

Audit Review and Evaluations OF

JEMISON METALS

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

Dates of Audit: 8/27/19 and 8/29/19
Date of Submittal: 9/2/19

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

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 Rodrick Johnson and Gerardo Martinez training documentation.

Roderick Johnson New Hire training documented and turned into human resources. FHR002 Rev -8, Checklist for Press Brake Operator Training LYN-F-007 Rev-0

Gerardo Martinez, Training and Equipment Checklist, Temporary Staffing Plant Labor FHR006-Rev-3

(Observation 1: Employees had trouble locating procedure on computer on floor. All were aware of procedures and followed procedure during process)

8.2 Requirements for products and services

Munters PO 269399 sent on evening of 8/16/19 order acknowledged by Paula Loveless on 8/19/19. Sales order LYN 16815-1-2 entered on 8/18/19 due 9/5/19, shipped 8/29/19 B/L 14563

8.4 Control of externally provided processes, products and services

Mill Coil #499752.100 from Nucor Berkley received off of PO 3243-1 Receiver 6237 dated 8/14/19 Bucket POC CSBTP 14L 60.25” met all requirements for customer parts in that bucket

8.5-Production & Service Provisions

B/L 1427700 (PO LYN 3243) Receiving paperwork signed and dated by Stanley Gallier, Document stamped, filled in, signed and dated, per the receiving procedure. Receiver 6237

Production:

W/O 11892 Eaton part 42C4745H05 stock job was reviewed in process on Press brake. All checks performed and documented by operator per procedure LYN-PB-001

W/O 11891 WIP laser job documentation reviewed. Met all requirements of Procedure LYN-LA-001

W/O 11805 WIP level job documentation reviewed. Met all requirements of Procedure LYN-LRB-001

7.1.3 Infrastructure

Preventive Maintenance: Reviewed with Bill Huffman and Justin Riley Schedule calendar for June, and July Internal preventive maintenance reviewed.

All schedule maintenance documented as performed for June.

July preventative maintenance not performed due to unscheduled maintenance.

Maintenance of down machinery performed in lieu of preventative to minimize downtime. Preventative maintenance documents for July did not document reason for delay or a reschedule date of July Preventative maintenance. (Minor finding #1)

Documentation of maintenance (crane inspection) performed by outside service up to date: Koneo cranes performed inspection as scheduled 12/11/2018

7.1.5 Monitoring and Measuring Resources

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

Press Brake:

Micrometer 293-831-30 Due 9-19 (OBS #2 sticker due date listed as 3//19)

Protractor 048 due 11/19

Caliper 17060338 due 2/20

Rowe:

Micrometer 039 due 2/20

Red Bud:

Tape 01 due 12/19

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.

Reject tags 25479 and 94185 reviewed and traced.

10.2 Nonconformity and Corrective Action

CA 16350 reviewed, Due to recent occurrence and delay in Absorb implementation keep CA open until reviewed on next quarterly call.

10. Improvement

New turret punch Laser installation began. New Turret punch laser, 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 ISO audit

Observations from previous internal audit:

1. Reviewed: Supervisor sign off added and performed on all PM sheets
2. Reviewed: Completion of PM's documented on PM schedule.

ISR audit registration notes:

1. Caliper Calibration - 4 measuring uses, but we're only calibrating the main jaws. We need to create a new caliper calibration sheet. Don't have to do multiple checks on each of the 4, just multiple checks on the main jaws and 1 check on the other 3 to ensure they match up.

Complete 4/10/19 new document live 4/25/19

2. When calibrating height gauges, all items used should be documented (i.e. blocks, surface plate, ring gauges etc).

Complete 1/16/2019

3. Combined breaks with 30 min lunch to achieve 1 full hour, is this allowed in Virginia under work laws?

Complete 3/5/2019 (legal)

4. Bar and Ball checks on Romer Arm. Zach not doing? Get with Brian so we are consistent.

Complete 4/11/19

5. Some instruments have stickers, some do not. Should we go all one way or not? Maybe the difference is outside calibration vs inside calibration? Is this even feasible? We should review and discuss

In progress-R. Rowland to add "where applicable"

6. Lifting device tracking & Verification. There were lifting straps in the plant.

Completed 3/28/19, eliminated need for straps and discarded.

