

# Audit Review and Evaluation of Jemison Metals

8100 Aetna Road  
Cleveland, OH 44105

Dates of Audit: 3/29/17  
Date of Submittal: 5/20/17

Auditors: Rick Rowland – SR VP Quality & Engineering

## 1.0 Summary

This internal audit review provided an evaluation of Jemison Demsey Metals' current level of conformance to ISO 9001, 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 (see audit areas underlined in 2.2 below). **Based upon my review, the QMS is effectively implemented.**

### Audit Detail/Observations/Findings (Detail listed in table at end of report)

4-QMS - Documentation requirements – The following forms and documents were verified during the audit: CLV-RC-001 (Receiving Procedure, [hardcopy posted but not listed in hardcopy listing, Minor Finding #1](#)), JDM-F-001 (Receiving Form), JDM200 (Quality Policy), MF021 (Maintenance Checklist), SAF063 (Crane Inspections), JDM13 (Quality Checklist)

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

### 7.2 – Customer Related Processes

PO 8873667 sent on 3/28/17, due on 3/29/17. Order acknowledged on 3/28/17 by Jim Gagnon.

### 7.5-Production & Service Provision.

Receiving of customer owned coil 17083007, heat 31708330, was observed during receiving. Placed into inventory by size. B16/B17. [Sonny Wiseman was performing the receiving but was unaware of the receiving procedure. Observation #1.](#) Documented OJT was performed by Jack Cochran prior to the end of the audit. [Observation #2 – Receiving procedure, step 3, calls for coil weight verification. This was not performed on the coil being received.](#)

Work order 64280 (Liebert Ironton) was observed in production on the Redbud. Gauge, width, length, flatness, square were all within the work order requirements. Purchase requirements of master coil (PO CLV23811) was verified against work order/part spec requirements.

Shipping was audited. Load CLV109911 (Lincoln Electric) was observed with Tyrone Vason. The wrong tags were applied by sales and was caught by shipping personnel. The error was corrected by sales and the load was completed according to all requirements.

Preventive maintenance was reviewed with Rick Ladow. Redbud preventive maintenance was documented on MF021 and daily crane inspections were observed on SAF063 for crane (Demag 10T in B-Bay).

7.6-Control of Monitoring and Test Equipment. The following gauges were verified to be calibrated in compliance with calibration records: Receiving (0-1” Mic 014, Jo Block 000460, Rockwell Testers 81121 & 869015, Crane Scale Block),

8.3-Control of Nonconforming Product – The sheet non-conforming area was well defined and all material in this area was tagged appropriately. [Minor Finding #2 – 1 coil was on the “reject” rack that was not a reject coil. Additionally, 4 coils were adjacent to the reject rack of which 2 were reject coils.](#)

### Corrective/Preventive Action Follow-Up

CA 12511 – Reviewed. Steve should add remarks in follow-up if the part spec has been updated.

CA 12430 – Verified. Close.

CA 12214 – Verified. Close.

CA 11941 & 11725 – could not verify in this audit.

CA 11658 – needs follow-up remarks.

## **2.0 Overview**

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

Sonny Wiseman (Receiving) Jack Cochran (Redbud Operator) Jim Gagnon (Inside Sales) Steve Busicnki (QA)	Rick Ladow (Maintenance)
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### **2.2 Audited Requirements**

<p><b>4 Quality Management System</b></p> <p>4.1 General Requirements</p> <p>4.2. Documentation Requirements</p> <p><b>5 Management Responsibility</b></p> <p>5.1 Management Commitment</p> <p>5.2 Customer Focus</p> <p>5.3 Quality Policy</p> <p>5.4 Planning</p> <p>5.5 Responsibility, Authority and Communication</p> <p>5.6 Management Review</p> <p><b>6 Resource Management</b></p> <p>6.1 Provision of Resources</p> <p>6.2 Human Resources</p> <p>6.3 Infrastructure</p> <p><u>6.4 Work Environment</u></p>	<p><b>7 Product Realization</b></p> <p>7.1 Planning of Product Realization</p> <p>7.2 Customer-Related Processes</p> <p>7.3 Design and Development (N/A)</p> <p>7.4 Purchasing</p> <p><u>7.5 Production and Service Provision</u></p> <p><u>7.6 Control of Monitoring and Measuring Devices</u></p> <p><b>8 Measurement, Analysis and Improvement</b></p> <p>8.1 General</p> <p>8.2 Monitoring and Measurement</p> <p><u>8.3 Control of Nonconforming Product</u></p> <p>8.4 Analysis of Data</p> <p><u>8.5 Improvement</u></p>
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### 2.3 APPROVAL/SIGN-OFF

