

Audit Review and Evaluations of JEMISON METALS

**3001 Hickory Street
Gadsden, AL 35904**

Dates of Audit: 10/29/25
Date of Submittal: 12/11/25

Auditors: Rick Rowland – SR VP QA & Eng.

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 and were found to match the current revision level and date on the master listing: JDM-F-014 (GL4), JDM011 (Slitter), GAD009 (Receiving), JDM200 (Breakroom, Main Office, Plasma)

7 Support

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

Tools at the processes were clearly identified with the new tables giving the associates a dedicated place to work and keep supplies.

7.2 Competence

Interviewed Pete Valdez (Laser Operator), Mike Sigmon (Slitter Operator), Eric Hedgeworth (Receiver), Arturo Escamilla (Shipper), Cade Tittle (Materials Manager), Phillip Mathis (QA) and Denise Clayton (Inside Sales). All were able to locate the Jemison Quality Intranet, Quality Policy, and Procedures.

Reviewed Training Status Matrix, for plant employees, which had employees clearly identified as competent for their respective roles.

8.2 Requirements for products and services

Contract Review/Order Acknowledgement: Bush Hog sent PO 2453607 on 10/20/25. Denise Clayton (Inside Sales) acknowledged the PO on 10/21/25 via email and entered sales order 37543.

Purchasing: Tag 44915, at receiving was received against PO 3832. Tag 44915 had the following information: ASTM A1011 SS36 Type 1, HRPO, .2150" min thickness x 47.92" wide, weighed 40,140lbs and was purchased for Gorbels. PO 3832 had the following requirements: ASTM A1011 SS36 Type 1, .2150" min thickness x 47.92" wide with weight requirements of 36,000-43,000lbs. All requirements of the PO and grade (including YTE) were met on the as received coil.

8.4 Control of externally provided processes, products and services.

Receiving: BOL F140686 was received by Eric Hedgeworth on Receiver 8375 against PO 3832. Mill Coil 5405739.000 was weighed at 40,140 lbs. Receiving Inbound Inspection report GAD009 9/18/2017, Rev 2 was filled out completely and verified that the material met the PO requirements that could be determined without unwrapping the coil completely. Material was purchased from Nucor Decatur for Jemison Customer Gorbels. The coil was placed in location C21R4.

8.5-Production & Service Provisions

Production:

Work Order 57324, customer Heil on GL5 (laser). Laser program 35010C for Part# W311-5193 to produce 150 pcs. This was a production job to produce flat stock to go to the press brakes for final part production. First piece inspections were documented on the JemPrint: Material Thickness: .235-.265, .235 Actual, Dim A: 22.98-23.10, 23.04 Actual, Dim B: 30.46-30.58, 30.52 Actual, Dim C: .590-.650, .620 Actual.

Work Order 57015, Customer Rheem Scottsboro on S22 (Slitter). This was a break by weight job with no edge slitting required. Part# 08105017, ASTM A653 G90 CSB Non Chem Treat Light Oil. Material used was ASTM A653 G90 CSB Chem Treat Dry. [Minor Finding #1: Material used did not match the requirements listed on the customer part](#). It was determined that the part number description was inaccurate and that the material being used was correct. All of the customer parts were corrected in the system and new tags with the correct descriptions were reprinted and hung on the same day. This CA was closed before the final issuance of this report. The other requirements of this job, such as gauge, width, weight and packaging met the requirements on the work order.

Shipping: Bush Hog Sales Order 37543, PO 2453607, BOL 17320 was audited. 19 part numbers, 39 tags, 10,286lbs were staged and ready to be loaded onto a truck. All tags on the loading list and packing list matched what was staged.

7.1.3 Infrastructure

Preventive Maintenance: Phillip Mathis provided the following PM evidence from eMaint:

- Laser 5: Weekly PMs with 9 tasks were completed, next due 11/3/25. Monthly PM with 6 tasks completed next due 11/3/25.