7. Cannot use Romer arm for gauge blocks, not 10x accuracy. See item above about purchasing new items.

Completed 8/15/19 purchase new blocks when calibration is needed.

8. LYN-F-001 Step 6 "First piece Inspection procedure" Step 7 "first article inspection", should be first piece inspection. Maybe somewhere in the system state that first article and first piece are the same? Verify for the same issue in GAD.

In progress-document created and approved at GAD, sent to R. Richards and R. Rowland for final approval.

9. Forklift - daily visual, nothing recorded. Is this ok? Safety checklist (Larry Strimple)

Completed. Document added to FL 5/19/19

10. Draka part specs have a reference to a skid diagram (leftover from SMT).
Remove? Also a reference regarding Gauge to call Patrick (should be QA or Plant Mgr).

Completed 3/11/19

11. Work Order Stamp Change. Not being filled out. Modify as needed, maybe add "Reference" to the stamp?

Completed 4/8/2019

12. Rowe Scale. Rarely used for weighing skid then skid + steel. We aren't using it to weigh scrap. Do we need this scale?

Completed 3/7/2019 changed and identified as reference only

13. Coil Tipper - has OFR lockout procedure on it.

Completed 3/5/2019 procedure removed

14. Quality Intranet, LYN page, says QA Mgr, Zach is QMC. We should just reference QA?

In progress

2.0 Overview

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

Rodrick Johnson-Press Brake Operator Gerardo Martinez-Press Brake helper Stanley Gallier- Receiver Justin Riley-Maintenance	Paula Loveless-Inside sales Bill Huffman-Plant Manager Frank Simms –Shipper Zachary Delp-Quality Management Coordinator
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2.2 Audited Requirements

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

Report Prepared by Patrick Macias

Date 9/2/19

Nonconforming Corrective Action Report (CAR) for Jemison
Metals

CAR #	ISO 9001: 2015 Clause / Sub-Clause	Findings/Requirements	Observation	Minor	Major
MF 1	7.1.3	July reason for delay in performing and reschedule dates for Preventative Maintenance not documented		X	
NA	7.2	Employees, while aware of and following procedure, they were not able to easily locate the electronic copy	X		
NA	7.1.5	Micrometer calibration sticker out of date. Calibration was current and documented both on log as well as individual calibration documentation.	X		

CINGINNATI®
LASERS PRESS BRAKES SHEARS PM PRESSES BLANK

This certifies that

RODERICK JOHNSON

has satisfactorily completed the Training

Autoform Maxform Goform Operator

this 17th day of November 2017.

Bruce Poynter
Instructor

Steve The
President

Checklist for Press Brake Operator Training

Name

Roderick Johnson

Payroll#

Promotion

Cross Training

New Hire

☒

Start Date

10/23/17

Completion Date

12/22/17

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>WA</u>	<u>RJ</u>	1	Policy and Procedures
<u>WA</u>	<u>RJ</u>	2	Personal protective Equipment requirements
<u>WA</u>	<u>RJ</u>	3	Housekeeping requirements
<u>WA</u>	<u>RJ</u>	4	Identify and utilization of Press Brake Fabrication tools
<u>WA</u>	<u>RJ</u>	5	Basic operation/function of Press Brake
<u>WA</u>	<u>RJ</u>	6	Basic understanding of Press Brake theory and techniques
<u>WA</u>	<u>RJ</u>	7	Press Brake Procedures/ concerns
<u>WA</u>	<u>RJ</u>	8	Proper startup and shutdown procedures
<u>WA</u>	<u>RJ</u>	9	LO/TO procedure

