

**Audit Review and Evaluations
OF
JEMISON METALS**

**8100 Aetna Road
Cleveland, OH 44105**

Dates of Audit: 9/23/22

Date of Submittal: 12/29/22

Auditors: Patrick V. 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 Electronic), JDM-F-001 Mill/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-82341), CLV-RB-002 Rev 5 Hardcopy was posted at the machine, near the measurement table with sampling frequency highlighted, Documented in "Master Listing of Hardcopy Controlled Documents" In Quality Intranet, Auto-generated loading order from Stelplan (CLV 13316, Lincoln Electric).

7 Support

Employees appeared competent and well trained. Adequate resources (gauges, safety equipment, operating equipment, environment) were observed during the audit. Anthony Walton was able to pull up the receiving and Quality Policy without issue and was familiar with both. Clearly explained Quality Policy meaning and his role in achieving the quality goals as stated in the Policy. Darrell Williams, performance of job duties on work order CLV-82341 Customer AMC was excellent. Tom Rodriguez performance of job duties on work order CLV-82385 Customer Lozier was excellent.

7.2 Competence

Reviewed JDM-F-014 Rev 0, training status matrix. Up to date. This matrix is in the process of being replaced by a more comprehensive document whose roll out is expected in the first or second quarter of 2023.

8.2 Requirements for products and service

AMC on P/N CLV-82341 (CR2) was observed. Inside sales handled by Susanna Swift, Joe Merritt the Territory Manager. CR2 P/N CLV-82341 was created to support Sales Order CLV-999047. Customer release was based on an emailed purchase order number 11857. Email received by Susanna Swift 9/7/22, Acknowledged same day.

8.4 Control of externally provided processes, products and services

Mill coil 987602-02b, Master tag 670051 (AK Steel Corp) was utilized for the AMC production on P/N CLV-82341. Coil was transferred from SMT facility on Transfer 16203 on 2/14/22. This coil was purchased on Jemison PO# SMT 27885-001 and received Into Sumter on Receiver 62954 on 11/15/21 CR Coil DSENT Type 1, .04325" min x 52.5" width.

Coil met all PO order requirements.

8.5-Production & Service Provisions

Receiving: Anthony Walton was audited for the first portion of the 1st 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 Two Metal One coils from Cleveland Cliffs Coil numbers T44732 (Jemison tag 29101), and T44733 (Jemison tag 29102). The receiver weighed the coil and verified weight against the mill paperwork. The weight was within 40 lbs of the mill reported weight. The coils were placed in inventory 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 82341, AMC, was observed on CR2 (Redbud). The 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.

Production: Work order 82385, Lozier, was observed on CLO (Slitter). The operator was Tom Rodriguez. All checks performed per Loopco Operating procedure (CLV-SL-001) and the customer part specification requirements. Thickness, width, and camber were all within work order requirements.

Preventive Maintenance: Reviewed with Larry Strimple, Schedule calendar for August reviewed & complete. Also reviewed the following specific items for August. RBI-2, CR2 (Redbud) PM sheet was reviewed. All 3 pages of the PM sheet were filled out

Shipping: Anthony Hartman was interviewed in shipping.

Shipping loading Order CLV 133316, to Lincoln Electric was audited. Lincoln specific instructions were present on the loading instructions, Specifically, skids not to be stacked more than 4 high and 2 boards running the full 96" length.

Loading order 133374 for Arrow Tru-Line loading observed. No loading instructions present on the B/L. All shipping personnel were very familiar with the shipping requirements but only as

“tribal” knowledge as it was not documented with instructions. ([OFI 1-List loading instructions on global remarks under shipping](#))

ASL: The following suppliers were verified as active on the Approved Supplier Listing:

Metal One, 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 2022, due Sept 2023)

Redbud: 0-1” Mic, ASP016 (Sep 22, due OCT 22), Raytech Table (Dec 19, due Dec 22), 25’ Tape Measure #14 ([OBS 1 Tape was present and calibration record was up to date, but no legible identification was present](#)), 16’ Tape Measure 1&2 (All 3 Sept 22, due Sept 23)

Office: .250” gauge block ID90337 (Nov 20, due Nov 23) per Broadview Instrumentation
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: No coil currently present in nonconforming coil area.

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. Tags 259563, 358704, 261160, and 262788. All found to have current information.

10.2 Nonconformity and Corrective Action

No open corrective actions in Cleveland.

10 Continual Improvement

Training log replacement in production phase to be rolled out in first half of 2023

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

MF:

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.

OBS:

Observation #1: Receiver was able to pull up the receiving procedure with some minor assistance.

Observation #2: There was a conflict on the loading order regarding max stack height (one area said 4max, another said 3 max). Material being loaded was not in excess of either measurement.

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.

OF

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 #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 #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.

All reviewed and addressed in Corrective action 21576 entered 9/15/2021 closed 11/19/2021

2.0 Overview

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

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| Larry Strimple-Maintenance Anthony Walton-Receiving Darrell Williams-RBI2 Operator Tom Rodriguez-CLO operator | Kathy Manka-Production Planner/Receiver Susanna Swift-Inside sales |
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2.2 Audited Requirements

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

Report Prepared by Patrick Macias

Date 12/29/2022

Nonconforming Corrective Action Report (CAR) for Jemison
Metals

| CAR # | ISO 9001: 2015 Clause / Sub-Clause | Findings/Requirements | Opportunity for improvement | Observ ation | Mino r | Major |
|------------------|---|---|--|-------------------------|-------------------|--------------|
| NA | NA | Arrow Tru-Line loading instructions were not present on loading order although all shipping employees are very aware of loading requirements. | X | | | |
| NA | 7.1.5 | Tape was present at Redbud and calibration record was up to date, but no legible identification was present. | | X | | |
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