# **Audit Review and Evaluations OF**

## **JEMISON METALS**

8100 Aetna Road Cleveland, OH 44105

> Dates of Audit: 8/24/21 -8/25/21 Date of Submittal: 9/2/21

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 Electronic), JDM-F-001Mill/Receiving Information Rev-2 Dated 7/30/13, JDM200 Quality Policy Rev-1 (Multiple locations, listed in hardcopy listing, to include Receiving & CR2), Auto-generated work order for CR2 from Stelplan (PN: CLV-79139), CLV-RB-002 Rev 5 (MF#1, Hardcopy was posted at the machine, near the measurement table with sampling frequency highlighted), FQA066 (Calibration Worksheet) Rev 3 (Observation #3, Gagetrak not operational due to computer having to be replaced; however, all gauges were being tracked manually and checked out as in calibration), Auto-generated loading order from Stelplan (CLV 129741, Lincoln Electric).

#### 7 Support

Employees appeared competent and well trained. Adequate resources (gauges, safety equipment, operating equipment, environment) were observed during the audit. Observation #1, Receiver (Anthony Walton) was able to pull up the receiving procedure with some minor assistance. Opportunity for Improvement (OFI #2, Redbud Operator, Darrell Williams, could point to the hardcopy quality policy posting; however his explanation of his role relative to quality could use some improvement. His performance of job duties on work order CLV-79139 was excellent.

#### 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

Denyo production on P/N CLV-79139 (CR2) was observed. Inside sales handled by Denise Clayton, James Stephens is the Territory Manager. CR2 P/N CLV-79139 was created to support Sales Order CLV-99513. Customer release was based on an emailed excel document against Denyo purchase order number 70075572. Email from Denyo dated 8/11/21 and was confirmed back by Inside Sales on 8/12/21.

8.4 Control of externally provided processes, products and services Mill coil 4237310.000, Master tag ND24973 (Nucor Decatur) was utilized for the Denyo production on P/N CLV-79139. This coil was purchased on Jemison PO# CLV-027815-001 and

received on Receiver# CLV-054206-001 on 7/6/21. PO date was 4/28/21, due week of 6/19/21. ASTM A1008 CR Coil, CS Type B, .0687" min x 59.925" Wide. Nucor Decatur acknowledged on 5/10/21 for week ending 6/19/21. Nucor Order # 318140, Original Mill Test Report # 86519.

#### 8.5-Production & Service Provisions

Receiving: Anthony Walton was audited for the first portion of the 1<sup>st</sup> receiving step. JDM-F-001, Mill/Receiving Information form (Rev. 2 7/30/13) was observed. All fields were filled out appropriately. The auditor observed the receiving of a customer owned coil (Arrow-Tru-Line), Mill Coil 21H944917A, Jemison Tag 25580. The receiver weighed the coil and verified weight against the mill paperwork. The weight was within 40 lbs of the mill reported weight. The coil was placed in location B15 and the paperwork was turned into Sandy Damato for review and tag printing. The auditor later reviewed the coil to see that the tag was in fact hung on the coil. The paperwork was then turned into Kathy Manka for the second receiver process. Kathy performed the second receiver steps to release the coil to inventory.

Production: Work order 79139, Denyo, was observed on CR2 (Redbud). Operator was Darrell Williams. All checks performed per Redbud Operating procedure (CLV-RB-002) and the customer part specification requirements. Thickness, width, length, square, packaging, and piece count were all within work order requirements (see notes, page 2, for further details).

Preventive Maintenance: Reviewed with Larry Strimple, Schedule calendar for July reviewed & complete. Also reviewed the following specific items for August. A-Bay Crane (Receiving, Serial # 92146, monthly inspection was performed on 8/9 on form MF056 Rev 3). Annual crane inspection reviewed for A-Bay Crane, Serial #92146, performed by Star Crane & Hoist on 10/16/2020. 4 safety items were identified in this report; #1 Wire rope needs replacement, #2 Limit switches needed replacement, #3 Bumpers needed replacement, and #4 Bumper extensions should be removed from trolley. Items 1-3 were completed. Item 4, bumper extensions needing to be removed was performed as they were being stored and secured on the crane, but were not in use. CR2 (Redbud) PM sheet was reviewed. All 3 pages of the PM sheet were filled out appropriately and documented on 8/2/21. Forklift ERC100 maintenance records were reviewed and were up to date through 8/23/21 with no issues observed.

