

AK TUBE – WALBRIDGE ONLY EXTERNAL (SUPPLIER) RAW MATERIAL SPEC REQUIREMENTS	PAGE 1 OF 8	REVISION DATE 4/16/10	NUMBER RM-005
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1.0 PURPOSE

- 1.1. The purpose of this specification is to define the requirements for the purchase and/or processing of Raw Material for AK Tube LLC

2.0 SCOPE

- 2.1. This specification applies to the purchase and/or processing of Raw Material for AK Tube LLC

3.0 SLIT COIL REQUIREMENTS

- 3.1. Coils must be slit to the ordered width with a tolerance of $\pm .010$ " max.
- 3.2. Maximum burr of .005" allowed on edges.
- 3.3. No rolled edges, scratches or loose-wrapped coils.
- 3.4. Steel gauge check must be taken at a minimum frequency of three times per coil (head, middle, & tail), **OR** steel gauge check with gamma chart throughout coil. Gauge must fall within the specified gauge range.
 - 3.4.1. The high and low readings obtained must be recorded on the coil tag.
- 3.5. Coil Dimensions:
 - 3.5.1. ID of 20" min and 22" max
 - 3.5.2. OD of 72" maximum.
 - 3.5.3. Minimum of 500 PIW.
 - 3.5.4. Maximum 1000 PIW

4.0 MATERIAL DEFECTS FOR SLIT COIL

- 4.1. If defects are found in the material during processing, the following actions should be taken:
 - If the defect is a gauge or chemistry problem, slitting should be halted and the AK Tube Purchasing department notified before continuing to process the material. At that time, AK Tube will authorize either rejection or completion of processing.
 - If the defect is visual in nature, including but not limited to rust, stain, lamination, cross breaks or severe edge wave, slitting should be halted and the AK Tube Purchasing Department must be notified before continuing to process the material. At that time, AK Tube will authorize either rejection or completion of processing.
- 4.2. Any authorization to continue processing with reported defects must be communicated with a deviation form (form # 7.1.4-PC-01-F) completed by AK Tube. A copy of this form must accompany the slit coil when shipped to AK Tube.

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5.0 MATERIAL QUALITY FOR SLIT COIL

- 5.1. Material must be free of rust, pits, stains, flaking, lamination or other injurious defects.
- 5.2. Material must be free of coil breaks, stretcher strains, and fluting.
- Unless other wise stated in this specification or the AK Tube purchase order, all material must meet the quality chemical, mechanical, and dimensional tolerances per the latest applicable revision of the appropriate ASTM specification:
 - ASTM A568 steel, sheet, carbon, and high-strength, low-alloy, hot-rolled, and cold rolled.
 - ASTM A463 steel, sheet, aluminum-coated, by the hot-dip process.
 - ASTM A653 steel, sheet, zinc-coated (Galvanized) or zinc-iron alloy-coated (Galvannealed) by the hot-dip process.
- 5.3. Welded Coils
- 5.3.1. Any coils Butt Welded to create a larger OD, must first be approved by AK Tube LLC.
- 5.3.2. Must be a true weld. No Taping or other forms of attachment will be accepted.
- 5.3.3. If approved, butt weld MUST be clearly marked on the side wall of the coil to show the location of the weld.
- 5.3.4. A tag stating “WELDED COIL” must also be attached to the coil tag if this is a welded coil.
- 5.3.5. Face of the strip must be spray painted on the top and bottom two (2) feet on each side of the weld, so that is is visible when it is paying off. Must use Yellow paint for marking of end welds.

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6.0 BANDING AND TAGGING OF SLIT COIL

