

Audit Review and Evaluations OF

JEMISON METALS

**8100 Aetna Road
Cleveland, OH 44105**

Dates of Audit: 7/16/19 -7/17/19
Date of Submittal: 8/2/19

Auditors: Rick Rowland – SR VP Quality & Engineering

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 – Documentation Requirements

The following forms and documents were verified during the audit: CLV-RC-001 Receiving Procedure (Quality Intranet-no hard copy present), JDM-F-001 Mill/Receiving Information Rev-2, JDM200 Quality Policy Rev-1 (Multiple locations, listed in hardcopy listing), Auto-generated work order from Stelplan (PN: 72853), CLV-RB-002 Rev 4, FQA066 (Calibration Worksheet) Rev 3, Auto-generated loading order from Stelplan (CLV 121527, Unified Brands).

7 Support

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

7.2 Competence

Reviewed JDM-F-014 Rev 0, training status matrix. Employees were clearly identified as to competence levels.

8.2 Requirements for products and service

Kidron production on P/N 72853 was a consignment stock production job. We produce to planned stock levels. Each Wednesday, customer sends a consignment "needed" list that sales confirms this same day via email. They also send a P.O. for what's been used from consignment.

8.4 Control of externally provided processes, products and services

Mill coil GA18808 was utilized against Jemison PO 26365 and was received on receiver 49426. Purchase grade met the requirements of the customer part specification. Material was specified as ASTM A1011 HSLA Grade 50 class 1. **Minor Finding #1: GA18808 did not have the mechanical properties listed on the tag per the requirements of ASTM. This was corrected during the audit; however, a CA should be put in place to fix the root cause of the missing information.**

8.5-Production & Service Provisions

Receiving: Was unable to audit receiving in real time. Reviewed receiving paperwork of PO 26365 Receiver 49426. Sandy Damato performed 1st receiver duties, while Kathy Manka performed 2nd receiver duties.

Production: Work order 72853, Kidron, was observed on CR2 (Redbud). Operator was John McCullough. All checks performed per Redbud Operating procedure (CLV-RB-002) and the customer part specification requirements. Thickness, width, length, flatness, packaging, # tags/bundle, and 3,000 lb max weight were all within work order requirements (see notes for further details).

Preventive Maintenance: Reviewed with Larry Strimple, Schedule calendar for June reviewed. All schedule maintenance marked as performed. A-Bay Crane (Receiving, Serial # 92146, monthly inspection was performed on 6/19 on form MF056 Rev 3). [Minor Finding #2: Annual crane inspections \(by outside crane company\) were not available during the audit. Last documented crane inspections were in 2017.](#) RBI 2 Preventive maintenance checklist (for June) was reviewed. All items were documented as performed on June 10th.

Nucor Gallatin & AWL Trucking verified to be on the Approved Supplier Listing.

7.1.5 Monitoring and Measuring Resources

The following gauges were verified to be calibrated in compliance with calibration records: Receiving: 16' Tape Measure, #10; 2 rockwell hardness testers (81121 & 869015). [Opportunity for Improvement #1: 81121 had a calibration report, but not a certificate of calibration like 869015. It is in calibration, but should probably get the certificate as well. Also recommend getting updated versions without white out on them.](#) Redbud: 24" calipers, 081; 16' Tape Measure #1; 0-1" Micrometer, ASP016.

8.7 Control of Nonconforming Product

Both sheet and coil nonconforming areas were well defined and neat. Coil area had zero items. Sheet area had multiple items and all were identified and tagged correctly.

10.2 Nonconformity and Corrective Action

CA 16806 Reviewed, all actions complete. Closed 7/17/19

CA 16718 Reviewed, Verified twice during process audits. Closed 7/17/19

10 Continual improvement

Gagetrak to be implemented by end of 2019.

2 new banders for slitters

Absorb training software purchased, company-wide, to be implemented by end of Q1 2020.

