

# Audit Review and Evaluation of Jemison Metals

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#250  
Birmingham, Al 35243

Date of Audit: 10/21/15  
Date of Submittal: 11/13/15

Auditors: Rachel White—Quality Manager

## 1.0 Summary

This internal audit review provided an evaluation of Jemison Metals' current level of conformance to ISO 9001, against the current internal audit schedule. The audit measured how effectively the quality management system is implemented in conformance with the applicable requirements and standards (see audit areas underlined in 2.2 below). **Based upon my review, the QMS is effectively implemented.**

### Audit Detail/Observations/Findings (Detail listed in table at end of report)

4.1-QMS – Document & Data Control – Reviewed following documents during audit; JDM 500 Rev 0 (Part spec audit form);

4.2-QMS – Control of Quality Records- Reviewed hard copy of Quality Manual kept on-site in Birmingham. Did a spot check to ensure all documents were properly identified and contain correct revision levels, signatures and dates.

7.1-Contract Review. – Reviewed Model for Bush Hog (7/27/15)- Documents attached to the model include: Customer purchase order, Contract review documents that used on the award call (including a list of attendees), Part specification documents from Bush Hog

8.2-Internal Auditing- Reviewed Part Spec Audit from CLV plant that was performed on 10/01/15. Job 57409. Audit reviews part specs, material used as well as finished product. Notes made on this audit referencing that slit edge for coil is under gauge; However, referencing ASTM A568 Note 1 Table 4 says that mic'ing is "not less than 5/8" from the edge". Gauge chart from run shows crown and is within spec.

Observation: Q3 Internal audit at Corporate performed during Q4

8.3-Control of Nonconforming Product – MRB calls held of first Friday of every month. During this time quality and materials management discuss and disposition aged material, rejected material and material that is claimed back to the mill.

8.11 Corrective & Preventative Action -- Reviewed CAR 9408 for the Sumter location. CA was filled out completely with relative comments and updates. No issues found.

COP #1 Quotation --See contract review Bush Hog

COP#2 Contract Review /Amendments – Reviewed Bush Hog award model. Found to be complete

COP#3 Product Realization (Production & Shipping) – reviewed part spec for Lakeside part number GG90CN024PCI and compared to purchase order from customer. Lakeside's purchase order references their spec #DRF003 Rev E. Jemison has that spec on file but do not reference any of it in the Stelplan part spec. This was questioned and it

is noted that nothing on their part spec is special or out of the ordinary to Jemison's normal checks.

SOP#1 Training – Reviewed all new employee check lists and training for Tanner Williams. All was found to be filled out correctly.

SOP#2 Purchasing - Review PO CLV-22086-001 which was used to order material for the job 57409. Compared the Jemison's mill order to the Purchase order from the customer. Customer PO 11061. Information matched.

Observation #1: Coil weight on PO different than weight on FIT requisition.

Observation #2: PO referenced wrong requisition and date in remarks. Correct requisition was filed with PO in the paperless system. Actual PO had been copied from previous PO and that information had not been updated.

SOP#3 Control of Monitoring & Test Equipment N/A

Finding: This should be removed from the BHM internal audit as it is not Applicable

MOP#1 Management Review- Read notes from management review meeting held on 11/17/14. Discussed company OTD goal was not met in 2014. Attributed to start up issues in Decatur. After reviewing internal audit results, discussed increasing the frequency of those audits. R. Rowland to find best method to move forward. In addition to this, it was discussed that the activity level on corrective actions should improve.

MOP#2 Continual Improvement – Increased part spec audits and attached to quality intranet is an example of Jemison's efforts toward continual improvement. New Training matrices are also being added for employees.

MOP#3 Analysis of Data - Reviewed Q3 Supplier Scorecard PDF for Severstal as well as master build up sheet for suppliers.

Observation: Error in found in PDF. The scorecards had not yet been sent out and the issue was corrected before the end of the audit.

## 2.0 Overview

### 2.1 Personnel Interviewed (Audit evidence found in the Audit Worksheets)

Rick Rowland Sarah Stanford	
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### 2.2 Audited Requirements

<b>4 Quality Management System</b> 4.1 General Requirements 4.2. Documentation Requirements <b>5 Management Responsibility</b> 5.1 Management Commitment 5.2 Customer Focus 5.3 Quality Policy 5.4 Planning 5.5 Responsibility, Authority and Communication 5.6 Management Review <b>6 Resource Management</b> 6.1 Provision of Resources 6.2 Human Resources 6.3 Infrastructure 6.4 Work Environment	<b>7 Product Realization</b> 7.1 Planning of Product Realization 7.2 Customer-Related Processes 7.3 Design and Development (N/A) 7.4 Purchasing 7.5 Production and Service Provision 7.6 Control of Monitoring and Measuring Devices <b>8 Measurement, Analysis and Improvement</b> 8.1 General 8.2 Monitoring and Measurement 8.3 Control of Nonconforming Product 8.4 Analysis of Data 8.5 Improvement
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### 2.3 APPROVAL/SIGN-OFF

Report Prepared by

Rachel White

Rachel White  
Internal Auditor

Date