WA

RJ

Step 1 Completion Date

12/22/17

Trainee

Step 2

<u>WA</u>	<u>RJ</u>	1	Material Specific Knowledge
<u>WA</u>	<u>RJ</u>	2	Pre-work setup/ understanding of customer requirements
<u>WA</u>	<u>RJ</u>	3	Ability to perform job duties of Press Brake operation
<u>WA</u>	<u>RJ</u>	4	Check and Double check system for quaility
<u>WA</u>	<u>RJ</u>	5	Ability to perform basic Press Brake techniques
<u>WA</u>	<u>RJ</u>	6	Understand and perform Stelplan system procedures
<u>WA</u>	<u>RJ</u>	7	Packaging, labeling and staging processed materials
<u>WA</u>	<u>RJ</u>	8	List below additional items/ requirements reviewed

WA LS Step 2 Completion Date 12/22/17

Comments

This image shows a single sheet of white paper with horizontal blue or grey ruling lines. The lines are evenly spaced and run across the width of the page. There is no handwriting or other markings on the paper.



Training & Equipment Checklist

Temporary Staffing Plant Labor

(This document is kept on file at each branch)

Name: GERARDO MARTINEZ Location: LYNCHBURG

Hire Date: 7/22/19 Completed by: W. Haffner

Req	Training & Equipment	Initials		Req	Training & Equipment	Initials	
		Trainer	Employee			Trainer	Employee
A	Safety Video	WA	GM	A	PPE	WA	GM
	Emergency Exits, Fire Extinguisher, Emergency Contingency, Emergency Action Plan, Tornado Evacuation, Earthquake, Fire Evacuation, Fire/Tornado Drills, Warehouse Environment Checklist, Housekeeping, Debris Management, Security & Terrorism, Safety Teams, Safety Surveys, Safety Training Checklist, Safety Suggestions, Overall Safety, Wellness, Blood Borne Pathogens, What to do – Serious Accident, Respirator Training, Machine Guarding, Gauger Safety (as applicable), Lifting & Carrying, Confined Space, Chains and Slings, Chain Saw/Radial Arm Saw Safety, Daily Crane Inspection, Micrometer & Tape Use, Container Labeling, MSDS, Lock Out/Tag Out, Arc Blast				Gloves, Safety Glasses, Hearing Protection		
				N	Arm Protectors (PPE)		GM
				A	Plant Tour	WA	GM
				N	Safety Video – Forklift	WA	GM
				N	Written Test – Forklift	WA	GM
				N	Safety Video – Overhead Crane	WA	GM
				N	Written Test – Overhead Crane	WA	GM
				N	Crane Training/Certificate		
				N	Welding		
				N	Cutting		
				N	Intro. to Computer		
				A	ISO-9001: *	ZDD	GM
				A	Workplace violence Video Employee or Manager	WA	GM

A = Required by all N = As Required per position

*ISO Training by Plant QMC, ISO QMR, or ISO QMR Designee

All Positions:

Supervisor or Department Head

Date:

Trainee:

Signature and Date

DOC#: FHR006

DATE: 06/13/2013

Date: 10/31/2013

1-23-2018 Consolidated safety video items, adjusted HR signature for Temp Reqmt

2-16-2018 Consolidated Training Requirements in on Video – Made Exclusive to Temp Emp Only

REVISION LEVEL: 3



LYR 16815

PURCHASE ORDER

VENDOR

JEMISON METALS
188 ENTERPRISE DRIVE
MADISON HEIGHTS, VA 24572 USA

Attn: SHARON MARKHAM
Email: smarkham@jemisonmetals.com
JEMI001 VA188 US00

PO NUMBER	269399
PRINT DATE	August 16, 2019 14:11:51
PAGE NUMBER	1 of 1
CURRENCY	USD
TERMS	NET 60 DAYS
DELIVERY TERMS	
CARRIER	BEST WAY
PO TYPE	SO

SHIP TO

MUNTERS CORPORATION
225 S MAGNOLIA AVE RTE #501S
BUENA VISTA, VA 24416 USA

INVOICE TO

MUNTERS CORPORATION
225 SOUTH MAGNOLIA AVENUE
BUENA VISTA, VA 24416 USA

NOTE: For "Ship To" other than Munters, the supplier is to notify the buyer the day of shipment and provide carrier and tracking information. For non-Web Portal orders notification, notification is to be via email.

NOTE: Munters item numbers and PO Numbers to appear on all documentation.

