

Audit Review and Evaluations OF

JEMISON METALS

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

Dates of Audit: 9/1/2021
Date of Submittal: 9/7/2021

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, GAD059 Rev 0 Press Brake check sheet, LYN-F-001 REV 1 CTL QA form

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 Training Status Matrix:

Confirmed training status:

Tim Guthrie-Punch combo trained

William Bersch-Laser trained

Mike Brown-Laser trained

Roderick Johnson-Press Brake Trainer

Lacy Rush-Red Bud operator Trainer

Frank Sims-Shipping Trainer

8.2 Requirements for products and services

Hill Phoenix FAB requisition 261229 due 8/30/2021-Received by Dean Burley 8/27/2021 (S/O 26788-3 due 8/30/2021), PN 21251

8.4 Control of externally provided processes, products and services

Mill Coil #1575482 from Nucor Berkley received off PO LYN 4754-1 Receiver 9657 dated 9/1/2021 Bucket GVC C90CDX 23A 60” met all requirements for customer parts in that bucket. Receiver stamped and signed

8.5-Production & Service Provisions

Receiving:

B/L 15754821 (PO LYN 4754) Receiving paperwork stamped and filled out but not signed. (Minor #1)

Shipping:

B/L SM2 1984 - S/O SM2-4602-1 shipped 9/1/2021 All tags were matched and all material shipped and was checked off. No signature of Consignor. Other bills reviewed, Consignor signature requirement space was used for consignee (Minor #2)

Production:

1st shift

Red Bud: W/O LYN 21798 O'Neal Bham part 11/GNS14GAX60X240 to fulfill S/O 26746-1. All checks performed and documented on LYN-F-001 by operator Lacy Rush per procedure LYN-LRB-00. Operator displayed proficiency and ability to locate procedure.

Punch: W/O LYN 21251 HP Fab part 3453/P113399A to fulfill S/O 26788-3, All checks performed (Jem Print) and documented by operator Tim Guthrie, Met all requirements of Procedure LYN-PC-001. Operator displayed proficiency and ability to locate procedure.

Press Brake: W/O 21451 HP Fab stock job part 3453/F838374GGL, documentation reviewed Doc GAD 059 filled in incorrectly: Check mark used in pass fail column (observation #1) Sampling check frequency met all requirements of Procedure SM2-PB-001. Operator Roderick Johnson displayed proficiency and ability to locate procedure.

Laser: W/O SM2 9406 Trane Clarksville part 3488/438584150001 stock job. All checks performed and documented on Jem Print and GAD 059 (repeat of observation #1) by operator William Bersch, Met all requirements of Procedure LYN-LA-001. Operator displayed proficiency and ability to locate procedure.

2nd shift:

Laser: W/O 21543 Hill Phoenix Fab part 3453/P113387F stock job. All checks performed and documented on Jem print and GAD 059 by operator Mike Brown, Met all requirements of Procedure LYN-LA-001. Operator displayed proficiency and ability to locate procedure

7.1.3 Infrastructure

Preventive Maintenance: Reviewed with Bill Huffman and Justin Riley Monthly PM schedule and status for August Internal preventative maintenance reviewed. All schedule maintenance documented as performed for August all documents Initialed dated and approved.

7.1.5 Monitoring and Measuring Resources

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

Measuring equipment:

Calipers LS2 due 01/2022

Protractor 048 due 01/2022

Micrometer 03 due 01/2022

Tape 053 due 01/2022

Micrometer 02 due 01/2022

Tape 04 due 01/2022

Measuring Standards:

H6049-2/2023

H0057-2/2023

LM-001 2/2023

LM-004 9/2023

8.7 Control of Nonconforming Product

Nonconforming area was well defined and neat. One item did not have an “R” designation on tag. ([Observation #2](#))

- Tags:

93339 Removed from system after designated to scrap, will physically scrap when enough SS to call a truck in.

133703 LBR material physically in reject area, and virtually designated as reject. Does not have an “R” designation on hard copy of tag.

10.2 Nonconformity and Corrective Action

CA 20799 completed and closed.

CA 21243 open, training and two of three audits performed.

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 audit:

SRI Surveillance Audit performed 2/2-5/2020

No observations or findings

Observations from previous internal audit:

1. GAD 059 incorrectly filled in. Job identification number left off. All GAD 059 found to have job ID during current audit.

2.0 Overview

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

Roderick Johnson-Press Brake Operator Mike Brown-Laser operator Tim Guthrie-Laser punch combo operator Stanley Gallier- Receiver Justin Riley-Maintenance	William Bersch-Laser operator Lacy Rush-Red Bud operator Dean Burley-Inside sales Bill Huffman-Plant Manager Frank Sims –Shipper Nathan Ragland-Quality Tech
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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</p>
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	action
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2.3 APPROVAL/SIGN-OFF

Report Prepared by Patrick Macias

Date 9/7/2021

Nonconforming Corrective Action Report (CAR) for Jemison
Metals

CAR #	ISO 9001: 2015 Clause / Sub-Clause	Findings/Requirements	Observati on	Mino r	Major
NA	8.1	Form GAD059 Press Brake Check Sheet filled out incorrectly. Column designated as Pass/Fail filled in with a check mark instead of an indication of pass fail	1		
NA	8.7.1	Reject tag 133703 did not have an "R" on hard copy	2		
21545	8.4.1	Receiver stamped and correctly documented inspection but did not sign or date B/L		1	
21545	8.6	Shipper did not sign or date outgoing B/L in the Consignor location.		2	

25Aug21 11:59

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

LYN 21798

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 ONEAL -BHAM
Desc P-1 O'NEAL 26746-1
Due Date 31Aug21 Whs LFG
Setup 00:00 Run 01:39 Prtd By lunsfor

<<< JOB SPECIFICATIONS >>>

Group GNS Grade CSA40 Gauge 0.0785 (0.0725 to 0.0845) ID 0.0000

<<< ORDER SPECIFICATIONS >>>

F 01 GNS/14/CSA40/60.0000"X240.00/.0785N CS A40
Ord LYN 26746- 1 Cust ONEAL -BHAM Ga 0.0785 Wth 60.0000 Lth 240.0000
Part 11/GNS14GAX60X240 A653CSA40 NCTD Ga 0.0785 Wth 60.0000 Lth240.0000
Ga Rng 0.0725to 0.0845 Pc/Tag 27
WthTol + 0.1875 - 0.0000 Wt/Skd
LthTol + 0.1250 - 0.0000 Ty JD6 Pk

** CUT COIL TAG #'S 14114 & 14115 ***

** PKG 27 PCS/ SKID

*** USE CUSTOMER RETURNED SKIDS ****

*MUST SKID (JD6)
NO PAPER INTERLEAVE PLACE BOARDS BETWEEN SKID AND
MATERIAL TO ALLOW SHEET LIFTER/FORK LIFT UNLOAD MU
ST SKID WITH SLATS RUNNING THE WIDTH OF THE MATERI
AL NO PAPER IN BUNDLE OR BETWEEN SHEETS NO STICKER
S OR LABELS ON MATERIAL BUNDLE MUST BE BANDED WIDT
H AND LENGTH OF MATERIAL NEATLY STACKED IDENTIFY M
ATERIAL BY USING TAG AND ATTACH TAG TO BANDING OF
BUNDLES

** CUT COIL TAG #'S 14114 & 14115 ***

** PKG 27 PCS/ SKID

*** USE CUSTOMER RETURNED SKIDS ****

<<< PROCESSING INSTRUCTIONS >>>

<Step 1>
Level To: 60.0000 X 240.0000 143 Pcs 45843 LBS 27 Pcs/Tag

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

LYN 21798

Jemison Metals - Lynchburg

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<GNC/14/CSA40>								
14114	LCO	0.0705M	60.0000		1	23391	NUDCA260	
14115	LCO	0.0705M	60.0000		1	22939	NUDCA2680	
Total:					2	46330		

<<< MATERIAL TO BE SHIPPED >>>

01 Ord LYN 26746-	1 Cust ONEAL -BHAM	Part GNS14GAX60X240	A653CSA40	NCTD
A 653 GALVANNEALED SHEET CS A40		Pcs/Tg 27	Bal 143	Pcs
.0785 Nom X 60.0000" X 240.0000"		DueDt 31Aug21	46,943 LBS	

** CUT COIL TAG #'S 14114 & 14115 ***

** PKG 27 PCS/ SKID

*** USE CUSTOMER RETURNED SKIDS ****

* SI # 18885581

*MUST SKID (JD6)

NO PAPER INTERLEAVE PLACE BOARDS BETWEEN SKID AND MATERIAL TO ALLOW SHEET LIFTER/FORK LIFT UNLOAD MUST SKID WITH SLATS RUNNING THE WIDTH OF THE MATERIAL NO PAPER IN BUNDLE OR BETWEEN SHEETS NO STICKERS OR LABELS ON MATERIAL BUNDLE MUST BE BANDED WIDTH AND LENGTH OF MATERIAL NEATLY STACKED IDENTIFY MATERIAL BY USING TAG AND ATTACH TAG TO BANDING OF BUNDLES

Itm Rmks: S XX

LOAD FORK SIDE

MATERIAL MUST BE TARPED

10,000 LB MAX SKID

CALL 24 HOURS IN ADVANCE FOR APPOINTMENT

599-8179

RECEIVING HOURS - 7:00AM - 2:00PM

XXX

Con Tag	Whs	Tag No	Whs T	Gauge	Width	Length	OD	Pcs	Weight
14114	LCO	OB45303	LCO F	0.0785	60.0000	240.0000		27	8,656
		OB45304	LCO F	0.0785	60.0000	240.0000		27	8,656
		OB45305	LCO F	0.0785	60.0000	240.0000		27	8,656
14115	LCO	OB45306	LCO F	0.0785	60.0000	240.0000		27	8,656
		OB45307	LCO F	0.0785	60.0000	240.0000		27	8,656
		OB45308	LCO F	0.0785	60.0000	240.0000		9	2,885
Total	No Tags	6						144	46,165

<<< JOB RECAP >>>

	PCS	Weight	Scrap	Scrap %	Unactd Scr %
Material Allocated	2	46,330			
Master Returns					
Returns to Stock					