- 6.1. All coils must be packaged with a minimum of:
- 6.1.1. Three (3) ¾” side bands spaced evenly around the coil in such a manner that they will not damage the slit edge, or allow the coil to telescope. These bands cannot be used to hold wood blocking or spacers. They are only to be used to secure the coil laps.
 - 6.1.2. One (1) Bellyband around the circumference of the coil.
 - 6.1.3. Material .050” gauge or lighter must have:
 - 6.1.3.1. Corrugated plastic donuts, protecting the sidewall of the coil, under the ¾” sidebands.
 - 6.1.3.2. Protectors around the banding seal to prevent the seal from damaging the material
 - 6.1.3.3. Corner protectors over the edge to prevent banding from damaging outer laps of coil.
 - 6.1.4. No VCI coated OR wax paper is to be applied to the sidewall of the coils.
 - 6.1.4.1. If AK Tube requires **VCI treated paper** to prevent rust/condensation on the coil, it must be applied UNDER the ¾” sidewall banding. Treated side of the paper towards the sidewall of the coil.
- 6.2. Banding used must be steel. No tape or poly banding is permitted.
- 6.3. Do not mix heats on a lift of coils.
- 6.4. Each coil must be tagged with, at a minimum, the following information:
- Description of material
 - Material width and gauge
 - Actual material gauge readings
 - Material heat number
 - Purchase order number
 - Master coil number
 - Coil Weight

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7.0 LOADING OF SLIT COIL

- 7.1. Maximum weight of an individual coil or coils combined to make a lift cannot exceed 18,000 lbs
- 7.2. Stand Up Coils
 - 7.2.1. ONLY coils 12” and wider **may** be shipped standing up.
 - 7.2.2. If stand up coils are combined to ship as a lift”
 - 7.2.2.1. 4” spacers must be used to separate the coils. The 4x4s **MUST** be banded to one of the coils to prevent falling while being lifted.
 - 7.2.2.2. The total width of the coils placed together (Sidewall to Sidewall) cannot exceed 62”
 - 7.2.2.3. The Outside diameter of coils bundled as as a lift cannot vary by more than 2” . The center “eye” must be aligned to allow for level lifting with crane or forklift.
 - 7.2.3. The maximum weight for coils shipped standing up is 50,000 lbs per lift with a maximum individual coil weight of 18,000 lbs.
- 7.3. Lay Down Coils –
 - 7.3.1. Coils less than 12” wide **must** be shipped lying down.
 - 7.3.2. Coils shipped lying down must be loaded for side unload and have a minimum of 4” clearance between bottom of coil and truck bed.
 - 7.3.3. No skids may be used. Loose 4 x 4 spacers must be used.
 - 7.3.4. Multiple coils may be stacked onto a lift with a minimum of 4” spacers between coils a maximum lift weight of 18,000 lbs.
- 7.4. All wood spacers and blocks must be covered with a moisture barrier that will protect the coil edges from rust.
- 7.5. All 4 x 4 blocking must be at least 2 ½ feet apart to allow entry of forks.
- 7.6. Coils must be protected from damage during transit.
- 7.7. Tarps and chain protectors must be used.

8.0 WIDE BAND COIL CRITERIA

- 8.1. ID=20” Minimum to 24” Maximum
- 8.2. OD=72” Maximum and 36” Minimum
- 8.3. Width=62” Maximum Width & 20” Minimum
- 8.4. A minimum of 500 PIW is required.
- 8.5. A maximum coil weight cannot exceed – 44,000 lbs.

Procedures are Electronically Controlled unless a paper copy is stamped CONTROLLED in Red.
 INFORMATION IN THIS DOCUMENT IS THE CONFIDENTIAL PROPERTY OF AK TUBE AND IS NOT TO BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO OUR INTEREST.

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9.0 WIDE BAND COIL LOADING

- 9.1. Coils must be loaded for crane unload.
- 9.2. Coils must be protected from damage in transit.
- 9.3. Tarps and chain protectors must be used.

10.0 WIDE BAND COIL PACKAGING

- 10.1. All coils must be packaged to ensure safe transportation and handling in a manner that will not damage the coil.
- 10.2. Each coil must be tagged with, as a minimum, the following information:
 - Description of material
 - Material width and gauge
 - Material heat number
 - Purchase order number
 - Master coil number
 - Coil weight

11.0 MATERIAL QUALITY FOR WIDE BAND COIL

- 11.1. Material must be free of rust, pits, stains, flaking, lamination or other injurious defects.
- 11.2. Material must be free of coil breaks, stretcher strains, and fluting.
 - Unless other wise stated in this specification or the AK Tube purchase order, all material must meet the quality chemical, physical and dimensional tolerances per the latest applicable revision of the appropriate ASTM specification:
 - ASTM A568 steel, sheet, carbon, and high-strength, low-alloy, hot-rolled, and cold rolled.
 - ASTM A463 steel, sheet, aluminum-coated, by the hot-dip process.
 - ASTM A653 steel, sheet, zinc-coated (Galvanized) or zinc-iron alloy-coated (Galvannealed) by the hot-dip process.