NOTE: The Required Date is in North American format of MM/DD/YY.

LINE	ITEM	UM	TAX	QUANTITY	UNIT PRICE	EXTENSION
Comment: SWITCH GRR COWLING 21954276-003 PC						
0001	STE00241-22	PC		5.0000	47.2400	\$236.20
	STE,CS,GLN,18GA,48X96 A653,A60,GALVANNEALED,#69.0					
	Delivery No.	Delivery Qty.	Delivery Date			
	001	5.0000	09/05/2019			
0002	STE00241-08	PC		13.0000	70.8600	\$921.18
	STE,CS,GLN,18GA,48X144 A653,A60,GALVANNEALED,#103.					
	Delivery No.	Delivery Qty.	Delivery Date			
	001	13.0000	09/05/2019			

Grand Total:

\$1,157.38

THIS PURCHASE ORDER IS EXPRESSLY CONDITIONED ON YOUR ASSENT TO THE MUNTERS' TERMS AND CONDITIONS AS STATED ON THE ATTACHED TERMS AND CONDITIONS OF PURCHASE. YOU INDICATE YOUR ACCEPTANCE TO THESE TERMS AND CONDITIONS OF PURCHASE IF YOU FAIL TO DELIVER WRITTEN NOTIFICATION OF OBJECTION WITHIN TEN DAYS OF THE DATE OF THIS PURCHASE ORDER.

BUYER:

REBECCA PATTERSON

ACKNOWLEDGEMENT:

Required within 24 hours of receipt of purchase order.

BUY LANGUAGE:

ENG

19Aug19 12:16 S A L E S A C K N O W L E D G M E N T No: LYN PI-16815

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

Sold To: (3036)
Munters Corporation
225 S. Magnolia Ave
Buena Vista VA 24416

Ship To: (1)
Munters Corporation
225 S. Magnolia Ave
Buena Vista VA 24416

Trm NET 60 DAYS
Frt Included in Price
Con Sarah Dudley
Slp Sharon Markham

Ord 18Aug19 Due05Sep19 09/05/19
Via ALL METALS TRAN FOB Destination
PO/Rel 269399
Tel 540-291-1111 Fax 540-291-2222

=====

S A L E S A C K N O W L E D G M E N T - REPRINT SO No LYN PI-16815

=====

1 A 653 GALVANNEALED SHEET CS-B *60 CT DRY .0516 Nom X 48.0000" X 96.0000" Part No STE00241-22 SWITCH GRR COWLING 21954276-003 PC MATERIAL	5 PCS		345 LBS
	5 PCS @	47.2400 EA	236.20
2 A 653 GALVANNEALED SHEET CS-B *60 CT DRY 18GA X 48" X 144" Part No STE00241-08 SWITCH GRR COWLING 21954276-003 PC MATERIAL	13 PCS		1,347 LBS
	13 PCS @	70.8600 EA	921.18

ALL LOADS MUST BE TARPED REGARDLESSS OF WEATHER

ALL TAGS TO BE ATTACHED WITH SLIP TIES ON SIDE OF
SKID AND LOADED WITH TAGS ON PASSENGER SIDE

Order Totals:		2 Items	1,692 LBS
Material	Processing	Freight	Other
1,157.38			
		Taxes	ORDER AMT
			1,157.38

STRAIGHT BILL OF LADING - SHORT FORM

ORIGINAL - NOT NEGOTIABLE

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

FROM: NUCOR STEEL BERKELEY

TELEPHONE: 843/336-6000

AT: 1455 Hagan Avenue
Huger, SC 29450

DATE 8/13/19

BILL OF LADING NO. 1427700

PAGE : 1

Subject to Section 7 of the terms and conditions of this bill of lading, if this shipment is to be delivered to the consignee without recourse to the consignor, the consignor shall sign the following statement:
The carrier may decline to make delivery of this shipment without payment of freight and all other lawful charges.