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

LYN 21798

Jemison Metals - Lynchburg

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Work in Process
Material to be Shipped      144      46,165
Rejects
Net Weight to be Produced   144      46,165                      165      0.36
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AGT400 Coil Summary Report

Jemison Metals -- 72 Red Bud Multi-Blanking

Work Order: 21798 Coil Number: 14114

Customer Name: ONEAL Heat Number: NA Vendor: ONEAL

Product: Galvannealed Sep-1-21 1:04 PM to 1:10 PM (clock 6.2 min/ run 6.2 min) Shift: 1

Average Thickness and Tolerance Data

Target	0.0785 in	Average*	0.0717 in	Average - Target	-0.0068 in (-8.70%)
				Standard Deviation*	0.0005 in (0.66%)
Length*	289 ft	Above High Limit	0.0845 in	0 ft	(0.0%)
Width	60.000 in	In Tolerance		3 ft	(1.1%)
Weight	4236 lbs	Below Low Limit	0.0725 in	286 ft	(98.9%)
Max Thickness	0.0726 in at	63 ft	Min Thickness	0.0700 in at	262 ft
Head Scrap	0 ft		Tail Scrap	0 ft	

Statistical Process Control Data

Upper Control Limit	0.0732 in	Upper Tolerance Limit	0.0845 in
X Double Bar	0.0717 in	R Bar	0.0016 in
Lower Control Limit	0.0701 in	Lower Tolerance Limit	0.0725 in
CR	26.0% (Capability Ratio %, 100/CP)		
CP	3.846 (Process Capability, HiLim-LoLim/6*Sigma)		
CPK	-0.532 (Capability vs Limits)	TMW Ratio	1.012 (Low Limit/Avg)

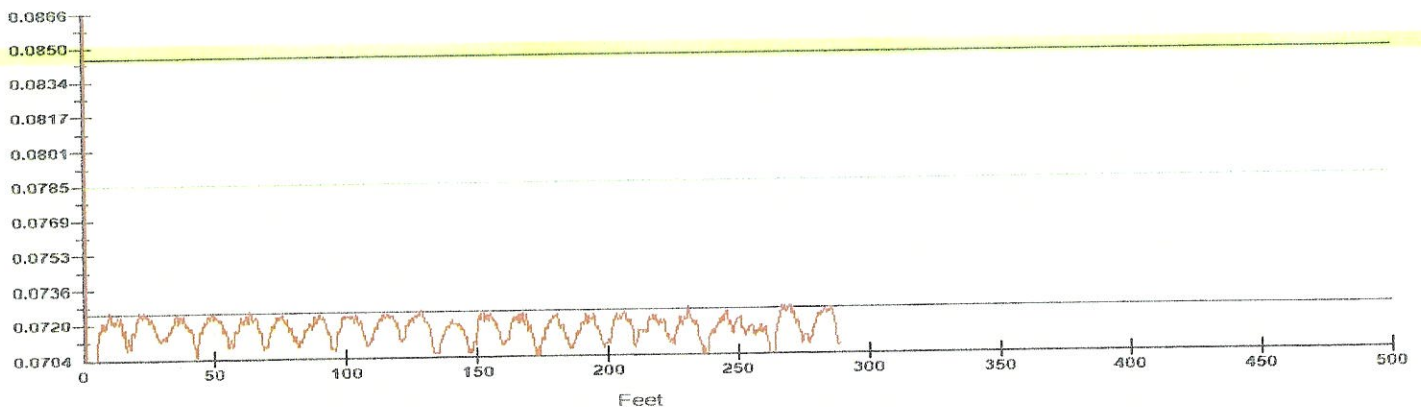
Thickness Distribution Relative to the Target

+++	0.0%
+0.0100	0.0%
+0.0090	0.0%
+0.0080	0.0%
+0.0070	0.0%
+0.0060	0.0%
+0.0050	0.0%
+0.0040	0.0%
+0.0030	0.0%
+0.0020	0.0%
+0.0010	0.0%
+0.0000	0.0%
-0.0010	0.0%
-0.0020	0.0%
-0.0030	0.0%
-0.0040	0.0%
-0.0050	0.0%
-0.0060	1.1% **
-0.0070	67.0% ----->
-0.0080	30.4% -----
-0.0090	1.5% ---
-0.0100	0.0%
---	0.0%

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

0.0% is within ± 0.0020 in of the target 0.0% is within ± 0.0050 in of the target
100.0% is within ± 0.0100 in of the target 100.0% is within ± 0.0200 in of the target

Thickness vs Length (Coil Number 14114)



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

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

LYN 21798

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

Job Type LEV Process PWC LRB
Metric N Cust ONEAL -BHAM
Desc P-1 O'NEAL 26746-1
Due Date 31Aug21 Whs LFG
Setup 00:00 Run 01:39 Prtd By lunsfor

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<GNC/14/CSA40>								
14114	LCO	0.0705M	60.0000		1	23391	NUDCA260	
14115	LCO	0.0705M	60.0000		1	22939	NUDCA2680	
Total:					2	46330		

*** Reference Only***

Start Time 1222

Stop Time 110

*** Reference Only***

Start Time 110

Stop Time _____

Lynchburg Cut To Length
Quality Assurance Form

Date: 9 1 20

Operator: AL

Prod. Job #: 21798

Master Coil Width: 60 1/2

Unplanned Downtime: _____

Notes: _____

Tag#	Wght.	Flatness	PC	Tag#	Wght.	Flatness	PC	Tag#	Wght.	Flatness	PC
45303	7722		PC-27								
Mic	070			Mic	070			Mic			
Width	60 1/2	Length	240 1/2	Width	60 1/2	Length	240 1/2	Width		Length	
Diagonal (a)	247 7/8	Diagonal (b)	247 1/2	Diagonal (a)	247 7/8	Diagonal (b)	247 1/2	Diagonal (a)		Diagonal (b)	

Tag#	Wght.	Flatness	PC	Tag#	Wght.	Flatness	PC	Tag#	Wght.	Flatness	PC
45304	7722		PC-27								
Mic	070			Mic				Mic			
Width	60 1/2	Length	240 1/2	Width		Length		Width		Length	
Diagonal (a)	247 7/8	Diagonal (b)	247 1/2	Diagonal (a)		Diagonal (b)		Diagonal (a)		Diagonal (b)	

Tag#	Wght.	Flatness	PC	Tag#	Wght.	Flatness	PC	Tag#	Wght.	Flatness	PC
45305	7722		PC-27								
Mic	070			Mic				Mic			
Width	60 1/2	Length	240 1/2	Width		Length		Width		Length	
Diagonal (a)	247 7/8	Diagonal (b)	247 1/2	Diagonal (a)		Diagonal (b)		Diagonal (a)		Diagonal (b)	

Non-Conformance Information

Tag#	Reason or explanation of rejection/ non-conformance	Attach NC check sheet

27Aug21 11:41

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

LYN 21251

(R E P R I N T)

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

Job Type SHR Process PWC LP1
 Metric N Cust
 Desc P-1 H-P P113399A
 Due Date 06Aug21 Whs LFG
 Setup 00:00 Run 05:50 Prtd By lunsfor

<<< JOB SPECIFICATIONS >>>

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

<<< ORDER SPECIFICATIONS >>>

F 01 GVS/24D/CB40CD/47.9996"X56.27/.0298N CS-B ^40 CT DRY
 Ord LYN 26788- 3 Cust Hill Phoen FAB Ga 0.0298 Wth 47.9996 Lth 56.2789
 Part 3453/P113399A Ga 0.0298 Wth 47.9996 Lth 56.2789
 Ga Rng 0.0260to 0.0300 Pc/Tag 75
 WthTol + 0.0100 - 0.0100 Wt/Skd 1713
 LthTol + 0.0100 - 0.0100 Ty JD7 Pk

 WGT PER PIECE: 22.83

<<< PROCESSING INSTRUCTIONS >>>

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<GVS/24D/CB40CD>								
140514	LPW	0.0296N	51.5000	67.5000	75	1929	NUB1107019	
Total:					75	1929		

<<< MATERIAL TO BE SHIPPED >>>

01 Ord LYN 26788- 3 Cust Hill Phoen FAB Part P113399A
 A 653 GALVANIZED SHEET CS-B ^40 CT DRY Pcs/Tg 75 Bal 75 Pcs
 .0298 Nom X 48.0000" X 65.4040" DueDt 01Sep21 1,712 LBS
 MSK

Con	Tag	Whs	Tag No	Whs T	Gauge	Width	Length	OD	Pcs	Weight
140514	LPW	145467	LFG F	C.0298	47.9996	56.2789			75	1,712

<<< JOB RECAP >>>

	PCS	Weight	Scrap	Scrap %	Unactd	Scr %
Material Allocated	75	1,929				
Master Returns						
Returns to Stock						
Work in Process						
Material to be Shipped	75	1,712				
Rejects						
Net Weight to be Produced	75	1,712			217	11.25

27Aug21 11:41

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

LYN 21251

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

Job Type SHR Process PWC LP1
Metric N Cust
Desc P-1 H-P P113399A
Due Date 06Aug21 Whs LFG
Setup 00:00 Run 05:50 Prtd By lunsfor

