

Audit Review and Evaluation of Jemison Metals

3800 Colonnade Parkway, Suite 250
Birmingham, AL 35242

Date of Audit: 12/28/2017

Auditor(s): Patrick Macias – Quality Manager-Eastern 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.**

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

Observation 1-Master listing of Hardcopy Controlled Documents Issue date and Revision on documents were not up to date and did not match Quality Manual Table of Contents

2.0 Overview

2.1 Personnel Interviewed (Audit evidence available in either hard, supplied, or electronic copies)

Rick Rowland Sam Curtis Brandy Slonneger	
--	--

2.2 Approvals/Sign Off

Patrick Macias
Auditor

Date 12/28/17

4 Quality Management System

4.1 Document and Data Control

QMP 4.1 Reviewed. Found that in the Master listing of Hardcopy Controlled Documents revision level and Issue date on 4.1 listing were not up to date. (OBS-1). All revision levels and issue dates on the 4.1 document are up to date.
(Document copy in audit evidence)

4.2 Control of Quality Records

QMP 4.2 Reviewed. Found that in the Master listing of Hardcopy Controlled Documents revision level and Issue date on 4.2 listing were not up to date. (OBS-1). All revision levels and issue dates on the 4.2 document are up to date.
(Document copy in audit evidence)

7 Product Realization

QMP 7.1, COP 2 Contract Review

QMP 7.1 Reviewed. The contract review for JB Stamping, on 12/27/17 was reviewed. Fab award for 100,000 .375" washers. All appropriate company functions were represented, and contract review documents were available on call invite. Notes from call also documented on schedule invite.
(Document copy in audit evidence)

8 Measurement, analysis and improvement

8.2 Internal Audits

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

CLV-18

DEC-22

GAD-17

LYN-22 (12/6/17 Process Audit, Job 5236 Cus. Nordfab reviewed)

SMT-38 (12/21/17 Process Audit, Job 68250 Cus. Altec reviewed)

Both audits reviewed found to be complete and in conformance
(Document copy in audit evidence)

8.3 Control of Nonconforming Product

MRB meets first available Friday of each month, via conference call, to ensure appropriate review and disposition of all nonconforming product. Disposition is a function of the QMR and Material Management. The MRB from 12/15/17 was reviewed, a large drop in the 14 day or older reject warehouse, the majority of this due to the DRJ

warehouse resolutions. Mill claim warehouse over 14 days was elevated mostly due to a Metal One WN discoloration issue.
(Evidence available in electronic copy)

8.11 Corrective and Preventive Action

Reviewed observations from last surveillance audit: 6/5/2017 BHM OBS 1: The organization should review Stel-Plan ASL to ensure current requirements are reflected (i.e. Carbonite).

ASL reviewed and found up to date, Carbonite added to ASL.
(Evidence available in Stelplan)

COP 1 Quotation

Reviewed request for quote from JB Stamping 12/27/17 contract review call. Information complete and in conformance
(Document copy in audit evidence)

COP 3 Production and Shipping

On time delivery reports for the last year reviewed.

YTD averages as follows

JM companywide 95.90%

CLV 98.40%

GAD/DEC 91.18%

LYN 98.69%

SMT 98.31%

Goal 98%

June through October fabrication delays in GAD lowered the average under the target YTD for companywide and GAD/DEC. All other locations have met target YTD.

(Document copy in audit evidence)

SOP 1 Training

On the job training documents moved to public drive. 12/18/17 OJT form for training on LYN FAB 001 Fabrication First Article Inspection document reviewed.

(Document copy in audit evidence)

SOP 2 Purchasing

Purchasing process reviewed, coil NB56526, PO SMT 21218-1. For bucket GNC 19C CB40NO 60". Met standards for SOP 2. Supplier Performance measured by YTD 2017 claim Summary.

(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

12/18/17 Management Review Minutes reviewed. Found to be in conformance.

(Document available in electronic copy)

MOP 2 Continual Improvement

Reviewed continual improvement projects are as follows:

Replaced lights in Sumter facility, completed July 2017. Improving visibility in both plant and office areas.

Installed Fiber Optic Laser and Press Brake in Lynchburg facility, Laser installation completed August 2017, Press Brake installation completed October 2017. Improving product line and opening up new business with both new and existing customers.

MOP 3 Analysis of Data

YTD data recorded and monitored. Reviewed YTD DPPM's (met internal target companywide), YTD On time Delivery (met internal target in three of four recorded locations), and Supplier performance.

(Document copy in audit evidence)

4.1 and 4.2 - ~~3.1~~

Quality Manual

Issuance and maintenance of the Quality Manual is the responsibility of the Quality Management Representative (QMR) and will be reviewed and updated, as appropriate, to ensure that it reflects the current status of our quality manual.

Revision status is illustrated on each page of the manual via revision date and level. Monitoring the accuracy of the revision status is the responsibility of the QMR. The approval of all revisions is the responsibility of the QMR and signatories on the approval page of the Quality Manual.

Master Copy of the Quality Manual is retained by the QMR. A controlled hardcopy (with signatures) resides with the QMR for registrar purposes.

Distribution - The Quality System is available electronically.

Authorization of the Quality Manual is the responsibility of the QMR and signatories on the approval page of the Quality Manual.