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

Prepaid

(Signature of Consignor)

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

SHIP JEMISON DEMSEY METALS
69 188 ENTERPRISE DRIVE
TO: MADISON HEIGHTS, VA 24572SOLD JEMISON DEMSEY LLC DBA
105 JEMISON METALS
TO: 3800 COLONNADE PKWY STE 250
BIRMINGHAM AL 35243 0000

ROUTE

CARRIER TRUCK MILES 00363
LEWIS TRUCK LINESCAR OR
VEHICLE NO. 1958
Trailer Number

Load 1604272 Ticket...: 2706165

Contract:

Gross Wt: 76,660.00

COIL NBR	PO# /HEAT-SEQ#	PRODUCT (inches)	CALC LF	ORDER/LINE	WEIGHT
499752.100	LYN-3243	.0690 MIN X 60.2500 MIN	1453	466608-1	22,320.00
		ASTM A1011 / CS-B / REV: 2018a		Due 7/27/19	
	2911043-2	POTP /Mill Edge	MEPOTP.069X6025		
499752.200	LYN-3243	.0690 MIN X 60.2500 MIN	1452	466608-1	22,300.00
		ASTM A1011 / CS-B / REV: 2018a		Due 7/27/19	
	2911043-2	POTP /Mill Edge	MEPOTP.069X6025		

Melted and Manufactured In the USA.

Total Pounds 44,620.00

(in percent)																	
Heat	C	Mn	P	S	Si	Cu	Ni	Cr	Mo	Sn	Al	V	Nb	N	Ti	B	Ca
2911043	.05	.27	.006	.001	.03	.07	.03	.03	.01	.004	.034	.003	.000	.006	.002	.000	.002

TARP ALL LOADS

Ship-To Contact: For delivery appointment, Ship-To Phone#: 4349296802

M-F (ApptReq) | M-F (8AM 2:30PM) | Sa-Su (Closed)

Load Created by: JLM

Coil information matches bill of lading YES/NO

Bill of lading matches PO YES/NO

Packaging and coil dry and in good shape

Actual weight within 1% of B/L weight YES/NO

Load tarped YES/NO

Explanation of any no answers

8-14-19

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

NUCOR STEEL BERKELEY

1455 Hagan Avenue
Huger, SC 29450

Permanent post office address of shipper

148947

{END}

SHIPPER'S
SIGNATURE

BRUCE D MARTIN

CARRIER'S
SIGNATURE:

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

STRAIGHT BILL OF LADING - SHORT FORM

ORIGINAL - NOT NEGOTIABLE

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

FROM: NUCOR STEEL BERKELEY

TELEPHONE: 843/336-6000

AT: 1455 Hagan Avenue
Huger, SC 29450

DATE 8/26/19

BILL OF LADING NO.

1430479

PAGE : 1

Subject to Section 7 of the terms and conditions of this bill of lading, if this shipment is to be delivered to the consignee without recourse on the consignor, the consignor shall sign the following statement.

The carrier may decline to make delivery of this shipment without payment of freight and all other law charges.

(Signature of Consignor)

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

Prepaid

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

SHIP JEMISON DEMSEY METALS
TO: 188 ENTERPRISE DRIVE
MADISON HEIGHTS, VA 24572

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

ROUTE

CARRIER TRUCK MILES 00363

CAR OR
VEHICLE NO. 2109

Load 1607114 Ticket...: 2710269

Contract:

EXPEDITED LOGISTIC SOLUTIONS

Trailer Number

Gross Wt. 77,620.00

COIL NBR	PO# /HEAT SEQ#	PRODUCT (inches)	CALC LF	ORDER/LINE	WEIGHT
502008.100	LYN-3265	.0170 MIN X 50.3120 MIN	7697	467165-1	22,920.00
		ASTM A653 / CS TYPE B / 18		Due 8/31/19	
G40	1911753-1	GALVANIZED	.017X50.312	G40 Dry/CHM	
502008.200	LYN-3265	.0170 MIN X 50.3120 MIN	7779	467165-1	23,140.00
		ASTM A653 / CS TYPE B / 18		Due 8/31/19	
G40	1911753-1	GALVANIZED	.017X50.312	G40 Dry/CHM	

Melted and Manufactured In the USA.