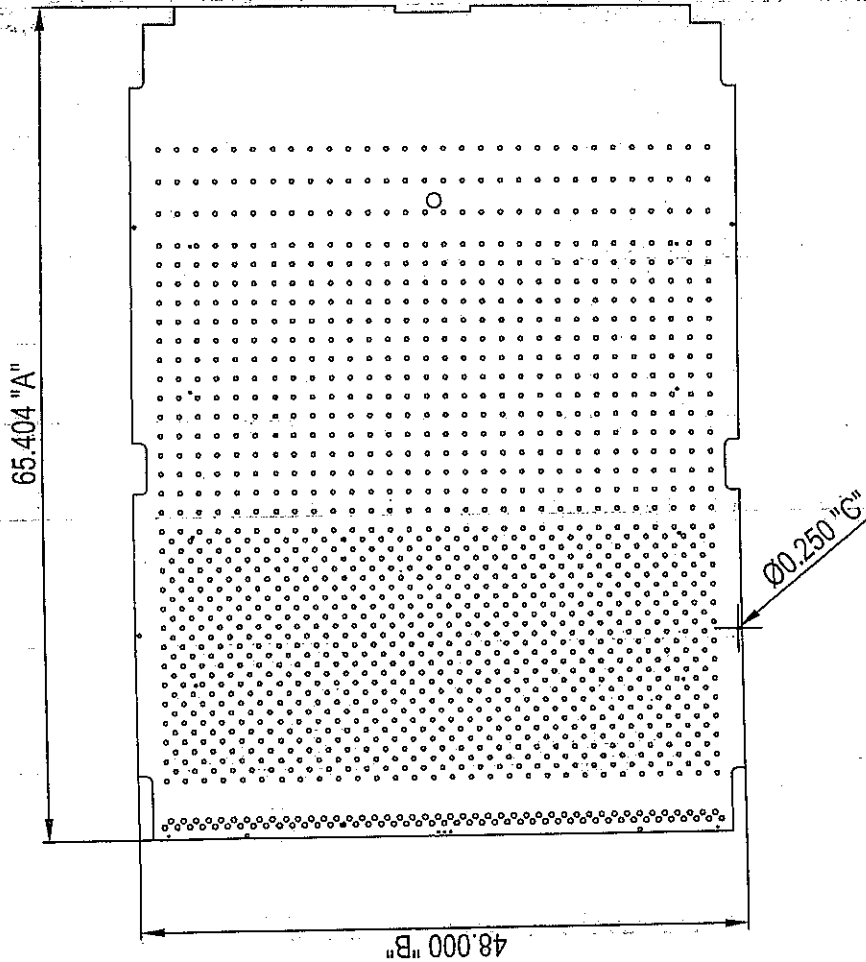
<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<GVS/24D/CB40CD>								
140514	LPW	0.0296N	51.5000	67.5000	75	1929	NUB1107019	
Total:					75	1929		

49x66

5710 49x66

JEMISON REVISION		CUSTOMER REVISION	
REV.	DESCRIPTION	REV.	DESCRIPTION
		1	



CUT/BURNT FIRST ARTICLES		TOLERANCES UNLESS OTHERWISE SPECIFIED	
NOMINAL	TOLERANCE	ACTUAL	LINEAR
MTL THICKNESS	.028	.028-.030	DIM IN THE FLAT ± .010
TOL "A"	65.404	65.394-65.414	DIM IN THE FORM ± .030
TOL "B"	48.000	47.990-48.010	HOLE DIA ± .01
TOL "C"	.250	.240-.260	ANGLES ± 1°
			WEIGHT:
		215	

CUSTOMER		HILL PHOENIX	
		TIE	
		MATERIAL 22GA GALV	
BY CC	DATE 6/14/19	SAT 1 OF 1	
PART NO. P878041AGL	QUANTITY 0	QUANTITY 1	

P113399A

Schedule Sheet Report

11/21/2019

Joint

None

P113399A

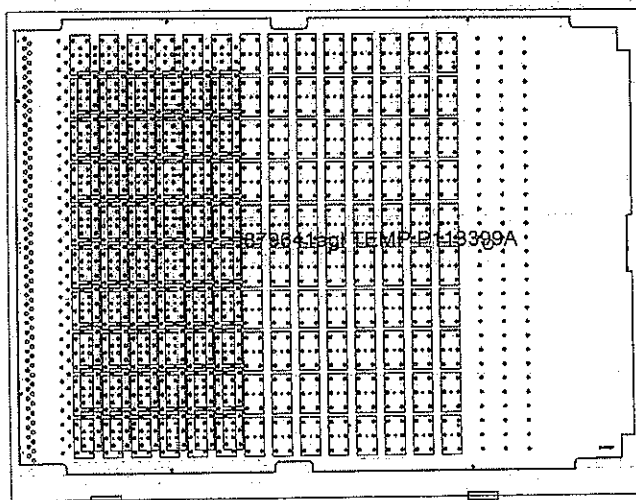
Schedule Name P113399A

Program Comment

Machine Name EMLKAJ

Sheet Name P113399A

Material Name	22GA.030GALV	Planned Process	01-27-30 5.5 HR 5 350
Sheet Size	67.5 X 51.5	Creation Date	2019/11/21
Thickness	0.03	Utilization	89.05%
Sheet Count	20 75	Due Date(Sheet)	2019/11/21
Grain Direction	Horizontal	Due Date(Schedule)	2019/11/21
Sheet Code	GVS24D51.5X67.5		
Clamp Position	10.00, 50.00, 85.00		



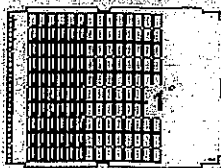
Laser Material Name 22GA.030GALV

Tool Information

T_Number	ManagerName	Shape	X	Y	R	Process Angle	Die
	SPKey	Usage	Air	MCode1	MCode2		
204	RO125	RO	0.125	0.125	0.	0	0.
		1		0	0		
106	RO375	RO	0.375	0.375	0.	0	0.
		1		0	0		
108	RO313	RO	0.313	0.313	0.	0	0.
		1		0	0		
311	RO1125	RO	1.125	1.125	0.	0	0.
		1		0	0		
112	RO188	RO	0.188	0.188	0.	0	0.
		1		0	0		
213	RO250	RO	0.25	0.25	0.	0	0.
		1		0	0		
233	RO281	RO	0.281	0.281	0.	0	0.
		1		0	0		

144	SP2	SP	1.813	3.313	0	0	0
		1		0	0		

Part Information



Part Name	f879641agi TEMP P113399A		
Due Date	2019/11/21	Weight	5442.59
Part Comment			
Unfold Size	65.4037 X 47.9996		
Qty/Total/Planned	1 / 20 / 20		

Used Material Info Report

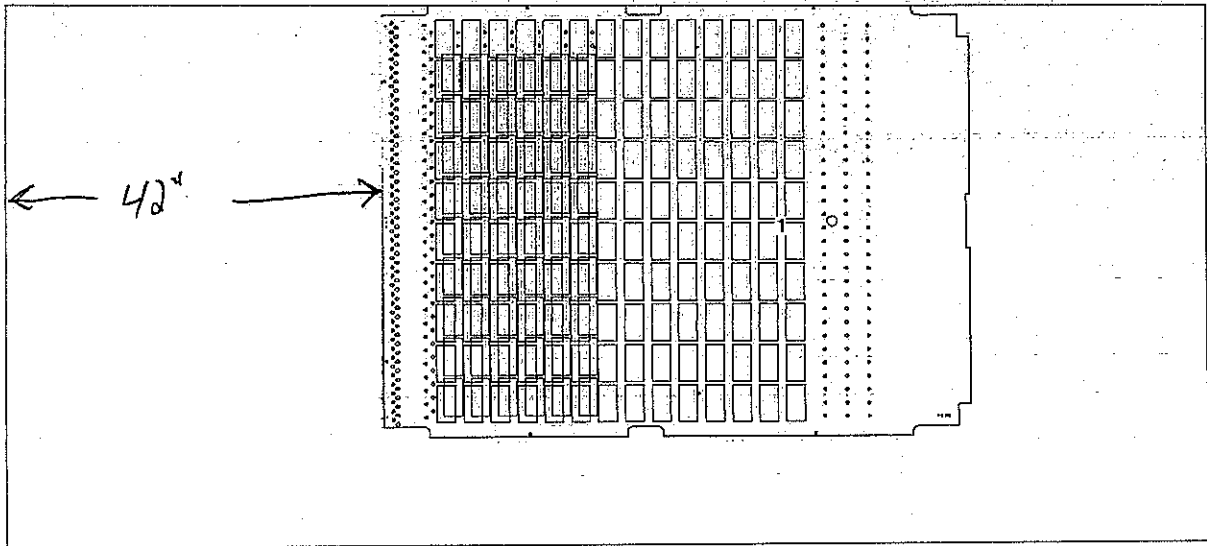
11/21/2019

Schedule Name	W/C Name
P113399A	
Machine Name	Date
EMLKAJ	2019/11/21

Material Name	Thickness	Sheet Code	Sheet Size	Sheet Count
22GA.030GALV	0.03	GVS24D51.5X67.5	67.5 X 51.5	20

Stacking Layout Report

Schedule Name P113399A
Program Name P113399A
Program Comment
Machine Name EMLKAJ
Pallet Name TK Station1



Part Information

NO.	Part Name	Part Comment	Unfold Size	Layout Base Point	Quantity / Total
1	f879641agl TEMP P113399A		65.4037 X 47.9996	42. X 12.	20 / 20

23Jul21 06:40

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

LYN 21451

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-1 H-P F838374GGL
Due Date 23Aug21 Whs LFG
Setup 00:00 Run 01:50 Prtd By lunsfor

<<< JOB SPECIFICATIONS >>>

Group GVS Grade CB40CD Gauge 0.0340 (0.0340 to 0.0340) ID 0.0000

<<< ORDER SPECIFICATIONS >>>

F 01 GVS/22B/CB40CD/9.7883"X125.88/.0358N CS-B ^40 CT DRY
Part 3453/F838374GGL Ga 0.0358 Wth 9.7883 Lth125.8812
Ga Rng 0.0320to 0.0360 Pc/Tag 20
WthTol + 0.0300 - 0.0300 Wt/Skd 251
LthTol + 0.0100 - 0.0100 Ty JD7 Pk

WGT PER PIECE - 12.51

<<< PROCESSING INSTRUCTIONS >>>

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<GVS/22B/CB40CD>								
48823	LPW	0.0358N	9.7883	125.8812	60	751	NUB1015770	
Total:					60	751		

<<< MATERIAL TO STOCK >>>

Cons	Tg	Spc	Prod	Tg	Whs	Ty	Gauge	Width	Length	OD	PCS<Prn>Wt	PCS<Res>Wt
48823												
1		48824		LFG	F		0.0358	9.7883	125.8812		60	751

<<< JOB RECAP >>>

	PCS	Weight	Scrap	Scrap %	Unactd Scr %
Material Allocated	60	751			
Master Returns					
Returns to Stock					
Work in Process					
Material to be Shipped	60	751			
Rejects					
Net Weight to be Produced	60	751			

