Audit Date: 12/8/2016				Purpose: BLUE BIRD SQ ABUUE BRED S& AUDIT REPORT									Audit Type					
Addit Date.			12/0/2010	This new supplier on-site audit is to evaluate and approve Jemison Metals for Blue Bird. This assessment will be conducted per the ISO 9001:2008 standard, and Blue Bird requirements. Scope of								Existing Supplier: Yes No				>		
Recommendation			commendation:	visit will include review of Quality, Engineering, Planning and Purchasing items within defined areas of the organization. Blue Bird Purchasing is planning to resource (4) parts to Jemison Metals as										es	No			
•	Approval		х		cost savings initiative. (Upon the approval of this supplier PN 10040609 will be resourced from GH Metals, and PN 10031321, on Metals)	1004	41133,	0007	73339 w	ould be resourced from Machine Tech								
nam m	E BIRD	Temporary Approval Not Approved		to ocnina	on wecas)							ssuer: Date:		azzini				
BLL	E BIRD	Not Approved										Date:		1/3/20	16			
	<u> </u>										-		Blue Bird Rep	resentatives				
	r/In-House	Jemison Metals			Jemison Metals has a current ISO 9001:2008 certification. The facility that will be producing Blue Bird parts is located in Gadsden, AL. This facility can only produce basic fabricated parts such as  Department  Name													
Location:					and bending (no welding available). Jemison has a traceability system for finished products back to the steel mill.		7			endy Fazzini								
Part Number/Model: PN 10040609; 10031321; 10041133;				Supplier Ranking: B.  The SQ team recommends this supplier for approval with a low parts volume. Jemison will need support in completing the Level 3 PPAP, and another trip should be scheduled to their facility upon											bridge			
Part Name: Front crossmember close out; seat washer; switch activator bracket; front angle tie down.				the rece	pt of Blue Bird business.	,				, -,								
	Supplier Rep		Title	Areas fo	r improvement are noted in "blue" font in the body of this report.													
	James St	tephens	Territory Manager															
	John F		Director of Operations															
	Brian S	Smith	Quality Coordinator								-	< Yes	Follow-up Vis	it Required	No			
												163	_		NO			
											Date:	Date: TBD - Pending placement of business						
														ponse SQ				
No.	Process Co	Confirmation Items Control Items		$Ox\Delta$	Δ         Actual Fact         Level   Score   H   M   L   9.3.1         Cause/E					Cause/Explanation	Countern	Countermeasure		Response Who Date Jud		idge F/U		
						Ť		<del>-   `</del>	, 0, 1				******	Duto	ouugo	.,,		
1	Company Histo	ry	Overview of company and customers	0	Jemison Metals is ISO 9001 - 2008 certified. This organization primarily operates in the Steel industry Jabrication business. Jemison has five manufacturing facilities located in the U.S. (Al. OH, S.C. VA) and employs approximately 140 people. Jemison-Demsey has been in business for 29 years. The company is privately owned and is estimated to generate \$59.1 M in annual revenue in 2016. They were awarded the AMM Service Center of the year in 2015. In 2016, Jemison achieved 99.1% OTD, Zero lost time accidents, and Quality Defects goal of <4,000 DPM. The facility that will be producing Blue Bird parts is located in Gadsden, Al This facility is currently operating at 65% capacity during slow seasons. They have a 72° Braner slitting line, 60° Rowe leveling line, (3) Cincinnatt C1-440 lasers, a Trump 5030 8kw laser, and (2) Cincinnatt Maxform press brakes. They offer Hot Rolled, Hot Rolled Pickled & Oiled, Cold Rolled, Galvanized, Galvannelade, Aluminized, and Electro Galvanized products. Customer base is mainly Truck and Agricultural transportation.		М		9						ОК	N/A		
2	Tour of the faci	lities	Verify Parts Identification, Flow, and Dedicated BB Location.	$\triangle$	The tour of the 96,000 sq ft Gadsden AL facility included the review of all processes from Receiving to Shipping. The Quality management system implementation was not very evident upon entering the facility. Quality policies were not posted. The area was organized and well lit, with separate areas for receiving, shipping, and a non-conformance area. The forty year-old building appearated to be in good condition. The supplier is currently repainting the floors to improve the appearance and efficiency. There appeared to be more waste materials present at some work stations than others, but overall the facility was clean and tidy. All materials received goes through a receiving inspection program and internal tags are created before it is placed in inventory. Items are picked for each customer order per the production schedule. Each item is scanned to the order if and then then the order is scanned to the manufacturing equipment. Operators are required to record all measurements on the drawing and get a secondary sign off on all new parts. Operator inspection frequency is 1/20 pieces unless specified by customers. If all inspections are recorded in the work order folder. There is no final inspection for the finished part before shipment to the customers. All finished goods are staged in one area, but not separated by customers. They have a system in place for order pulls and shipments. All finished goods have tags on them with a barcode system that provides traceability. Barcodes on the final product ensure traceability, of the fabricated part including each process and operator back to the steel mill where the material was purchased.		М		3				John Foster	2/8/2016		2/9/2016		
