - Lynchburg

188 Enterprise Drive

Madison Hts, VA 24572

Tel: 434-929-6802 Fax: 434-929-4335

Job Type SHR Process PWC LB1

Metric N Cust

Desc P-2 H-P F867362GGL

Due Date 18Nov20 Whs LFG

Setup 00:00 Run 02:00 Prtd By lunsfor

<<< JOB SPECIFICATIONS >>>

Group GVS Grade CB40CD Gauge 0.0710 (0.0710 to 0.0710) ID 0.0000

<<< ORDER SPECIFICATIONS >>>

F 01 GVS/15C/CB40CD/3.0373"X5.33/.0710N CS-B ^40 CT DRY
 Part 3453/F867362GGL Ga 0.0710 Wth 3.0373 Lth 5.3386
 Ga Rng 0.0680to 0.0740 Pc/Tag 327
 WthTol + 0.0300 - 0.0300 Wt/Skd 107
 LthTol + 0.0100 - 0.0100 Ty JD7 Pk

 WGT PER PIECE - 0.3265 LBS

<<< PROCESSING INSTRUCTIONS >>>

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<GVS/15C/CB40CD>								
40856	LPW	0.0710N	3.0373	5.3386	576	188	NLMCSP19A026176	
Total:					576	188		

<<< MATERIAL TO STOCK >>>

Cons Tg	Spc	Prod Tg	Whs	Ty	Gauge	Width	Length	OD	PCS<Prn>Wt	PCS<Res>Wt
40856										
1		40857	LFG	F	0.0710	3.0373	5.3386		576	188

<<< JOB RECAP >>>

	PCS	Weight	Scrap	Scrap %	Unactd Scr %
Material Allocated	576	188			
Master Returns					
Returns to Stock					
Work in Process					
Material to be Shipped	576	188			
Rejects					
Net Weight to be Produced	576	188			

13Nov20 13:00

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

LYN 17780

Jemison Metals - Lynchburg
188 Enterprise Drive
Madison Hts, VA 24572

Job Type SHR Process PWC LB1
Metric N Cust
Desc P-2 H-P F867362GGL
Due Date 18Nov20 Whs LFG
Setup 00:00 Run 02:00 Prtd By lunsfor

=====

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<<< MATERIAL TO BE USED >>>								
<GVS/15C/CB40CD>								
40856	LPW	0.0710N	3.0373	5.3386	576	188	NLMCSP19A026176	
Total:					576	188		

13Nov20 13:00

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

LYN 17749

Jemison Metals - Lynchburg
 188 Enterprise Drive
 Madison Hts, VA 24572
 Tel: 434-929-6802 Fax: 434-929-4335

Jcb Type SHR Process PWC LP1
 Metric N Cust
 Desc P-1 H-P P113383D
 Due Date 18Nov20 Whs LFG
 Setup 00:00 Run 03:35 Prtd By lunsfor

<<< JOB SPECIFICATIONS >>>

Group GNS Grade CB40CD Gauge 0.0280 (0.0280 to 0.0280) ID 0.0000

<<< ORDER SPECIFICATIONS >>>

F 01 GNS/24D/CB40CD/12.6334"X79.33/.0298N CS-B ^40 CT DRY
 Part 3453/P113383D Ga 0.0298 Wth 12.6334 Lth 79.3306
 Ga Rng 0.0260to 0.0300 Pc/Tag 75
 WthTol + 0.0100 - 0.0100 Wt/Skd 636
 LthTol + 0.0100 - 0.0100 Ty JD7 Pk

 WGT PER PIECE: 8.47

<<< PROCESSING INSTRUCTIONS >>>

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<GNS/24D/CB40CD>								
106645	LPW	0.0296N	57.0000	99.0000	18	768	NUB1907079	1flmar
Total:					18	768		

<<< MATERIAL TO STOCK >>>

Cons Tg	Spc	Prod Tg	Whs	Ty	Gauge	Width	Length	OD	PCS<Prn>Wt	PCS<Res>Wt
106645										
1	40728	LFG F			0.0298	12.6334	79.3306		72	610

<<< JOB RECAP >>>

	PCS	Weight	Scrap	Scrap %	Unactd	Scr %
Material Allocated	18	768				
Master Returns						
Returns to Stock						
Work in Process						
Material to be Shipped	72	610				
Rejects						
Net Weight to be Produced	72	610			158	20.57

13Nov20 13:00

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

LYN 17749

Jemison Metals - Lynchburg
188 Enterprise Drive
Madison Hts, VA 24572

Job Type SHR Process PWC LP1
Metric N Cust
Desc P-1 H-P P113383D
Due Date 18Nov20 Whs LFG
Setup 00:00 Run 03:35 Prtd By lunsfor