HOT

23Jul21 06:40

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

LYN 21451

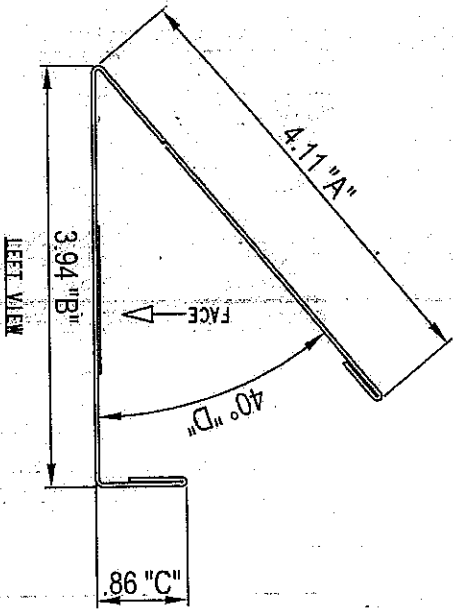
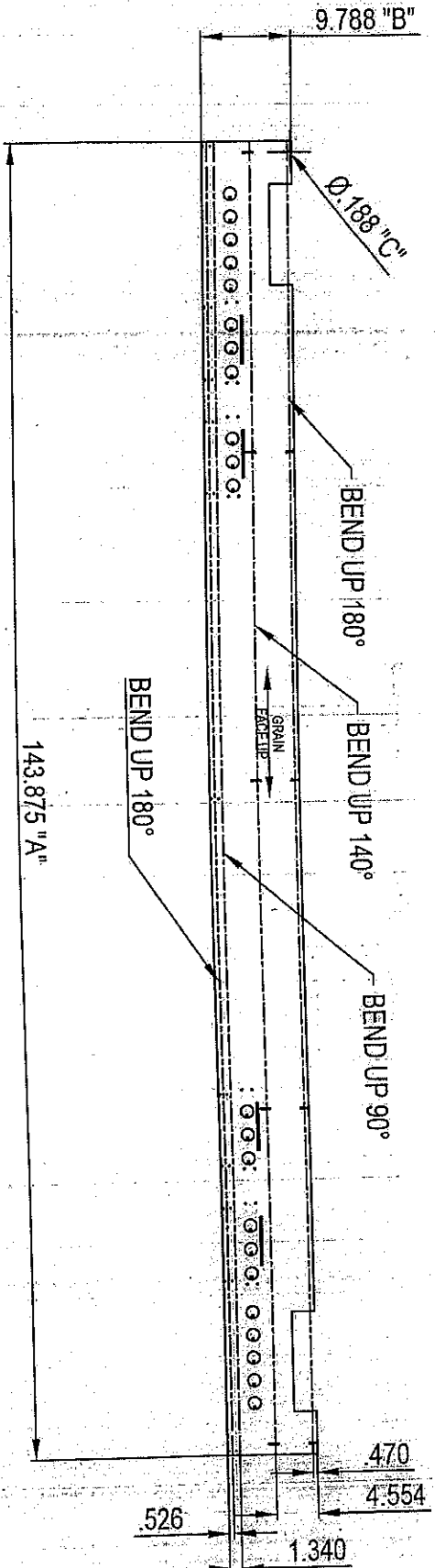
Jemison Metals - Lynchburg
188 Enterprise Drive
Madison Hts, VA 24572

Job Type SHR Process PWC LB1
Metric N Cust
Desc P-1 H-P F838374GGL
Due Date 23Aug21 Whs LFG
Setup 00:00 Run 01:50 Prtd By lunsfor

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<GVS/22B/CB40CD>								
48823	LPW	0.0358N	9.7883	125.8812	60	751	NUB1015770	
			Total:		60	751		

JEMISON REVISION		CUSTOMER REVISION	
REV	DESCRIPTION	DATE	REV
2			



DEBUR ALL SHARP EDGES
PART HAS GRAIN CONSTRAINTS

BENT/FORGED FIRST ARTICLES			CUT/BURNT FIRST ARTICLES			TOLERANCES UNLESS OTHERWISE SPECIFIED	
NOMINAL	TOLERANCE	ACTUAL	NOMINAL	TOLERANCE	ACTUAL		
TOL. "A"	4.11	4.08-4.14	4.10	MTL THICKNESS	.034	.032-.036	ALL BENDS 90° UNLESS SPECIFIED. DIM ON FLAT VIEWS ± .010 DIM ON FORGED VIEWS ± .08 ANGLES ± 1°
TOL. "B"	3.94	3.91-3.97	3.925	TOL. "A"	143.875	143.865-143.885	
TOL. "C"	.86	.83-.89	.87	TOL. "B"	9.788	9.778-9.798	
TOL. "D"	40°	38-41°	40°	TOL. "C"	.188	.178-.198	

JEMISON
METALS

HILL PHOENIX

TITLE

MATERIAL 20 GA GALVANIZED

DATE 1/9/19

PART NO. P839374GGL

REV 1 OF 1

DESIGNED 0

COST REV 2

PRESS BRAKE FORM

Job Number: 21451	Operator Name: Gm
Part number: 838374	Date: 09-1-21

Check all formed deminsions on 1st pc, at 20 pc intervals and on last pc of the job.

Frequency	Pass/Fail
1st pc	✓ P
20th	✓ P
40th	✓ P
60th	
80th	
100th	
120th	
140th	
160th	
180th	
200th	
220th	
240th	
260th	
280th	
300th	
320th	
340th	
360th	
380th	
400th	
420th	
440th	
460th	
480th	
500th	

19Aug21 07:20

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

SM2 9406

Jemison Metals - Sumter 2
 2630 US Highway 15
 Sumter SC 29154
 Tel: 803-469-3901 Fax: 803-469-3927

Job Type SHR Process PWC LL2
 Metric N Cust
 Desc P-1 CLARK 438584150001
 Due Date 08Sep21 Whs FFG
 Setup 00:00 Run 05:30 Prtd By lunsfor

<<< JOB SPECIFICATIONS >>>

Group GVS Grade CB90CD Gauge 0.0700 (0.0700 to 0.0700) ID 0.0000

<<< ORDER SPECIFICATIONS >>>

F 01 GVS/15/CB90CD/13.2730"X107.25/.0700N CS-B *90 CT DRY
 Part 3488/438584150001 Ga 0.0700 Wth 13.2730 Lth107.2504

TOLERANCES - same as previous Order Item

PACKAGING INSTRUCTIONS
 JD6 14"X122"

<<< PROCESSING INSTRUCTIONS >>>

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<GVS/15/CB90CD>								
10840	FOL	0.0700N	54.0000	122.0000	36	4514	NUB1109394	
Total:					36	4514		

<<< MATERIAL TO STOCK >>>

Cons	Tg	Spc	Prod	Tg	Whs	Ty	Gauge	Width	Length	OD	PCS<Prn>Wt	PCS<Res>Wt
10840												
1		22977			FOL	F	0.0700	13.2730	107.2504		48	1356
1		22978			FOL	F	0.0700	13.2730	107.2504		48	1356
1		22979			FOL	F	0.0700	13.2730	107.2504		48	1356
Total:											144	4,068

<<< JOB RECAP >>>

	PCS	Weight	Scrap	Scrap %	Unactd	Scr %
Material Allocated	36	4,514				
Master Returns						
Returns to Stock						
Work in Process						
Material to be Shipped	144	4,068				
Rejects						
Net Weight to be Produced	144	4,068			446	9.88

19Aug21 07:20

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

SM2 9406

Jemison Metals - Sumter 2
2630 US Highway 15
Sumter SC 29154

Job Type SHR Process PWC LL2
Metric N Cust
Desc P-1 CLARK 438584150001
Due Date 08Sep21 Whs FFG
Setup 00:00 Run 05:30 Prtd By lunsfor

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<GVS/15/CB90CD>								
10840	FOL	0.0700N	54.0000	122.0000	36	4514	NUB1109394	
Total:					36	4514		