Observations and findings from previous ISO audit (7/24/18)

MF1

FHR002, new hire document, wrong revision used. CA closed.

Observations:

1 Unidentified skid located in sheet non-conforming area. Closed prior to end of audit.

2.0 Overview

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

Anthony Walton - Receiver Sandy Damato – Traffic/Receiver Larry Strimple-Maintenance	Kathy Manka-Production -Planner John McCullough – CR2 Operator Rick Ladow - Maintenance Martha Strachan-Inside sales
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2.2 Audited Requirements

4 Context of the Organization 4.4 Quality Management System and its processes 5 Leadership 5.1 Leadership and commitment 5.1.2 Customer Focus 5.2 Policy 5.6 Management review 6 Planning 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	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 provided processes, products and services 8.5 Production and service provision 8.7 Control of nonconforming outputs 9 Performance evaluation 9.1 Monitoring, measurement, analysis and evaluation 9.1.1 General 9.1.3 Analysis and evaluation 10 Improvement 10.2 Nonconformity and corrective action
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2.3 APPROVAL/SIGN-OFF

Report Prepared by Rick Rowland

Date 8/2/19

Nonconforming Corrective Action Report (CAR) for Jemison Metals

CAR #	ISO 9001: 2015 Clause / Sub-Clause	Findings/Requirements	Observation	Minor	Major
1	8.4	Minor Finding #1: GA18808 did not have the mechanical properties listed on the tag per the requirements of ASTM. A1011 HSLA Grade 50 Class 1. Corrected during the audit, but CA needed to ensure root cause is fixed.		X	
2	8.5	Minor Finding #2: Annual crane inspections (by outside crane company) were not available during the audit. Last documented crane inspections were in 2017.		X	
n/a	7.1.5	Opportunity for Improvement #1: 81121 had a calibration report, but not a certificate of calibration like 869015. It is in calibration, but should probably get the certificate as well. Also recommend getting updated versions without white out on them.	X (OFI)		

7-16-19 CLV Internal Audit
+ 7-17-19
Coil CRJ - well defined & Empty

Sheet CRJ 230570 4 April 18
End of Coil 1/2" wave
everything properly
Labeled as Reject 236396

Anthony Walton ✓ Policy
✓ Rcvg Procedure ~~0854~~ ✓

Rcvg ① JDM-F-001 Rev. 2 7/30/13 in use. Filled out properly for PKG complete

Truck wet, Material wet & Initials.

① 16' Tape #10 RCVG ✓ Yearly 9-18, matches
Calib Record

Quality Policy in by hardness
Testers @ Rcvg

① 2 Hardness Testers 6-4-19, due 12-19

✓ JDM 200 Rev. 1 7/2/11

CR2 - Redbud P/W 72853 John McCullough

Kidron 48x120 + 48x96 POS 10L H550-1 ✓ .126-.142 Gauge (.129-.130)
Coil Info ✓ Width .9999 (Mill Edge) (48.437)
✓ Length -0, +.25 (120.062, 96.062)

GA 18808
A1011 HRPO HSLA Gr 50 Class 1
PO# 26365

* 50ksi min
* 65 ksi min
* 22% El. min

✓ JD3

(JD3 Paper Top 2x2 Bund w/ Edge Prot)

RC 49426

✓ 2 Tags/Bundle

(- Shipping Remark)

✓ 3,000 lb Max

(2730 lbs)

✓ Flat < .25

(< .120)

Sales Martha
Strachan

Finding
#1

* No Mechanicals on
Tag.