=====

Tag No	Whs	Gauge	<<< MATERIAL TO BE USED >>>		PCS	Weight	Heat Number	Locn
<GNS/24D/CB40CD>			Width	Length				
106645	LPW	0.0296N	57.0000	99.0000	18	768	NUB1907079	1f1mar
				Total:	18	768		

LOADING ORDER

Ship From:
Jemison Metals - Lynchburg
188 Enterprise Drive
Madison Hts, VA 24572
Tel: 434-929-6802 Fax: 434-929-4335

No: LYN 19668
Ship Date 11Nov20 at 15:27 From LFG
Probill
Via BEST WAY
FOB Destination
Frt Included in Pri
Route 0- 0 Manifest 7752
Vhcle Trailer
Slp Paula Loveless
Sold To: (3068)
England's Stove Works Inc
589 S 5 Forkes Road
Monroe VA 24574

Ship To: (1)
England's Stove Works Inc
589 S 5 Forkes Road
Monroe VA 24574
Tel: 434-929-0120 Fax: 434-929-4810

Con Tel 434-929-0120 Fax 434-929-4810

===== L O A D I N G O R D E R - REPRINT =====

1) Our Order LYN- 22634- 1 Your PO # 9377
Part # 12GAPOS48X96 Rel #
A1011 HRP&O SHEET CS TYPE B TEMP PASS

.1046 Nom X 48.0000" X 96.0000"

Loc	Heat Number	Tag No	Quantity	PCS	Wt LBS
	1010601	127929		36	5039
	1010601	127930		36	5039
	1010601	127931		36	5039
	1010601	127932		30	4199
	1010601	127934		36	5039
	1010601	127935		36	5039
	1010601	127937		30	4199
	1010601	127928		36	5039
	2013016	127939		36	5039
	2013016	127945		36	5039
	Total:			348	48710

TOTAL: Tags 10 PCS 348 LBS 48710

RECEIVING HOURS 8AM - 3PM M-F

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

11Nov20 15:29 B I L L O F L A D I N G M A N I F E S T Manifest LYN- 7752

From:

Jemison Metals - Lynchburg
188 Enterprise Drive
Madison Hts, VA 24572
Tel: 434-929-6802

Route 4 2ND LOAD - ENGLAND STOVE
Probill
Dlv Mth CC Via ALL METALS TRAN
Load Dt 11Nov20 Drivers
Ship Dt 11Nov20
Status SCH Vehicle
Trailer

=====

1 D BL LYN- 19668

England's Stove Works Inc
589 S 5 Forkes Road
Monroe VA 24574

Pcs Weight
48710

TOTAL DELIVERY

48710



Lynchburg LCT Preventative Maintenance

Monthly

- 1 ☒ Check to make sure all guards and safety devices are in place
- 2 ☒ Drain all air filter of water
- 3 ☒ Check oil level in air line lubricators
- 4 ☒ Check for air leaks
- 5 ☒ Check bolts in reel for tightness
- 6 ☒ Check and drain oil pans at leveler
- 7 ☒ Check oil level in automatic way lubricators for Wysong shear and give the ways a couple shots of oil
- 8 ☒ Check grease level in the automatic lubricator for the leveler and pneumatic pinch rolls
- 9 ☒ Grease all bearings and guides
- 10 ☒ Check all drive chains and sprockets
- 11 ☒ Check oil level in gearboxes- add as required
- 12 ☒ Check rollers in leveler and pneumatic roll entry table
- 13 ☒ Check shear blades and ways for wear and damage
- 14 ☒ Check condition and tracking of conveyor belts
- 15 ☒ Check and clean filter for leveler drive motor
- 16 ☒ Check all anchor bolts
- 17 ☒ Secure all exposed wiring and cables

Quarterly

- 1 ☐ Clean and lubricate coil buggy (four grease fittings in buggy Shell Alvania EP-1)
- 2 ☐ Grease Fittings on threading table, feed rollers, side guide rollers, paper rewinder,
- 3 ☐ side adjust keyways, leveler side guide rollers, chain guide mechanism on exit conveyor
- 4 ☐ Grease fittings on the threading control arm and lubricate drive chains on control arm (85W140 Hydrotex Oil)
- 5 ☐ Grease open drive gears of flattner adjustmen (Shell Alvania EP-1)
- 6 ☐ Clean Leveling Rolls
- 7 ☐ Clean and lubricate Chip Conveyor Drive chains (Shell Avitrea oil 100)
- 8 ☐ Clean and lubricate exit conveyor tracks (Shell Avitrea oil 100)
- 9 ☐ Replace leveler drive motor cooling fan filter

