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Surveillance Audit No: 7

ISO 9001:2015

CONFIDENTIAL

Report
For

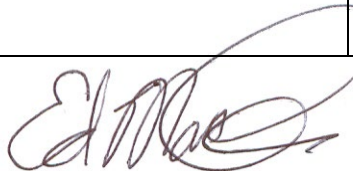
JEMISON METALS

**Madison Heights, Virginia, Vestavia Hills and Trinity,
Alabama**

Date of Report:	February 26, 2026
Date(s) of Audit:	January 29 - 30, 2026
Number of total mandays scheduled for this audit:	1.5
Number of total mandays actually conducted:	1.5
Audit Team Members (Lead name first):	John Griffin
Nonconformances (CAN numbers) issued this audit:	None
Nonconformances (CAN numbers) closed this audit:	None

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Associate V.P. Certification:



Edward L. Maschmeier

Date: February 26, 2026

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Executive Summary

An audit was conducted at the location(s) on the date(s) cited above. The purpose of this audit was to ensure that the auditee was continuing to maintain a documented and effective Quality Management System, to meet the organization's objectives, in conformance with the Quality Management System requirements. A draft audit report, consisting of the audit team recommendation (R20.36) and related corrective action notifications (R20.35), was provided to the organization by the Lead Auditor prior to the closing meeting.

The audit followed PRI's guidelines and procedures. The scope of the audit was a review of the scheduled processes and any area(s) of nonconformance cited and/or remaining open from the previous audit.

Timing requirements for responding to Corrective Action Notifications are listed on the second page of the R20.35 form, which is part of the draft audit report.

The recommendation in the draft audit report is any one of the following:

Unconditional: No nonconformances were issued. The registered organization was able to demonstrate the capability to implement and maintain an effective Management System, to meet the organization's objectives and intended results, in conformance with the Management System requirements.

Conditional: One or more minor nonconformances were issued. The registered organization was able to demonstrate the capability to implement and maintain an effective Management System, to meet the organization's objectives and intended results, in conformance with the Management System requirements, except where described in the Corrective Action Notification(s).

Terminated: The audit was stopped before a recommendation could be established.

Failed (IATF audits only): The certificate will be withdrawn.

Registration Withheld or Status Notice (Suspension): One or more major nonconformances were issued. The organization was unable to demonstrate the capability to implement and maintain an effective Management System, to meet the organization's objectives and intended results, in conformance with the Management System requirements. For uncertified organizations, no action to issue the initial certificate will occur until the major nonconformity (s) are closed. For certified organizations, PRI will determine if the certificate can be maintained or whether a suspension status or withdrawal of the certificate is warranted. A separate communication will identify the final decision and communicate how the closure of the nonconformity (s) will be handled.

General observations made by the audit team:

- Progress made toward meeting Continual Improvement targets is satisfactory.
- Audit results observed were better than the previous audit activity.
- Marks and logos were found to be in conformance.
- The certificate scope was found to be appropriate.
- The audit objectives have been fulfilled.
- There were no deviations from the audit plan.
- There were no issues affecting the audit program.
- There were no unresolved issues at the end of the audit.

The audit evidence collected during an audit will inevitably be only a sample of the information available, partly due to the fact that the audit is conducted during a limited period of time and with limited resources. Therefore, there is an element of uncertainty inherent in all audits, and all users of the results of the audit should be aware of this uncertainty.

The audit team would like to thank all personnel for their hospitality and cooperation during the audit.

Auditor Commentary

Based on the audit investigations, interviews, observations, and review of records, the following comments summarize the audit team's observations and findings:

<p>Internal Audit Results:</p>	<p>The Internal Audit activities were reviewed for the audit and were found to follow an established and documented process. (QMP-9.2) The Internal Audit process was managed through the corporate support process, with a schedule to conduct process related audits on a monthly basis and 1 Quality Management System (QMS) system audit per year which was conducted on 11-31-25 (VA) and 10-23-25 (AL).</p> <p>This audit showed one minor NC and 6 OFIs (VA) and 0 NCs (AL). Corporate/Quality management personnel managed the audit process conducted the audits. These personnel were trained and competent to conduct QMS audits. Records of the most recent QMS system Internal Audits at the three locations were reviewed for the audit.</p> <p>The Lynchburg, Virginia location record showed that the audit conducted on 10-9-24 had one NC written. This NC was entered into the CAPA (CASE) software system (CASE# 26384). The Sumter SC location audit conducted on 10-23,24-24 showed 0 NCs and 2 OFIs were written in this audit. The Vestavia Hills, Alabama site was audited on 11-3-24. There were no NCs found in this audit and 1 OFI.</p> <p>The Trinity, Alabama site Internal Audits were reviewed. Records appeared to show that audits are planned and conducted in an organized planned manner. The process was found to be implemented and effective.</p>
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<p>Management Review Results:</p>	<p>The company's Management Review related activities were reviewed for the audit and were found to follow an established and document process. (MOP-1) The company's Management Review activities for all sites are conducted per the process on an annual basis. The last Corp. QMS review was conducted on 1-26-2026. Records showed that all key members of leadership were in attendance for the review and were involved in the activities of the review. The power point records of the review and the meeting summary were examined and were found to follow the ISO 9001 section 9.3 inputs and outputs agenda.</p> <p>The review also included data of the VA and AL sites QMS KPIs and goals for 2025. These included; VA-Ext/DPPMs Flat Goal-<3500, actual-3438, Ext/DPPMs Fab.-goal-<2000 actual-496, Int DPPMs-Fab goal-<10,000O, actual-5718, Flat goal-<3500, actual-3617, Customer Complaints goal-?, actual 74, OTD-Flat-goal->98%, actual-89.9%, Fab.-goal->89%, actual 77.3%, AL-DPPMs-goal<3500, actual 1785, On time delivery-goal->98%, actual-92%, Devaluations-goal-<.20%, actual-.28%.</p>
<p>Corrective/Preventive Actions:</p>	<p>The company's corrective action-related activities were reviewed for the audit and were found to follow an established and document process. (QMP-10.2) The company's CAPA activities for 2025 were reviewed for the audit. In the VA site, there were 3 actions related to customer complaints addressed through the formal CAPA system in 2025. These issues were sampled for the audit.</p> <p>(CAR#s 40524, 40589, 405691) In the Corporate audit, there was one customer related NC that was reviewed.</p> <p>(Nordfab/PO2892) The Trinity, Alabama site had two customer related issues in 2025. Customer complaints are managed in the company's BEST intranet software system. This system manages the RMA, credits and corrective action investigations records for each incident, except when customers require the use of their records.</p> <p>These records indicated that an 8D type problem solving process was employed to determine root causes. Interviews with key employees (VP QA) showed that these processes were implemented as described and were effective.</p>

Customer Complaints:	The company's Customer satisfaction and complaints activities were reviewed for the audit and were found to follow an established and documented process. (QMP 10.2) The company manages customer satisfaction by monitoring customer complaints and examining customer supplied scorecards. The company currently does not conduct customer surveys. Customer complaint records were reviewed for the audit. CASE records showed that there three customer related issues recorded in 2025 for Lynchburg, Virginia, and one for the Corporate site, and Trinity, Alabama site. The CASE records showed that various forms of corrective actions are taken and these actions are decided at weekly Quality meetings. Several records were examined to verify this process was implemented and effective. (VA-CASE# 40524, 405589, 405691)
Quality System Changes:	There are none.
Areas Identified as Not Applicable:	All Three Sites: 8.3 Design and development of products and services Justification: Make to specification or print only.
Regulatory / Statutory requirements identified or added since the last event:	Identified statutory or regulatory requirements (i.e., those recorded on the R20.62) were reviewed and no issues were identified. REACH, RoHS, DOT, Conflict Minerals, NAFTA
Auditor Comments (Important Observations, Strengths, Exclusions):	<p>The Jemison Metals company, headquartered in Vestavia Hills, Alabama is a company consisting of six manufacturing locations that process hot and cold rolled steel using various processes including slitting, cut to length, blanking, bending, laser cutting, and assembly for a variety of customers in a variety of industries.</p> <p>This particular audit focuses on two manufacturing locations: Lynchburg, Virginia, and Trinity, Alabama and the Support functions of the corporate headquarters in Vestavia, Alabama. in the areas of leadership, Quality Engineering, Sales and Purchasing.</p> <p>The company is in expansion mode with a recent acquisition in the steel processing industry. The company's current risk issues include the management of the company's transition to a new IT / ERP system, and a balancing of production capability.</p>

