

# **Audit Review and Evaluations of JEMISON METALS**

**3001 Hickory Street  
Gadsden, AL 35954**

Dates of Audit: 9.29.21

Auditors: Brian P. Smith – Quality Manager-Central Region

## 1.0 Summary

This internal audit review provided an evaluation of Jemison's current level of conformance to the ISO 9001:2015, 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. **Based upon our review, the QMS is effectively implemented.**

### Audit Detail/Observations/Findings

#### 7.5 – Documented Information

The following forms and documents were verified during the audit:

GAD009 9.18.17 Rev Level 2 in Receiving, GAD-VA-009 5.7.20 Rev 0 at laser, JDM-F-014 at laser, GAD-LA-001 5.1.19 Rev 2, Jemison created part print HDBBZ1984 Rev B. GAD-VA-010 2.28.20 Rev 0 in shipping.

#### 7 Support

Employees appeared competent and well trained. Adequate resources (gauges, safety equipment, operating equipment, and environment) were observed during the audit.

#### 7.2 Competence

Spoke with Jonathan Mathis in receiving. He was able to complete inspections and correctly fill out the inbound inspection report GAD009 for coils. However, he was not completely trained on receiving sheet material. He took his information to a competent employee (Mark Clough) who entered the required information into Stelplan and printed the tag to be applied. Russ McCoy was interviewed as the operator at laser 4 as well as William Jenkins and Mike Cantrell in shipping department. All were clearly identified on the Gadsden training status matrix.

- OFI 1: Train Jonathan Mathis on how to completely receive sheet items.

#### 8.2 Requirements for products and services

Tarter PO# 40548-TIC was sent on 9.13.21 with a due date of 9.16.21 to Vicki Fontcuberta. Sales order 114182 was entered by Vicki and was shipped on 9.30.21 on BOL 104355.

#### 8.4 Control of externally provided processes, products and services

Sheet bundle 72703 was received by Jonathan with the aid of Mark Clough under receiver number 56024 from Gadsden PO number 19995.

The bucket in FIT CRC/14/CSB/48.000 met customer requirements.

## 8.5-Production & Service Provisions

Production job number 145999 for Tarter fab was observed on the laser 4. Quality checks were being performed and documented in accordance with the requirements of the Jemison part print and laser operator procedure GAD-LA-001. Parts met all dimensional requirements. Packaging was correct and Wip material tag was available and matched job paperwork.

BOL 104366 for Blue Bird was reviewed in shipping during shipment preparations. Parts were correctly packaged and identified.

- **Minor 1: Shipping procedure (GAD-SH-001 12.14.20 rev 0) states that there should be two signatures from two different shippers on the BOL. Each signature indicates material was verified to be correct and match the loading order. There was only one signature on the Blue Bird BOL that was observed.**

## 7.1.3 Infrastructure

Preventive Maintenance: Wayne Angle and Chris Ellis are the Maintenance team. We specifically investigated the PM records for laser 6. All documentation was available electronically in the paperless folder.

## 7.1.5 Monitoring and Measuring Resources

The following gauges were verified to be calibrated in compliance with calibration records:

Receiving:

Micrometer serial number 2088 August 2021 calibration due August 2022

Tape Measure serial number T3060 March 2021 due March 2022

Laser 4:

Micrometer serial number M009 November 2020 calibration due November 2021

Tape Measure serial number TM005 November 2020 calibration due November 2021

Caliper serial number C007 July 2021 calibration due July 2022

## 8.7 Control of Nonconforming Product

Nonconforming area had tag 294390 for press brake part 113-6446-007. Remarks on tag stated parts were formed out of tolerance.

## 10.2 Nonconformity and Corrective Action

Corrective Action 21616 reviewed. Randal Garner at the slitter banding line was able to describe the tag weight issue. He elaborated on how slit coils are weighed and tags printed with the actual weights. Quality was also present to perform verifications and all printed tag weights were accurate.

## 10. Improvement

Additional press brakes and lasers being added to Gadsden facility.

### Observations and findings from previous internal audit

Observations from previous internal audit:

1. Reviewed: OBS1 – Ship procedure was available on quality intranet.

## 2.0 Overview

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

Mike Cantrell – Shipping Scott Houk – Shipping William Jenkins – Shipping Jonathan Mathis – Receiving Russ McCoy – Laser 4 operator	Wayne Angle – Maintenance Chris Ellis – Maintenance Vicki Fontcuberta – Inside Sales Randal Garner – Slitter banding line.
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### 2.2 Audited Requirements

<p><b>4 Context of the Organization</b></p> <p>4.4 Quality Management System and its processes</p> <p><b>5 Leadership</b></p> <p>5.1 Leadership and commitment</p> <p>5.1.2 Customer Focus</p> <p>5.2 Policy</p> <p>5.6 Management review</p> <p><b>6 Planning</b></p> <p><b>7 Support</b></p> <p>7.1.1 General</p> <p>7.2 Competence</p> <p>7.1.3 Infrastructure</p> <p>7.1.4 Environment for the operation of processes</p> <p>7.1.5 Monitoring and measuring resources</p> <p>7.5 Documented information</p>	<p><b>8 Operation</b></p> <p>8.1 Operational planning and control</p> <p>8.2 Requirements for products and services</p> <p>8.3 Design and development of products and services (N/A)</p> <p>8.4 Control of externally provided processes, products and services</p> <p>8.5 Production and service provision</p> <p>8.7 Control of nonconforming outputs</p> <p><b>9 Performance evaluation</b></p> <p>9.1 Monitoring, measurement, analysis and evaluation</p> <p>9.1.1 General</p> <p>9.1.3 Analysis and evaluation</p> <p><b>10 Improvement</b></p> <p>10.2 Nonconformity and corrective action</p>
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## 2.3 APPROVAL/SIGN-OFF

Report Prepared by Brian P. Smith

Date 9.29.21

Nonconforming Corrective Action Report (CAR) for Jemison Metals

<b>CAR #</b>	<b>ISO 9001: 2015 Clause / Sub-Clause</b>	<b>Findings/Requirements</b>	<b>Observation</b>	<b>Minor</b>	<b>Major</b>
OF1	7.2	Train Jonathan Mathis to completely receive sheet material.	OFI		
MF1	8.5	Shipping procedure (GAD-SH-001 12.14.20 rev 0) state that there should be two signatures from two different shippers on the BOL. Each signature indicates material was verified to be correct and match the loading order.		X	