Semi Annually

- 1 ☐ Check lubricant level of transmission fluid in leveler
- 2 ☐ Check drive motor lubricant level in two gearboxes
- 3 ☐ Check transmission oil level in coil pay off reel and clamping mandrel
- 4 ☐ Check lubricant level in transmission of all roller conveyor systems
- 5 ☐ Check tension and alignment of all chain drives in conveyor system- Lubricate
- 6 ☐ Check lubricant level of flattening and feed mechanisms
- 7 ☐ Check lubricant level in chip conveyor gear box
- 8 ☐ Check lubricant level in exit conveyor motor housing
- 9 ☐ Check lubricant level in paper rewind gearbox
- 10 ☐ Clean oil filter bowl and comb type filter element of leveler

Notes:

Date: 10/21/20
Performed By: SPR
Approved By: WA



JEMISON
METALS

Lynchburg LRB Preventative Maintenance

Monthly

Power Unit

- 1 ☒ Check Hydraulic Oil Levels
- 2 ☒ Check Pressure equals label
- 3 ☒ Check if cooler and blower are working
- 4 ☒ Check oil filter pressure gauge, change filter as needed
- 5 ☒ Check accumulator charge pressure, recharge as requires (900psi)

Coil Stage and Lift

- 6 ☒ Grease axel bearings and vertical gibbs
- 7 ☒ Oil Chain
- 8 ☒ Check Chain tension

Reel

- 9 ☒ Grease mandrel while expanding and contracting
- 10 ☒ Check that grease is seen at shoe slides
- 11 ☒ Oil Chains
- 12 ☒ Check chain tension
- 13 ☒ Check brake shoes for wear
- 14 ☒ Grease mandrel bearings
- 15 ☒ Grease traversing base axels
- 16 ☒ Check chain tension traversing base

Peeler Breaker

- 17 ☒ Grease Gauging rolls
- 18 ☒ Clean and oil lead screws
- 19 ☒ Oil Slides

Pinch Rolls

- 20 ☒ Grease rolls

Motor Grip Feed

- 21 ☒ Check accumulator pressure and recharge as required (900psi)
- 22 ☒ Check air filter make sure it is drained
- 23 ☒ Check that feed cycke, straightner lights work
- 24 ☒ Grease dual motor clutch and bearings
- 25 ☒ Clean and oil all guides, screws and shafts
- 26 ☒ Grease drive shafts
- 27 ☒ Oil chains
- 28 ☒ Check chain tension
- 29 ☒ Check length adjustment woth standard
- 30 ☒ Check drive belt tension
- 31 ☒ Tighten all loose bolts, hydraulic hose clamps

Slitter Head

- 32 ☒ Grease slitter arbor bearings
- 33 ☒ Grease drive shaft bearings
- 34 ☒ Grease knife backup bearings
- 35 ☒ Grease lead screw thrust bearings
- 36 ☒ Clean and oil upper and lower knife backup gibbs
- 37 ☒ Clean and oil gauge locators and lead screws

Scrap Winders

- 38 ☒ Remove all excess scrap on winders
- 39 ☒ Grease bearings
- 40 ☒ Oil traversing arm slides
- 41 ☒ Oil Pivot points

Shear

- 42 ☒ Oil Gibbs
- 43 ☒ Grease Pinch roll bearings
- 44 ☒ Check pinch roll springs
- 45 ☒ Check pinch roll chain tension
- 46 ☒ Grease swivel base

Strip Stacker

- 47 ☒ Clean and oil divider gibbs
- 48 ☒ Clean oil and adjust power lead screws and arm slides

Stack Table

- 49 ☒ Grease bearings

Voss

- 50 ☒ Grease jacks
- 51 ☒ Inspect drive shafts for broken shafts
- 52 ☒ Inspect rolls for wear
- 53 ☒ Inspect gear box , semi annually

Rollout

- 54 ☒ Clean and oil center slide, shafts and screws
- 55 ☒ Check chain tension

Notes:

Date: 10/21/20
Performed By: JMK
Approved By: WJA



JEMISON
METALS

Lynchburg Pallet Inverter Preventative Maintenance

- Monthly**
- 1 ☒ Check Hydraulic Fluid Level
 - 2 ☒ Check for any visible Leaks
 - 3 ☒ Check and lubricate Drive Chain as required
 - 4 ☒ Check Drive Sprocket
 - 5 ☒ Check and lubricate (2) rotation chains
 - 6 ☒ Check (2) rotation sprockets
 - 7 ☒ Check Clamping Table
 - 8 ☒ Check Table Cylinder
 - 9 ☒ Check rotation wheels
 - 10 ☒ Check and lubricate rotation bearings
 - 11 ☒ Check rotation shafts

