



Audit Record Report

Post Production Audit (Audit-2025-08053)

4/24/2025

Supplier Name: Jemison-demsey, LLC

Auditor Name: Jarvi, Benjamin

Part Number: B50E124A3 7123P // B4A72A 0448P // B8A3A 0773S // B8A3A 3262S

Start Date :

Tier 2 Business(es):

Supplier Quality Leader: Mullett, Paul

Due Date: 12/31/2025

Question Number	Question Category	Audit Question	Response	Justification of Response
1	Post Production: Company Certification 1	Does the supplier have a QMS that is ISO compliant and / or accompanying certification (ISO 9001, ISO/TS 16949,...)?	Pass	Good until March 2028
2	Post Production: Company Certification 4	If applicable, does the supplier have another certification specifically required for Wabtec parts?	Not Applicable	None
3	Post Production: Document Control 1	Is the drawing/part list/specification to the current revision level and is the update and distribution of these documents monitored, controlled and restricted?	Minor	All specs are used frequently by supplier and not needed unless there is a quote for a new material style. Requesting that supplier can prove that they are able to review all current material specs.
4	Post Production: Document Control 2	Are the manufacturing/inspection documents being used up-to-date?	Pass	Yes. See attached inspection sheets.
5	Post Production: Document Control 3	Do the manufacturing/inspection documents address all process parameters?	Pass	See attached inspection sheets

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6	Post Production: Document Control 4	Do the manufacturing/inspection documents address all product characteristics?	Pass	See attached inspection sheets
7	Post Production: Document Control 9	Do the Process Flow Diagrams, PFMEAs, Gage R&Rs, Capability Studies, Control Plans, materials used and sub-tier suppliers match the NCI or PPAP?	Pass	Reviewed 2 latest PPAPs completed and all documents used were up to date.
8	Post Production: Document Control 10	Are other process control documents up-to-date? (Examples: process sheets, inspection and test instructions, standard operating procedures, preventive maintenance instructions)	Pass	All up to date as shown below
9	Post Production: Document Control 11	Are the manufacturing computer programs used to the latest validated revision? (Examples: Software used in testing, CNC & PLC programs).	Not Applicable	All levelers and arbors are preset to size of material being run. All measurement devices are calibrated for each job.
10	Post Production: Document Control 12	Is objective evidence available the supplier is controlling sub-tier suppliers? (e.g. audits, inspections, etc.)	Pass	Supplier scorecard - tracks scrap rate and on-time delivery.
11	Post Production: Document Control 12 (a)	If applicable, Does supplier conduct any Special Process audits at sub-tier ?	Opportunity for improvement	Not needed because of incoming inspection but possibility to verify steel grade and quality at supplier's.

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12	Post Production: Document Control 13	Is there a clear traceability between supplier's applicable internal documentation (drawings etc.) and the revisions of the Wabtec documentation?	Fail	supplier's process is to convert their internal label to the Wabtec stocking tag per our requirement. Only issue that could occur here is with the example of NCMR-2024-075647, we received the wrong thickness of material from what was ordered and what the tag information showed. Likely the tag was placed incorrectly. Would prefer to see an investigation into this.
13	Post Production: Document Control 14	Does the supplier have the latest revisions of applicable international or national standards (ASTM, AAR, ISO, ASME, EN, AMS, SAE,...) referenced in the parts documentation?	Pass	They have all latest standards that are sent over from the mills.
14	Post Production: Document Control 15	Does the supplier have a functional procedure for repeating MSA (Gage R&R or equivalent) studies - regularly or when any important condition changes (new measurement devices installed, new inspectors on-board, inspection techniques modified, surrounding conditions changed, tolerances narrowed down etc.)?	Pass	Gage R&R performed and demonstrated.
15	Post Production: Material and Process Control 1	Is the frequency and method of inspection being performed, as described in the manufacturing/inspection documents?	Pass	Cut edge sampling rate - 1st and last piece of 1st bundle, then last piece of every 7000 lbs Stock edge sampling rate - 1st and last piece of 1st bundle, then last piece every 14000 lbs
16	Post Production: Material and Process Control 2	Is objective evidence available the supplier performs 100% feature inspection per the latest revised print?	Pass	Provided to the latest spec which they verified with inspection report
17	Post Production: Material and Process Control 3	When performing a capability study, did the sample size, frequency and sampling method take into account the sources of variation? (Examples: multiple machines or fixtures for same characteristic, multi-cavity molds for the same part, and changes over time, like tool wear and environment, multiple shifts, multiple people)	Pass	Capability SPC data provided in inspection report