[Back to Corporate](#)

Table of Contents

<u>Title</u>	<u>Contents</u>	<u>Type</u>	<u>Issue Date</u>	<u>Revision</u>
<u>Introduction</u>	Signature Page, Exclusions, Facilities	Level 1	2/13/17	H
<u>4 Quality Management System Requirements</u>	QMS, Document Hierarchy, Diagram, Records	Level 1	11/09/09	Original
<u>5 Management Responsibility</u>	Commitment, Quality Policy, Planning, Resources, Responsibility & Authority, Management Representative, Management Review, Organizational Chart	Level 1	09/20/16	H
<u>6 Resource Management</u>	Provision of Resources, HR, Facilities, Maintenance	Level 1	11/04/11	A
<u>7 Product and/or Service Realization</u>	Planning, Purchasing, Purchased Material Flowchart, Production & Service Operations, Process Control, Control of Measuring & Monitoring Equipment	Level 1	02/13/17	D
<u>8 Measurement, Analysis, & Improvement</u>	Planning, Measurement & Monitoring, Control of Nonconformity, Analysis of Data, Improvement, Corrective & Preventive Action Flowchart	Level 1	11/05/12	B
<u>Miscellaneous</u>	List of QMPs, Interaction of Processes, QMS Flow Diagram	Level 1	11/09/09	Original
<u>QMP 4.1 Document & Data Control</u>		Level 2	9/26/16	D
<u>QMP 4.2 Control of Quality Records</u>		Level 2	9/26/16	C
<u>QMP 7.1 Contract Review</u>	Scope, Responsibilities, Flowchart	Level 2	2/12/16	D
<u>QMP 8.2 Internal Auditing</u>		Level 2	08/06/10	A
<u>QMP 8.3 Control of Nonconforming Product</u>		Level 2	08/06/10	A
<u>QMP 8.11 Corrective & Preventive Action</u>		Level 2	10/09/12	C
<u>COP #1 Quotation</u>	Diagram	Level 2	08/06/10	A
<u>COP #2 Contract Review</u>	Diagram	Level 2	08/06/10	A
<u>COP #3 Product Realization</u>	Diagram	Level 2	08/06/10	A
<u>SOP #1 Training</u>	Diagram	Level 2	08/06/10	A
<u>SOP #2 Purchasing</u>	Diagram	Level 2	10/28/12	B
<u>SOP #3 Control of Monitoring & Test Equipment</u>	Diagram	Level 2	08/06/10	A
<u>MOP #1 Management Review</u>	Diagram	Level 2	08/06/10	A
<u>MOP #2 Continual Improvement</u>	Diagram	Level 2	08/06/10	A
<u>MOP #3 Analysis of Data</u>	Diagram	Level 2	08/06/10	A



4.1 and 4.2

Master Listing of Hardcopy Controlled Documents

Master List of Hardcopy Controlled Documents					
Document Number	Document Name	Location	Original Issue Date	Revision Level	Revision Date
Level I	Introduction	Electronic, 1 Hardcopy at Corporate with QMR	11/09/09	G	09/20/2016
	Section 4 Quality Management Requirements	Electronic, 1 Hardcopy at Corporate with QMR	11/09/09	Original	11/9/2009
	Section 5 Management Responsibility	Electronic, 1 Hardcopy at Corporate with QMR	11/09/09	H	09/20/2016
	Section 6 Resource Management	Electronic, 1 Hardcopy at Corporate with QMR	11/09/09	A	11/4/2011
	Section 7 Product and/or Service Realization	Electronic, 1 Hardcopy at Corporate with QMR	11/09/09	B	11/5/2012
	Section 8 Measurement, Analysis & Improvement	Electronic, 1 Hardcopy at Corporate with QMR	11/09/09	B	11/5/2012
	Miscellaneous	Electronic, 1 Hardcopy at Corporate with QMR	11/09/09	Original	11/9/2009
Level II	QMP 4.1 Document & Data Control	Electronic, 1 Hardcopy at Corporate with QMR	11/09/09	C	11/16/2015
	QMP 4.2 Control of Quality Records	Electronic, 1 Hardcopy at Corporate with QMR	11/09/09	B	11/16/2015
	QMP 7.1 Contract Review	Electronic, 1 Hardcopy at Corporate with QMR	11/09/09	C	11/4/2011
	QMP 8.2 Internal Auditing	Electronic, 1 Hardcopy at Corporate with QMR	11/09/09	A	8/6/2010
	QMP 8.3 Control of Nonconforming Product	Electronic, 1 Hardcopy at Corporate with QMR	11/09/09	A	8/6/2010
	QMP 8.11 Corrective & Preventive Action	Electronic, 1 Hardcopy at Corporate with QMR	11/09/09	C	10/9/2012
Process Maps					
COP 1	Quotation	Electronic, 1 Hardcopy at Corporate with QMR	11/09/09	A	8/6/2010
COP 2	Contract Review/Amendments	Electronic, 1 Hardcopy at Corporate with QMR	11/09/09	A	8/6/2010
COP 3	Production	Electronic, 1 Hardcopy at Corporate with QMR	11/09/09	A	8/6/2010
SOP 1	Training	Electronic, 1 Hardcopy at Corporate with QMR	11/09/09	A	8/6/2010
SOP 2	Purchasing	Electronic, 1 Hardcopy at Corporate with QMR	11/09/09	B	10/28/12
SOP 3	Measuring and Test Equipment	Electronic, 1 Hardcopy at Corporate with QMR	11/09/09	A	8/6/2010
MOP 1	Management Review	Electronic, 1 Hardcopy at Corporate with QMR	11/09/09	A	8/6/2010
MOP 2	Continual Improvement	Electronic, 1 Hardcopy at Corporate with QMR	11/09/09	A	8/6/2010
MOP 3	Analysis of Data	Electronic, 1 Hardcopy at Corporate with QMR	11/09/09	A	8/6/2010
Level IV	Quality Forms (See Listing)				
JDM 200	Quality Policy	SMT (Time Clock, Breakroom); CLV (Main Office, Shipping Office, Information Boards (Paxson, Banding Line, RBI-1, Loopco, RBI-2), Receiving Desk; GAD (Breakroom, Main Office, Plasma); DEC (Bulletin Board), LYN (QA Board-Timeclock, Shop Breakroom, LRB Operator, Pick & Pull Station, LCT Operator, Office Copy Machine, Plant Mgr Office)	05/15/10	0	5/15/2010
FQA013	Rockwell Conversion Table	SMT - Lab	02/16/01	0	2/16/2001
JDM-VA-001	JD Skid Types	CLV (K. Manka, Office, R. Richards, Pallet Build Area); SMT (Redbud, Woodpile); DEC (Operator Platform, Packaging, Woodpile), LYN (Production Planner), GAD (Rowe)	08/31/10	0	8/31/2010
JDM-VA-005	Banding Line Inspection Visual Aid	CLV Banding Line	05/02/16	0	05/02/16
<div> <div>Revision Number</div> <div>Original</div> </div> <div> <div>Document Change Description</div> </div> <div> <div>Date</div> <div>5-25-2012</div> </div>					