Validation of CANs issued during previous activity:	There are none.
Review of Outsourced Processes:	There are none.
Shifts:	No changes in shifts or times were observed.
Notable changes (e.g., address, management rep., shifts, scope, processes, employee count, etc.):	There are none.

R20.62 Auditee Information

Auditee: Jemison Metals

Auditee No: 6796-06

Address: 188 Enterprise Drive
Madison Heights, VA 24572
Main Phone Number: 434-929-6802
Web Site: <http://jemisonmetals.com>

Auditee Contacts

Mr. Rick Rowland, SR VP Quality & Engineering, Metallurgical Engineer
Jemison Metals
1000 Urban Center Dr. , Ste 650, Vestavia Hills, AL 35242
Tel: 205-986-6627
Email: rrowland@jemisonmetals.com

Audit Event

Surveillance: 01/29/2026 - 01/30/2026

Total Mandays: 1.5

John Griffin, Lead Auditor

PRI Audit Support Specialist: Kelly Surgalski

Specialist Phone: 1-724-778-9044

Specialist Email: ksurgalski@sriregistrar.com

Audit Scope

Standard: ISO 9001:2015 (non-design)

Areas Identified As Not Applicable: 8.3 Design and development of products and services
Justification: Make to specification or print only

Scope: Processing and distribution of ferrous and non-ferrous sheet and coil products,
including laser cutting, forming, kitting, cut-to-length, punching and blanking operations.

SIC Codes: 5051

IAF: 29

NACE Codes: G51.5

No. of Employees: 43

Products: Steel

Regulatory/Statutory Requirements: REACH, RoHS, DOT, Conflict Minerals, NAFTA

Accreditation Mark(s): ANAB

Registration Approach: Sampling

Certificate Expiration: 03/10/2028

No Shifts: 2

Times of Shifts: 6:00am-4:30pm, 2:00pm-10:30pm

R20.62 Auditee Information

Auditee: Jemison Metals

Auditee No: 6796-01

Address: 1000 Urban Center Dr.
Ste 650
Vestavia Hills, AL 35242
Main Phone Number: 205-986-6627
Web Site: <http://jemisonmetals.com>

Auditee Contacts

Mr. Rick Rowland, SR VP Quality & Engineering, Metallurgical Engineer
Jemison Metals
1000 Urban Center Dr. , Ste 650, Vestavia Hills, AL 35242
Tel: 205-986-6627
Email: rrowland@jemisonmetals.com

Audit Event

Surveillance: 02/03/2026 - 02/04/2026
John Griffin, Lead Auditor

Total Mandays: 1.5

PRI Audit Support Specialist: Kelly Surgalski
Specialist Phone: 1-724-778-9044
Specialist Email: ksurgalski@sriregistrar.com

Audit Scope

Standard: ISO 9001:2015 (non-design)

Areas Identified As Not Applicable: 8.3 Design and development of products and services
Justification: Make to specification or print only

Scope: Processing and distribution of ferrous and non-ferrous sheet and coil products, including plasma and laser cutting, forming, machining, kitting, slitting, cut-to-length, stretch leveling, blanking and shearing operations.

