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Surveillance Audit No: 5

ISO 9001:2015

C O N F I D E N T I A L
Report
For

JEMISON METALS

Gadsden and Birmingham, Alabama, and Sumter, South Carolina

Date of Report:	April 16, 2024
Date(s) of Audit:	March 26 – 27, 2024
Number of total mandays scheduled for this audit:	4.0
Number of total mandays actually conducted:	4.0
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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Staff Auditor: David D. Hansell Date: April 16, 2024

Ownership of the audit report is maintained by SRI.
Right of perusal by a third party can only be obtained after permission of the audited company.

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 SRI'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, SRI 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:

Internal Audit Results:	The company's Corporate Internal audit activities were reviewed during the audit and were found to follow an established and documented process. (QMP 9.2) There were six audits done 2023, one for each manufacturing plant. Of those audits, records review revealed that there were seven observations (OFIs), and 2 NCRs. Records showed that the two NCRs were corrected; they had a CAPA activity associated with them (NCR#s 26474, 26475) The company also does process related audits. In 2023 there were 41 of these audits done, up from 31 in 2022. Both Gadsden, Alabama and Sumter, South Carolina sites has separate process and layered audit programs that are done on a random basis. Overall, the audit process was found to meet requirements.
Management Review Results:	The company's corporate Management review activities were reviewed during the audit and were found to follow an established and documented process. Reviews of the QMS are scheduled to be done once per calendar year. The last review of the QMS was done on March 18, 2024. Records review indicated that the review covered all of the requirements, contained in section 9.3 of the ISO standard were contained in the review record. Record indicate that leadership was present at the meeting and was involved in the review process. The review record also contained the following QMS goals and objectives.
Corrective/Preventive Actions:	The company's corporate corrective action activities were reviewed during the audit and were found to follow an established and documented process. (QMP 10.2) The company's software system (FIT) creates a case number for each CAPA issue addressed by the system. For each case the CAPA records review indicated that there was an 8D style record created to record each step of the process. Random records review indicated that the process was in place and being managed by the system as described.

Customer Complaints:	The company's corporate Customer complaints / satisfaction activities were reviewed during the audit and were found to follow an established and documented process. The company does not currently use a customer survey to measure customer perceptions. (See OFI-3) The customer does use defect data to measure customer satisfaction. (DPPM) The corrective action system has a process for investigating customer issues and documenting their resolution.
Quality System Changes:	There were none.
Areas Identified as Not Applicable:	8.3 Design and development of products and services
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-There were no specific QMS requirements found.
Auditor Comments (Important Observations, Strengths, Exclusions):	Jemison metals is a privately owned company headquartered in Birmingham, Alabama, that processes rolled, flat, and fabricated steel products in multiple locations across the US. The production of steel products occurs at six different locations. The company has had a successful 2023 and is on track to have a better 2024. The company has recently purchased another steel fabrication shop in Georgia. Risk issues for the company include the implementation of a new ERP system called (BEST), that will update the older DOS based system to make the company's operations more efficient.
Validation of CANs issued during previous activity:	There were no CANs issued during previous activity.
Review of Outsourced Processes:	There were none.
Shifts:	No changes in shifts or times were observed.

Notable changes (e.g., address, management rep., shifts, scope, processes, employee count, etc.):	There were no notable changes.

R20.62 Auditee Information

Auditee: **Jemison Metals** **Auditee No:** 6796-01

Address: 3800 Colonnade Parkway
Suite 250
Birmingham, AL 35243
Main Phone Number: 205-986-6627
Web Site: http://jemisonmetals.com

Auditee Contacts

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Audit Event

Surveillance: 03/26/2024 - 03/27/2024 Total Mandays: 4.0
John Griffin, Lead Auditor

SRI Audit Operations Coordinator: Kelly Surgalski
Coordinator Phone: 724-934-9000 ext. 667
Coordinator 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
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: 30
Products: Steel
Regulatory/Statutory Requirements: REACH, RoHS, DOT, Conflict Minerals, NAFTA
Accreditation Mark(s): ANAB
Registration Approach: Sampling
Certificate Expiration: 03/10/2025
No Shifts: 1
Times of Shifts: 8:00am-5:00pm