[Back to Quality Intranet Home](#)

7.1 - COP 2

JB Stamping Award Review

Attendees: Bill Hornfeck, Randy Richards, Sam Curtis, Jim Gagnon, Zach Delp, Bill Huffman, Christina Cornelius

- JB Stamping Fab Customer number to be created
- Part spec to be created, add remarks regarding release quantity is 6200-6500 pcs, product of 2 master sheets (.375 x 60 x 120)
- Packaging to be heavy duty boxes
- Zach to review Jemison Print & DXF that are created and in CAD folder
- 10 pcs trial. Zach will perform first article paperwork.
- Can we cut with Nitrogen to cover note 2 on customer print. Bill Huffman to discuss with John Foster. We will try 10 pcs with Nitrogen. If successful, we will proceed. If not, we will cut 10 pcs with oxygen and provide to the customer as an option without cleaning off laser edge slag for approval. If not, ok, we can back away from this business.

h5Ll

7.1 - Cor² - Cor¹

 Φ



Internal Audits - Cleveland

<u>12/20/17 #1</u>	<u>8/30/17 #2</u>	<u>8/30/17 #1</u>	<u>7/31/17</u>	<u>12/20/17 #2</u>
<u>6/29/17</u>	<u>6/28/17</u>	<u>5/31/17 #2</u>	<u>5/31/17 #1</u>	<u>7/27/17</u>
<u>4/25/17</u>	<u>3/30/17 #2</u>	<u>3/30/17 #1</u>	<u>3/29/17*</u>	<u>4/26/17</u>
<u>1/31/17</u>	<u>1/30/17</u>	<u>12/21/16</u>	<u>12/20/16</u>	<u>2/28/17</u>
<u>10/28/16</u>	<u>9/30/16 #2</u>	<u>9/30/16 #1</u>	<u>8/12/16</u>	<u>10/31/16</u>
<u>7/26/16</u>	<u>6/29/16</u>	<u>6/28/16</u>	<u>5/27/16</u>	<u>7/29/16</u>
<u>4/28/16</u>	<u>4/26/16</u>	<u>3/30/16</u>	<u>2/26/16</u>	<u>5/25/16</u>
<u>1/15/16</u>	<u>12/18/15</u>	<u>11/24/15</u>	<u>11/12/15</u>	<u>1/29/16</u>
<u>11/4/15</u>	<u>10/30/15</u>	<u>10/23/15</u>	<u>10/16/15</u>	<u>11/4/15*</u>
<u>10/1/15</u>	<u>9/25/15</u>	<u>9/14/15</u>	<u>9/11/15</u>	<u>10/9/15</u>
<u>8/28/15</u>	<u>8/17/15</u>	<u>8/14/15</u>	<u>7/31/15</u>	<u>9/4/15</u>
<u>7/10/15</u>	<u>7/2/15</u>	<u>6/26/15</u>	<u>6/19/15</u>	<u>7/16/15</u>
<u>6/5/15</u>	<u>5/29/15</u>	<u>5/22/15</u>	<u>5/7/15</u>	<u>6/12/15</u>
<u>4/17/15</u>	<u>4/10/15</u>	<u>3/27/15</u>	<u>3/20/15</u>	<u>5/1/15</u>
<u>3/6/15</u>	<u>2/27/15</u>	<u>2/20/15</u>	<u>2/13/15</u>	<u>3/13/15</u>

* Denotes Full Audit vs
Process

[Back to Corporate](#)