SIC Codes: 5051

IAF: 29

NACE Codes: G51.5

No. of Employees: 45

Products: Steel

Regulatory/Statutory Requirements: REACH, RoHS, DOT, Conflict Minerals, NAFTA

Accreditation Mark(s): ANAB

Registration Approach: Sampling

Certificate Expiration: 03/10/2028

No Shifts: 1

Times of Shifts: 8:00am-5:00pm

R20.62 Auditee Information

Auditee: Jemison Metals

Auditee No: 6796-02

Address: 914 Maero Street NW

Trinity, AL 35673

Main Phone Number: 205-986-6630

Web Site: <http://jemisonmetals.com>

Auditee Contacts

Mr. Rick Rowland, SR VP Quality & Engineering, Metallurgical Engineer

Jemison Metals

1000 Urban Center Dr. , Ste 650, Vestavia Hills, AL 35242

Tel: 205-986-6627

Email: rrowland@jemisonmetals.com

Audit Event

Surveillance: 02/05/2026

Total Mandays: 1.0

John Griffin, Lead Auditor

PRI Audit Support Specialist: Kelly Surgalski

Specialist Phone: 1-724-778-9044

Specialist Email: ksurgalski@sriregistrar.com

Audit Scope

Standard: ISO 9001:2015 (non-design)

Areas Identified As Not Applicable: 8.3 Design and development of products and services

Justification: Make to specification or print only

Scope: Processing and distribution of ferrous sheet products utilizing cut-to-length and stretch leveling operations.

SIC Codes: 5051

IAF: 29

NACE Codes: G51.5

No. of Employees: 20

Products: Steel

Regulatory/Statutory Requirements: REACH, RoHS, DOT, Conflict Minerals, NAFTA

Accreditation Mark(s): ANAB

Registration Approach: Sampling

Certificate Expiration: 03/10/2028

No Shifts: 2

Times of Shifts: 1st 6:00a-4:00p M-F, 2nd 4:00p-2:30a M-Th

Audit Plan

The audit plan, audit team members, and qualifications, representatives, working documents, audit plan schedule, process matrix, and auditor assignments have been reviewed with the organizations and are on file with PRI. The final Audit Plan is considered part of the report and is maintained as an audit record.

Audit Records

Form R20.36: Which shows the registrar confirmation of the audit results was completed, signed by both parties on-site, returned to PRI, and is on file.

Assessment Narrative: The pre-audit/post audit conference list of attendees and standard agenda are on file, as is the agenda. The registered company has acknowledged and signed any corrective action notifications issued at this event.

The PRI Auditor Notes: Auditor notes were captured and returned to PRI, along with the "Interview Listing" (I8-3), all of which are on file.

Assessment Summary Matrix: The assessment summary matrix was completed by the lead assessor and indicates the areas in which the selected processes were assessed and the areas requiring corrective action. If there are several distinct audit tracks or business units, each has a matrix completed for it. The matrix is provided.

Corrective Actions: If any, are included with this report and summarized in numerical order, showing the referenced cited standard section, process, a description of the nonconformity, and the level of severity indicated as "M = Minor" or "H = Hold." Form R20.35 provides the detailed nature of the nonconformance.

Opportunities for Improvement: If the lead auditor noted opportunities for improvement (OFIs), these were provided to the auditee during the post-audit meeting. The opportunities for improvement are listed.

Report Distribution

Distribution by PRI is only to the auditee, the auditor assigned for the next scheduled audit event, PRI, and any accreditation body, when requested, where their oversight is required.

Assessment Summary

Processes Assessed	Performance			
	Satisfactory	Org. Action Plan in Place	Not Identified	Unsatisfactory
Corp. Award	X			
Corp. Purchasing	X			
Corp. Sales	X			
Production	X			
Receiving	X			
Shipping	X			
Support	X			

Process Summary

Process	Comments
Corp. Award	<p>The company's Awards process was reviewed for the audit and was found to follow an established and documented process. (QMP 8.1) This process describes the feasibility activities of reviewing customer orders from new customers and / or new parts to be added to the production operations. The RFQs are received from Outside sales in the form of emails and are forward those to the Business analysts to begin the quote/award process.</p> <p>The analysts build a part profile using the company "BEST" software are called a "Part Tech Template". This is viewable by all sales and support employees and facilitates a feasibility review that could include Sales, Purchasing, Quality and Engineering. A completed review will result in a quote. If the customer accepts the quote there will be an award. Random Awards were reviewed for the audit. (Award#/Customer/date-4597/Power partners/1-22-26, 5360/Rheem Mont./9-19-25, 5274/Mathews/8-4-25).</p> <p>Awards prior to Purchasing materials-Goal-100%, actual 100%.</p>