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18	Post Production: Material and Process Control 4	Are inspection data and process records retained and stored appropriately, for a defined period of time?	Pass	Hard copies kept 7+ years. Digital records kept forever.
19	Post Production: Material and Process Control 5	Are materials/parts handled with care, protected from damage and deterioration and separated & identified adequately throughout the process?	Pass	Good flow through shop and solid practices for using pallets to stack bundles.
20	Post Production: Material and Process Control 6	Is there objective evidence that supplier's personnel have adequate training and qualification?	Pass	Reviewed training matrix. Was recently updated by plant manager.
21	Post Production: Material and Process Control 7	Is the inspection status of materials and parts identifiable throughout the manufacturing cycle and are they on-hold until the required inspections/tests have been completed and proven to be compliant?	Fail	Potential for incorrectly shipped material , as demonstrated with 2024 NCMRs. Incorrect thickness issue and over allowance on flatness requirement.
22	Post Production: Material and Process Control 8	Where applicable does marking meet Wabtec drawing/specification requirements?	Pass	only Wabtec tagging is applied.
23	Post Production: Material and Process Control 9	Where applicable, does the marking applied support a full traceability of the product to supplier's process which would allow to identify and isolate a suspect batch of parts?	Pass	Tag is traceable back to PO and Heat #

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24	Post Production: Cleanliness Control 9	Does the supplier continue using the Wabtec approved surface rust protection (chemicals) applied on the parts?	Not Applicable	None applied unless spec specifies oiling.
25	Post Production:Tools/Gages 1	Is there documentation of which tools/gages are needed for each operation, and are the needed tools/gages at the work station per the manufacturing/inspection plan?	Pass	Gage listed with each check. Shown on calibration records.
26	Post Production:Tools/Gages 2	Does the operator understand the proper use of the tools/gages and is he/she using them properly?	Pass	Training matrix includes all gages and equipment.
27	Post Production:Tools/Gages 3	Is equipment, including tooling, properly maintained?	Pass	Calendar has maintenance logs for all machines
28	Post Production:Tools/Gages 4	Are all the gages, torque tools etc, calibrated, records retained, and traceable back to primary calibration standards (NIST or equivalent)?	Pass	Calibration records and standards attached
29	Post Production:Tools/Gages 5	Do the gages & measurement devices used for the inspection of Wabtec products have a sufficient resolution (at least 10x better than the corresponding tolerance range)?	Pass	Yes

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30	Post Production: Tools/Gages 6	When a gage was found to be out-of-calibration, is there a process in-place to conduct a new inspection of products previously inspected with that gage and are the results documented?	Pass	QMP 8.7 - Control of nonconforming outputs
31	Post Production: Corrective Action/ Non-Conforming Material 1	Is there a documented Containment Plan for defects?	Pass	QMP 8.7 - Control of nonconforming outputs
32	Post Production: Corrective Action/ Non-Conforming Material 2	Is there an adequate process for isolation & control of non-conforming material & is it being followed?	Pass	QMP 8.7 - Control of nonconforming outputs
33	Post Production: Corrective Action/ Non-Conforming Material 3	Is an effective closed-loop corrective action process (internal and external), including identification of root causes?	Pass	Reviewed case # 25744 for corrective action plan
34	Post Production: Corrective Action/ Non-Conforming Material 4	Are Corrective Actions issued in the past 3 years still in place?	Pass	Yes for internal CARs. No SCARs issued by Wabtec.
35	Post Production: Corrective Action/ Non-Conforming Material 5	Is there a process in-place in supplier's system to notify Wabtec about a need to quarantine & recall suspect or nonconforming parts delivered?	Pass	Escapes fall outside of containment. Jemison would contact commodity leader or quality regarding such issues.