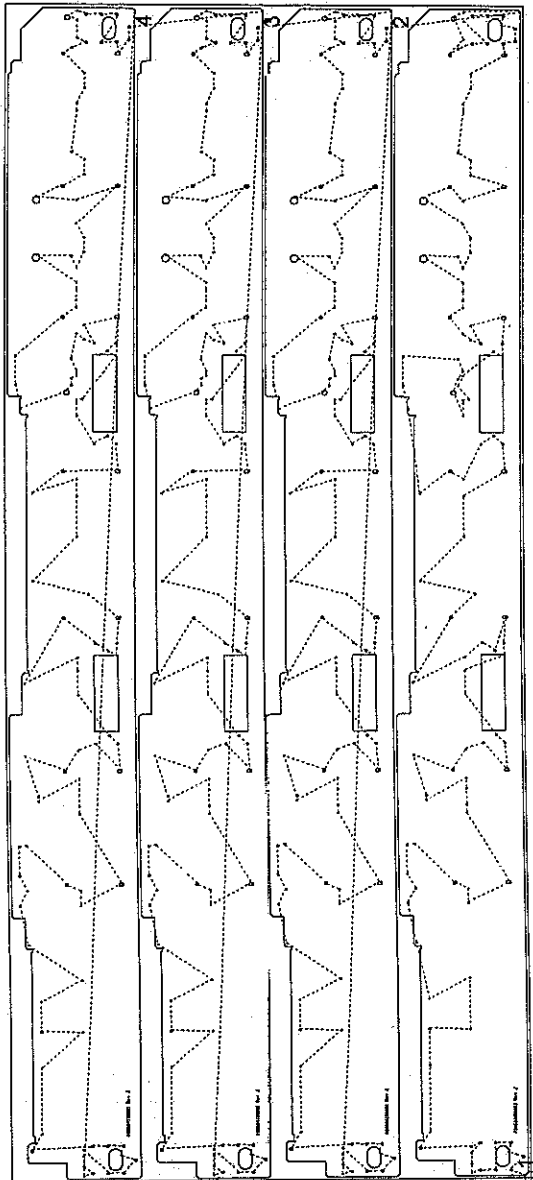
4B PC LIFTS

3 - 14x12

Layout Detail

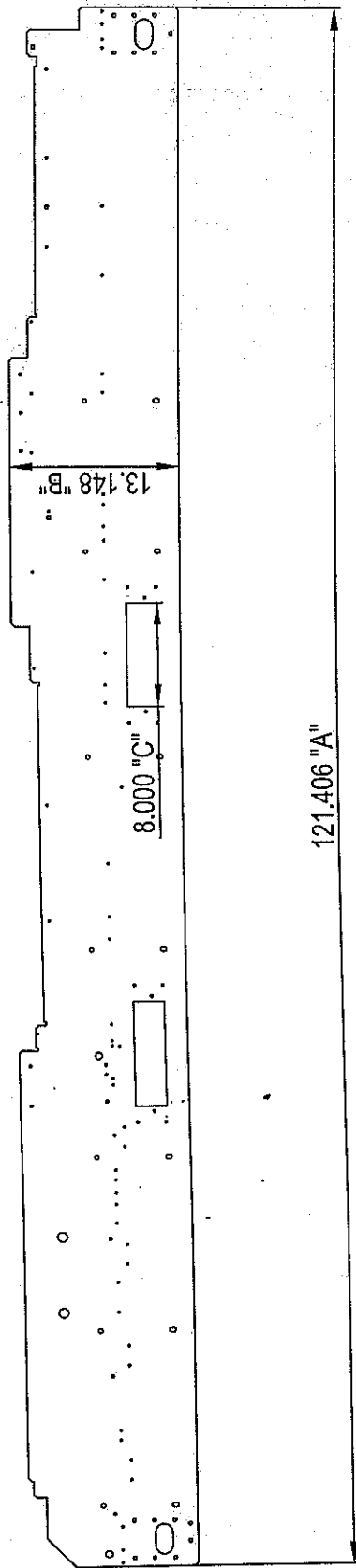
Machine TRUMPF_TruLaser_3040_S

Task Name: 438584150001 Program Name: 28424			
Number of Sheets with Same Layout		36	13.998
Stack Quantity		1	3.082
		Qty Required	144
		Qty Nested	4
		Layout 1 of 1	



Material	MS	Sheet Length	122.000"	Sheet X Used	121.656"	Heat Number	Mill
Thickness	0.078	Sheet Width	54.000"	Sheet Y Used	53.742"	Sheet Location	Prime Code
Sheet Name		Cutting Time	00:07:02	Cutting Length	1682.827"	Bin Number	Parameters NITROGEN
Part ID	Part Name	Qty Req	Qty Nested	Net Weight	Drawing Number	Revision Number	Work Order Number
1	43858415000	144	144	31.33lb			
							Cutting Time
							00:07:02
							INGERSOLL

JEMISON REVISION		CUSTOMER REVISION	
REV	DESCRIPTION	DATE	REV
			G



CLARKSVILLE

JEMISON METALS

CUSTOMER: INGERSOLL RAND

FILE: BLANK

MATERIAL: 15GA ZINC COATED CS GALV G30

BY CC DATE: 12/19/19 SET: 1 OF 1

PART NO: 438584150001 JEMISON REV: 0 CUST REV: G

CUT/BURNT FIRST ARTICLES				TOLERANCES UNLESS OTHERWISE SPECIFIED	
	NOMINAL	TOLERANCE	ACTUAL	LINEAR DECIMAL = +/- .030	ANGULAR = +/- .5°
MTL THICKNESS	.070	.067-.073	.070		
TOL "A"	121.406	121.376-121.436	121.4		
TOL "B"	13.148	13.118-13.178	13.4		
TOL "C"	8.000	7.970-8.030	8.0		
				WEIGHT:	

PRESS BRAKE FORM

Job Number: 5m2 9406	Operator Name: WB
Part number:	Date: 09-01-21

Check all formed deminsions on 1st pc, at 20 pc intervals and on last pc of the job.

Frequency	Pass/Fail
1st pc	✓
20th	
40th	
60th	
80th	
100th	
120th	
140th	
160th	
180th	
200th	
220th	
240th	
260th	
280th	
300th	
320th	
340th	
360th	
380th	
400th	
420th	
440th	
460th	
480th	
500th	

29Jul21 08:16

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

LYN 21543

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

Job Type SHR Process PWC LL1
 Metric N Cust
 Desc P-1 H-P P113387F
 Due Date 20Aug21 Whs LFG
 Setup 00:00 Run 03:30 Prtd By lunsfor

<<< JOB SPECIFICATIONS >>>

Group GVS Grade CB40CD Gauge 0.0340 (0.0340 to 0.0340) ID 0.0000

<<< ORDER SPECIFICATIONS >>>

F 01 GVS/22B/CB40CD/30.7184"X107.28/.0358N CS-B ^40 CT DRY
 Part 3453/P113387F Ga 0.0358 Wth 30.7184 Lth107.2848
 Ga Rng 0.0320to 0.0360 Pc/Tag 26
 WthTol + 0.0100 - 0.0100 Wt/Skd 870
 LthTol + 0.0100 - 0.0100 Ty JD7 Pk

 WGT PER PIECE - 33.46

<<< PROCESSING INSTRUCTIONS >>>

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<GVS/22B/CB40CD>								
142432	LPW	0.0358N	63.0000	130.0000	39	2910	NUB1108458	
Total:					39	2910		

<<< MATERIAL TO STOCK >>>

Cons	Tg	SpC	Prod	Tg	Whs	Ty	Gauge	Width	Length	OD	PCS<Prn>Wt	PCS<Res>Wt
142432												
1		49041		LFG	F		0.0358	30.7184	107.2848		26	870
1		49042		LFG	F		0.0358	30.7184	107.2848		26	870
1		49043		LFG	F		0.0358	30.7184	107.2848		26	870
Total:											78	2,610

<<< JOB RECAP >>>

	PCS	Weight	Scrap	Scrap %	Unactd	Scr %
Material Allocated	39	2,910				
Master Returns						
Returns to Stock						
Work in Process						
Material to be Shipped	78	2,610				
Rejects						
Net Weight to be Produced	78	2,610			300	10.31

29Jul21 08:16

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

LYN 21543

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

Job Type SHR Process PWC LL1
Metric N Cust
Desc P-1 H-P P113387F
Due Date 20Aug21 Whs LFG
Setup 00:00 Run 03:30 Prtd By lunsfor

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<GVS/22B/CB40CD>								
142432	LPW	0.0358N	63.0C00	130.0000	39	2910	NUB1108458	
Total:					39	2910		

1-0

26 PC LIFTS

3 SKIDS 32x130

12/18/2019 8:24:05 AM

Task Name: T22307 Program Name: 18767

Program Name: 18767

Number of Sheets with Same Layout

39

True Scrap

11.889

Qty Required

78

Layout 1 of 1

Stack Quantity

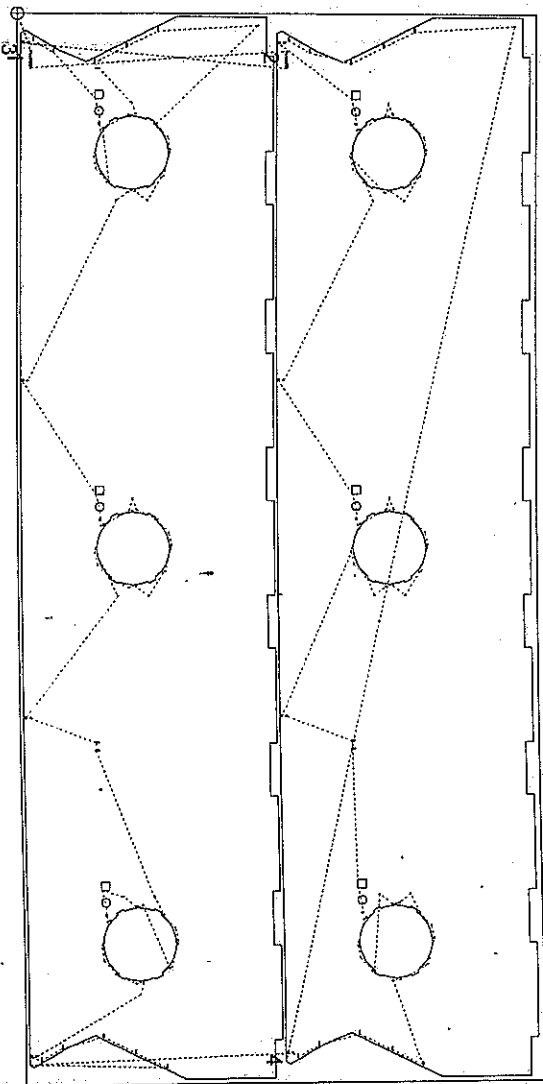
—

Rect Scrap

3.231

City Nested

2



Material	MS	Sheet Length	130.000"	Sheet X Used	129.400"	Heat Number	Mill
Thickness	0.039	Sheet Width	63.000"	Sheet Y Used	62.243"	Sheet Location	Prime Code
Sheet Name		Cutting Time	00:03.34	Cutting Length	988.551"	Bin Number	Parameters NITROGEN
Part ID	Part Name	Qty Req	Qty Nested	Net Weight	Drawing Number	Revision Number	Work Order Number
						Customer	Cutting Time