8.2



Internal Audits - Decatur

<u>8/30/17 #2</u>	<u>12/27/17 #2</u>	<u>12/27/17 #1</u>	<u>10/30/17</u>	<u>9/20/17</u>
<u>4/24/17 #2</u>	<u>8/30/17 #1</u>	<u>5/25/17</u>	<u>5/12/17</u>	<u>5/11/17</u>
<u>3/21/17*</u>	<u>4/24/17 #1</u>	<u>4/21/17</u>	<u>4/19/17</u>	<u>4/5/17</u>
<u>1/30/17</u>	<u>2/27/17</u>	<u>2/24/17</u>	<u>2/21/17</u>	<u>2/20/17</u>
<u>12/8/16</u>	<u>1/27/17</u>	<u>1/11/17 (3 Shipping Audits)</u>	<u>12/20/16</u>	<u>12/12/16</u>
<u>10/13/16 #2</u>	<u>11/29/16</u>	<u>11/8/16</u>	<u>10/21/16</u>	<u>10/13/16 #3</u>
<u>6/22/16 & 6/30/16</u>	<u>10/13/16 #1</u>	<u>9/26/16</u>	<u>8/9/16 & 8/31/16</u>	<u>7/14/16 & 7/28/16</u>
<u>8/18/15</u>	<u>4/28/16 (2)</u>	<u>11/16/15</u>	<u>11/16/15*</u>	<u>10/20/15</u>
<u>5/5/15</u>	<u>8/4/15</u>	<u>7/29/15</u>	<u>6/15/15</u>	<u>5/20/15</u>
	<u>3/30/15</u>	<u>3/19/15</u>	<u>3/10/15</u>	<u>3/3/15</u>

* Denotes Full Audit vs Process

[Back to Corporate](#)

8.2



Internal Audits - Gadsden

<u>10/2/17</u>	<u>9/5/17</u>	<u>8/29/17</u>	<u>12/12/17</u>	<u>11/2/17</u>
<u>6/1/17</u>	<u>5/15/17</u>	<u>5/5/17</u>	<u>6/30/17</u>	<u>6/19/17</u>
<u>3/22/17*</u>	<u>3/15/17</u>	<u>2/27/17</u>	<u>4/20/17</u>	<u>3/31/17</u>
<u>1/23/17</u>	<u>12/9/16 #2</u>	<u>12/9/16 #1</u>	<u>2/1/17</u>	<u>1/25/17</u>
<u>10/26/16</u>	<u>10/10/16</u>	<u>9/30/16</u>	<u>11/11/16</u>	<u>11/9/16</u>
<u>7/29/16</u>	<u>6/21/16 & 6/23/16</u>	<u>5/2/16 & 5/18/16</u>	<u>9/16/16</u>	<u>8/11/16 & 8/30/16</u>
<u>3/30/16</u>	<u>1/22/16*</u>	<u>11/10/15*</u>	<u>4/6/16 & 4/29/16</u>	<u>3/31/16</u>
<u>9/29/15</u>	<u>5/21/15</u>	<u>3/18/15</u>	<u>10/28/15</u>	<u>10/8/15</u>
			<u>3/11/15 #2</u>	<u>3/11/15 #1</u>

* Denotes Full Audit vs
Process

[Back to Corporate](#)



Internal Audits - Lynchburg

<u>10/12/17</u>	<u>10/11/17</u>	<u>9/28/17 #2</u>	<u>9/28/17 #1</u>	<u>12/6/17</u>
<u>9/5/17 #1</u>	<u>7/28/17 #2</u>	<u>7/28/17 #1</u>	<u>6/26/17</u>	<u>9/5/17 #2</u>
<u>6/1/17 #2</u>	<u>6/1/17 #1</u>	<u>5-1-17 #2</u>	<u>5-1-17 #1</u>	<u>6/21/17</u>
<u>3-31-17 #1</u>	<u>2-28-17</u>	<u>2-23-17*</u>	<u>2-20-17</u>	<u>3-31-17 #2</u>
<u>1-20-17</u>	<u>12-14-16</u>	<u>9-1-16*</u>	<u>6-14-16</u>	<u>2-1-17</u>
* Denotes Full Audit vs Process				

[Back to Corporate](#)

8.2

Process/Product Audit Checklist

Cust #: <u>3037</u>		Customer: <u>Nordfab</u>		GRP/Size/GRD/Width: <u>GRS CB60CD-.051"</u>	
PWC: <u>LRB</u>		W/O#: <u>5236</u>		Date: <u>12/6/17</u> Part #(s): <u>351M-0918-1PM000</u> Auditor: <u>Z. Delp, P. Macias</u>	
Gauge Range: <u>.046"-.056"</u>		Actual Gauge: <u>.051"</u>		Width Range: <u>60"→60.25"</u> Width Actual: <u>60.161"</u>	
Length Range: <u>27.814"→27.854"</u>		Length Actual: <u>27.839"</u>		Other: <u>0→.03943"</u> Other Actual: <u>.009"</u>	
Other: <u>n/a</u>		Other Actual: <u>n/a</u>		Other: <u>n/a</u> Other Actual: <u>n/a</u>	
Item	YES	NO	N/A	Comments/Action Taken (Required for NO)	
Process Inspection Sheets filled out according to <u>frequency</u> and <u>sampling</u> required?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
Correct raw material type and size?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Tag(s) to use <u>DU4063</u> Tag(s) used <u>DU4063</u>	
Setup performed according to W/O?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
Product is acceptable according to customer-specific requirements? [Fab: Is the Part Print Present & the correct Revision? Are required measurements documented?]	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	Bottom side finish does not meet customer requirements, parts will be flipped (completed 12/6/17) [Fab: Print Rev: _____, W/O Rev: _____, Part Spec Rev: _____] (Leave blank if non-Fab audit)	
Packaging is acceptable according to customer-specific requirements?	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	Product not completely packaged, still needs to be flipped (completed 12/6/17)	
Visual Inspection performed and product meets requirements?	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	Visual inspection was performed, material did not meet visual standard	
Out of spec noted, with actions taken?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
Non-conforming material put into reject warehouse and physically put into non-conforming area?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
Required gages available & functional?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
All Gages Calibrated (List in Comments)	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Gages Observed (list last calibration and when due) 039 mic - 8/17 - 2/18 01 Tape - 7/17 - 1/18 3109 measure table - 4/16 - 4/18	
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
Required PPE being worn?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
Forms are the latest revision per Quality Intranet?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	List Forms (Observed Rev vs Intranet Rev) <u>3DM-F-009 Rev. 1</u>	
Hardcopy Controlled Documents are listed on Quality Intranet by location?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	List Documents and their Location: <u>LYN-LRB-001</u> <u>Located @ Redbud line</u>	