Shipping: Tyrone Vason was interviewed in shipping. Tyrone has over 40 years in this facility. Shipping Work Order CLV PI-993724, which later became Loading Order CLV-129741, to Lincoln Electric was audited. The initial work order listed 13 skids of Lincoln part number RMB53-100 (CRS/12/CSB 48x96) totaling 48,712 lbs. 12 skids (44,788 lbs) were loaded per the updated Loading Order, due to the constraints of the particular truck assigned to the load. Loading order remarks were verified while the truck was loaded. Specifically, skids not to be stacked more than 4 high and 2 boards running the full 96" length. Observation #2, there was a conflict on the loading order. Specifically, one remark said material not to exceed 4", while another said 3" max height of material. I believe this conflict exists between a global shipping remark vs the part spec shipping remark. All skids were less than 3" in height, so there was no escape. OFI #3 – there were two opportunities for improvement. First, there was a note that said "Toll Processing".

This is not a toll processing customer and this could create confusion. Second, the loading order says "All Times Noted are Central Standard Time". Since this customer is in the eastern time zone and our plant is in the eastern time zone, it seems that adjusting the times to eastern time would prevent confusion for plant personnel.

ASL: The following suppliers were verified as active on the Approved Supplier Listing: Nucor Decatur, Star Crane & Hoist, Broadview Instrumentation Services

#### 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 (Sept 2020, due Sept 2021), Rockwell Hardness Testers 811-21 & 869-015 (6/10/21, due Dec 2021 for both).

Redbud: 0-1" Mic, ASP016 (Aug 21, due Sept 21), Raytech Table (Dec 19, due Dec 22), 25' Tape Measure ID14, 16' Tape Measure ID1&2 (All 3 Sept 20, due Sept 21), 0-24" Caliper ID180 (Jun 21 due Sept 21) OFI#1 – the 24" caliper is not used as the Raytech table is easier to use. Consider moving this to the office and keep as backup in case there is an issue with the Raytech table. This will also prevent potential damage to the caliper.

Office: .250" gauge block ID90337 (Nov 20, due Nov 23) per Broadview Instrumentation Services (BIS), BIS Report#441543579, 24" Caliper Standard (Nov 20, due Nov 23) per BIS Report#441584730

Broadview Instrumentation Services A2LA Cert# 2046.01, verified on A2LA's website, expiration 3/31/23 ISO/IEC 17025:2017.

#### 8.7 Control of Nonconforming Product

Both sheet and coil nonconforming areas were clearly delineated and neat. All audit samples met nonconforming identification criteria.

Coil: The coil nonconforming area had 4 coils in it. 2 tags were recorded and researched in the system. Tag 253153, dated 7/14/21 was in the stelplan reject warehouse with tag remarks "no good rust". Tag 306945, dated 7/2/21 was in the stelplan reject warehouse with tag remarks "rust".

Sheet: The sheet nonconforming area had several stacks of material in it consisting of multiple bundles each. 4 tags were recorded and researched in the system. Tag 25397, dated 8/10/21, was listed in the stelplan reject warehouse with tag remarks "bowed'. Tag 242256, dated 11/27/19, was actually in the scrap warehouse with an R status. Tag remarks were "end of coil deep scratches". Tag 253581, dated 8/4/21, was listed in the stelplan reject warehouse with tag remarks. Tag 248232, dated 11/2/20, was actually in the scrap warehouse with an R status.

# 10.2 Nonconformity and Corrective Action No open corrective actions in Cleveland.

10 Continual Improvement

Upgrade to scrap winder and tensioner New bearings on Loopco Uncoiler Knives & Rubbers Capex complete

Observations and findings from previous ISO audit (12/29/21)

MF1 None

Observations:

1 Receiving BOL copy from PO 27249-1 not signed or dated by Jemison personnel. BOL C885471, from the Denyo Nucor Decatur Coil ND24973 was initialed and dated by Anthony Williams on 7/6/21 against receiver 54206 during this audit.