1 P113387F

78

78

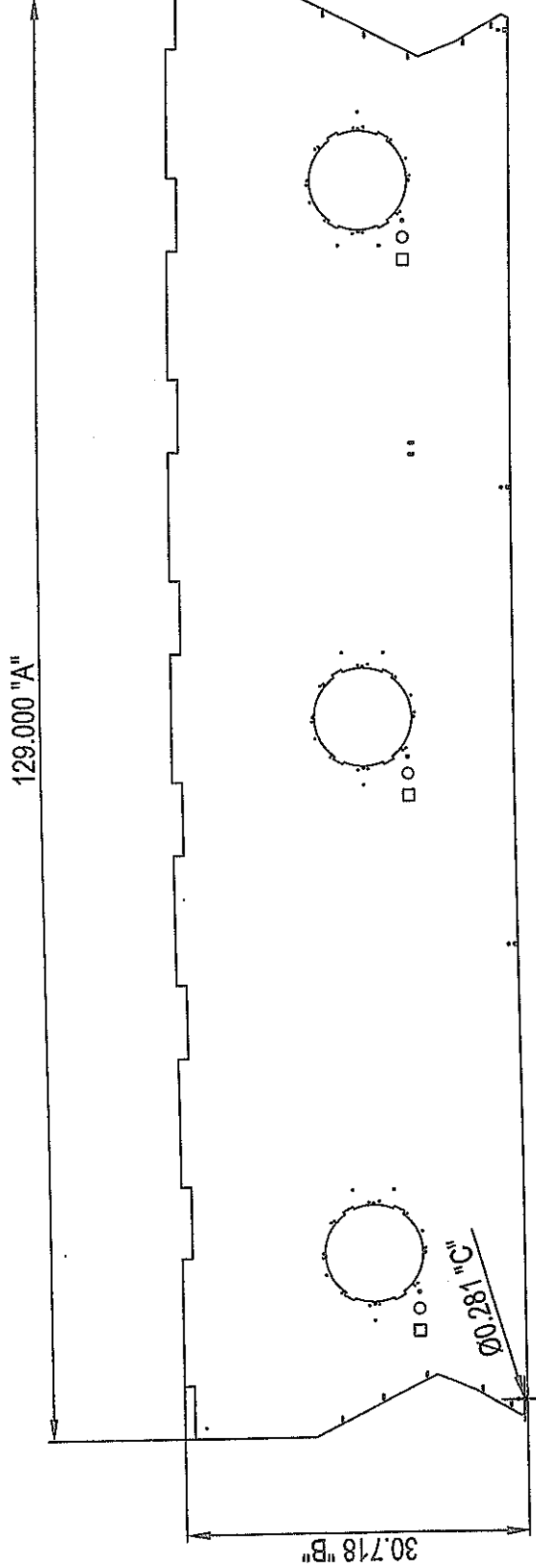
39.911b

H.P.

00:03:34

129

JEMISON REVISION		CUSTOMER REVISION	
REV.	DESCRIPTION	REV.	DESCRIPTION



JEMISON METALS		CUSTOMER HILL PHOENIX	
TOLERANCES UNLESS OTHERWISE SPECIFIED		TIME	
LINEAR		HARDEN 20GA GALV	
DIA IN THE FLAT $\pm .010$		BY CC DATE 6/14/18 SHI 1 OF 1	
DIA IN THE FORN $\pm .030$		PART NO. P857371MGL JEMISON REV. 0	
HOLE DIA. $\pm .01$		POST REV.	
ANGLES $\pm 1^\circ$			
WEIGHT:			
CUT/BURNT FIRST ARTICLES			
NOMINAL	TOLERANCE	ACTUAL	
MTL THICKNESS .034	.032-.036	.0325"	
TOL "A" 129.000	128.98-129.01	129"	
TOL "B" 30.718	30.708-30.728	30.575	
TOL "C" .281	.271-.291	.291"	

P113307F

PRESS BRAKE FORM

Job Number: 21543	Operator Name: NO/MA
Part number: P113387F	Date: 9-1-21

Check all formed deminsions on 1st pc, at 20 pc intervals and on last pc of the job.

Frequency	Pass/Fail
1st pc	PASS
20th	PASS
40th	PASS
60th	
80th	
100th	
120th	
140th	
160th	
180th	
200th	
220th	
240th	
260th	
280th	
300th	
320th	
340th	
360th	
380th	
400th	
420th	
440th	
460th	
480th	
500th	

LOST

Bill L. Huffman

Subject:

Monthly PM/ Inspection Schedule

Start:

Mon 8/16/2021 12:00 AM

End:

Tue 8/17/2021 12:00 AM

Show Time As:

Free

Recurrence:

(none)

Organizer:

Bill L. Huffman

<u>Date</u>	<u>Complete</u>	<u>Description</u>
8/23/21	JR	1. LRB- Print complete and turn in Monthly PM schedule
8/23/21	JR	2. LCT- Print complete and turn in Monthly PM schedule
8/23/21	JR	3. Laser 1- Print complete and turn in Monthly PM schedule
8/23/21	JR	4. Laser 2- Print complete and turn in Monthly PM schedule
8/23/21	JR	5. Press 1- Print complete and turn in Monthly PM schedule
8/23/21	JR	6. Press 2- Print complete and turn in Monthly PM schedule
8/23/21	JR	7. Lyn Shear Print complete and turn in Monthly PM schedule
NA	NA	8. Laser Punch Combo Under Development Weekly Clean Lube
8/23/21	JR	9. Pallet Inverter- Print complete and turn in Monthly PM schedule
8/23/21	JR	10. Coil Tipper- Print complete and turn in Monthly PM schedule
NA	NA	11. Out Sourced Annual Inspection (October/ November)
8/23/21	WH	12. Warehouse and Fire Extinguisher Monthly Inspections- Print complete and turn in

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 feel 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: Aug 1902/
 Performed By: SDN
 Approved By: WA

BILL OF LADING

No: SM2 1984

Ship From: Jamison Metals - Sumter 2
2630 US Highway 15
Sumter SC 29154
Tel: 803-469-3901 Fax: 803-469-3927

Ship Date 01Sep21 at 8:29 From FFD
Probill
Via CP
FOB Shipping Point
Frt Customer Pick U
Route 0- 0 Manifest
Vhcle Trailer
Slp Dean Burley
Sold To: (3489)
Trane Technologies Company LLC
2701 WILMA RUDOLPH BLVD
Clarksville TN 37040-5846

Ship To: (1)
Trane Technologies
2701 Wilma Rudolph Boulevard
Clarksville TN 37040-5846
Tel: Fax:

BILL OF LADING

1) Our Order SM2- 4602- 1 Your PO # 30125180-1105
Part # 438584150001 Rel #
V2 BASE CELL GV DSB 90 CT
SHEET; SPECIALTY PUNCHED BLANK

Heat Number	Tag No	Quantity	PCS	Wt LBS
1106875	22502		48	1356
1106875	22503		47	1328
1106875	22504		48	1356
1109394	22929		48	1356
1109394	22930		48	1356
1109394	22931		48	1356
1109865	22956		47	1328
1109865	22957		48	1356
1109865	22958		47	1328
1109865	22963		48	1356
1109865	22964		48	1356
1109865	22965		48	1356
Totals:			372	16180

2) Our Order SM2- 4604- 1 Your PO # 30125180-1106
Part # 438584150001 Rel #
A 603 GALVANIZED SHEET CS-B *90 CT DRY
.0358" Nom X 51.3442" X 84.9696"
60 PCS PER SKID
OVERALL HEIGHT NOT TO EXCEED 13"
SKIDS SHOULD BE 1" LESS THAN PART WIDTH & LENGTH
TO ALLOW MATERIAL TO OVERHANG.

PARTS MUST BE NEATLY STACKED FOR AUTO LOADER

Page: 1 ... Continued

The property described above, 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 meaning any person or corporation in possession under the contract) agrees to carry to its usual place of delivery at said destination, if on its route, otherwise to deliver to another carrier on the route to said destination. It is mutually agreed as to each carrier of any said property over or any portion of said route to destination, and as each party at any time interested in all or any of said property, that every service to be performed hereunder shall be subject to all the terms and conditions of the Uniform Domestic Straight Bill of Lading set forth (1) in Official, Southern, Western, and Illinois Freight Classifications in effect on the date hereof if this is a rail or a rail-water shipment, or (2) in the applicable motor carrier classification or tariff if this is a carrier shipment. The shipper hereby certifies that he is familiar with all terms and conditions of the said bill of lading including those on the back thereof, set forth in the classification of tariff which governs the transportation of this shipment, and the said terms and conditions are here agreed to by the shipper and accepted for himself and his assignees.

Subject to Section 7 of conditions of applicable bill of lading, if this shipment is to be delivered to the consignee without recourse on the consignor, the consignor shall sign the following statement: The carrier shall not make delivery of this shipment without payment of freight and all other lawful charges.		CARRIER Mercoer	FREIGHT Prepaid <input type="checkbox"/> Collect <input type="checkbox"/>
SIGNATURE OF CONSIGNOR X		AGENT PER (Driver's Signature) X IND 3011211	DATE
To apply in payment of the charges on the property described hereon.		AGENT OR CASHIER	CHARGES ADVANCE
If charges are to be prepaid write or stamp here, "To Be Prepaid."		\$	
RECEIVED		The signature here acknowledges only the amount prepaid.)	

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

No: SM2 1984

Ship From: Jamison Metals - Sumter SC
2630 US Highway 15
Sumter SC 29154
Tel: 803-469-3901 Fax: 803-469-3927

Ship Date 01Sep21 at 8:29 From FFG
Probili
Via CP
FDB Shipping Point
Frt Customer Pick U
Route 0- 0 Manifest
Vhcle Trailer
Slp Dean Burley
Sold To: (3488)
Trane Technologies Company LLC

Ship To: (1)
Trane Technologies

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

Heat Number	Tag No	Quantity	PCS	Wt LBS
1106096	22694		59	2591
1106098	23158		60	2635
Total:			119	5226

3) Our Order SM2- 4651- 2 Your PO # 30125180-1118

Part # X05401115010 Rel #
36-22 BV CSB 90 CT

SHEET: SPECIALTY: PUNCHED BLANK .122T

Heat Number	Tag No	Quantity	PCS	Wt LBS
2108123	22129		72	1078

4) Our Order SM2- 4614- 1 Your PO # 30125180-1113

Part # 439532090200 Rel #
3F-52T BV CSB 90 CT

SHEET: SPECIALTY: PUNCHED BLANK .062T

Heat Number	Tag No	Quantity	PCS	Wt LBS
1108532	22241		60	2357

5) Our Order SM2- 4649- 2 Your PO # 30125180-1117

Part # X05400854010 Rel #
574 01 BV CSB 90 CT

SHEET: SPECIALTY: 15.511 X 61.875

Heat Number	Tag No	Quantity	PCS	Wt LBS
1107920	22294		144	1391

6) Our Order SM2- 4649- 2 Your PO # 30125180-1117

Part # X05400852010 Rel #
352 01 BV CSB 90 CT

SHEET: SPECIALTY: 24.953 X 63.350

Heat Number	Tag No	Quantity	PCS	Wt LBS
1106098	22514		98	2006
1106098	22515		98	2006
Total:			196	4012

Page: 2Continued

The property described above, 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 meaning any person or corporation in possession under the contract) agrees to carry to its usual place of delivery at said destination, if on its route, otherwise to deliver to another carrier on the route to said destination. It is mutually agreed as to each carrier of all any said property over or any portion of said route to destination, and as each party at any time interested in all or any of said property, that every service to be performed hereunder shall be subject to all the terms and conditions of the Uniform Domestic Straight Freight Tariff (1 in Official, Southern, Western, and Illinois Freight Classifications in effect on the date hereof if this is a rail or a rail-water shipment, or (2) in the applicable motor carrier classification or tariff if this is a carrier shipment). The shipper hereby certifies that he is familiar with all terms and conditions of the said bill of lading including those on the back thereof, set forth in the classification of tariff which governs the transportation of this shipment, and the said terms and conditions are hereby agreed to by the shipper and accepted for himself and his assignees.