Internal Audits - Sumter

<u>12/15/17</u>	<u>11/16/17</u>	<u>11/1/17</u>	<u>10/10/17</u>	<u>12/21/17</u>
<u>9/19/17</u>	<u>8/31/17</u>	<u>8/30/17</u>	<u>8/22/17</u>	<u>10/3/17</u>
<u>7/25/17</u>	<u>7/18/17</u>	<u>7/5/17</u>	<u>6/27/17</u>	<u>8/2/17</u>
<u>6/14/17</u>	<u>6/7/17</u>	<u>6/6/17</u>	<u>6/5/17</u>	<u>6/22/17</u>
<u>6/1/17 #1</u>	<u>5/25/17</u>	<u>5/16/17</u>	<u>5/11/17</u>	<u>6/1/17 #2</u>
<u>4/12/17</u>	<u>4/4/17</u>	<u>3/29/17</u>	<u>3/16/17</u>	<u>4/18/17</u>
<u>2/15/17</u>	<u>2/9/17*</u>	<u>2/8/17</u>	<u>2/1/17</u>	<u>3/1/17</u>
<u>1/17/17</u>	<u>1/12/17</u>	<u>12/20/16</u>	<u>12/18/16</u>	<u>1/25/17</u>
<u>11/2/16</u>	<u>10/26/16</u>	<u>10/17/16</u>	<u>10/12/16</u>	<u>12/12/16</u>
<u>10/3/16*</u>	<u>9/29/16</u>	<u>9/14/16</u>	<u>9/1/16</u>	<u>10/5/16</u>
<u>7/12/16</u>	<u>7/7/16</u>	<u>6/29/16</u>	<u>6/15/16</u>	<u>7/18/16</u>
<u>5/25/16</u>	<u>5/11/16</u>	<u>4/26/16</u>	<u>4/14/16</u>	<u>6/7/16</u>
<u>3/9/16</u>	<u>3/1/16</u>	<u>2/2/16</u>	<u>1/24/16</u>	<u>3/17/16</u>
<u>1/5/16</u>	<u>12/28/15</u>	<u>11/19/15</u>	<u>11/18/15*</u>	<u>1/18/16</u>
<u>11/5/15</u>	<u>10/19/15</u>	<u>10/15/15</u>	<u>10/13/15</u>	<u>11/12/15</u>
<u>9/17/15</u>	<u>9/10/15</u>	<u>9/3/15</u>	<u>8/27/15</u>	<u>9/30/15</u>
<u>7/23/15</u>	<u>7/10/15</u>	<u>6/22/15</u>	<u>5/28/15</u>	<u>8/18/15</u>
<u>4/24/15</u>	<u>4/18/15</u>	<u>4/3/15</u>	<u>3/28/15</u>	<u>5/8/15</u>
<u>3/12/15</u>	<u>3/6/15</u>	<u>2/26/15</u>	<u>2/22/15</u>	<u>3/25/15</u>
				<u>2/13/15</u>

* Denotes Full Audit vs
Process

[Back to Corporate](#)