Process	Comments
Corp. Purchasing	<p>The corporate groups Purchasing activities were reviewed for the audit and were found to follow an established and documented process. The primary material managed by the group is the Steel supplier group which includes many of the local steel producers in the Southeast US. Materials are purchased and received by the company's individual plants. The POs for the company specify which types of steel are required and which supplier has the most cost-effective delivery rate. The Company's software system (BEST) compares the COA data on the BOL to the Company's steel specification requirements to ensure that the materials Bill of lading (BOL) is compared to the company's material specification to ensure that the material meets customer requirements. (See BP-2) If not the system locks out the steel and it cannot be processed or shipped. The corporate supplier evaluation process was reviewed for the audit. The corporate purchasing support activity conducts supplier evaluations on a quarterly basis and formally communicates results to steel suppliers. The company averages these scores and presents them as a KPI for leadership review. (2011-2025/ <3.0->3.6)</p> <p>The company averages quarterly supplier evaluation scores and presents them as a KPI for leadership review. (2011-2025/ <3.0->3.6).</p>
Corp. Sales	<p>The corporate groups Sales activities were reviewed for the audit and were found to follow an established and documented process. This process describes the routine review and scheduling of reoccurring orders for existing customer base. These orders are reviewed for pricing, due date, stock on hand, and quantity. When orders are reviewed the company software system creates an automated order "acknowledgement form", as a record of the order review. These forms are sent automatically to the customer and saved as a QMS record. (See BP-4) Random orders were reviewed for the audit.</p> <p>(Customer/PO#/Date-AAF Flanders/83984/1-27-26, Schwartz/2504520/1-28-26, Trane/301251800/1-27/26) The review verified that the process was implemented as described. (See OFI-5)</p> <p>Same day/48 hrs. acknowledgement of inside sales orders-Goal 100%, actual ??? (See OFI-5)</p>

Process	Comments
Production	<p>VA facility Production-The Production processes at the Virginia facility were reviewed for the audit. This includes one steel slitter machine, one leveler / CTL, and one blanking line. The operations of these lines was found to follow a documented process (slitter-CLV-SL-001 / Leveler-CLVRB-001) The processes are managed by INVEX software system that takes input sales orders and generates work (Job) orders for each customer PO. Electronic job schedules at each work-station show the order and types of orders to be run for the workday. The hardcopy orders assigned to each machine describe the job spec, order spec., set-up instructions, processing instructions, packaging, materials to be used, and time used for production.</p> <p>AL-The Trinity, AL facility processes steel roll coils primarily from the AMS Calvert and NUCOR Decatur OEM Steel facilities. The coils are processed for leveling, stretching and cut to length. Schedules (Work center line-up) are managed from the machine and the set-up instructions for each machine. (Job Work orders) are used to operate the process. Process monitoring and measurements were recorded for each job. (Daily production report/DEC-BB1-CTL) Random orders were reviewed in the production area. (Work orders#/Customer-71947/Blue bird, 75683/Blue bird, 75722/Hunter Eng.) Records showed that the process was implemented as described.</p> <p>Operators follow the job order instructions to set up the tooling / process to make the various sizes of the orders per customers' requirements. Several of these orders were reviewed for various production processes. (Job #s/Date/Customer-71929/1-26-25/Hill Phoenix, 75080/130-25/Modine, 74708/Hill Phoenix/1-30-25) Operations personnel were interviewed and were found to follow the processes as described.</p> <p>Both sites-Physical characteristics such as length, width, thickness, flatness, and squareness are measured at the beginning and ends of each run. These measurements are captured on hard copy records. (JDM-13, 03) Production runs are visually monitored for surface quality.</p> <p>A Gamma gage is used to continuously monitor material thickness as the run progresses. Several random orders were reviewed for the audit.</p>

