

Audit Review and Evaluations of JEMISON METALS

**8100 Aetna Road
Cleveland, OH, 44105**

Dates of Audit: 10/15/25
Date of Submittal: 10/23/25

Auditors: Patrick Macias Quality Manager-Eastern Division

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: JDM-F-001 Rev 2 7/30/13 in Receiving, JDM200 Quality Policy 7.21.18 Rev-1 posted in shipping office and Loopco Slitter information board, JDM3 Slit Size Inspection 3/1/17 Rev 4 and JDM4 Slitting Orders 7/21/11 Rev 7 both at the Loopco Slitter, CLV-RB-002 Redbud Procedure rev 5 8/16/19 Electronic copy Red Bud computer and hardcopy posted on Red Bud operator stand

7 Support

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

7.1.3 Infrastructure

Preventive Maintenance: Rick Ladow provided the following PM evidence that was performed either by Rick Ladow (Jemison Maintenance) or an outside provider:

- Red Bud (RBI 1) PMs were reviewed from Jan-Sept 2025, Sections:
 - 1 Power Unit, Coil Reel were reviewed and all indicated ok.
 - 2 Peeler, Pinch Roll, Feed, Slitter Head, scrap winders were reviewed and all indicated ok.
 - 3 Shear, Strip stacker, Stack Table, Voss roll out
- Loopco slitter PMs were reviewed from Jan-Sept 2025. Slitter PMs consists of two main parts:
 1. Entry Exit, Uncoiler, Shear, Slitter and
 2. Pit/Table, tension stand, overarm, recoiler, power units and gauger.

7.1.5 Monitoring and Measuring Resources

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

Micrometer serial#: RBI 2 Past due calibration ([MF#2](#))

Caliper serial#: SP1 Past due calibration ([MF#2](#))

Step gauge Serial# ST2 Past due calibration ([MF#2](#))

Measuring Table last Calibration 9/16/2025, due 9/16/2026

12' tape Serial#, #4 Past due calibration ([MF#2](#))

Micrometer RBI 21 Past due calibration ([MF#2](#))

Caliper Serial#, SH1 Past due calibration ([MF#2](#))

25' Tape Serial# 6 Past due calibration ([MF#2](#))

[MF #2 Calibration on multiple devices due previous month.](#)

Maintenance Office:

0.100" Gauge Block serial#: 237107, Calibration Due Nov 2026

0.500" Gauge Block serial#: 232090, Calibration due Nov 2026

1.000" Gauge Block serial#: 233453, Calibration due Nov 2026

7.2 Competence

Interviewed Jaylin Hoyet (1st Receiver), Kathy Manka (Production Planner & 2nd Receiver), Thomas Rodrieguez (Slitter Operator), and Paul "Lefty" Bouska (Shipping). Jayshaun Gary (Red Bud Operator), Billie Thomas (Logistics) All were able to locate the Jemison Quality Intranet, Quality Policy, and their respective procedures, if applicable.

Additional employees talked to: Sarah Howard (Inside Sales), Rick Ladow (Maintenance), Reed Fulmer (Purchasing/Materials Mgmt), John Lathan (shipping)

Reviewed Training Status Matrix, which had employees clearly identified.

8.2 Requirements for products and services

Contract Review/Order Acknowledgement: Stahl sales order 35620-5 Sarah Howard is the inside sales representative for this customer. The customer sends PO requirements via email. In this case they emailed PO 014403 on 10/8/2025 and Sarah confirmed back quantities the same day and entered Sales Order 35620-5. Order due date was 10/15, produced and shipped 10/15/2025.

Purchasing: Tag 42602 and 42605 were observed during 2nd receiver on 10/15/2025. It was purchased on PO 3341-1-1. Reed Fulmer is the materials manager for this account in Cleveland.

PO 3341-1-1 was sent to Cleveland Cliffs on 8/8/2025 and acknowledged by Metal one for

Cleveland Cliffs on 8/26/2025. Grade, order quantity, thickness, width etc were verified in the acknowledgement vs the purchase order. Due to ship September 2025 arrived 10/14/2025.

8.4 Control of externally provided processes, products and services Receiving: Mill coil 500813-02 from Cleveland Cliffs was received against PO# 3341-1 by Jaylin Hoyett (1st Receiver) and Kathy Manka (2nd Receiver). JDM-F-001 Rev 2 7/30/13 was not filled in ([MF#1](#)) documenting: Mill, Gauge, Size, Description, weight, tag number, location and with yes/no questions for PKG Complete, Truck Wet, Material Wet. Tag number 42605 was generated and hung on the coil place in location A15. Purchased for customer Wabtec Trans.