① CLV-RB-002 - Ref. JDM ⁵, step 12

① + Quality Policy. JDM 200 Rev. 1 7/2/18 ✓ Yes/No
step 13 Tag
write on Bundle

John did Good

~~Ref J-1~~

✓ 24" Calipers 081

Assigned to RB12 6-19, due 9-19

✓ 16' Tape #1

RB12 ✓ Yearly on 9-18 by Larry
matches Calib log

✓ 0-1" Mic ASP016

RB12 monthly July 19, due Aug 19

① Calib Verification
Sheet DOC# FQA066 Rev. 3 Joked 4/10/17

OFI #1

81121 + 869015 - Hardness Testers
Rb Superficial

81121 Had Calib Report
but Not the Certificate
like 869015

It is in Calib, but
Need Certificate.
Also Get updated
versions without
White out.

Consignment Customer. We
produce to Planned Stock levels
Each Wednesday, customer
sends a consignment
"needed" list that Sales
Confirms. They also send
a P.O. for what's been
used from Consignment.
Sales Confirms the
"Needed" list items
Same day. * via email

7-17-19 CLV Internal Audit
pg. 2

25 Ton A-Bay Crane - Revg. Serial #92146
✓ monthly Inspection MF056 Rev. 3 6/2001
Dated 6-19 all Good

Annual Inspection

MF #2

Last Performed in 2017

Saw a quote dated 7/2/19
they are working on it as
the previous company was bought out.

RBI Preventive
Maintenance

Reviewed CLV Maintenance Calendar on
Public Drive. Displays what dates
specific PM's are completed

✓ Reviewed RBI 2 PM. Checklist for June, performed on
Everything is in order June 10th

Shipping Tyrone

Verified Brands Loading Order CLV 121527
All 13 Bundles Loaded + Verified
Load Tarped while Indoors

AWL
~~FLX~~

Trucking.

✓ ASL

L O A D I N G O R D E R

No: CLV 121527

Ship From:
Jemison Metals - Cleveland
8100 Aetna Drive
Cleveland, OH 44105
Tel: 216-271-1500 Fax: 216-271-0013

Ship Date 16Jul19 at 10:30 From CFG
Probill
Via AWL TRANSPORT,
FOB DESTINATION
Frt PREPAID FREIGHT
Route 0- 0 Manifest
Vhcle Trailer
Slp

Ship To: (1)
Unified Brands
520 South Coldwater Road
Weidman MI 48893
Tel: 989-644-3331 Fax:

Sold To: (2801)
Jemison Metals - Cleveland
8100 Aetna Drive
Cleveland, OH 44105

Con

Tel 989-644-3331 Fax 601-372-9589

L O A D I N G O R D E R - REPRINT

1) Our Order CLV-981651- 1 Your PO #

Part # ST SHT102 Rel #
Galvannealed Sheet A 653 CS TYPE B A40 CT DRY
0.1084 Nom 48.0000 X 144.0000

Loc	Heat Number	Tag No	Quantity	PCS	Wt LBS
	AMT192315797	UB8976 ✓	720.00 SFT	15	3270
	AMT192315797	UB8977 ✓	864.00 SFT	18	3924
		Total:	1,584.00 SFT	33	7194

2) Our Order CLV-981651- 2 Your PO #

Part # ST SHT122 Rel #
Galvannealed Sheet A 653 CS TYPE B A40 CT DRY
0.0635 Nom 48.0000 X 144.0000

Loc	Heat Number	Tag No	Quantity	PCS	Wt LBS
SHP	NLK1952707	UB8906 ✓	1,536.00 SFT	32	4096
SHP	NLK1952707	UB8907 ✓	1,536.00 SFT	32	4096
SHP	NLK1952707	UB8908 ✓	1,536.00 SFT	32	4096
		Total:	4,608.00 SFT	96	12288

3) Our Order CLV-981651- 3 Your PO #

Part # ST SHT1146 Rel #
A463 Aluminized Sheet CS TYPE B T125
0.0456 Nom 48.0000 X 144.0000

Loc	Heat Number	Tag No	Quantity	PCS	Wt LBS
SHP	197668	UB8912 ✓	2,064.00 SFT	43	3956

L O A D I N G O R D E R

No: CLV 121527

Ship From:
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Cleveland, OH 44105
Tel: 216-271-1500 Fax: 216-271-0013