Process	Comments
<p>Production (Continued)</p>	<p>AL site (Work orders #/Customer-71947/Blue bird, 75633/Blue bird, 75722/Hunter Eng.) Both sites were found to follow the process as described and the process was deemed to be effective. NCM on the line is segregated on the line and tags are printed for the materials. This also locks out the material to prevent shipment. (Status code) Operators were interviewed for the audit and were found to be competent, experienced and aware of the QMS and their roles in it.</p> <p>VA-Ext/DPPMs Flat Goal-<3500, actual-3438, Ext/DPPMs Fab.-goal-<2000 actual-496, Int DPPMs-Fab goal-<10,000O, actual-5718, Flat goal-<3500, actual-3617, Customer Complaints goal-?, actual 74, OTD-Flat-goal->98%, actual-89.9%, Fab.-goal->89%, actual 77.3%.</p> <p>AL-DPPMs-goal<3500, actual 1785, On time delivery-goal->98%, actual-92%, Devaluations-goal-<.20%, actual-.28%.</p>
<p>Receiving</p>	<p>Receiving process-The VA, and AL site's Materials receiving related activities were reviewed for the audit and were found to follow an established and document process. (LYN-RC-001) The primary material critical to quality is the rolled steel material which is processed by the site. The company's process for managing the receiving process for rolled steel is through a "Load off sheet", that records which loads of steel coils will be shipped into the site on each day. The ERP (INVEX) is used to track and identify shipments of rolled steel from the corporate purchasing activity. A list of expected inbound steel is printed out each day. Materials arrive by rail and by truck. Cranes and forklifts are used to offload materials. The B.O.L.s for each load are matched to the purchasing PO to ensure that materials received match the materials ordered.</p> <p>Scannable tags are printed for each coil received and locations are electronically entered into the ERP system. Each coil is checked for any signs of physical damage or packaging issues. Any damaged or unidentified materials are segregated for disposition. VA-Random B.O.L.s were examined during audit. (BOL #/Supplier/Date-1883374/NUCOR-B/1/27/25, 1883101/NUCOR-B/1/26/25, 1882918/NUCOR-B/1/24/25) This review verified that the process was implemented as described (OFI-2) and was effective. (BP-1) AL-(BOL/Customer /date-173510/NUCOR/2-4-26, 161214/Calvert/2-4-26).</p>

Process	Comments
<p>Receiving (Continued)</p>	<p>The steel is off loaded by cranes and is checked for any physical defects, width and thickness and results recorded. (JDM-F-001) The rolls are then entered into the sites ERP (INVEX) system and given an inventory Id number and a warehouse location and is entered into the customer database for each heat used to fulfill a customer order. Each BOL document is stamped with an "inspection stamp" that is completed by the receiver showing that an inspection and processing has taken place. The NC materials are locked out in the system to avoid further processing and processed for return to the supplier.</p> <p>Ext/DPPMs Flat Goal-<3500, actual-3438, Ext/DPPMs Fab.-goal-<2000 actual-496, Int DPPMs-Fab goal-<10,000O, actual-5718, Flat goal-<3500, actual-3617, Customer Complaints goal-?, actual 74, OTD-Flat-goal->98%, actual-89.9%, Fab.-goal->89%, actual 77.3%.</p>
<p>Shipping</p>	<p>The VA and AL sites packaging and shipping related activities were reviewed for the audit and were found to follow an established and document process. (work orders / load orders) The production process is managed by the use of production orders. As an addendum to these orders are instructions on how the orders are to be shipped including; banding, spacers, tagging, palletizing, weight, and paper covering. These instructions are set up in the INVEX software system for each customer according to their requirements. These instructions are followed to ensure that packaging meets customer requirements.</p> <p>There are also "Load lists" for each order/shipment to define the customer loading requirements for each order. Shipping personnel receive these hard copy written orders for each load and pull materials for each order, and define materials covering (tarps), loading / unloading preferences (back / side), tag stubs, COA requirements, Heat, and BOL. The truck driver also plays a role in determining how and where materials are loaded onto the flatbed truck. BOLs are signed by both shipper and driver when the load was complete.</p> <p>At the VA site, random load orders / packing lists were reviewed. (Pack list#/Customer /Date-22829-1/BSH/1-23-26, 22954-1/ACCU-FB/1-28-26, 22887-1/Hill Phoenix/1-27-26). At the AL site, random load orders / packing lists were reviewed. (Packing list#/Customer/date-23579/Blue bird/2-5-25, 23781/Coats/2-5-25, 235779/Blue bird/2-5-25) This review verified that the process was implemented as described and effective.</p>