12.0 SHIPPING DOCUMENTS

- 12.1. The following documents must accompany all shipments:
 - A packaging slip that contains the AK TUBE purchase order number
 - Description of the material (type, gauge and width)
 - List of each coil or lift with the corresponding weight and heat number of each.
 - The number of coils in each lift must be noted.
 - The raw material heat number for each coil, chemistry and physicals (if required), and country of origin. This information may be included on the packing slip or on a separate certification document.
 - If the material was processed with a deviation from AK Tube, the deviation form must accompany the shipment.

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13.0 DEVIATIONS FOR WIDE BAND MATERIAL

- 13.1. Any deviation to these specifications must be communicated to the AK Tube purchasing department. If approved by AK Tube, a signed completed deviation form will be forwarded to your facility. This form must accompany all shipments of material covered by the deviation. AK owned coils do not require a deviation form.
- 13.2. Any authorization to ship nonconforming material must be communicated with a deviation form (form # 7.1.4-PC-01-F) completed by AK Tube. A copy of this form must accompany the material when shipped to AK Tube.

14.0 ON TIME DELIVERY REQUIREMENTS SLIT AND WIDE BAND

- 14.1. AK Tube requires 100% on time delivery.
- 14.2. Criteria for On time delivery are as follows:
 - 14.2.1. Order quantity +/- 10%
 - 14.2.2. Delivery Received two (2) working days prior to due date through due date of purchase order.
- 14.3. With approval of AK Tube, this requirement may be waived through the deviation process.
- 14.4. On time delivery performance will be monitored on a monthly basis and reported to the supplier monthly.

15.0 QUALITY PERFORMANCE

- 15.1. Quality performance for nonconforming raw material will be monitored on a monthly basis and reported to the supplier monthly.
- 15.2. Cumulative quality performance goals are .5% rejection rate maximum for a calendar year.
- 15.3. Rejection rates in excess of 2% in any month may result in a request for written corrective action depending upon the severity and impact.
- 15.4. Any rejection may result in a request for written corrective action based upon the severity and impact.

16.0 MATERIAL CERTIFICATION

- 16.1. All material certifications must be traceable to the producing mill and certified by an A2LA certified laboratory.
- 16.2. If not originally provided with shipment, upon request by AK Tube, the producing mill or A2LA laboratory certification must be provided within 48 hours of such request.

17.0 FAILURE TO COMPLY

- 17.1. Failure to comply with any of these specifications may result in a rejection and claim or refusal to unload material. Non-compliance with this specification, depending upon the severity, may result in

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a request for written corrective action. Material that is refused at AK Tube receiving for noncompliance will be returned to the supplier facility.

18.0 REFERENCE:

DEVIATION FORM - 7.1.4-PC-01-F

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REV #	REVISION DATE	REVISION SUMMARY	AFFECTED PAGES
0	1/15/10	New Raw Material Spec created out of the consolidation of RM-001, 002, 003 and RM-004 per Tom Greco	All
1	1/18/10	Added 8.1 & 8.2 ID/OD Min/Max	3
2	2/5/10	7.2.2.2 change 40” to 62” – width of coils side by side cannot exceed per Tom Greco	3
3	3/2/10	Added: No VCI coated OR wax paper is to be applied to the sidewall of the coils. If AK Tube requires VCI treated paper to prevent rust/condensation on the coil, it must be applied UNDER the ¾” sidewall banding. Treated side of the paper towards the sidewall of the coil. Per Tom Greco	3
4	3/16/10	Added “Walbridge Only” to the heading to ensure this does not cause confusion for Columbus customers: per John Osadchuk	All
5	4/16/10	Under Section 10.2 – removed “ <i>Actual material gauge readings</i> ” per Ken Howe	5

APPROVALS

Signature	Title	Date
	Site Manager	
	VP Purchasing/Procurement	
	Production Manager	