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 SRI. 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 SRI, 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 SRI Auditor Notes: Auditor notes were captured and returned to SRI, 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 SRI is only to the auditee, the auditor assigned for the next scheduled audit event, SRI, 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
B-Award Review	X			
B-Purchasing	X			
B-Sales	X			
B-Support activities	X			
G-Packaging and service	X			
G-Production and Service	X			
G-Support activities	X			
S-Control M&M resources	X			
S-Packaging and Shipping	X			
S-Production and service	X			
S-Receiving	X			
S-Sales	X			
S-Support activities	X			

Process Summary

Process	Comments
B-Award Review	The company's Awards review activities were reviewed during the audit and were found to follow an established and documented process. (QMP 8.1) The awards review is an expanded form of contract review for new clients or clients who are creating orders for new products not previously produced. The process involves a feasibility review with a cross functional team. The team reviews all critical information concerning the client and the potential order prior to accepting the RFQ. The information is loaded into a spec system called STELPLAN. This software system captures and saves critical customer/client information such as spec requirements packaging and billing information. This record is saved and becomes the basis for inside sales reviews of reoccurring orders from established customers. Persons associated with this process were interviewed and random records of the awards review (Spot RFQ / model) were examined to verify that the process was in place and effectively implemented. (See OFI-4) <u>Metrics:</u> Customer feedback DPPM goal-<2000-3500, actual 5264, Internal rejects-goal <.35% sales, actual-.50%, On time delivery-goal >98%, actual 84.3%.

Process	Comments
B-Purchasing	The company's Purchasing activities were reviewed during the audit and were found to follow an established and documented process. The primary materials purchased for the production activity is steel. The company provides a combination of hot and cold rolled steel materials from a series of steel mills and secondary sources. The company software stores a list of approved suppliers. Suppliers are added using a "New supplier checklist"(JDM-F-012). Suppliers are reviewed on a quarterly basis in 3 areas: quality, service and delivery. Each is given a score (1-5) and the scores are averaged together on a "Quarterly supplier evaluation form" (JDM-F-050). All suppliers scores are averaged together for an aggregate score that is tracked as a key process metric. This data shows a steady improvement in supplier performance over a 2-year period. (2.4-3.5) (See BP-1) Managers interviewed indicated that processes exist at each plant to inspect steel when it is received to ensure quality and correct content. Purchase orders are reviewed to ensure that they are accurate before release. All evidence indicated that this system is implemented and effective. <u>Metrics:</u> Customer feedback DPPM goal-<2000-3500, actual 5264, Internal rejects-goal <.35% sales, actual-.50%, On time delivery-goal >98%, actual 84.3%.
B-Sales	The company's Sales / contract review activities were reviewed during the audit and were found to follow an established and documented process. (COP #1). The review of reoccurring orders is conducted by the inside sales group. members of this group match the POs from the customer to the materials spec sheets in STELPLAN. The customer and part numbers are aligned and the basic requirements for materials and equipment availability are determined and reviewed for each order. In most cases, the inside sales personnel create an email record acknowledging the review of each order or print out the order and create hand notations of the order review and scanning them to send to the customer as proof of an order review. These records are kept in the sales group as a QMS record. (See OFI-1) <u>Metrics:</u> Customer feedback DPPM goal-<2000-3500, actual 5264, Internal rejects-goal <.35% sales, actual-.50%, On time delivery-goal >98%, actual 84.3%.

Process	Comments
B-Support activities	The company's Support-related activities were reviewed during the audit and were found to follow an established and documented process. (Corp. QAM) Key support processes such as Management Review, Internal Audits, and Corrective action were reviewed during the audit and the contents are covered in other areas of this report. Other support areas audited include: 4.0 The company's corporate QA Manual contained details of the QMS including the QMS scope, interested parties, and key processes. 5.0 The leader of the organization was interviewed for the audit. The leader indicated that they and the organization were committed to the QMS and its management. The QMS policy and organizational chart was also reviewed. Evidence (MRR) indicates that the leadership was supportive and engaged in the management of the EMS. 6.0 The company's QMS risk matrix follows a FMEA style format and was verified and reviewed for the audit. Goals and objectives were reviewed as follows; Customer feedback DPPM goal-<2000-3500, actual 5264, Internal rejects-goal <.35% sales, actual-.50%, On time delivery-goal >98%, actual 84.3%. The company also showed evidence that they were attempting to save critical organizational knowledge by using a software program (BEST) 7.0 Resources to manage the QMS were reviewed for this audit (organization chart) The IT function (See OFI-2) and the Maintenance function were audited and key personnel were interviewed. The training activities were reviewed. Each job has a description which forms the basis of the new hire training requirements. Employees were interviewed during the audit and were aware of their QMS and their roles in it. Communications methods were displayed at each site and were sufficient to meet requirements. Documents were reviewed during the audit at all three sites. Records showed that documents in the QMS were under control and the most current versions were in use. No obsolete documentation was found in any work area. 8.0 The company's production operations were audited and result covered in other sections of this report.(See G/S production)