Process	Comments
Shipping (Continued)	Ext/DPPMs Flat Goal-<3500, actual-3438, Ext/DPPMs Fab.-goal-<2000 actual-496, Int DPPMs-Fab goal-<10,000O, actual-5718, Flat goal-<3500, actual-3617, Customer Complaints goal-?, actual 74, OTD-Flat-goal->98%, actual-89.9%, Fab.-goal->89%, actual 77.3%.
Support	<p>The Support related activities of the QMS were reviewed for the audit At the VA and AL sites and were found to follow established and documented processes. The primary support activities for the QMS; Management review, internal audits, corrective action and customer satisfaction were reviewed and documented in other areas of this report. Other areas of the QMS were examined as follows;</p> <p>4.0 The company Corporate Quality manual (9-6-24) contains the company scope and policy. An interested parties log (JDM-F-100) was examined. Processes for the QMS were defined.</p> <p>5.0 The company's ownership and CEO work from the Vestavia Hills, Alabama location. The CEO of the organization was available and was interviewed for the audit. The leader expressed commitment to the QMS and evidence showed that the resources to manage the QMS were being provided. Employees interviewed for the audit were aware of their QMS and articulated their roles in it.</p> <p>6.0 The company's risk analysis documents were reviewed for the audit. (Matrix rev 3, 9-6-24) Multiple Goals and Objectives were defined in the QAM and KPIs for VA and AL were evidenced in the most recent Management Review record.</p> <p>7.0 Resources-Human resources were observed to be adequate for each facility and there was no evidence manpower shortages, and all budgeted positions were filled. (See OFI-1) Random training records for the Lynchburg, VA location was reviewed for the audit at the Corporate site in Vestavia Hills, AL. (Name/Job-F. Simms/Receiver, A. Dannell/ production, N. Torrents/ Production, W. Bresch/Production) Records were found to be complete and up to date. Corporate documents for various jobs (Description/Job#- Team leader, Senior team leader/30071,30170, Material handler/30020) were observed and verify that the training process is implemented as described. A training matrix at each site codes each critical activity as being- 1) In-training, 2) Trained, 3) Trainer capable.</p>

Process	Comments
<p>Support (Continued)</p>	<p>Corporate HR manages the job descriptions, onboarding and keeps records of safety, crane, and forklift training. Interviews determined that employees were communicated with and were aware of their QMS.</p> <p>Maintenance-A manual system for PM scheduling (monthly) and records keeping for PMs was observed. The sites PM schedules and random equipment PM records for the VA and AL sites were reviewed for the audit. (VA-Equipment/PM date-Coil tipper/1-15-26, LP-1 Laser/1-15-26, Pallet inverter/1-15-26-AL Cam roll bearing/1-12-26, Main shaft/1-15-26, Hydraulic shear/2-5-26) This review indicated that the PM systems were implemented and effective. (See OFI-3)</p> <p>Document control for tiers 1 and 2 are controlled by a corporate system. Local records were found to use corporate managed forms and were complete, as reviewed.</p> <p>Calibration activities for the Lynchburg, VA site were reviewed for the audit. The company uses the Gage-Trak software system to manage calibration records. A review showed some 34 devices in the system including micrometers, dial calipers, tape measures, CMM arm, Faber vision and ray tech dimensional tables, Gage blocks, and angle plate. Random devices records were reviewed for the audit. (Device name/ #/ last Cal. Date-Micrometer/MIC-01/1/30/25, Dial caliper/CP-LB-01/1-30-26, Length bar/LB/1-30-24) All devices were managed in the system and were in a state of calibration. In the Trinity, AL site, there were far fewer devices that are less sophisticated. (Tape measure, micrometers) Several devices were observed (Mic 017, Tape measure 242) and were found to be in a state of calibration.</p> <p>8.0 The Lynchburg, VA, and Trinity AL production locations was audited and documented in other parts of this report.</p> <p>9.0 Inspections-Monitoring and Measurement activities were reviewed for the audit. Received materials are visually inspected and reports of this inspection are documented on the BOL stamped) The INVEX system checks the COA. (see BP-1) For Flat product, the physical characteristics such as length, width, thickness, flatness, and squareness are measured at the beginning and ends of each run.</p>