## 2.0 Overview

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

Anthony Walton - Receiver	Kathy Manka-Production Planner/2 <sup>nd</sup> Receiver
Sandy Damato – Traffic/Receiver	Darrell Williams – CR2 Operator
Larry Strimple-Maintenance &	Tyron Vason - Shipping
Calibration	Denise Clayton-Inside sales
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## 2.2 Audited Requirements

4	Context of the Organization	8	Operation
4.4	Quality Management System	8.1	Operational planning and
and its process	ses		control
5	Leadership	8.2	Requirements for products and
5.1	Leadership and commitment		services
5.1.2	Customer Focus	8.3	Design and development of
5.2	Policy		products and services (N/A)
5.6	Management review	8.4	Control of externally provided
6	Planning		processes, products and
7	Support		services
7.1.1	General	8.5	Production and service
7.2	Competence		provision
7.1.3	Infrastructure	8.7	Control of nonconforming
7.1.4	Environment for the		outputs
opera	tion of processes	9	Performance evaluation
7.1.5	Monitoring and measuring	9.1	Monitoring, measurement,
resou	rces		analysis and evaluation
7.5	Documented information	9.1.1	l General
		9.1.	3 Analysis and evaluation
		10	Improvement
		10.2	Nonconformity and corrective
		action	2
0.0.4			

### 2.3 APPROVAL/SIGN-OFF

Report Prepared by Rick Rowland

Date 9/15/21

Nonconforming Corrective Action Report (CAR)

CAR	ISO 9001:	Findings/Requirements	Observation	Minor	Major
#	2015 Clause /				Ŭ
	Sub-Clause				
21576	7.5	Minor Finding #1: Hardcopy of CLV-RB-002 was posted at the machine near the measuring table, with sampling frequency highlighted. Document was revision #5, which was the current revision.		Х	
NA	7.2	Observation #1: Receiver was able to pull up the receiving procedure with some minor assistance.	Х		
NA	8.1	Observation #2: There was a conflict on the loading order regarding max stack height (one area said 4" max, another said 3" max). Material being loaded was not in excess of either measurement.	Х		
NA	7.1.5	Observation #3: Gagetrak was not operational due to a computer having to be replaced. However, all gauges were being tracked manually and all sampled gauges were found to be in calibration with appropriate documentation.	Х		
	7.1.5	OFI #1: The 24" caliper is not being used at the Redbud because the Raytech table is easier to use and is more accurate. Consider moving this to the office and keeping it as backup.	OFI		
	7.3	OFI #2: Redbud Operator could point to the hardcopy quality policy posting; however, his explanation of his role relative to quality could use some improvement. Consider some coaching here.	OFI		
	8.1	OFI #3: See bottom of page 3, top of page 4 regarding reference to toll processing and times denoted in central time zone. Consider removal of toll processing reference and switching everything to the eastern time zone, which is where the plant and the customer are located.	OFI		

JEMISON DATE: TO: METALS CLV Infernal Audit FROM: 8/24/21 Anthony walton ~ 2yrs at Junison 2yrs Rovg. Coil Reject Avea 4 Corls total All @ 253153 R No Good Rust Labeled R Receiving 7/14/21 Ju Stelplan Broker 0 306945 R SPI Col ( 41, 240, 41, 200 Actual Rust vIn Stelplan Broker Threshold = 1001bs bring it up to someone else Area clearly chained off + identified 7/2/21 & Quality Policy Hardcopy in Lab Beside Rockwell Tester. Sheet Reject Area OBS#1 Anthony could get to receiving 025397 R S/10/21 Bowed V Il pcs. In Stelplan Procedure with some assistance. 0 24 2256 R 11/27/19 & JDM-F-001 Mill Roug Info End of Coil Deep 21 Scrafches 1.50 4 pcs 917 165 Rev. 2 7/30/13 Pa .1749 Nom X48×96 HRPO CSBTP SDI Coil - Customer owned @ 253581 R 8/4/21 Roller Marks for Arrow-Tru-Line .0478 CR 48×144 CSB . 0555 × 46.7750" V In Stelplan 0 248232 R HRPO? check on this. Placed in Location B15 In Stelplan 11/2/20 C CSCRU Patoick BOL initialed for Turn-in Form TDM-F-001 + Bol's Receiving Gauges furned into sandy Hardness Testers 811-21 6/10/21 due 12/21 She Prints Tags + Does 2nd Ø 1 140 2 869-015 6/10/21 due 12/21 Receiver, Anthony Hangs Tass. N NO 10. 10 3 16' Tape Measure Ø ag Hung. 25580 (3) (3) Customer Owned. Sept 20 due Sept 21 Kathy Monka Zue Ravr. Compares PO to the received Info (BOL, MTR etc)