Report Prepared by Rick Rowland

Rick Rowland  
Lead Auditor/QMR

Date **20 May 2017**

Nonconforming Corrective Action Report (CAR) for Jemison Metals

<b>CAR #</b>	<b>ISO 9000: 2000 Clause / Sub-Clause</b>	<b>Findings/Requirements</b>	<b>Observation</b>	<b>Minor</b>	<b>Major</b>
1	4.2.3 (Control of Documents)	<u>Minor Finding #1</u> - CLV-RC-001 (receiving procedure) was posted in receiving, but is not listed in the hardcopy posting listing.		X	
n/a	7.4.3 (Verification of purchased product)	<u>Observation #1</u> - Receiving personnel were not aware of the receiving procedure. Documented OJT performed prior to the end of the audit.	X		
n/a	7.4.3 (Verification of purchased product)	<u>Observation #2</u> - Receiving procedure, step 3, calls for coil weight verification. This was not performed on the coil being received.	X		
2	8.3 (Control of non-conforming product)	<u>Minor Finding #2</u> - 1 coil was on the “reject” rack that was not a reject coil. Additionally, 4 coils were adjacent to the reject rack of which 2 were reject coils.		X	

CLV Internal Audit 3-29-17

## Receiving-

Sonny Wiseman

OJT w/ Jack

Some Responsibilities w/ Sandy during Training

SOI .0440 x 45312 42,250 lbs Customer Owned.  
for Arrow  
Mill Coil # 17083007  
Heat 31708330

Placed into inventory by size. B16/B17

## Reject Areas

Sheet: 13 Rundles in Reject  
Well-Defined Area, clearly delineated.  
All Tags have "R" status

Coil: 4 Coils on Reject Rack  
3 have R status  
1 has W status on Job  
4 additional Coils Adjacent to Rack  
1 23762 - orange Tag W/HS LOC  
2 224931 - R status + Reject Tag (orange)  
3 23763 same as #1 above  
4 224877 R status + Reject Tag (orange)

Redbud Jack Cochran  
w/o 64280 CLV 966305-1 Liebert Ironton  
Part 6887/R5-8107

Gauge .0330 - .0340 .0325 - .034  
Width 40.75, -0 + .187 40.765"  
Length 120, -0, + .25 120.187"

Flatness .12 - ok'd by Jack (sup.)  
Square .05 max 0 to .05"

Material To be used 224624 CPW .0325 min x 41.25  
JD7 Packaging  
JDM13 3/1/17 Rev. 7

Sales Jim Gagnon

PO 8873667

sent on 3/28/17, due on 3/29/17

order acknowledged 3/28/17 ✓

Error was from Pulling from stock Available  
+ Missing/Jumping a couple of line items  
as the Tags do show which customer  
the material is assigned to when you  
drill down into tag details.

CA. 12511 - state should add Remarks in Follow-up, if  
the part spec language has been updated

C.A. 12430 Verified. Close. RR  
C.A. 12214 Verified. Close. T2R  
C.A. 11941 Couldn't Verify  
C.A. 11725 " "  
C.A. 11658 Needs Follow-up Remarks

Finding #1  
Hardcopy of RCVG  
Procedure Posted in  
Rcvg. Not in Hardcopy  
Post Listings.

Form JDM-F-001 Rev 2 7/30/13  
in use

CLV-RC-001 Rev. 0 12/5/16  
Hardcopy Posted in RCVG  
QA Policy Hardcopy Posted in RCVG  
JDM 200 Rev. 0 5/15/2010  
D-1" M.c 014 Due 4/17  
RCVG

000460, due 10/12/17 J5-Block  
Rockwell 81121 Due 6-17  
Rockwell 869015 Due 6-17  
Crane Scale Block Due 4/17  
JD?

## Preventive Maintenance Risk Ladow

Redbud. Once/month  
RDI II Last Documented Feb. 2017  
MFOZI checklist  
Crane Inspections - Daily  
Sam Daily  
SAF 063 12/12/12 Rev. 3  
Demag 10T B-Bay

Shipping, 8/4/109911 Tyrone Vason  
Load # CLV 109911 - Lincoln Electric  
Wrong Tags Applied to Load  
by Sales. Shipping caught  
it because Pkg is different

13 Tags. 28,566 lbs.  
sheet lifter unload  
Must be Taped.  
Load match, pulled Tags after on Truck

Sales  
Load # CLV 109911 Lincoln Electric  
- why the Tag error?  
{ 82185 was one of the wrong  
.0478 Nom x 48 x 26  
CR CS-8

THE LOHR

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COMPANY...THE CAROLINAS