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

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

SIGNATURE OF CONSIGNOR

X

DATE

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

RECEIVED

\$

To apply in payment of the charges or the property described hereon.

CARRIER

Mercer

AGENT PER (Driver's Signature)

X Ind 301/211

AGENT OR CASHIER

(The signature here acknowledges only the amount prepaid.)

FREIGHT

Prepaid ☐

Collect ☐

DATE

CHARGES ADVANCED

\$

BILL OF LADING

No: SM2 1984

Ship From:

Ship Date 01Sep21 at 8:29 From FFD

Jamison Metals - Sumter 2

Probill

2630 US Highway 15

Via CP

Sumter SC 29154

FDB Shipping Point

Tel: 803-469-3901 Fax: 803-469-3927

Frt Customer Pick U

Route 0- 0 Manifest

Vhcle Trailer

Slp Dean Burley

Ship To: (1)

Sold To: (3488)

Trane Technologies

Trane Technologies Company LLC

BILL OF LADING

	Tags	PCS	LBS
TOTAL:	19	1164	30252

Page: 1 of 1 Last

The property described above, 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 meaning any person or corporation in possession under the contract) agrees to carry to its usual place of delivery at said destination, if on its route, otherwise to deliver to another carrier on the route to said destination. It is mutually agreed as to each carrier of any said property over or any portion of said route to destination, and as each party at any time interested in all or any of said property, that every service to be performed hereunder shall be subject to all the terms and conditions of the Uniform Domestic Straight Bill of Lading set forth (1) in Official, Southern, Western, and Illinois Freight Classifications in effect on the date hereof if this is a rail or a rail-water shipment, or (2) in the applicable motor carrier classification or tariff if this is a carrier shipment. The shipper hereby certifies that he is familiar with all terms and conditions of the said bill of lading including those on the back thereof, set forth in the classification of tariff which governs the transportation of this shipment, and the said terms and conditions are hereby agreed to by the shipper and accepted for himself and his assignees.

Subject to Section 7 of conditions of applicable bill of lading, if this shipment is to be delivered to the consignee without recourse on the consignor, the consignor shall sign the following statement: The carrier shall not make delivery of this shipment without payment of freight and all other lawful charges.		CARRIER <i>Mercer</i>	FREIGHT Prepaid <input type="checkbox"/> Collect <input type="checkbox"/>
SIGNATURE OF CONSIGNOR X		AGENT PER (Driver's Signature) <i>X Ind</i>	DATE <i>3011211</i>
If charges are to be prepaid write or stamp here, "To be Prepaid."	RECEIVED \$	AGENT OR CASHIER (The signature here acknowledges only the amount prepaid.)	CHARGES ADVANCED \$

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

Sold To: (3453)
Hill Phoenix FAB
1925 Ruffin Mill ROad
Colonial Heights VA 23834

Ship To: (1)
Hill Phoenix FAB
1925 Ruffin Mill ROad
Colonial Heights VA 23834

Trm NET 120 DAYS
Frt Included in Price

Ord 27Aug21 Due 01Sep21 08/30/21
Via ALL METALS TRAN FOB DESTINATION
PO/Rel 407082/261229-MSK
Tel 804-451-2467 Fax 804-526-9805

Slp Dean Burley

S A L E S A C K N O W L E D G M E N T SO No LYN PI-26788
Test Certs: Chem Y Phys Y 0 Compliance copies with shipment, 1 with Invoice

1 A 653 GALVANNEALED SHEET CS-B ^40 CT DRY	75 PCS	1,316 LBS
.0298 Nom X 48.0140" X 52.3580"		
Part No P113361M		
MSK		
MATERIAL	75 PCS @ 28.0900 PCS	2,106.75

2 A 653 GALVANIZED SHEET CS-B ^40 CT DRY	75 PCS	899 LBS
.0248 Nom X 30.5240" X 64.0630"		
Part No P113392E		
MSK		
MATERIAL	75 PCS @ 21.0500 PCS	1,578.75

3 A 653 GALVANIZED SHEET CS-B ^40 CT DRY	75 PCS	1,712 LBS
.0298 Nom X 48.0000" X 65.4040"		
Part No P113399A		
MATERIAL	75 PCS @ 37.0500 PCS	2,778.75

Order Totals: 3 Items 3,927 LBS

Material	Processing	Freight	Other	Taxes	ORDER AMT
6,464.25					6,464.25

Requisition	Date	WH	Dept	Planner	Part	Drawing No	Quantity	Required	P.O. Nbr
261229	8/27/2021	2	MSK	MARY PARZIALE	P113361M	P113361M	75	8/30/2021	407082
261229	8/27/2021	2	MSK	MARY PARZIALE	P113365B	P113365B	150	8/30/2021	407082
261229	8/27/2021	2	MSK	MARY PARZIALE	P113386H	P113386H	52	8/30/2021	407082
261229	8/27/2021	2	MSK	MARY PARZIALE	P113389B	P113389B	26	8/30/2021	407082
261229	8/27/2021	2	MSK	MARY PARZIALE	P113392E	P113392E	75	8/30/2021	407082
261229	8/27/2021	2	MSK	MARY PARZIALE	P113399A	P113399A	75	8/30/2021	407082

LYN - 26788 Planned

LYN - 26786 5/14/21

STRAIGHT BILL OF LADING - SHORT FORM

ORIGINAL - NOT NEGOTIABLE

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

FROM: NUCOR STEEL BERKELEY

TELEPHONE: 843/336-6000

AT: 1455 Hagan Avenue
Huger, SC 29450
DELIVER TO: Paulette BeckhamDATE: 8/13/21
EMAILCOPY

BILL OF LADING NO.

1575482

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 lawful charges.

W.A.K.

(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 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 RICHMOND MARINE TERMINAL
86 5000 DEEPWATER TERMINAL RD
TO: RICHMOND, VA 23234
TRUCK DELY TO JEMISON DEMSEY METALS
188 ENTERPRISE DRIVE
ROUTE MADISON HEIGHTS, VA 24572

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

CARRIER

CSXT

CAR OR Load 1768453 Ticket...: 2921617
VEHICLE NO. CSXT498455 Contract:
Trailer Number Gross Wt: 202,600.00

COIL NBR	PO# /HEAT-SEQ#	PRODUCT (inches)	CALC	LF	ORDER/LINE	WEIGHT											
* 643025.100	SM2-365	.0540 MIN X 60.0000 MIN	1988	516427-1		22,460.00											
		ASTM A653 / CS TYPE B / 20			Due 8/07/21												
G90	1113024-6	GALVANIZED			Dry/CHM												
643025.200	SM2-365	.0540 MIN X 60.0000 MIN	1983	516427-1		22,400.00											
		ASTM A653 / CS TYPE B / 20			Due 8/07/21												
G90	1113024-6	GALVANIZED			Dry/CHM												
643039.100	LYN-4752	.0342 MIN X 60.0000 MIN	3147	517569-1		22,700.00											
		ASTM A653 / CS TYPE B / 20			Due 8/21/21												
G90	2113025-4	GALVANIZED			Dry/CHM												
643039.200	LYN-4752	.0342 MIN X 60.0000 MIN	3143	517569-1		22,640.00											
		ASTM A653 / CS TYPE B / 20			Due 8/21/21												
G90	2113025-4	GALVANIZED			Dry/CHM												
643094.200	LYN-4754	.0282 MIN X 60.0000 MIN	3719	517594-1		22,260.00											
		ASTM A653 / CS TYPE B / 20			Due 8/21/21												
G90	1113031-6	GALVANIZED			Dry/CHM												
* 643204.100	LYN-4754	.0282 MIN X 60.0000 MIN	3752	517594-1		22,500.00											
		ASTM A653 / CS TYPE B / 20			Due 8/21/21												
G90	2113032-1	GALVANIZED			Dry/CHM												
Total Pounds						134,960.00											
Melted and Manufactured In the USA.																	
(in percent)																	
Heat	C	Mn	P	S	Si	Cu	Ni	Cr	Mo	Sn	Al	V	Nb	N	Ti	B	Ca
1113024	.03	.21	.008	.003	.02	.09	.03	.03	.01	.007	.031	.002	.000	.006	.001	.002	.002
1113031	.02	.20	.007	.003	.02	.09	.03	.03	.01	.006	.030	.002	.000	.005	.001	.002	.002
2113025	.04	.21	.010	.003	.02	.09	.04	.04	.01	.005	.030	.002	.000	.005	.001	.002	.002
2113032	.03	.21	.008	.003	.02	.09	.04	.03	.01	.005	.030	.002	.000	.005	.001	.002	.002
Coil information matches bill of lading							YES/NO										
Bill of lading matches PO							YES/NO										
Packaging and coil dry and in good shape							YES/NO										
Actual weight within 1% of declared weight							YES/NO										
The agreed-on declared value of the property is correct, and the 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							YES/NO										
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							YES/NO										
Explanation of any no answers							YES/NO										

NUCOR STEEL BERKELEY
1455 Hagan Avenue
Huger, South Carolina 29450

Permanent post office address of shipper

SIGNATURE ON FILE
SHIPPER'S SIGNATURE: Whitney Ackerman Kuritz

CARRIER'S SIGNATURE: *[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 using same.)

