



BLUE BIRD SQ AUDIT REPORT														
No.	Process Confirmation Items	Control Items	○ X Δ	Actual Fact	Level			Score	Cause/Explanation	Countermeasure	Response		SQ	
					H	M	L	9, 3, 1			Who	Date	Judge	F/U
					Level			Score			Response		SQ	
No.	Process Confirmation Items	Control Items	○ X Δ	Actual Fact	H	M	L	9, 3, 1	Cause/Explanation	Countermeasure	Who	Date	Judge	F/U
6	Quality System, ISO9001:2008, Section 7 (Product Realization)	Planning and product realization, Customer related processes, product requirements review, customer communication; design and development planning, inputs, outputs, review, verification, validation, change control.	○	The parts Blue Bird will be purchasing are fabricated parts. Currently Jemison produces similar parts to other customers. Blue Bird is responsible for the part design. Jemison Metals does not design products and have limited project management capabilities. Change control is documented when the change is received from the Customer. Jemison Metalscontinually looks for opportunities to improve their fabrication operations.	H			9					OK	N/A
7	Quality System, ISO9001:2008, Section 7 (Product Realization)	Purchasing process, purchasing information, verification of purchased product.	○	Jemison- Demsey Metals has a supplier management system in place. Items included are: Purchasing conditions and manuals for suppliers conducting business with Jemison. These documents also include Corporate responsibility. Jemison purchase orders specify quantity and quality requirements. Quality requirements for control items are: All purchased Control Items will be verified for conformance to the Purchase Order. Purchased Control Items will not be released for issue until required documentation or test data has been verified. Jemison will reject purchased items at any time that evidence is obtained that the item does not meet specified quality standards. Jemison purchasing is responsible for the selection and qualification of process-related items and value-added suppliers. Each supplier must provide corrective action if/when failures occur. Jemison evaluates supplier performance in terms of quality and workmanship. Key supplier performance reports are generated quarterly. KPI's include, but not limited to: Quality, On-Time Delivery, and Service.	H			9					OK	N/A
8	Quality System, ISO9001:2008, Section 7 (Product Realization)	Control of production and service provision, identification and traceability, customer property, product handling, Calibration control.	Δ	Production is planned based on customer orders. . Product is processed using a work order (production order and/or Tag System) which includes an internal lot # (when required by customer), and provides unique traceability and is maintained through delivery. Work orders are computer generated for each order number that identifies the sequence of operations and lists pertinent data to meet customer requirements. The work order utilizes tag number and job number for traceability and feedback to the system. It's purpose is to identify any processing issues and inspection concerns. Any routing issues are addressed with changes, if required, before the job is processed again. Product identification and inspection status of materials are identified using a work order that accompanies material through the stages of processing and indicates the conformance or nonconformance of product with regard to inspection and tests performed. A "Reject" tag is attached to material that is nonconforming. Only product that passed required inspections is used. Lean manufacturing principles were utilized at Jemison. The lean philosophy is keep it simple- eliminate waste and continuously improve. Controls are in place to assure that the correct material is available at each workstation. Job orders are used for identification. Product identification and traceability were verified throughout the process from raw material to finished product. Operator sign-offs were verified at first piece, in-process inspection points. <u>There is no final inspection for the finished part before shipment to the customer.</u> There is no Blue Bird owned tooling on site. Jamison utilizes their own tooling - there is no customer tooling on site. All equipment is calibrated and maintained utilizing the PM process - <u>however there is limited evidence of a robust maintenance schedule.</u> Measuring equipment is identified per the part to be inspected. Accuracy of each instrument used for final acceptance must be calibrated as required by the instrument manufacturer or by the instrument history. Calibration standards are traceable to the National Institute of Standards & Technology. Inspection tool calibration was current for tools inspected on the production floor and all tools are calibrated per a schedule. Equipment and power supply are properly marked with a calibration label.	H			3			John Foster	2/8/2016		2/9/2016
9	Quality System, ISO9001:2008, Section 8 (Measurement, analysis, and improvement)	Customer Satisfaction, Internal Audit, Process and product Monitoring and measurement, control of non-conforming product, Data analysis, Improvement, Corrective and Preventive Action	○	Jemison is committed to preventing non-conforming material from reaching the customer and ensuring OTD and accuracy. Production is planned based on customer orders, which was verified on site. The company utilizes an 8D format for corrective actions both internally and for customers and suppliers. During the plant tour we saw defined areas for non-conforming material. Non-conforming material dispositions are made after an audit and root cause analysis review. The quality team performs Internal Audits, Process and product monitoring and measurement, controls an dispositions non-conforming product, and follows up on Corrective and Preventive Actions for quality defects. Corrective Actions identify actions and time frames for immediate short-term solutions and long-term solutions. These are followed up with audit verification and validation to ensure implementation of permanent corrective action. Customer information is retained in the compapany database..	H			9					OK	N/A
10	Review of PPAP's	PFMEA RPN values, testing, Quality inspections, PPAP capability	Δ	Jemison only provides Level 3 PPAPs upon request. The Level 3 PPAP example that was reviewed included: ballooned drawing, ISIR, and material cert only. They have Basic Process Flow amd Control Plans. <u>Supplier PPAP experience is limited on fabricated parts.</u>	H			3			John Foster	2/8/2016		2/9/2016
Legend: ○ = No Concerns    Δ = Some Concern    X = Unacceptable														