

Audit Review and Evaluations of JEMISON METALS

**3001 Hickory Street
Gadsden, AL 35904**

Dates of Audit: 10/25/24
Date of Submittal: 10/31/24

Auditors: Craig Scott - 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

- > GAD-LA-001, GAD-PB-001, GAD059, JDMF-015, GAD-009

7 Support

- > Associates on the floor are competent with one being unsure of the job requirement because it changes often. This is not unusual for a smaller manpowered operation, but roles and responsibilities could be better defined to eliminate frustration or confusion.
- > Tools at the processes were clearly identified with the new tables giving the associates a dedicated place to work and keep supplies.
- > Group training has been very beneficial and done on a regular basis with process changes.
- > The Quality policy is not well known and could be better communicated and visible.

7.2 Competence

- > Associates audited were Johnny Helms, Daniel Jones, Jesus Gamez, Charles Love, Mark Clough, Cody Mathis, Phillip Mathis and Logan Shinn. Associates have a solid understanding of processes and daily tasks.

8.2 Requirements for products and services

- > Sales order 140867 Gorbelt verified with acknowledgement back to the client.
- > Blue Bird orders verified via client portal parts123 and order acknowledgement.
- > PO GAD-24201 to Nucor verified with order acknowledgement from the mill for sales order Gorbelt 140867.

8.4 Control of externally provided processes, products and services.

- > The receiving associate was very knowledgeable and knew where to locate his procedure on the intranet.
- > POGAD-24144 was verified with correct BOL, receiver and incoming inbound inspection report.

7.1.3 Infrastructure

- > Infrastructure from a preventative maintenance and facilities standpoint is managed by external software called E-Maint. Work order 6802 was verified as started and complete with associate responsibility and hours recorded.

7.1.5 Monitoring and Measuring Resources

- > Calibrations are monitored and stored by external software called GaugeTrak. A report was run for the Gadsden facility and all gauges show up to date at the time of this audit. The gauges were verified as present at GL8, GL7 and PB2.
- > The fabrivision, laser measuring table, is hard to keep clean and protected in the shop (near laser 6). Should consider moving it to a safer cleaner location, such as the quality lab, to preserve it.

8.7 Control of Nonconforming Product

- > Non-conforming products are accumulated and disposition in the reject area that is designated and lined off in the southeast corner of the plant.
- > The following tags were confirmed in the reject area as well as StelPlan.
 - ✓ 914873R - GE Lighting
 - ✓ 908624R Eaton TN
 - ✓ 908623R - Eaton TN
 - ✓ 233519R - Eaton TN

10.2 Nonconformity and Corrective Action

- > Nonconformities are pushed back to the line via a Quality Alert and left for 2 weeks with training and sign off by the associates.
- > Corrective action report 24-5732 (Bluebird) verified and communicated back to the client via email 7/29/2024.

10. Improvement

- > New production tables were built and placed at all laser work cells for associates.
- > Rolling tables being built to facilitate better material handling at the press brakes.
- > 5S racks installed for each production process.
- > Ethernet cables were run to each press brake for network connectivity.

2.0 Overview

<p>Logan Shinn - Quality Mark Clough - Plant Manager</p> <p>Phillip Mathis - Maintenance Daniel Jones - Laser 8 Johnny Helms – FGs Handler</p>	<p>Jesus Gamez - Press Brake Cody Mathis - Shipping</p> <p>Charles Love - Inside Sales Eric Edgeworth - Receiving</p>
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2.1 Personnel Interviewed (Audit evidence found in the Audit Worksheets) _____

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 Craig Scott

Date 10/31/2024

Nonconforming Corrective Action Report (CAR) for Jemison Metals

CAR #	ISO 9001: 2015 Clause / Sub-Clause	Findings/Requirements	Observation	Minor	Major
	7.1.5	Should consider moving the Fabrivation laser measuring table into the quality lab for a cleaner environment and to better protect it.	X		