

Audit Review and Evaluations of JEMISON METALS

**914 Maero St. NW
Trinity, AL 35673**

Dates of Audit: 9/25/19
Date of Submittal: 11/15/19

Auditors: Brian P. Smith – Quality Manager-Central Region

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 – Documented Information

The following forms and documents were verified during the audit: GAD009 9.18.17 Rev Level 2 in Receiving, DEC-BB1-CTL 6.26.17 Rev Level 4 at the operator's platform, JDM-VA-0018.31.10 Rev level 0 at operators platform and at packaging computer. JDM200 Quality Policy 7.21.18 Rev-1 posted at bulletin board. Training Status Matrix JDM-F-014 11.25.18.

7 Support

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

7.2 Competence

Interviewed Greg Chandler and Bronnie Grissom, both were able to locate the Jemison Quality Intranet, Quality Policy and Procedures. Bronnie was able to elaborate on how he contributes to the quality policy by performing his required quality checks.

Reviewed Training Status Matrix JDM-F-014 11.26.18 Rev 0 which had employees clearly identified, Greg and Bronnie both competent and fully trained.

8.2 Requirements for products and services

Eaton Mexico PO# 4165-024477 sent 9.2.19 with a due date of 9.30.19. Sales order 90805 entered by Sam Curtis on 9.20.19 which shipped on 9.30.19 on BOL 79188.

8.4 Control of externally provided processes, products and services

Coil 3713979.000 received under 48200.

- **Minor 1: It was stated that complete coil inspections are only required when time permits. Mostly verify coil numbers and weight to the PO. This contrasts to the receiving procedure on DEC-RC-001 6.23.14 Rev 0.**

8.5-Production & Service Provisions

Production job number 103391 for Eaton Mexico was observed on the BB1 cut to length line. Quality checks were being performed and documented in accordance with the requirements by Bronnie Grissom.

Packaging job number 103391 for Eaton Mexico was also reviewed and met the requirements of the packaging specs. It was also noted that packagers were checking the top sheet of every bundle for any surface defects before paper wrapping per the order requirements. This was clearly explained by Nate Morgan. He also referenced the visual aid posted by the packaging computer (DEC-VA-PKG01 – Eaton MX 7.11.18 Rev 1).

7.1.3 Infrastructure

Preventive Maintenance: James Bryant was able to provide completed August PM schedule.

- Observation 1: September records were recorded with a 2018 year date and appears to be a typo since August had correct year date recorded.

7.1.5 Monitoring and Measuring Resources

The following gauges were verified to be calibrated in compliance with calibration records:

Receiving:

Micrometer serial number 009 due July 2020 and calibrated July 2019

Tape Measure serial number T1027 due July 2020 and calibrated July 2019

BB1 CTL:

Micrometer serial number 009 due July 2020 and calibrated July 2019

AGT 800 laser gauger due 1.31.20 and calibrated 7.19.19

Step gauge serial number ST-8 due July 2020 and calibrated July 2019

Tape Measure serial number T3033 due October 2019 and calibrated October 2018.

Flatness Table serial number 63332 due 2.13.20 and calibrated 2.13.19.

8.7 Control of Nonconforming Product

Nonconforming area was neat and identified with tags that had descriptions in the comments about the defect.

10.2 Nonconformity and Corrective Action

CA 15878 reviewed and confirmed as effective during production run at BB1. Operators were taking the required samples and performing inspections.

10. Improvement

Absorb training software in process.

GAGEtrak calibration management software to be completed and implemented Q4 2019.

. SRI audit registration notes:

1. Caliper Calibration - 4 measuring uses, but we're only calibrating the main jaws. We need to create a new caliper calibration sheet. Don't have to do multiple checks on each of the 4, just multiple checks on the main jaws and 1 check on the other 3 to ensure they match up.

Complete 4/10/19 new document live 4/25/19

2.0 Overview

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

<p>Bronnie Grissom – BB1 CTL Operator Nate Morgan – Packaging Greg Chandler - Receiver</p>	<p>Sam Curtis-Inside sales Justin Pate - Plant Manager James Bryant - Maintenance</p>
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2.2 Audited Requirements

<p>4 Context of the Organization 4.4 Quality Management System and its processes</p> <p>5 Leadership 5.1 Leadership and commitment 5.1.2 Customer Focus 5.2 Policy 5.6 Management review</p> <p>6 Planning</p> <p>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</p>	<p>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</p> <p>9 Performance evaluation 9.1 Monitoring, measurement, analysis and evaluation 9.1.1 General 9.1.3 Analysis and evaluation</p> <p>10 Improvement 10.2 Nonconformity and corrective action</p>
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2.3 APPROVAL/SIGN-OFF

Report Prepared by Brian P. Smith

Date 9/25/19

Nonconforming Corrective Action Report (CAR) for Jemison Metals

CAR #	ISO 9001: 2015 Clause / Sub-Clause	Findings/Requirements	Observation	Minor	Major
M 1	8.4	Receiving procedure not being followed at all times.		X	
NA	7.1.3	Recorded wrong year date for September PMs.	X		