Total Pounds

46,060.00

(in percent)

Heat	C	Mn	P	S	Si	Cu	Ni	Cr	Mo	Sn	Al	V	Nb	N	Ti	B	Ca
1911753	.02	.17	.007	.003	.03	.16	.04	.05	.01	.006	.028	.001	.001	.006	.001	.004	.003

TARP ALL LOADS

Ship-To Contact: For delivery appointment, Ship-To Phone#: 4349296802

M-F (ApptReq) | M-F (8AM 2:30PM) | Sa-Su (Closed)

Load Created by: JLM

877-19

Is the bill of lading (YES/NO)
 matches PO (YES/NO)
 Is the coil dry and in good shape (YES/NO)
 Is the coil weight (YES/NO)
 Is the coil weight (YES/NO)
 Is the coil weight (YES/NO)

If the shipment moves between two ports by a carrier by water, the law requires that the bill of lading shall state whether it is "carrier's weight" or "shipper's weight".

The agreed-on declared value of the property is hereby specifically stated by the shipper to be not exceeding per...
 Shipper hereby certifies that he is familiar with all the terms and conditions of this bill of lading, including those on the back hereof, and the said terms and conditions are hereby agreed to by the shipper and accepted for itself and its assigns.

NUCOR STEEL BERKELEY

1455 Hagan Avenue

Huger, SC 29450

Permanent post office address of shipper

161476

{{{FNT}}}

SHIPPER'S
SIGNATURE:

LUCRETIA R CROKER

CARRIER'S
SIGNATURE:

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

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

RC 6237	Act Dt 14Aug19	Description	Probill Number
By lyn1	Ent Dt 14Aug19	COIL	1427700

Item	Type	Order Number	Vendor/Customer	Shp Fr	Bill of Lading	U/M
1	P	LYN 3243-001	35 NUCOR-BERKELEY		1427700	LBS
					PCS	Quantity
POC/14L/CSBTP					Coil Lgth	1,578 FT
A 1011 HRPO COIL CS TYPE B TEMP PASS					1	22,320 LBS
.0690 Min X 60.2500"					Pack	22,320 LBS
Tag NB9178 LPW Loc					Theo	22,320 LBS
NUB 2911043						
EATON-FAB						
POC/14L/CSBTP					Coil Lgth	1,576 FT
A 1011 HRPO COIL CS TYPE B TEMP PASS					1	22,300 LBS
.0690 Min X 60.2500"					Pack	22,300 LBS
Tag NB9179 LPW Loc					Theo	22,300 LBS
NUB 2911043						
EATON-FAB						
Item	1 Totals		Weight	Packing Slip		
PCS			44,620 LBS	Theoretical	44,620 LBS	
2					44,620 LBS	
Receiver	6237	Total Equivalent Weight		44,620 LBS		
		Total Coil Length		3,154 FT		

By: zdelp	At: LYN	Date: 27Aug19	Time: 07:53
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LYN Tag NB9178 Whs LPW

Tag Info

POC	Dim 60.2500	Lgth	Type
14L	Ga .0690 M Avg	PIW	Status M
CSBTP		Tag Ref No 499752.100	
Part No		Owner O Own/For 3018 EATON-FAB	
Heat NUB 2911043	C=<.05> Mn=<.27> P=<.006> S=<.001> Si=<.03> N=<.006>		
Cr=<.03> Mo=<.01> Cu=<.07> Al=<.034> V=<.003> Ti=<.002> Ni=<.03> Nb=<.000>			
Specs			

Cond		ID	OD
Rmks EATON-FAB			
Ven Ref No			
Pur PO LYN 003243-001	Width		
Rcv RC LYN 006237-001 14Aug19 Trans	Gauge		
Master Tag	Created 14Aug19	Length	Due
Lnd 26.4469	Parent Tag		Hold Code
Mat 26.4469			Hold Rsn
Frt			Loc
Pro			Skd Ty
Oth			Cut No
Tot 26.4469 /CWT	Pcs		Reject Rsn
Made	Qty 0		Archived
1-Reservns 2-Tag Tracing 3-Heat Zoom 4-Rmks 5-Other			Tag Ref 6-StdLoc 7-MN Ref