[Signature]

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

RC 9657 Act Dt 01Sep21 Description Probill Number
By lyn1 Ent Dt 01Sep21 coil 1575482

Item	Type	Order Number	Vendor/Customer	Shp Fr	Bill of Lading	U/M
1	P	LYN 4754-001	35 NUCOR BERKELEY		1575482	LBS
					PCS	Quantity
					Coil Lgth	3,907 FT
					1	22,500 LBS
					Pack	22,500 LBS
					Theo	22,500 LBS

GVC/23A/C90CDX Other Tag Ref: 643204.100
A 653 GALVANIZED COIL CS-B G90 CT DRY, XS
.0282 Min X 60.0000"
Tag NB14175 LPW Loc NUB 2113032

NORDFAB LLC

Item	1 Totals	Weight	Packing Slip	22,500 LBS
PCS		22,500 LBS	Theoretical	22,500 LBS
1				

Receiver	9657	Total Equivalent Weight	22,500 LBS
		Total Coil Length	3,907 FT



Corrective Action Report

Case#	20799	Date Created	5/26/2021
Branch	LYN	Created By	Patrick Macias
Assigned Responsibility	Operations	Customer	HILL PHOENIX LY
Internal/External	Internal		

Has finished goods inventory been checked for the same issue? N/A

Problem Description:
(Who, What, Where, When)
SHIPPED WRONG TAG # - CORRECT MATERIAL JUST WRONG TAG

Root Cause Of Issue:
(Why)
Root Cause: Tag 1222887 was the reserved tag. Tag 1222877 was the shipped tag
Escape Point: Performed tag scan, but scanned shipped tag (Tag 1222877)

Interim Responsible	Frank Simms/Bill Huffman	Implementation Date:	5/26/2021
Plan:	1. Talked to shipping department, and with Bill Huffman, about the issue. 2. Reviewed/verified tags on all shipments, while creating a plan to eradicate issue.		

Permanent Responsible	Bill Huffman/Frank Simms	Implementation Date:	6/2/2021
Plan:	1. Shipping department will no longer remove stock tags, to replace them with shipping tags 2. Both tags will remain on each skid and coil throughout the pulling/staging process to ensure numbers are not mixed up 3. When tag scan is performed the stock tags will be removed and scanned to ensure that the correct tag/skid is being shipped.		

Material Disposition

Audit Date 1	6/4/2021	Outcome 1	Pass
Audit Date 2	6/9/2021	Outcome 1	Pass
Audit Date 3	6/18/2021	Outcome 1	Pass

Follow Up:

Elevate to risks and opportunities document: No
 Change required to QMS (Forms/Procedures etc): No
 6/4/2021 Hill Phoenix B/L 22063 reviewed. Nathan Ragland - Quality Technician
 6/9/2021 Nordfab B/L 22096 reviewed. Nathan Ragland - Quality Technician
 6/18/2021 Hill Phoenix B/L 22203 reviewed. Nathan Ragland - Quality Technician
 8/12/2021 Hill Phoenix Fab B/L 22783 reviewed. Nathan Ragland - Quality Technician

Complete

Yes **Closed**

Yes

JDM 200 10-09-13 Revision 2

Continue

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

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

(Attendees):

Print Name	Initial	Print Name	Initial
Brian Burke	BB		
Ethan Howes	EH		
Frank Simms	FS		

All Attendees have successfully completed OJT for:

Location: LYN

Training Start Date: 06/02/2021 Completion Date: 06/18/2021

Description: CORRECTIVE ACTION CASE 20799 NEW SHIPPING PROCEDURES

Department: SHIPPING

Subject: CORRECTIVE ACTION

Signature of Trainer: ATG 06/18/2021

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



Corrective Action Report

Case#	21243	Date Created	6/29/2021
Branch	LYN	Created By	Patrick Macias
Assigned Responsibility	Operations	Customer	HILL PHOENIX
Internal/External	External		
Has finished goods inventory been checked for the same issue?			Yes

Problem Description:
(Who, What, Where, When)

Parts identified in house at customer to have a slot made vertically and should be horizontally. Hill Phoenix requested Corrective Action. Reference: Hill Phoenix SCAR Jemison P115673G (submitted to Hill Phoenix 6/23/2021)

Root Cause Of Issue:
(Why)

Root Cause: Obround tool misoriented for this part in turret punch due to previous part program requirement. Escape Point: Instructional prompt on machine to rotate tooling was not recognized and overridden by operator

Interim Responsible

Tim Guthrie

Implementation Date:

6/22/2021

Plan:

Operator training: Review recognition of prompts supplied by program in turret for required tooling adjustments for each part, and the actions necessary to complete them.

Permanent Responsible

Tim Guthrie/Bill Huffman/Nathan Ragland

Implementation Date:

6/24/2021

Plan:

Added notes on future jobs for tooling adjustment confirmation to be signed off by Quality Personnel or Plant Manager.
A First Part Inspection will be performed using our Fabrivation Laser measuring system to confirm proper orientation of slot on all future jobs.

Material Disposition

Audit Date 1	8/4/2021	Outcome 1	Pass
Audit Date 2	8/13/2021	Outcome 1	Pass
Audit Date 3	-----	Outcome 1	-----

Follow Up:

Elevate to risks and opportunities document: No
Change required to QMS (Forms/Procedures etc): Yes. Part spec changes to remark.
8/4/2021 HPX Fab PN 21407 reviewed. Nathan Ragland - Quality Technician
8/13/2021 HPX Fab PN 21082 reviewed. Nathan Ragland - Quality Technician

Complete

Yes Closed

No

JDM 200 10-09-13 Revision 2

Continue

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

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

(Attendees):

Print Name	Initial	Print Name	Initial
Tim Gauthier	TO		
Theresa Chambers	TC		
Michael Brown	MB		

All Attendees have successfully completed OJT for:

Location: LYN

Training Start Date: 06/30/2021 Completion Date: 07/08/2021

Description: CORRECTIVE ACTION 21243 - OPERATOR TRAINING

Department: FABRICATION

Subject: CORRECTIVE ACTION 21243

Signature of Trainer: MTG

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

Training Status Matrix

Employee	Trumpf Fiber Operator	Trumpf Helper	LRB Operator	LCT Operator	LRB/LCT Helper Package	Material Handler	Receiving	Shipping	Logistics Planner	Press Brake Operator	Press Brake Helper	Laser Punch Combo	Production Planner	Skid Builder	Quality Tech	Maintenance Tech	Inside Sales
Amere Pannel	3	3	X	X	X	2	1	2	X	X	1	3	X	2	X	X	X
Tim Guthrie	2	3	X	X	1	1	X	X	X	X	X	2	X	2	X	X	X
Nathan Ragland	3	3	X	X	X	3	X	2	X	X	X	3	X	2	1	X	X
Eric Hayes	3	3	X	X	X	2	X	X	X	X	X	X	X	2	X	X	X
Roderick Johnson	X	X	X	X	2	2	1	X	X	3	3	X	X	2	X	X	X
Gerardo Martinez	X	X	X	X	X	X	X	X	X	2	2	X	X	X	X	X	X
Tyrese Chambers	2	2	X	X	X	2	X	X	X	X	X	1	X	X	X	X	X
Mikchael Brown	2	2	X	X	X	2	X	X	X	X	X	1	X	X	X	X	X
Frank Simms	X	X	X	X	2	3	2	3	X	X	X	X	X	2	X	X	X
Clyde Ferguson	X	X	X	X	2	2	X	1	X	X	X	X	X	2	X	X	X
Vinnielou Lipscomb	X	X	2	2	2	2	2	2	X	X	X	X	X	2	X	X	X
Lacey Rush	X	X	3	3	3	3	2	2	X	X	X	X	X	2	X	2	X
Nick Torrents	X	X	3	3	3	3	2	2	X	X	X	X	X	2	X	2	X
Stanley Gallier	X	X	X	X	2	2	3	2	X	X	X	X	X	2	X	X	X
Herman Fontenot	X	X	1	X	2	2	X	1	X	X	X	X	X	3	X	X	X
Justin Riley	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	2	X
Brian Burke	X	X	X	X	X	2	X	2	X	X	X	X	X	X	X	X	X
Hernry Russel	X	X	X	X	2	2	X	X	X	X	X	X	X	X	X	X	X
William Bersh	2	2	X	X	X	1	X	X	X	X	X	X	X	X	X	X	X
Alonzo Clark (T)	X	X	X	X	X	1	X	X	X	1	1	X	X	X	X	X	X
Noel Depalma (T)	2	2	X	X	X	1	X	X	X	X	X	X	X	X	X	X	X
Judah Thomas (T)	2	2	X	X	X	1	X	X	X	X	X	X	X	X	X	X	X
Brandon Helton (T)	X	X	X	X	X	1	X	X	X	X	X	X	X	X	X	X	X
Terrace Payne (T)	X	X	X	X	X	1	X	X	X	X	X	X	X	2	X	X	X
(T)	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X
(T)	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X
(T)	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X
(T)	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X
Adam Lunsford	X	X	X	X	2	3	2	X	3	X	X	X	3	2	X	X	X
Bill Huffman	2	X	X	X	2	3	3	3	2	2	2	X	2	2	X	2	X
DeeDee Harris	X	X	X	X	X	X	3	X	3	X	X	X	X	X	X	X	X
Dean Burley	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	2
Paula Loveless	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	3
Employee	Trumpf Fiber Operator	Trumpf Helper	LRB Operator	LCT Operator	LRB/LCT Helper Package	Material Handler	Receiving	Shipping	Logistics Planner	Press Brake Operator	Press Brake Helper	Laser Punch Combo	Production Planner	Skid Builder	Quality Tech	Maintenance Tech	Inside Sales

8/31/2021

1 = In Training

2 = Competent & Fully Trained

3 = Trainer