Ship Date 16Jul19 at 10:30 From CFG
Probill
Via AWL TRANSPORT,
FOB DESTINATION
Frt PREPAID FREIGHT
Route 0- 0 Manifest
Vhcle Trailer
Slp

Ship To: (1)
Unified Brands

Sold To: (2801)
Jemison Metals - Cleveland
Tel 989-644-3331 Fax 601-372-9589

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L O A D I N G O R D E R - REPRINT

4) Our Order CLV-981651- 4 Your PO #
Part # ST SHT0927 Rel #
Galvannealed Sheet A 653 CS TYPE B A40 CT DRY
0.0396 Nom 48.0000 X 157.0000

Loc	Heat Number	Tag No	Quantity	PCS	Wt LBS
	NLK1952359	UB8978 ✓	1,831.67 SFT	35	3045
	NLK1952359	UB8979 ✓	1,831.67 SFT	35	3045
	NLK1952359	UB8980 ✓	366.33 SFT	7	609
	NLK1952359	UB8981 ✓	1,831.67 SFT	35	3045
		Total:	5,861.33 SFT	112	9744

5) Our Order CLV-981651- 5 Your PO #
Part # ST SHT1152 Rel #
A 653 GALVANNEALED SHEET CS-B ^40 CT DRY
0.0276 Nom 60.0000 X 144.0000

Loc	Heat Number	Tag No	Quantity	PCS	Wt LBS
	R83754	UB8982 ✓	540.00 SFT	9	630
	R83754	UB8983 ✓	3,420.00 SFT	57	3990
	R83754	UB8984 ✓	3,420.00 SFT	57	3990
		Total:	7,380.00 SFT	123	8610

	Tags	PCS	LBS
TOTAL:	13	407	41792

Heat Number 197668 *** Chemical Analysis ***
C=0.0400 Mn=0.3400 P=0.0090 S=0.0030 Si=0.0250 N=0.0080
Cr=0.0800 Mo=0.0240 Cu=0.1070 Al=0.0490 Cb=0.0010 V=0.0030
Ti=0.0020 Ni=0.0710
AMT192315797 C=<.09> Mn=<.45> P=<.016> S=<.005> Si=<.012> N=<.002> Cr=<.020>
Mo=<.002> Cu=<.010> Al=<.031> Ti=<.001> Ni=<.010> Nb=<.001>
Sn=<.001> B=<.0000>
NLK1952359 C=0.0200 Mn=0.2500 P=0.0170 S=0.0130 Si=0.0140 N=0.0030
Cr=0.0250 Mo=0.0030 Cu=0.0360 Al=0.0420 V=0.0010 Ti=0.0010

No: CLV 121527

Ship Date 16Jul19 at 10:30 From CFG
 Probill
 Via AWL TRANSPORT,
 FOB DESTINATION
 Frt PREPAID FREIGHT
 Route 0- 0 Manifest
 Vhcle Trailer
 Slp

Sold To: (2801)
Jemison Metals - Cleveland

Tel 989-644-3331 Fax 601-372-9589

- REPRINT

NLK1952707

Ni=0.0200 Nb=0.0002 Sn=0.0010 B=0.0002
C=0.0380 Mn=0.2700 P=0.0090 S=0.0070 Si=0.0060 N=0.0040
Cr=0.0300 Mo=0.0060 Cu=0.0200 Al=0.0340 Ti=0.0010 Ni=0.0100

PHONE# 989-644-3331 (ASK FOR STAMPING)

STEEL UNLOADS AT THE SOUTH END OF THE SHOP IN
STAMPING - NOT RECEIVING DEPARTMENT
MONDAY-THURSDAY 7AM-4PM

>>PROTECT FROM WEATHER / ALL LOADS TO BE TARPED<<

ALL TIMES NOTED ARE CENTRAL STANDARD TIME