[MF#1-JDM-F-001 was not in use consistently Employees who entered info into Invex for material receiving had not received a copy of JDM-F-001 this calendar year. The crane operator did have some filled in on clip board but had not turned them in.](#)

8.5-Production & Service Provisions

Production: Work Order 53465, customer Stahl S/O 35626-. Production of .1382" x 47.88" x multiple lengths on job (107.00", 121.00", 146.00") part 248917 (146" length observed)

Gauge (.1287"-.1472" Actual .131"). Width (47.85"-47.91", Actual 47.903"). Length (145.97"-146.03" actual 146") cut from coil 27011A (20711A was the correct coil as shown on "material to be used" on the work order). All checks, listed above, were within tolerance and documented on Quality Checklist document JDM 13 rev 7.

Shipping: Haydon Corp Loading Order 16542-1 (also the BOL) was staged in preparation for loading. Paul Bouska showed me the loading order showing the load was 45,165 lbs total that were staged. Loading order requirements included: Fork side Unload. These requirements along with the tags listed on the loading order were observed to be correctly loaded onto the Conestoga truck at 6:59 am, the scheduled time for the truck.

8.7 Control of Nonconforming Product

The nonconforming areas were neat and identified with tags that had descriptions in the comments about the issue ([OBS #1](#)). There are 2 nonconforming areas in Cleveland, one for sheet/blanks and one for slit coil. Both were clearly delineated, and sample tags were written down for further review.

- Sheet tag 24039J (7 pcs, 2072 lbs, 0.1110M" x 71.5" x 120"). Tag date was 10/9/25 remark section on tag left blank ([OBS #1](#))
- Sheet tag 28255I (pcs, 1766 lbs, 0.0910M" x 60" x 120"). Tag date was 9/10/25 remark section on tag left blank ([OBS #1](#))
- Sheet tag 281032 in the virtual reject warehouse but unavailable due to it being rejected as lost material. (2 pc 714 lbs 0.1790N" x 60" x 120"). Tag date moved to reject 9/10/2025

All 3 of these tags were verified to be in either the reject or mill claim virtual warehouse in Invex

OBS #1-Two tags in reject area did not have remarks in system stating the nonconformance reason. Reasons were being added by Quality personnel after material was segregated. (Reviewed with operators how to add remarks to system at the time of rejection)

10.2 Nonconformity and Corrective Action

Findings from Previous audit:

MF #1, Customer SCAR 02191, for bowed blanks at Lincoln, included implementing an action that had not been completed. Specifically, the remarks “Sampling 1pc/skid” was to be added to the part specification. This was corrected prior to the end of the audit.

CA 27401. Closed 1/2/2025 RR

OFI #1 Two rockwell hardness testing machines were located in the warehouse receiving area. They were labeled as “out of service”. The label was dirty and hanging by tape. Should consider selling the machines or moving to maintenance or at least providing better signage that is more robustly affixed to them.

-Better Signage posted

OF #1 CLV-RC-001, receiving procedure, revision from 2018 removed the requirement for coils to be weighed. JDM-F-001, Mill Receiving Worksheet, has a column for scale weight. Should consider removal of this column or mark it as optional so the blank spaces aren't questioned by customers and/or auditors.

See [MF #1](#) 10/15/2025 audit

Corrective Actions

CA 27946-Issue: Roll mark from DEC leveler-Action: Moved to CLV production.

Confirmed production has been set up in system to only produce in CLV location. **Can be closed**

CA 27769-Issues 1. Heavy oil, 2. Packaging issue, 3. Uneven stacking of sheets.

Need to be audited before closing.

10. Improvement

The Cleveland plant is one of our best performing plants regarding our key KPI's: Internal and External DPPMs and On Time Delivery %. Cleveland has done this while experiencing tonnage growth year over year. Internal DPPMs YTD are 2,335 vs goal of less than 2,500 (60 DPPM are operational related). External DPPMs YTD are 1,421 vs goal of less than 3500 (1,113 are operational related). On time delivery YTD is 98.1% vs goal of greater than 98%. Additionally, there were upgrades to the bathroom, breakroom, and locker room. New stainless steel stalls, new lockers and approximately \$30,000 worth of plumbing work were performed/installed.

2.0 Overview

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

2.2 Audited Requirements

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

Report Prepared by Patrick V. Macias

Date 10/23/25

Nonconforming Corrective Action Report (CAR) for Jemison Metals

CAR #	ISO 9001: 2015 Clause / Sub- Clause	Findings/Requirements	Observation	Minor	Major
MF#1	7.5.3 Documented Information	JDM-F-001 was not in use consistently. Employees who entered info into Invex for material receiving had not received a copy of JDM-F-001 this calendar year. The crane operator did have some filled in on clip board but had not turned them in.		X	
MF #2	7.1.5.2A Measurement Traceability	Calibration on multiple devices due previous month.		X	
OBS# 1	8.7.2A Control of Nonconforming Outputs	Two tags in reject area did not have remarks in system stating the nonconformance reason. Reasons were being added by Quality personnel after material was segregated. (Reviewed with operators how to add remarks to system at the time of rejection)	X		