Process	Comments
B-Support activities *(Continued)*	9.0 The company's Monitoring and Measurement activities were audited and result covered in other sections of this report. (See G/S Production) 10.0 The company's Continual improvement activities operations were audited. Evidence showed that the company was making a serious effort to try to manage risk issues involved in improvement of the QMS. Specifically, the risks of losing critical organizational knowledge is being addressed through the upgrade of the company software package (FIT) with an improved version called BEST. This upgrade is in process and ongoing. <u>Metrics:</u> Customer feedback DPPM goal-<2000-3500, actual 5264, Internal rejects-goal <.35% sales, actual-.50%, On time delivery-goal >98%, actual 84.3%.
G-Packaging and service	The company's Packaging and service activities were reviewed during the audit and were found to follow an established and documented process. The product packaging requirements are included as part of the production job packet for each order. The warehouse and storage areas for finished goods were observed during the audit. The areas observed were neat, orderly and exceptionally well organized. (See BP-3) Packaging includes a bar code scannable label and non-controlled copies of company part drawings. The product is skidded, stacked, and shrink wrapped to avoid movement and / or damaged materials. <u>Metrics:</u> Customer feedback DPPM goal-<2000-3500, actual 5264, Internal rejects-goal <.35% sales, actual-.50%, On time delivery-goal >98%, actual 84.3%.

Process	Comments
G-Production and Service	The company's Gadsden, Alabama Production process activities were reviewed during the audit and were found to follow an established and documented process. The company location employs one slitter line that slits rolled steel for a variety of external customers. There are eight laser cutters, one plasma cutter and five break presses that cut and bend parts to meet a variety of customer spec/requirements. Steel materials for the laser and break press materials is supplied by internal suppliers; slit raw materials are procured from external steel suppliers. Production schedules are created for all products and corporate scheduling calls every day at 9:00 am each morning. Planners for each site take customer requirements and create programs that machine operators use to set up "job orders" on the production schedule. (See OFI-5) Machine operators select the "program" for each customer order to laser cut and / or punch the steel to the customer's specifications. These laser processes are monitored using a first piece inspection and every 20th piece inspection. Records of these activities were examined and were verified to be in accordance with requirements. Check fixtures are sometimes used to verify shaped (bent/brake press) parts (See OFI-6) These operations were observed, operators interviewed, and records reviewed indicated that there was control of the processes as described. <u>Metrics:</u> Customer feedback DPPM goal-<2000-3500, actual 5264, Internal rejects-goal <.35% sales, actual-.50%, On time delivery-goal >98%, actual 84.3%.

Process	Comments
G-Support activities	The company's Gadsden, AL support activities were reviewed during the audit and were found to follow an established and documented process. Areas reviewed for this report are as follows: • 4.0 Context was audited and is covered in corporate QAM • 5.0 Leadership was audited is covered in Corporate (Birmingham) report. ○ Planning was audited is covered in Corporate (Birmingham) report. • 7.0 The maintenance / PM program was reviewed during this audit. The plant system uses a FLUKE software system to manage PMs. PMs are scheduled weekly, monthly, quarterly, and yearly. Random records of PMs showed that the process is implemented. (SEE OFI-7) The training records for employees are kept at the Birmingham location. A training matrix was reviewed for the audit. (JDM-F-014) Job description exist and were located in Birmingham corporate offices. All documents reviewed appeared to be under document control. • 8.0 Production operations were reviewed for the audit and reported in other areas of this report. • 9.0 The processes requires material alignment to be monitored visually to ensure correct cutting and bending of the metal. The measurement activities include 1st piece and every 20th piece inspections. Records of these measurement activities were reviewed and were verified to have been done as described. The plant does internal QMS systems audits, process layered audits and production process specific audits on a random basis throughout the year. Records of both types of audits were reviewed and were found to be implemented as planned. records showed that audits were done as planned with 1 QMS audit, 9 process, and 377 layered audits in 2023. (See BP-5) The layered audits showed that first piece inspections first the most prevalent failure modes in layered audits. There were 0 NCs in process and QMS audits. 10.0 Continual improvement activities were listed in the MRR and were reviewed for this audit. <u>Metrics:</u> Customer feedback DPPM goal-<2000-3500, actual 5264, Internal rejects-goal <.35% sales, actual-.50%, On time delivery-goal >98%, actual 84.3%.

