BRS Quality Control Program

The arrival of the IAS472 Accreditation program for manufacturers has placed heavy emphasis on Quality Control protocols and programs for metal building systems. BRS developed Quality Control evaluations at the request of numerous license holders pursuing IAS472 accreditation and others wanting to improve their internal Quality Control programs. An intensive Quality Control Program for our roof panels was developed for licensees that want to utilize the fee-based evaluation for their IAS472 accreditation procedures and/or those license holders which simply sought to hold themselves to higher QC panel production standards. The focus of this ongoing licensee QC program is to assure participants they are producing the finest run panel profile their rolling mill can manufacture and assist in monitoring excessive tooling wear. This inexpensive Quality Control Program is very comprehensive and rigorous by design. However, the tiered investigative levels of review by BRS allows licensee flexibility in selecting their degree of diagnostic measures tailored to their specific program needs.

A participating licensee is required to provide BRS some specific information when enrolling in the fee-based Quality Control Program. First, the participant will be obligated to provide BRS their tooling documentation from their roll forming manufacturer including pass settings, over-bend locations , etc. (Please contact your roll form manufacturer to ensure the latest correct drawings and information is being submitted.) Second, all pertinent contact information for the designated QC leadership personnel including their name(s), main phone numbers, email address, and mailing address. Finally, the frequency desired for the Quality Control evaluation(s) selecting whether monthly, quarterly , bi-annual, or annually. In conjunction with this information, BRS recommends the licensee to have their profile specific panel check gauge stationed at the panel line manufacturing location for an internal quick pre-production set up quality control compliance verification.

BRS Sample Travel cases provide hassle free way to send quality 3’-0” panel and coil strip width samples for the highest quality check reviews.

1. Provides exceptional protection and easy shipping of required 3’-0” panel and flat coil width production samples.
2. Assures the Quality Control sample parts are received as produced without transit damage.
3. Shipped to licensee via UPS along with return tag for easy shipping and program participation.
4. Welded aluminum hard case design features heavy duty handles, dual locks, and internal foam for receipt of high-quality samples.
5. Round trip shipping costs via UPS included in Quality Control Program fee.
6. Case and internal foam design allows dual license holders to send both panel profiles and coil samples within one case- saving costs.

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BRS Offers the Highest Level of Quality Control Measurement Taking:

Optical Comparator: This is the most accurate measurement method option. A test specimen sample must be carefully cut and prepared from the received donor panel to be placed in the optical comparator before so evaluation investigation can be conducted.

BRS accepts two (2) different sample panel lengths for Quality Control Checks. ***(Note: Each submission must include a 1'-0" blank coil sample utilized to manufacture the test panel.)***

1.) 3'-0" +/- panel sample cut from the center of a 10'-0" donor panel - BRS sample travel case provided – must contact BRS

2.) 10'-0" Full panel sample with end notching and punching (if production mill is equipped for panel end punching)

BRS Quality Control Program will evaluate* many or all the following:

1. Male side panel profile to include element lengths, angles, and radii.
2. Female side panel profile to include element lengths, angles, and radii.
3. Notches (proper size and location)
4. Factory punched hole locations at each end (this addresses tracking issues).
5. Rib Sealant location and volume
6. Rib Sealant start/stop verification
7. Panel Coverage
8. Excessive tooling wear when detectible

**Evaluated areas will depend on panel sample received.*

Price Summary:

Test Method	Items Evaluated (see first page)	Cost**
Optical comparator with 3'-0 panel sample	Items 1, 2, 5***, 7, 8	$1,025.00
Optical comparator with 10'-0 panel sample	Items 1, 2, 3, 4 ,5***, 6***, 7, 8	$1,250.00
In-facility inspection with hand instruments followed by BRS full lab comparator evaluation	Items 1, 2, 3, 4 ,5***, 6***, 7, 8	$1.200.00 per day + travel expenses + $825.00

** *Cost is per panel sample*
*** *If sealant is included*

BRS Quality Control Program

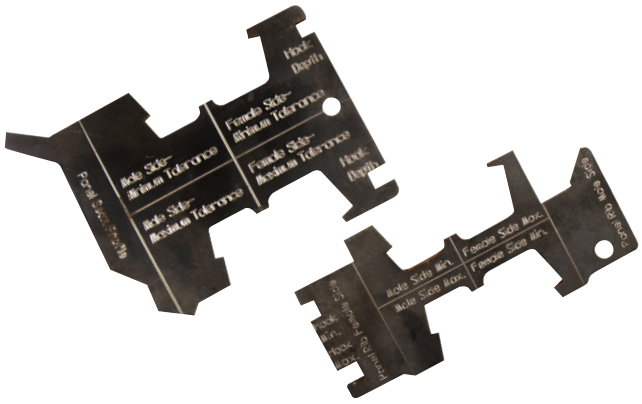
The Quality Control Program Provides the following:

- Detailed Comprehensive Report including:
  - Data of report, including the date of sample panel arrival
  - Data sheet with seam critical male and female element lengths, angles, and radii
  - Panel sample arrival photographs - ONLY REQUIRED IF ARRIVES DAMAGED IN TRANSIT
  - Panel sample photographs with QC panel check gauge on sample received
  - Panel sample photographs of profile evaluation
  - Any general notes/observations of the sample received during evaluation
- Friendly reminder of next upcoming QC check based on established licensee schedule
- Second follow up report following line modifications to address any out of specification issues *(second corrected panel sample must be received by BRS within 15 business days after first report submission)*

BRS Quality Control Program excludes the following:

- Panel Finish issues
- Oil Canning
- Ski, Dive, Twist, etc.
- Crating & Packaging
- Seamer Management & Adjustments

If the licensee has misplaced or lost their panel specific profile check gauge, BRS has these instruments available for purchase. These standard “go or no go” devices are available with dual surface engraved tolerance texts for easy reading. Third party individually numbered certified IAS472 gauges are available for an added upcharge along with increased lead time due to the required independent certification process. These dual etched surface gauges are $ 385.00 each. The third-party certification process adds 4-6 weeks for availability and costs an additional $225.00 per piece. BRS will include instructions for proper gauge use and a panel check gauge drawing when purchased. However, the use instructions and panel check gauge drawing should be included within your company’s Quality Control manual as reference for in facility inspections.



BRS has developed a panel check gauge for both the TS-324 & PanelCraft 216/218 panel rolling mill line profiles. The gauge was developed for use on the panel lines to perform a quick check of the seam sensitive elements. The gauge is placed on various parts of the panel profile to assure tolerance, element lengths, radii, and angles. The panel check gauge is a useful tool inhouse Quality Control Program and to assure the highest quality finish panels are being manufactured for supply.