Process	Comments
<p>Support (Continued)</p>	<p>9.0 (Continued) These measurements are captured on hard copy records. (JDM-13, 03) Production runs are visually monitored for surface quality. A Gamma gage is used to continuously monitor material thickness as the run progresses. Several random orders were reviewed and were found to follow the process as described and the process was deemed to be effective. (See receiving, Production and shipping areas of this report) NCM on the line is segregated on the line and tags are printed for the materials. This also locks out the material to prevent shipment. (Status code) Operators were interviewed for the audit and were found to be competent, experienced and aware of the QMS and their roles in it.</p> <p>Internal Audits, and Management Review was audited and documented in other parts of this report.</p> <p>10.0 Corrective action was audited and documented in other parts of this report. Continual improvement was reviewed with the CEO. They expressed the ongoing projects to implement a new ERP system (INVEX), ongoing efforts to better manage capacity within the production group as high priorities for the company moving forward.</p> <p>Ext/DPPMs Flat Goal-<3500, actual-3438, Ext/DPPMs Fab.-goal-<2000 actual-496, Int DPPMs-Fab goal-<10,000, actual-5718, Flat goal-<3500, actual-3617, Customer Complaints goal-?, actual 74, OTD-Flat-goal->98%, actual-89.9%, Fab.-goal->89%, actual 77.3%.</p>

Corrective Actions List

No nonconformities were identified during this audit event activity.

Opportunities for Improvement

The following Opportunities for Improvement were identified during this audit activity:

Process	Description
Support	OFI-1 The Lynchburg, VA site could choose to improve communication of QMS goals and objectives by creating a "QMS Metrics Scoreboard" that communicates the QMS key goals and objectives using real time data to solicit operator's efforts to meet these objectives.
Receiving	OFI-2 The site could choose to add the COA check by INVEX system as part of the documented process contained in document LYN-RC-001.
Support	OFI-3 The company/site could consider creating a maintenance / PM related KPI such as unscheduled downtime, to measure the performance of the maintenance activity.
Corp. Award	OFI-4 The company could choose to create a record that serves as a supplier agreement with customer signature and date to protect the company after an award, and its business prior to the first processing of a new business order.
Corp. Sales	OFI-5 The company could choose to create a metric for order acknowledgement timing in order to measure sales order review.

Note: Opportunities for Improvement are non-binding.

Best Practices Observed

The following Best Practices Observed were identified during this audit activity:

Process	Description
Receiving	BP-1 The company's new ERP system (INVEX) automatically checks the COA data provided by the steel supplier against the company's steel specifications and stops NC steel from being processed.
Corp. Purchasing	BP-2 The Company Receiving / purchasing system electronically compares the COA data to the product specification. If the materials are out-of-spec, the system automatically puts the steel coils "on hold" until the issue has been resolved or the data arrives for comparison. This prevents NC coils from being processed or shipped with out-of-spec materials.
Corp. Purchasing	BP-3 The corporate purchasing support activity conducts supplier evaluations on a quarterly basis and formally communicates results to steel suppliers. The company averages these scores and presents them as a KPI for leadership review. (2011-2025/ <3.0- >3.6)
Corp. Sales	BP-4 When orders are reviewed the company software system creates an automated order "acknowledgement form", as a record of the order review. These forms are sent automatically to the customer and saved as a QMS record.
Shipping	BP-5 The Trintiy, AL site shipping group uses unique colored flags to identify products in the warehouse to be pulled for loading for each shipping order.