9.2

Process/Product Audit Checklist

Cust #: <u>2719</u> Customer: <u>Altec</u> GRP/Size/GRD/Width: <u>GNS.0516C840ND 60</u>				
PWC: <u>SRB</u> W/OH: <u>68250</u> Date: <u>12-21-17</u> Part # (s): <u>970095939</u> Auditor: <u>B. Clem</u>				
Gauge Range: <u>.0446-.0566</u> Actual Gauge: <u>.045</u> Width Range: <u>60-60.9999</u> Width Actual: <u>59.991</u> <u>OK</u>				
Length Range: <u>144-144.1250</u> Length Actual: <u>144.020</u> Other: <u>FLATN 0--12</u> Other Actual: <u>.060</u>				
Wt. <u>5437 lbs.</u> Other Actual: <u>4990 lbs.</u> Other: <u>43 Des/Tag</u> Other Actual: <u>43 pcs/Tag</u>				
Item	YES	NO	N/A	Comments/Action Taken (Required for NO)
Process Inspection Sheets filled out according to <u>frequency</u> and <u>sampling</u> required?	<input checked="" type="checkbox"/>			<u>James W.</u>
Correct raw material type and size?	<input checked="" type="checkbox"/>			Tag(s) to use: <u>NB56526</u> Tag(s) used: <u>NB56526</u>
Setup performed according to W/O?	<input checked="" type="checkbox"/>			
Product is acceptable according to customer-specific requirements? [Fab: Is the Part Print Present & the correct Revision? Are required measurements documented?]	<input checked="" type="checkbox"/>			[Fab: Print Rev: _____, W/O Rev: _____, Part Spec Rev: _____] (Leave blank if non-Fab audit)
Packaging is acceptable according to customer-specific requirements?	<input checked="" type="checkbox"/>			
Visual Inspection performed and product meets requirements?	<input checked="" type="checkbox"/>			
Out of spec noted, with actions taken?	<input checked="" type="checkbox"/>			<u>width .009 under - OK (BC)</u> <u>width came up to tol by mid run.</u>
Non-conforming material put into reject warehouse and physically put into non-conforming area?		<input checked="" type="checkbox"/>		
Required gages available & functional?	<input checked="" type="checkbox"/>			
All Gages Calibrated (List in Comments)	<input checked="" type="checkbox"/>			Gages Observed (list last calibration and when due) <u>8-3 25' Tape 7-31-17 7-31-18</u> <u>my4 1" mic 6-27-17 6-27-18</u> <u>ST-5 Step Gauge 7-5-17 7-5-18</u> <u>63294 Meas. Table 4-19-17 4-19-18</u>
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	<input checked="" type="checkbox"/>			
Required PPE being worn?	<input checked="" type="checkbox"/>			
Forms are the latest revision per Quality Intranet?	<input checked="" type="checkbox"/>			List Forms (Observed Rev vs Intranet Rev) <u>SMT-SRB-001 11-8-14 5</u> <u>SMT-SH-001 10-26-11 0</u> <u>SMT-OP-001 4-21-15 0</u> <u>POP081 2-16-01 1</u>
Hardcopy Controlled Documents are listed on Quality Intranet by location?			<input checked="" type="checkbox"/>	List Documents and their Location:

Cop 1

CUST SORT	PART #	USAGE	USAGE (LBS)	PRODUCT	GAUGE	THICKNESS	GRADE:	DRAWN:	MASTER ID:
1	703-09712A	100,000	15,000	POS	375	0.3650	POS	Y	MASTER 2

COP 1

RECOVERY: \$ -

MASTER WIDTH	MASTER LENGTH	PCS / MASTER SHEET	MASTER SHEET WEIGHT	GROSS WEIGHT	NET WEIGHT	SCRAP %	FORMING SCRAP %	SHEET COST	SCRAP RECOVERY:	MATERIAL COST / PC
60.0	120.0	3,230.0	765.7	0.2	0.15	36.7%	0.0%	\$ 363.94	\$ -	\$ 0.11

3,951.08 23,707 15,000 36.73%

COPY 1

\$ 120.00

COUNTOUR LENGTH / PC	LINEAL INCHES / MIN	PROCESSING TIME (MIN)	PROCESSING TIME / PC (SEC)	SECONDS TO ADD	CHANGE- OVER TIME (MINUTES)	ADJUSTED PROCESSING TIME (HRS):	PROCESSING CHARGE	PRCOESS CHARGE / PC	# OF BREAKS	OPERATORS REQ	RUN QTY
17,800.0	260.0	68.46	1.3	0.0	30.0	1.64	\$ 196.92	\$ 0.06	0	0	0

LASER HRS:

35.3

\$ 6,096.69

0001

SET UP TIME (MIN) 0
CYCLE TIME (SEC) 0
PCS / HR 0.0
HRS REQ 0.0
CHARGE / HR \$ -
TOTAL FORM COST \$ -

FORM COST / PC
-

COMMENTS: # OF SKIDS

PACKAGING COST / PC
0.00

\$ 187.50

OTHER
COST:

OTHER COST / PC
-

\$ 1.25

\$ -

COPY

FREIGHT (CWT): \$ -

ALL COSTS (EXCLUDING FREIGHT)	OB FREIGHT	NET MARGIN	RESALE
\$ 0.18	\$ -	40%	\$ 0.29

NM \$ (JEMISON)	GM \$ (JEMISON)	MATERIAL COST AS % OF TOTAL COST:	GROSS weight price / lb	net weight price / lb
\$ 0.12	\$ 0.18	64.2%	\$ 1.23	\$ 1.95