17Aug19

27Aug19 08:01

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

LYN 11892

Jemison Metals - Lynchburg

188 Enterprise Drive
Madison Hts, VA 24572

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

Job Type SHR Process PWC TBL1

Metric N Cust

Desc EATON 42C4745H05

Due Date 27Aug19 Wht LRG

Setup 00:00 Run 06:00 Ptd By zdelp

<<< JOB SPECIFICATIONS >>>

Group POS Grade CSBTP Gauge 0.0747 (0.0747 to 0.0747) ID 0.0000

<<< ORDER SPECIFICATIONS >>>

F 01 POS/14/CSBTP/12.0200X37.74/.0747N CS TYPE B TEMP PASS

Part 3018/42C4745H05 Ga 0.0747 Wht 12.0200 Lth 37.7400

Ga Rng 0.0670to 0.0810 Pc/Tag 40

Whtol + 0.1250 - 0.0000 Wt/Skd

Lchtol + 0.0300 - 0.0300 TY JD6 PK

WAVE:0.00-.12

FLATN:0.00-.12

SQUA:0.00-.03

<<< PROCESSING INSTRUCTIONS >>>

<<< MATERIAL TO BE USED >>>

Tag No Wht Gauge Width Length PCS Weight Heat Number Locn

<POS/14/CSBTP>

27865 LPW 0.0747N 12.0200 37.7400 200 1922 NUB2911043

<<< MATERIAL TO STOCK >>>

Cons Tg

Spc Prod Tg Wht Ty Gauge Width Length OD PCS<Prn>Wt PCS<Res>Wt

27865

1 27866 LFG F 0.0747 12.0200 37.7400 40 385

1 27867 LFG F 0.0747 12.0200 37.7400 40 385

1 27868 LFG F 0.0747 12.0200 37.7400 40 384

1 27869 LFG F 0.0747 12.0200 37.7400 40 384

1 27870 LFG F 0.0747 12.0200 37.7400 40 384

Total: 200 1,922

<<< JOB RECAP >>>

Material Allocated PCS Weight Scrap Scrap % Unactd Scr %

Master Returns

Returns to Stock

Work in Process

Material to be Shipped

Net Weight to be Produced

Page:

1 Last

CALIBRATION/ VERIFICATION SHEET



INSTRUMENT CALIBRATED/ VERIFIED: Mititoyo 0-1" Micrometers
 *Indicate appropriate action(s)

INSTRUMENT ID# 293-831-30

AS FOUND PHYSICAL CONDITION: Excellent

ACTION TAKEN: Performed Calibration

STANDARD SERIAL #:

KNOWN VALUE:

AS FOUND READINGS:

VERIFICATION

LM-007

.250"

.250"

0

LM-005

.500"

.500"

0

LM-001

1.000"

1.000"

0

TEMPERATURE:

80°

HUMIDITY:

65%

VERIFIED BY

Z. Delp

DATE:

Mar-19

ISSUED TO:

LL1

DUE DATE

Sep-19

Allowable Deviation:

Callipers = ± .001"

Micrometers = ± .001"

Tape Measure = ± .03125"

*Inside
 **depth
 ***step

Extra Caliper Measurements where applicable

CALIBRATION/ VERIFICATION SHEET



INSTRUMENT

CALIBRATED/ VERIFIED: Protractor

*Indicate appropriate action(s)

INSTRUMENT ID# 048

AS FOUND PHYSICAL CONDITION: Good

ACTION TAKEN: Performed Calibration

STANDARD SERIAL #:

GI-M027

TEMPERATURE

78°

VERIFIED BY

Z. Delp

ISSUED TO:

LB1

Allowable Deviation:

Callipers = ± .001"

Micrometers = ± .001"

Tape Measure = ± .03125"

*Inside
**depth
***step

Extra Caliper Measurements where applicable

HUMIDITY:

40%

DATE:

May-19

DUE DATE

Nov-19

KNOWN VALUE:

30°

45°

60°

90°

AS FOUND READINGS:

30°

45°

60°

90°

VERIFICATION

CALIBRATION/ VERIFICATION SHEET



INSTRUMENT

CALIBRATED/ VERIFIED: Micrometer

*Indicate appropriate action(s)

INSTRUMENT ID # 039

AS FOUND PHYSICAL CONDITION: Fair

ACTION TAKEN: Performed Calibration

STANDARD SERIAL #:

LM-007

LM-005

LM-001

TEMPERATURE 65°

VERIFIED BY Z. Delp

ISSUED TO: LCT

Allowable Deviation:

Calipers = ± .001"

Micrometers = ± .001"

Tape Measure = ± .03125"

*Inside
**depth
***step

Extra Caliper Measurements where applicable

DUE DATE

Feb-20

DATE:

Aug-19

HUMIDITY:

40%

KNOWN VALUE:

0.250

0.500

1.000"

AS FOUND READINGS:

.250

.500

1.000"

VERIFICATION

CALIBRATION/ VERIFICATION SHEET



INSTRUMENT
 CALIBRATED/ VERIFIED: 25' Lufkin Tape line
 *Indicate appropriate action(s)

INSTRUMENT ID # 01

AS FOUND PHYSICAL CONDITION: Fair

ACTION TAKEN: Performed Calibration

STANDARD
 SERIAL #:

LM-005-001

KNOWN VALUE:

6.000"

AS FOUND READINGS:

5.9843

VERIFICATION

.0157"

TEMPERATURE: 79°

HUMIDITY:

70%

VERIFIED BY

Z. Delp

DATE:

Jun-19

DUE DATE

Dec-19

ISSUED TO:

LRB

Allowable Deviation:

Calipers = $\pm .001$ "

Micrometers = $\pm .001$ "

Tape Measure = $\pm .03125$ "

Extra Caliper Measurements where applicable

*Inside

**depth

***step

4/10/19

DOC#: FQA066

REVISION LEVEL:3

CERTIFICATE OF INSPECTION

Instrument: Gauge Block

Grade: AS-1 (ASME)

Date of inspection: 18th Apr. 2018

Unit: μ in

Nominal Length in	Ident. No.	Central Deviation	Maximum Deviation	Minimum Deviation	Variation
0.1	180773	0.0	+1.2	-2.4	3.6

ENVIRONMENT: Air temperature $(68 \pm 1.8)^{\circ}\text{F}$ $(20 \pm 1.0)^{\circ}\text{C}$

BASIS OF TEST: ASME B89.1.9-2002

MATERIAL: Steel

INSPECTION METHOD: by comparator

COEFFICIENT OF

THERMAL EXPANSION: $(6.0 \pm 0.3) \times 10^{-6}/^{\circ}\text{F}$ $(10.8 \pm 0.5) \times 10^{-6}/^{\circ}\text{K}$

EXPANDED UNCERTAINTY $\pm 4\mu\text{in}$ or less $2.4\mu\text{in}$ (For Central Deviation) $(k=2)$

Up to 20in $(1.2 + L / 2.3)\mu\text{in}$

TRACEABILITY: Traceable to NIST via No. 683/290402-17
(NIST-National Institute of Standard and Technology)

NIST: Confirmation of technical capability
by the transfer standard. (ISO/IEC17043)

Date 18th Apr. 2018

H. Takeyama

H. Takeyama

F-691(9)

MITUTOYO CO. HEADQUARTERS:

Postal code: 213-0012

20-1 Sakado 1-chome, Tokutsu-ku, Kawasaki-shi, Japan

Tel: 044(813)8201 Fax: 044(813)8210

SP

Certificate of Calibration

Size	Sample ID	Grade	Material	Master Set Serial #
500	G0851	AS-I	Steel	21491.2
				Master Set Calibrated On: 2012-09-27
				N.I.S.T. Test Number: 883283428-13

• The deviation shown is in .000001" increments.
 • The gage block was examined in compliance with ASME B89.1.9-2002 for flatness and parallelism.
 • The Master Set used in calibration is traceable to the NIST. Set calibrated at 68°Fahrenheit(20°C centigrade).

Inspected By: Kang Shao Date: 2017-06-02
 Date of purchase: _____