Notes:

Date: 10/21/10
Performed By: JDR
Approved By: WJA



JEMISON
METALS

Lynchburg Coil Tipper Preventative Maintenance

- Monthly**
- 1 ☒ Check Hydraulic Fluid Level
 - 2 ☒ Check for any visible Leaks
 - 3 ☒ Check and lubricate Drive Chain as required
 - 4 ☒ Check Drive Sprocket
 - 5 ☒ Check and lubricate (2) rotation chains
 - 6 ☒ Check (2) rotation sprockets
 - 7 ☒ Check rotation wheels
 - 8 ☒ Check and lubricate rotation bearings
 - 9 ☒ Check rotation shafts

Notes:

Date: 10/22/20
Performed By: [Signature]
Approved By: WA



JEMISON
METALS

Lynchburg Shear Preventative Maintenance

Monthly

- 1 ☒ Check lubrication system and reservoir for proper operation
- 2 ☒ Inspect and oil gibbs
- 3 ☒ Check drive gear reservoir
- 4 ☒ Check hold downs for proper operation
- 5 ☒ Check all air cylinders
- 6 ☒ Oil all pins and levers
- 7 ☒ Inspect bolts holding backstop to support arms
- 8 ☒ Check backstop for proper operation
- 9 ☒ Clean and lubricate backstop gears

Notes:

Date: 10/22/20
Performed By: SDR
Approved By: WJH



JEMISON
METALS

Lynchburg LL1 Preventative Maintenance

- 1 ☒ **Monthly**
2 ☒ Check all lube grease and oil reservoirs fill as required
3 ☒ Check water level for chiller
4 ☒ Check water level for resonator
5 ☒ Check clean or replace air filters chiller cabinet
6 ☒ Check hydraulic oil level on pallet exchanger fill as required
7 ☒ Check filter level of the dust exchanger filters clean/ replace as required
8 ☒ Clean/blow off laser head
9 ☒ Clean interior of machine
10 ☒ Clean interior exhaust vents to insure proper operation
11 ☒ Safety guards in place

Notes:

Date: 10/24/20
Performed By: CR
Approved By: WJH



JEMISON
METALS

Lynchburg LL2 Preventative Maintenance

- Monthly**
- 1 ☒ Check all lube grease and oil reservoirs fill as required
 - 2 ☒ Check water level for chiller
 - 3 ☒ Check water level for resonator
 - 4 ☒ Check clean or replace air filters chiller cabinet
 - 5 ☒ Check hydraulic oil level on pallet exchanger fill as required
 - 6 ☒ Check filter level of the dust exchanger filters clean/ replace as required
 - 7 ☒ Clean/blow off laser head
 - 8 ☒ Clean interior of machine
 - 9 ☒ Clean interior exhaust vents to insure proper operation
 - 10 ☒ Safety guards in place

Notes:

Date: 10/23/20
Performed By: TDR
Approved By: WTH



JEMISON
METALS

Lynchburg LB1 Preventative Maintenance

Monthly

- 1 ☒ Check reservoir oil level
- 2 ☒ Lubricate cylinder clevis pin
- 3 ☒ Clean/flush ram guides with oil
- 4 ☒ Check for water in reservoir
- 5 ☒ Lubricate AutoCrown pins as required
- 6 ☒ Clean/Lubricate all front gauges
- 7 ☒ Clean lubricate all guide rails
- 8 ☒ Clean/Lubricate all back gauges
- 9 ☒ Wipe entire machine clean as required

Notes:

0

Date: 10/23/20
Performed By: JBR
Approved By: WJA



JEMISON
METALS

Lynchburg LB2 Preventative Maintenance

Monthly

- 1 ☒ Check reservoir oil level
- 2 ☒ Lubricate cylinder clevis pin
- 3 ☒ Clean/flush ram guides with oil
- 4 ☒ Check for water in reservoir
- 5 ☒ Lubricate AutoCrown pins as required
- 6 ☒ Clean/Lubricate all front gauges
- 7 ☒ Clean lubricate all guide rails
- 8 ☒ Clean/Lubricate all back gauges
- 9 ☒ Wipe entire machine clean as required

Notes:

0

Date: 10/23/20
Performed By: WA
Approved By: CR