3		, ISO9001:2008, lity Management	Quality Policy, Quality Manual, Documented Procedures, Document Control, Records Control Work Instructions; ISO/TS Certification	$\triangle$	Jemison Metals currently holds ISO 9001:2008, certification number 2015/1205 from Ampulus Global Associates Inc. It was obtained on December 5, 2015 and its valid until September 5, 2018, Jemison has a quality manual this posted on their intranet for employees to access. Monthly DPPM reports are posted in the plant, did not see any quality policies posted. DPPM goal 4:000, Actual was 4,235. Work instructions are provided in the work order folder which travels with the parts from the beginning to the end of the process. Procedures are documented, records are kept for inspections from incoming inspection to final testing and shipping processes. Documents are retained per ISO guidelines. There are some concerns with DPPM goals not being met.	н			3				John Foster	2/8/2016		2/9/2016		
4	Quality System Section 5 (Man Responsibility)	, ISO9001:2008, agement	Management Commitment, Customer focus, Quality policy, Planning, Communication, Management review	0	Jemison management/supervisors hold weekly meetings to discuss quality, safety and manufacturing items. The primary customer focuses are quality, cost and on-time delivery. Strategy and targets are cascaded down throughout the organization, and reviewed during regular intervals dependent on priority (Annually, Monthly, Weekly, Daily). The company's focus is to resolve each customer complaint quickly by initiating a "case," (similar to 8D) as determined by the Quality Management Representative. Customer information is retained in information systems software.	н			9						ОК	N/A		
5		, ISO9001:2008, burce Management)	Provision of resources, Human resources, Competence, Training, and awareness, Infrastructure, Work Environment	0	The Human Resources department is located on site. There is an electronic Employee training matrix, along with training procedures and job descriptions. Work instructions are available for all of the assembly processes, including product receiving, production, and shipping. Some employees are cross-trained to use different equipment. The facility is well organized with good lighting, well maintainmed, and close to the inerstate.	н			9						ок	N/A		
_egenc	i: = No	Concerns	= Some Concern	Х	= Unacceptable													

No.	Process Confirmation Items	Control Items	ОхД	BLUE BIRD SQ AUDIT REPORT		Level		Score	Cause/Explanation	Countermeasure	Response			SQ	
		CONTROL HOME	<b>Ο</b> Λ.	/ Journal Park	H M Level				Gause/Explanation	oountormouour o	Who	Date	Judge		
No.	Process Confirmation Items	Control Items	ОхД	Actual Fact	н			Score 9, 3, 1	Cause/Explanation	Countermeasure	Resp	onse Date	Judge	SQ 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.	0	The parts Blue Bird will be purchasing are fabricated parts. Currenity Jemison produces similar parts to other customers. Blue Bird is responsibly 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 improvement their fabrication operations.	Н			9					ОК	N/A	
7	Quality System, ISO9001:2008, Section 7 (Product Realization)	Purchasing process, purchasing information, verification of purchased product.	0	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.	Н			9					ОК	N/A	
8	Quality System, ISO9001:2008, Section 7 (Product Realization)	Control of production and service provision, identification and traceability, usomer property, product handling, Calibration control.	_	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 itss 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 infocates 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 inclined 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. There is no flinal inspection for the finished part before shipment to the customer. There is no flinal mispection for the finished part before shipment of the customer. There is no flinal inspection for the finished part before shipment of the customer. There is no flinal inspection for the finished part before shipment of the customer. There is no flinal inspection for the finished part before shipment is calibrated and maintained utilizing the PM process - however there is limited evidence of a robust maintaneau scrutent for	н			з			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	0	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 comapany database.	н			9					ОК	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. Supplier PPAP experience is limited on fabricated parts.	н			3			John Foster	2/8/2016		2/9/2016	
Legeno	Legend: _ = No Concerns														

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