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EMISO DATE: TO: METALS SRB FROM: Darrell Williams Redbud Operator 2'2 yrs QJem. ~ lyr SRB ME#1 O CLV-RB-002 Hardcopy Posted @ SRB 8/6/19 Rev. 5 Dorrell could Explain the procedure. I Find it on intranet CLV 79139 (Work Order) CLV-993513510 Denise Clayton Inside O CR/14/CSB/60 ND24973 V Gauge .0697 -. 0787 .071-.072 Actual Width 59.925-60.125 60.00 Actual V Length 120-120.125 120,062 Actual .062-.093 Actual Square . 31 max JD6 28pcs on W/o Packaged on JD6 2" Edge Protectors, wax stripson skid, Paper Wrap on Top, 2×2 Bonding. 28pcs Gauges Aug 21 0-1 Mic ASPOLG Scp 21 Dec 19 BayTech Table Due 12/10/22 Dec 22 OFI # 0-24" Caliper 180 Jue sy 21 Not Needed due to table? Verify W/Michael O Remove, not 25' Tape 14 Sep 20 due sep 21 16 Tape IOI, ID 2 Sep 20 due Sep 21 Darrell Could Show QA Policy - Explanation could use some work 2

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Phone: 205-986-6600 Fax Administrative: 205-986-6601 Sales: 205-986-6604 Purchasing: 205-986-6606

EMISON DATE: 8/25/21 TO: METALS FROM: Tyrone Vason Shipping -15 4/0 w/2 Load Sheet, Find Tags, stage CLV PI-993724 CLV 129741 Lincoln Electric 48,712165 13 Bundles. 44,788 45 12 Bundler CRS/12/CSB 48×96 RMB53-100 All 12 loaded. 4 high. 085#2 ) Part Spec Remark - moterial not to exceed 4" Global Shipping Remark 3" May Ht of Unteriol V2 Boards Running full 96" O Tall Processing in Remarks OFJ3D Loading Order Says \* All Times Noted are Central Standard Time Culibration NF#2 Gase trak Issue Verified Gauges at REVG + SRB Allok . 250" Gouge Block Nov: 20 Broadview Instrumentation Services. 90337 due Nov 23 BIS Report# 441543579 V 24" Coliperstd. Nov 20 due Nov 23 AZLA Cert # 2046.01 Exp. 3/31/23 BIS Report # 441584730 I SO/IFC 12025:2017 # Maint. Monthly Schedule RBI2 P.M. Sheet 3 pgs All good. No Comment Made Annual by Star Crone & Hoist Crane PM. A-Bay 25 Ton Serial # 92146 10/16/2020 V4 Safety, Items I. Dentified Monthly performed 8/9/21 all ok Extensions NIA Forklift ERC 100 De to date thus 8/23/21 all Acceptable 3 3800 Colonnade Parkway · Suite 250 · Birmingham, AL 35243



DATE:	 
<u>TO:</u>	
FROM:	

Purchasing

ND 24973 from w/o CLV 79139 at CR2
Purchased on PO# CLV-27815 4/28/21 90,0001bs Due 6/19/21
.0687 min × 59.925 Wide @ ASTM A1008 CSB Light Oil
Nucor steel Decatur Order Acknowledged on 5/10/21 WK Ending 6/19/2/
Nocor Order # 318140, Original MTR # 86519
Sales
Denyo observed at CR2 on Sales Order CLV-993513
Customer Release based on email excel Document on PO 70075572
Email Dated 8/11/21 Confirmed back via email on 8/12/21
4

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