

# Audit Review and Evaluation of Jemison Metals

3800 Colonnade Parkway, Suite 250  
Birmingham, AL 35242

Date of Audit: 12/14/20

Auditor(s): Brian P Smith – Quality Manager-Central Division

## 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.**

### 6 Planning

QMP 6.3 Planning of Change. Date 8/21/18 Rev A

Scope that covers QMS changes that could affect the integrity of the QMS, resources, responsibilities and authorities. References QMP 8.4 New Supplier Evaluation & Approval based on the scope requirements and Section 5.1 reference to modifications of raw material providers. Reviewed most recently completed Process change form JDM-F-200 8.30.18 Rev 1 for a permanent change to open new fabrication facility to support new business. It was fully completed 11.1.19.

### 7 Support

7.5 Documented Information

QMP 7.5 Documented Information, date 11/1/18 Rev B Reviewed.

Reviewed JDM-F-200 for locations and revision level and found the locations to be a previous revision.

- OBS1: PCF form JDM-F-200 (8/30/18) Rev 1 is not the correct revision within each plant site quality intranet - (JDM-F-200 7/20/18 Rev 0).

### 8 Operation

QMP 8.1 Award Review, Date 7/20/18 Rev Original

Reviewed contract review for Freight Car America 4.7.20 for 25 fabrication parts.

All appropriate company functions were represented, and contract review documents were available on call invite.

(Document copy in audit evidence)

QMP 8.4 New Supplier Evaluation and Review, Date 7/09/18 Rev Original,

Scope covers new Supplier that that can affect Jemison's product Quality.

QMP 8.4 Most recent supplier evaluation checklist (JDM-F-012 8.30.18 Rev 1) was unconditionally approved and completed 2.12.19 for Hyundai Steel-Korea. Form was filled out in entirety at the current revision levels.

## 8.7 Control of Nonconforming Product

QMP 8.7 Control of nonconforming outputs. MRB meets first available Friday of each month, via conference call, to insure appropriate review and disposition of all nonconforming product. Disposition is a function of the QMR and Material Management. The MRB from 12/11/20 was reviewed. The 14 day or older reject warehouse is up 24% since previous month but down 55% from the highpoint in January. The mill claim warehouse has dropped 24% since previous month and overall down 73% since the highest month in July.

(Evidence available in electronic copy)

## **9 Performance Evaluation**

### 9.2 Internal Audits

Internal and Process audits were reviewed. YTD totals are as follows

CLV- 1 Internal

DEC-12 Process, 1 Internal

GAD-18 Process, 1 Internal

LYN-1 Process, 1 Internal

SMT-4 Process, 1 Internal

Corporate-1 Internal audit 11/13/19

1. Reviewed: OBS1 – After reviewing it was decided that this checkoff will not be controlled by quality.

## **10 Improvement**

### 10.2 Nonconformity and corrective action

No corrective actions at corporate since last audit.

## **COP 1 Sales, Quotation, (Contract/Review)**

Reviewed contract review for Freight Car America 4.7.20 for 25 fabrication parts.

All appropriate company functions were represented, and contract review documents were available on call invite.

(Document copy in audit evidence)

## **COP 2 Production**

On time delivery, and DPPM reports for the last year reviewed.

On time delivery YTD percentages as follows

JM companywide 92.38%

CLV: 98.96%

GAD/DEC: 81.02%

*GAD FAB: OCT 81.77% and NOV 85.37%*

LYN: 96.14%

*LYN FAB: OCT 74.88% and NOV 91.07%*

SMT: 94.76%

SM2: 68.40

Goal 98%

(Document copy in audit evidence)

*“Fabrication has been the main drag on company OTD performance. We began reporting GAD & LYN-FAB separately in Q4 of 2019 to better understand what’s occurring. We will continue to report/monitor FAB separately, although it is combined into the above reports. The main causes of the low OTD numbers for Fabrication are related to:*

*1) Capacity Planning/Visibility, 2) Machine Downtime, 3) Strong Fab Growth”*

DPPM YTD Goal <3,900

JM companywide 2,604

CLV: 5424

GAD: 2244

DEC: 1419

LYN: 2851

SMT: 2344

SM2: 3044

Goal <3,900

(Document copy in audit evidence)

## **SOP 1 Training**

New hire training checkoff for Nick Barton reviewed.

Sign offer letter, Acknowledgement of receiving new hire package and reading Jemison Metals Policies and Documents were all checked off as well as job appropriate new hire training. Dated 8/17/20.

## **SOP 2 Purchasing**

Purchasing process reviewed. Reviewed coil 1008027-5 purchased for Freight Car on PO GAD 17196-1, pulled all documentation (req, PO, B/L) from paperless system. All required documentation available in system. Supplier Performance measured by 3rd quarter Supplier Scorecard.  
(Document copy in audit evidence)

## **SOP 3 Control of Monitoring & Test Equipment**

No Monitoring or Test Equipment used at Corporate Office.

## **MOP 1 Management Review**

11/25/19 Management Review Minutes reviewed. Found to be in conformance.

Pages reviewed:

Requirements.  
Status of actions from Previous reviews  
Summary of major changes ISO9001:2015  
Corrective and Preventive Actions  
Customer Feedback  
(Document available in electronic copy)

2020 Management Review scheduled for early January 2021.

## **2.0 Overview**

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

Tina Brandt	Rick Rowland
Frank Mareno	

## 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 Approvals/Sign Off

Brian P Smith  
Lead Auditor/QM

Date **12/14/20**

Nonconforming Corrective Action Report (CAR) for Jemison  
Metals

<b>CAR #</b>	<b>ISO 9001: 2015 Clause / Sub-Clause</b>	<b>Findings/Requirements</b>	<b>Observati on</b>	<b>Mino r</b>	<b>Major</b>
OBS1	7.5	PCF form JDM-F-200 (8/30/18) Rev 1 is not the correct revision within each plant site quality intranet - (JDM-F-200 7/20/18 Rev 0).	X		