TOTAL
LASER
SECONDS
1.3

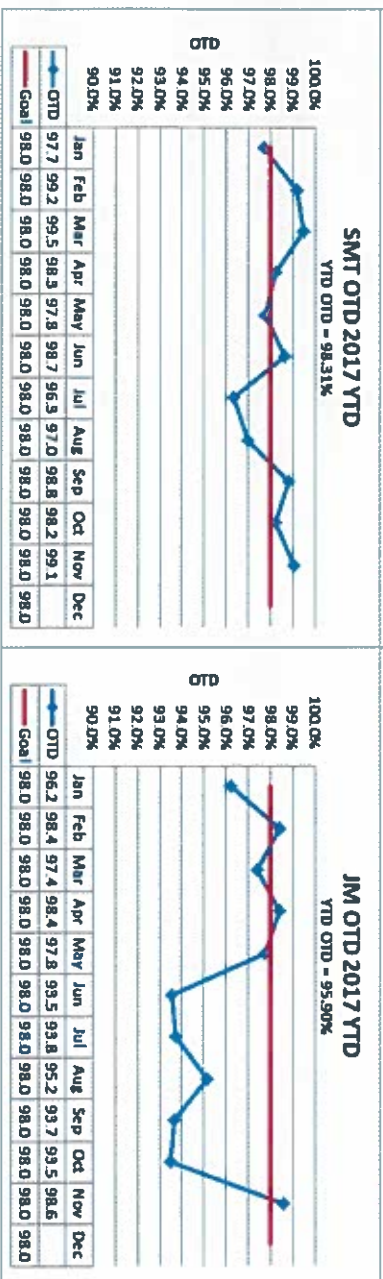
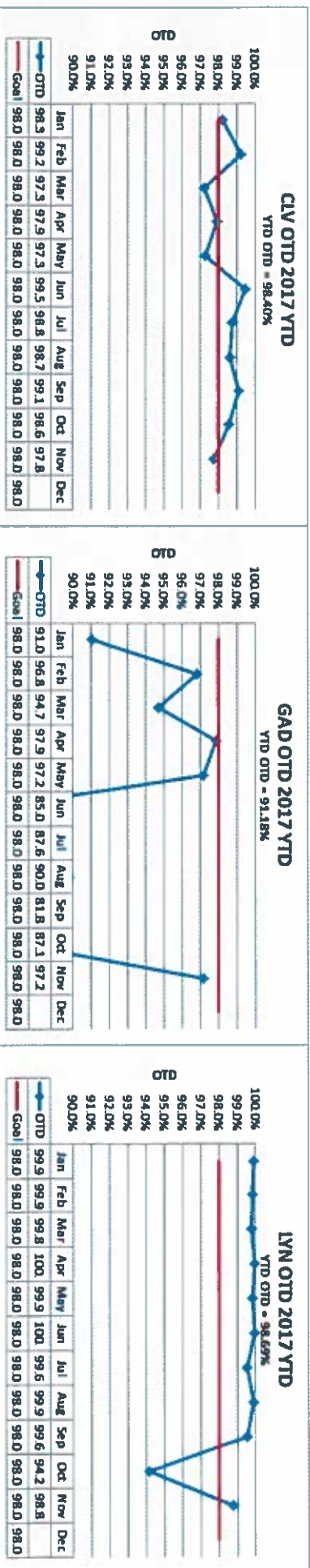
REVENUE:	\$	29,252.75	\$	1.95
GM \$	\$	19,629.29		
		67.1%		
NM \$	\$	11,701.10		
		40.0%		

cop 1

\$ 29,252.75

COPI 3 - MOP 5

November 2017 On-Time Delivery Performance



5001

Jemison Metals On-The-Job (OJT) Group Training Form

Continual Learning is key to Continual Improvement in the JDM QMS. This Form recognizes that:

(Attendees):

Print Name	Initial	Print Name	Initial
Americ Bonell	AB		
Kendall Kinzie	KK		
James Shiflett	JS		
Lesly Thurman	LT		
Katerick Johnson	KJ		
Tim Gupke	TG		
WA Stephens	WA		

All Attendees have successfully completed OJT for:

Location: Lynchburg

Training Start Date: 12/18/17 Completion Date: 12/18/17

Description: First Article Inspection Procedure Training

Department: Operations

Subject: Procedure Training

Signature of Trainer: [Signature]

According to this document, the OJT for these individuals have been trained and have demonstrated sufficient competence to conduct the documented function/task without further instructions. Continued performance evaluation and observation could result in additional training being specified.

Fabrication First Article Inspection Procedure

- 1. Operators will complete the first piece inspection on the print of the part, by writing in measured dimensions beside the correlating dimension on the print. A first piece inspection form may also be used when specified by work order or customer requirements. A first piece inspection shall be completed for every job assigned, unless otherwise specified on the work order and/or part specification.**
- 2. Operators will read the provided print and check all dimensions required for the operation they are performing**
- 3. They are required to check the first piece as well as any periodic checks described in the work order**
- 4. After operator verifies all dimensions are correct and the part has been made to print they shall resume production of the part. The following dimensions, at a minimum, shall be checked: 1) Thickness of material, 2) Tightest Tolerance Hole (Laser/Plasma Only), 3) At least 2 other "key" dimensions.**
- 5. A first piece inspection will be performed at the beginning of each shift change by the incoming operator in addition to any checks already performed**

Revision Date

12/11/17

Revision Level

0

Changes Made

Original Version

SOP 2

By: pmaci	At: SMT	Date: 28Dec17	Time: 14:05
-----------	---------	---------------	-------------

Type N	Purchase Order Item	PO No SMT- 21218- 1
NUCOR-BERKELEY		
Group GNC	A 653 GALVANNEALED COIL	
Size 19C	.0440 Min X 60.0000"	
Grade CB40NO	Width 60.0000"	Length
Order:	PCS Msr:	GaM 0.0440
Bal :	PCS Msr:	Wgt: 45000 LBS
Cst Description	A/V	Wgt: LBS
M Material	V	Quantity Ty
O VOLUME REBATE	A	Amount
	Rate UM	US
	43.7500 CWT	US
	1.7500-CWT	

