

Audit Review and Evaluations OF

JEMISON METALS

**8100 Aetna Road
Cleveland, OH 44105**

Dates of Audit: 7/24/18
Date of Submittal: 7/26/18

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 – Documentation Requirements

The following forms and documents were verified during the audit: CLV-RC-001 Receiving Procedure (Quality Intranet-no hard copy present) CLV –SL-001 Loopco Procedure (Quality Intranet Loopco computer-no hardcopy present) JDM3-Slit Size Inspection-Rev 4, JDM4 Slitting Orders-Rev-7, JDM-F-001Mill/Receiving Information Rev-2, JDM200 Quality Policy Rev-1, FHR002 Training & Equipment Checklist Plant Employees Rev-6 (Current Revision 8, Minor #1)

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 Regis Hill training documentation. New Hire training documented and turned into human resources. FHR002 Rev -6 (Minor-#1)

8.2 Requirements for products and service

PO 4500476599 sent on 7/24/18 order acknowledged by Martha Stachan on 7/24/18. Sales order 975508 entered on 7/24/18

8.4 Control of externally provided processes, products and services

Mill coil #2387956 received off of PO 25388-01 for Liebert Iron ton bucket POC CSBTP 14A 40.25" met all requirements for customer part in that bucket.

8.5-Production & Service Provisions

Receiving: Was unable to audit receiving in real time. Reviewed receiving paperwork of PO 25388-001 Receiver 47271, B/L 000260212. Receiving paperwork signed and dated by Frank March, Items 1-5 on CLV-RC-001 performed by Frank March, Item 6 performed by Kathy Manka at time of 2nd receiving

Production: W/O 69547 Arrow Tru Line was observed in Production on Loopco slitter. All checks performed per procedure, material met W/O tolerance requirements. Operator Regis Hill.

Preventive Maintenance: Reviewed with Larry Strimple, Schedule calendar for July reviewed. All schedule maintenance marked as performed. August calendar to be put together prior to August-1

7.1.5 Monitoring and Measuring Resources

The following gauges were verified to be calibrated in compliance with calibration records: Receiving: Micrometer 014, Jo Block 460, Loopco Micrometer RBI 21, Calipers SH-1

8.7 Control of Nonconforming Product

Both sheet and coil nonconforming areas were well defined and neat. Coil area had three items and all were identified and tagged correctly. Sheet area had ten items. One was not identified. ([Observation #1](#))

10.2 Nonconformity and Corrective Action

CA 12511 Reviewed, all three follow up checks recorded-Recommend close

CA 14546 Reviewed, two of the three follow up checks performed. Last on 4/23/18, confirmed no production on this part had occurred since 4/23.

10 Continual improvement

Remote controls for two cranes purchased and used to replace pendant controls. Improving, safety, and efficiency.

Observations and findings from previous ISO audit

OFI 1

In progress of auditing to new standard.

Observations:

- 1 In progress, finalizing last of SMT documents to new logo
- 2 In Progress, Management review to be completed before the end of August
- 3 Complete 1/29/18
- 4 Complete 3/1/18
- 5 Complete 2/21/18
- 6 Complete 2/28/18
- 7 Complete 2/6/18

2.0 Overview

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

Regis Hill –Slitter Operator Frank March- Receiver Larry Strimple-Maintenance	Kathy Manka-Production Planner/Receiver Martha Strachan-Inside sales
---	--

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
---	---

2.3 APPROVAL/SIGN-OFF

Report Prepared by Patrick Macias

Date 7/26/18

Nonconforming Corrective Action Report (CAR) for Jemison
Metals

CAR #	ISO 9001: 2015 Clause / Sub-Clause	Findings/Requirements	Observation	Minor	Major
1	7.5	FHR002 Revision 6 used by Human Resources on new hire package. Revision 8 is current revision. *Reviewed with human resources prior to end of audit.		X	
NA	8.7	Unidentified skid located in sheet nonconforming area. *Skid identified as a scrap skid and scrapped prior to end of audit.	X		