

JGM CONTRACT FABRICATION REQUIREMENTS

Purpose: This document outlines the technical and logistical requirements necessary for JGM to execute the scope of work as a fabricator. Acceptance of these requirements is a condition of the bid to ensure accurate scheduling, fabrication, and quality control.

1. DETAILING REQUIREMENTS

A. If Detailing is Provided by Customer

To ensure seamless integration with JGM's fabrication software (Tekla PowerFab), the following are required from customer's detailer:

1. General Protocols

- **Drawing Schedule:** Provided within 1 week of PO
- **Advance Bill of Materials (ABM), including any secondary AMB schedule:**
Required for all main members per schedule.
 - Include with ABM the Sequencing Plan
 - Sent as .IFC file
- **Part Numbering:**
 - **Preliminary Marks:** Must be maintained throughout the lifecycle of the project.
 - **Obsolete Parts:** Must be deleted, not merely hidden.
 - **No Recycling:** Part numbers must **never** be recycled or re-used for different geometries.
- **Communication:**
 - **RFI Log:** Provide direct access to the RFI log.
 - **Drawing Log:** Provide direct access to the drawing log.
 - **Change Requests:** All inquiries or change requests will follow JGM's standard RFA (Request for Approval) format.
 - **Customer Detailing Standard** To be provided to JGM
- **RFA Response Time:** Response to RFAs within **2 days**.

2. Issued for Approval (IFA)

- **Deliverables:** Fabrication and Erection drawings, as .pfx file
- **IFC Model:** Provide access to the IFC model.
 - Weekly model updates
- **JGM IFA Review**
 - Scope in compliance with purchase order
 - Weld callouts and symbols
 - Weight and Piece counts
 - Hardware (Point-to-point list if available; Bolt list)
- **JGM Comments**
 - JGM will submit marked-up drawings and comments to the Customer

3. Issued for Fabrication (IFF)

- **File Formats Required:**
 - **Data Exchange:** .pfx (Tekla PowerFab) or compatible contents (XML with project details and folders with relevant drawing files, NC1, IFC).
 - **CNC Files:** .nc1 (Strictly Required) and .dxf (for 2D plate work).
 - Layout lines included
 - **Model:** Link to existing **Trimble Connect** project
 - .ifc file on the Trimble Connect project must be updated with every release for fabrication.
- **Lists:**
 - Shop Bolt and Hardware List.
 - Customer-supplied Material Cut Lists with every IFF release

B. If Detailer is Hired by JGM

- **Documentation:** Customer to provide all Contract Documents and Specifications (specifically connection type preferences). In pdf format.
- **Drawing Log:** Direct access to the drawing log.
- **Standards:** Detailing according to JGM Detailing Standards.
- **RFA Response Time:** 2 business days
- **Drawing approval timeline:** 10 business days



2. MATERIAL REQUIREMENTS

1. Documentation

Advance Notification Prior to Scheduling Deliveries:

- If coming from Customer: Email excel export of all materials to be shipped
- If coming from mill or broker: any purchase orders and/or material lists (pricing excluded)
- Cut Lists
- Information on incoming material must include
 - Shape, Dimensions, Length, Grade, Quantity, Heat numbers (with accompanying Material Test Reports)

All deliveries are required to have an appointment scheduled with JGM purchasing.

- Email purchasing@jgmusa.com or call 484-888-4591 to make request.
- Receiving hours are 7:00 am to 2:00 pm Monday to Friday.
- A Bill of Lading (BOL) in PDF format must be emailed to purchasing@jgmusa.com **24 hours prior** to scheduled delivery including heat information and material test reports

2. Material Handling Considerations

Loading considerations for safe and prompt unloading.

- 10,000 lb. maximum pick weight
- Blocking between layers
- Materials may not be interlocked unless in a banded bundle
- Beams must be loaded in the H position

3. Arrival of Delivery

Drivers may arrive prior to their scheduled appointment at the correct JGM location time but no more than 1 hour. Hard copy of BOL must be present.

- JGM Coatesville: 1201 Valley Road, Coatesville, PA 19320
- JGM Sinking Spring: 601 Fritztown Rd, Sinking Spring, PA 19608
- JGM does not offer overnight parking.
- Drivers delivering to Coatesville will call the gate number upon arrival at their scheduled time. Gate Number is 484-698-6497.
- Drivers must have PPE on at all times (Steel-toed boots, hardhat, high-visibility vest).
- JGM's yard manager will direct drivers where to park for unloading.

4. Processed Parts and Hardware supplied by Customer



- Provided as an Excel list in advance of delivery
- Note if processed parts are fully processed or only partial
- Parts due 2 week (14 days) prior to start of fabrication
- List by, in order:
 - Sequence
 - Main Member
 - Piece mark
 - Quantity
- Palletize by sequence, shrink-wrapped with parts list inside
- Same delivery protocols for above

5. Specialty Materials

CVN / FCM: For raw materials requiring Charpy V-Notch (CVN) or Fracture Critical Member (FCM) designation, **certificates are required per individual stick or sheet of plate.**

6. Surface Preparation and Coatings

- Customer supplies paint
 - Paint must arrive one week prior to start of fabrication
 - Provide Safety Data Sheets (SDS) with paint
- Customer to provide any specialty tags for Galvanizing prior to the start of fabrication.

3. QUALITY CONTROL

- **Hold Points:**
 - Customer to submit any hold points beyond specifications one week after award of PO.
- **Third-Party Inspections:**
 - Any third-party inspections required by the project specifications must be coordinated by the Customer (unless the third-party agency is directly hired/owned by JGM).