F P/O Frt Cost	A	0.7500 CWT	P	US
Stk Inq Cost	/CWT A	Ex Rt	Bs Crncy Amt	
Stk Inq Y Alloc:				/
For Cus No 2719	Part No		Cus Own N	
Stk Inq Rmks ALTEC - NC MONTHLY ADJ			Upd Usq N	
Source PD	Status ACK	Item Due Date 10/28/17	Rdy Dt 11/01/17 A	
Rolling Wk	Prt Modif Y	Orig Due Date 10/28/17	Complete Y	
1-Chng Itm	2-Rmk	3-Cond Cds	4-PO Res	5-Res Incmg
			6-Res	7-Hdr
				8-Hist

5012

By: pmaci	At: SMT	Date: 28Dec17	Time: 14:05
-----------	---------	---------------	-------------

Item Remarks

Typ

Remarks

E *****CRU PROGRAM*****
E ASTM: A653 GALVANNEALED COIL
E GRADE: CS TYPE B
E COATING: A40
E SURFACE TREATMENT: NON CHEM TREAT
E **REGULAR OIL
E FINISH: MIN SPANGLE
E END USE:BODIES & SHELVING FOR ALTEC AERIAL TRUCK
E GAUGE TOLERANCE: .0440 MIN. .0490 MAX.
E COIL WEIGHTS: MIN: 12,000 MAX: 16,000
E MAX ID: 24
E LOADING: OVERHEAD CRANE
E EDGE: CUT
E
E \$40.25-CRU BASE
E \$.50 GALVANNEAL
E \$ 2.50 A40
E \$ 0.50 COIL SIZE
E

1-Copy Ven 2-Change Rmk 3-Review Rmk 4-Copy Tmpl

SOP 2

By: pmaci	At: SMT	Date: 28Dec17	Time: 14:05
-----------	---------	---------------	-------------

SMT Tag NB56526 Whs SPW

Tag Info

GNC	Dim	60.0000	Lgth	A Ven NUCOR-BERKELEY
19C	Ga	.0440 M Avg	.0452 PIW	Tag Ref No 366806.200
CB40NO				
Part No			Owner O Own/For	2719 ALTEC - NC
Heat	NUB 2715265-3	C=<.04> Mn=<.21> P=<.006> S=<.003> Si=<.03> N=<.005>		
Cr=<.05> Mo=<.01> Cu=<.13> Al=<.031> V=<.003> Ti=<.001> Ni=<.04> Nb=<.000>				
Specs				

Cond		ID	OD
Rmks ALTEC - NC MONTHLY ADJ		24.0000	43.0000 "
Ven Ref No			60.5000 "
Pur PO SMT 021218-001	Width		60.0000
Rcv RC SMT 050430-001 26Oct17 Trans	Gauge	.0440	
Master Tag	Created 26Oct17	Length	Due
Lnd 43.0706	Parent Tag		Hold Code
Mat 43.0706			Hold Rsn
Frt			Loc 10H1127 Pkg
Pro			Skd Ty Wgt
Oth			Cut No
Tot 43.0706 /CWT	Pcs		Reject Rsn
Made	Qty 0		Archived
1-Reservns 2-Tag Tracing 3-Heat Zoom 4-Rmks 5-Other			27Dec17
			Tag Ref 6-StdLoc 7-MN Ref



Q1-Q3 2017 Claims Summary

Total (All Groups)		
Vendor	Weight Claimed	Claims %
NLMK	956,238	2.11%
Nucor Decatur	992,647	1.08%
Metal One Ameri	380,481	1.10%
Nucor Berkeley	588,463	0.66%
Nucor Galatin	0	0.00%
Total (All Groups)	1,868,613	1.37%

CRC		
Vendor	Claimed	Claims %
NLMK	194,531	1.58%
Nu-Berkeley	87,672	0.90%
Nu-Decatur	84,297	0.70%
Metal One	0	0.00%
Total:	298,598	1.37%

HRC		
Vendor	Claimed	Claims %
Nu-Decatur	64,940	0.26%
Nucor Galatin	0	0.00%
Metal One	0	0.00%
Nu-Berkeley	0	0.00%
Total:	64,940	0.26%

POC		
Vendor	Claimed	Claims %
NLMK	403,677	3.53%
Nu-Decatur	872,781	2.35%
Metal One America	43,585	1.21%
Nu-Berkeley	200,776	0.41%
Nucor Galatin	0	0.00%
Total:	849,250	1.78%

Coated		
Vendor	Claimed	Claims %
Metal One America	336,896	1.74%
NLMK	358,030	1.68%
Nu-Berkeley	300,015	0.82%
Nu-Decatur	20,629	0.24%
Total:	720,765	1.15%



Q1-Q3 2017 CRC Claims



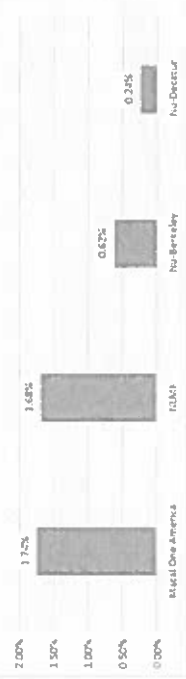
Q1-Q3 2017 HRC Claims



Q1-Q3 2017 POC Claims



Q1-Q3 2017 Coated Claims



November 2017 DPPM Performance

WCV ✓