Process	Comments
S-Control M&M resources	The company's Control Monitoring and measurement activities were reviewed during the audit and were found to follow an established and documented process. (SM2-Fab-001) The company does first piece inspections (JEM Print/par #) at the beginning of each production run. All key characteristics are measured against customer print specs and written on the JEM print. This print is scanned and saved as a QMS record and stays with the production packet. As the runs progress, every 20th part (JDM-F-060) is inspected as part of the M&M activity. Non-conforming materials are segregated and monthly MRBs are conducted, led by corporate to manage and disposition the materials in each plant manufacturing site. Monitoring activities are simple and straight-forward; the machines are loaded with conforming, defect free steel product, this material is aligned to start the production run and the correct cutting program selected. Records indicates that the process is in place and is effective. <u>Metrics:</u> Customer feedback DPPM goal-<2000-3500, actual 5264, Internal rejects-goal <.35% sales, actual-.50%, On time delivery-goal >98%, actual 84.3%.
S-Packaging and Shipping	The company's Packaging and shipping activities were reviewed during the audit and were found to follow an established and documented process. The packaging of the product for each order is done based upon the JEM spec and any notes on each customer order form. In some cases, the customer owned dunnage is used for the packaging activity. Banding or shrink wrap is also applied. For shipping, the loads are created for each customer based upon the data organized by shipping due dates on the plant "planning board". Materials are pulled and loaded with BOLs created for shipping records. Shipping records and interviews with employees indicate that the process was in place and was effective. <u>Metrics:</u> Customer feedback DPPM goal-<2000-3500, actual 5264, Internal rejects-goal <.35% sales, actual-.50%, On time delivery-goal >98%, actual 84.3%.

Process	Comments
S-Production and service	The company's Production and service activities were reviewed during the audit and were found to follow an established and documented process. (SM2-LA, PB-001) The Sumter / SM2 plant production activities consist of 3 break processes, 2 laser cutters, and 1 combo laser punch process. Production orders are scheduled by production planners located in Birmingham, AL. These planners load orders into each machine cell. Each operator receives production order packets for each order, in the order that the planner creates and manages. The packets contain all critical production information including packaging, banding, dunnage and other important information. The packet also includes the JEM drawing used for the first and 20th pcs inspections. Orders are processed and equipment operated in the same manner as the Gadsden, AL site. The exception is the punch / CNC machine. This special process punches holes and machines the part at the same station. This unique feature is created and programmed into the CNC / FIT software system by the production planner. (See OFI-8) Non-conforming materials are segregated and documented on the sites' MRB system. Records reviewed indicated that the process records the disposition of NCM and the authority who approves it. Interviews conducted on site, observations of the production areas and records reviews indicated that the process was operating as described. (See BP-7) <u>Metrics:</u> Customer feedback DPPM goal-<2000-3500, actual 5264, Internal rejects-goal <.35% sales, actual-.50%, On time delivery-goal >98%, actual 84.3%.
S-Receiving	The company's Receiving activities were reviewed during the audit and were found to follow an established and documented process. (SM2-RC-001) All materials used in the production process are received from internal suppliers (sister plants) Internal BOLs are received by the receiving operator, and materials types and totals are verified by matching the material tags to the BOL document. Materials are transferred to the receiving company location, in this case SM2, automatically when the inventory at the sister plant is adjusted at the shipping step. <u>Metrics:</u> Customer feedback DPPM goal-<2000-3500, actual 5264, Internal rejects-goal <.35% sales, actual-.50%, On time delivery-goal >98%, actual 84.3%.