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36	Post Production: Change Control 1	Does a Change Control Process exist, and is it documented? (All part and process documentation, including manufacturing/inspection documents, must be updated.)	Pass	Each bundle is made to each order, so tags would be changed for a new order when a change occurs. No programs exist that need changed.
37	Post Production: Change Control 2	Does the Change Control Process include sub-tier suppliers?	Pass	Supplier scorecard - includes scrap rates and on-time delivery for all suppliers
38	Post Production: Change Control 3	Is there a process to notify Wabtec of process changes?	Not Applicable	No process changes have occurred since Wabtec has been a customer.
39	Post Production: Packaging and Preservation 1	Does supplier have Wabtec packaging spec. 84A220081 and is referred for changes & implemented (e.g Nail free packaging)	Pass	Provided latest version for their records. Palleting and banding corresponds with our spec.
40	Post Production: Packaging and Preservation 2	Whether packaging procedure uniquely for the parts supplied, If Yes, Is it followed.	Pass	Pallets are consistent for all sizes of sheet & plate
41	Post Production: Packaging and Preservation 3	Does the packaging defined for both Sea and Air shipment mode and it is followed everytime according to the mode of dispatch	Not Applicable	Only domestic shipments

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42	Post Production: Packaging and Preservation 4	Are less-than-container load shipments adequately protected? (e.g. Shrink wrap of outgoing shipments)	Pass	Paper covering on bundles.
43	Post Production: Packaging and Preservation 5	Whether packaging is adequate enough to protect the parts from damage during shipping.	Pass	Yes
44	Post Production: Packaging and Preservation 6	If applicable , Are the external pallets are having the sufficient ground clearances to have the Fork lift approach	Pass	All pallet blocks allow for enough clearance.
45	Post Production: Packaging and Preservation 7	Wood Packaging Materials used in the construction of bases, pallets, boxes, crates, blocking, and all other packaging materials, it must meet all the treatment and stamping requirements of the International Standards for Phytosanitary Measures, ISPM #15. Is it followed ?	Pass	Wood used in pallet blocks are made in house with all ISPM materials.
46	Raw Material 1	Is all stored material free of burrs and edges?	Pass	Both cut edge and stock edge material are checked for allowance of burrs.
47	Raw Material 2	Are the parts/crate marked with the required information? Part #, Description, PO, SN, Supplier	Pass	Wabtec tagging is applied before each shipment that ensures all information is included.

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48	Raw Material 3	Is there a process to control nonconforming material?	Pass	Material is segregated, tagged with an "R", and a system status code is used that stops that material from getting a shipping label.
49	Raw Material 4	Is each heat tested to ensure material properties are acceptable? If no, is there a sampling rate?	Pass	1st and last piece of 1st bundle, then last piece of every 7,000 lbs for cut edge 1st and last piece of 1st bundle, then last piece of every 14,000 lbs for stock edge
50	Raw Material 5	Is there records kept for incoming inspection?	Fail	Verify weight, chemistry and physical condition. No retained data besides checks on inspection form.
51	Raw Material 6	Do CoCs exist for each PO and for minimum 6 months retroactively?	Pass	Able to provide CoCs at any time.
52	Raw Material 7	Is there any retained information on scrap rates? Root cause breakdown of scrap?	Pass	Scrap rates are kept and sorted based on supplier and material/defect type.

Audit Notes