Process	Comments
S-Sales	The Sumter SC sites' Sales activities were reviewed during the audit and were found to follow an established and documented process. The inside and outside sales activities for the Sumter, SC are managed by a sister facility and by the Birmingham AL corporate group (See Birmingham AL (B) report) Metrics: Customer feedback DPPM goal-<2000-3500, actual 5264, Internal rejects-goal <.35% sales, actual-.50%, On time delivery-goal >98%, actual 84.3%.

Process	Comments
S-Support activities	The company's Sumter SC Support activities were reviewed during the audit and were found to follow an established and documented process as follows; 4.0 The activities in section 4 are managed through the corporate processes See Birmingham report summary. (B) 5.0 The on-site leadership for production and quality was interviewed for this audit. Interviews showed the leadership was committed to the QMS and provided on site resources to manage the QMS. 6.0 The activities in section 6 are managed through the corporate processes See Birmingham report summary. (B) 7.0 The activities in section 7 are managed through the corporate processes. See Birmingham report summary. (B) 8.0 The production activities are managed through the site report summary See Sumter Production report (S) 9.0 The management review function was reviewed and was covered in the corporate report. The site does one QMS audit per year. The last one was performed on September 13, 2023. The record of this review was examined during the audit. There were zero NCs and one observation. The site also does internal production process audits on a random basis. There were five such audits conducted in 2023. Records of these audits were reviewed. There was one NC found during these audits. The site also does dock audits to ensure correct quantities, packaging and labeling of shipping orders. There were 48 of these audits that were conducted in 2023. These audits were randomly reviewed during the audit; there were some minor issues found concerning tag signoffs, use of dunnage, and packaging quality. In all cases, these issues were resolved in real time with no CAPA actions required. 10.0 The activities in section 10 are managed through the corporate processes See sites' report summary. (B/G/S) <u>Metrics:</u> Customer feedback DPPM goal-<2000-3500, actual 5264, Internal rejects-goal <.35% sales, actual-.50%, On time delivery-goal >98%, actual 84.3%.

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
B-Sales	OFI-1 The company could choose to include total complaints metric to go with customer feedback DPPM data to track customer satisfaction.
B-Support activities	OFI-2,3,7 The IT function could create and present metrics to measure the maintenance of the computer infrastructure. OFI-3 The company could consider the future use of customer surveys using a simple social media-based format to compliment the customer complaint data (DPPM) in determining customer perceptions of the company, its products and service. OFI-7 The company could choose to create and report a PM metric such as unscheduled downtime, Machine availability.
B-Award Review	OFI-4 The company could consider using an "N/A" type designation on the spot quote model form to identify checks on the form that do not need to be check mark approved.
S-Production and service	OFI-5The company could consider the creation of flow charts and / or other actions to capture organizational knowledge related to plant production programming/scheduling/planning activities at each plant.
G-Production and Service	OFI-6 The company could consider constructing a shadow board or other such area to store and manage part check fixtures in the laser and press brake areas of the production plant.
S-Production and service	OFI-8 The company could consider managing the punch tools area using their 5S processes to create a more neat and orderly storage area for tooling.

Note: Opportunities for Improvement are non-binding.

Best Practices Observed

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

Process	Description
B-Purchasing	BP-1 The Corporate Purchasing process features a quarterly supplier evaluation process. Data is collected that shows continual improvement is supplier performance which is currently at 3.0-3.5 out of five which is low risk.
G-Packaging and service	BP-2 The finished goods warehousing areas were clean, and extremely well organized with all materials having scannable tags and uncontrolled "jem" drawings of the each part in the location.
G-Support activities	BP-3,4,5,6 The company's QA activity has created a change management function using Microsoft teams software system that manages and tracks PPAP changes to customer specs. BP-4 The Gadsden plant does internal QMS systems audits, process layered audits and production process specific audits on a random basis throughout the year. BP-5 The Gadsden plant uses a FLUKE software system to better manage the PM function and has saved some 350k in reduced breakdown costs in 2023. BP-6 A new video communications board has recently been installed in front of the breakroom area. This board broadcasts the operator production performance metrics.
S-Production and service	BP-7 The company site has a robust 5S program; the work areas were neat clean and well organized.