- 6 overhead crane inspections (performed by external organization) was last performed on 10/23/23. Crane inspections, by an outside organization, were not performed in 2024. [Minor Finding #2: Annual Crane inspections not performed in 2024. All safety items from the 2023 report were completed. Update: Before the submission of this report, on 12/9/25 an annual crane inspection was performed by the outside organization. A plan for all safety related items is in place for repair. Annual crane inspection requirement added to eMaint. This CA is closed.](#)

7.1.5 Monitoring and Measuring Resources

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

Laser 5:

C018, 12" Calipers, due 3/11/26

M025, 0-1" Micrometer, due 11/18/25

TM046, 25' Tape Measure, due 2/13/26

Slitter:

1216, 40" Caliper, due 2/6/26

2050, 19" Caliper, due 2/6/26

2079, 0-1" Micrometer, due 9/17/26

2201, AGT400, due 1/18/26

8.7 Control of Nonconforming Product

The nonconforming area was neat, identified and well delineated with tags that had descriptions in the comments about the issue.

Tag 290518, HRPO A1011 CSB .100" min x 7.694" coil. Issue was dents/scratches. Put into reject on 10/29/25.

Tag 290516, HRPO A1011 CSB .100" min x 7.694" coil. Issue was dents/scratches. Put into reject on 10/29/25.

10.2 Nonconformity and Corrective Action

CA 27818, Bluebird Body, verified, Closed.

CA 27799, Freudenberg-NOK, verified, Closed.

CA 27779, Freudenberg-NOK, verified, Closed.

CA 27725, Heil-Fab, verified, Closed.

10. Improvement

Two new fiber lasers were installed. Push carts built and provided to save time waiting on forklifts.

2.0 Overview

Pete Valdez – Laser Operator Phillip Mathis – QA & Maintenance Mike Sigmon – Slitter Operator	Eric Hedgeworth – Receiving Arturo Escamilla – Shipping Cade Tittle – Materials Management Denise Clayton – Inside Sales
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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</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 Rick Rowland 12/11/25

Nonconforming Corrective Action Report (CAR) for Jemison Metals

CAR #	ISO 9001: 2015 Clause / Sub-Clause	Findings/Requirements	Observation	Minor	Major
1	8.5	Minor Finding #1: Material used did not match the requirements listed on the customer part. Customer part stated Non Chem Treat Light Oil, while material used was Chem Treat Dry		X	
2	7.1.3	Minor Finding #2: Annual Crane inspections not performed in 2024.		X	

Pete Valdez - GLS operator

Quality Policy

10/29/25

~~W017388~~ Work order 57324

Program 35010C

Part# W311-5193

Customer Heil

150 pcs

Layout Detail: 4 pcs per sheet

* Produce to stock

Inside Sales: Charles Love / Vicki Furtwuberta

Tem Print Measurements

	Material Thickness	Actuals
✓	.235 - .265	.235
✓	Dim A 22.98 - 23.10	23.04
✓	Dim B 30.46 - 30.58	30.52
✓	Dim C .590 - .650	.620

Gauges

- ✓ CØ18 12" Calipers 3/11/25 due 3/11/26
- ✓ MØ25 0-1" Micrometers 11/18/24 due 11/18/25
- ✓ TM046 25' Tape Measure 2/13/25 due 2/13/26

Documents

- ✓ JDM-F-014 2/19/21 Rev.0 Fab Production Report

Nonconformance Area

Well delineated. Metal Posts, sign + "Reject" Signage

Tag 290518

HRPO A1011 CSB .100min x 7.694" Coil

Issue: Dents/Scratches Shipping Dmg → Same

Put into Reject on 10/29/25 → Same

Tag 290516

HRPO A1011 CSB .100min x 7.694" Coil

522 Slitter Mike Sigmon Quality Policy Work Order 57015
Operator

Break by weight Job. No slitting.

Customer Rheem Scottsboro

Part# 08105017 AG53 G90 CS-B NCT L0

* .045min x 48.000 AG53 G90 CS-B CTOTL

Sales order 38174-1-1

Thickness: .045 - .055
Actual: .045 - .046

Packaging

C1 - Coil skid with 1" spacers
Paper Bottom Only

Gauges

- 0 1216 40" Caliper 2/6/25 due 2/6/26
- 0 2050 19" Caliper " " "
- ~~0 CØ18 12" Caliper 3/11/25 due 3/11/26~~
- 0 2079 0-1" Mic 9/17/25 due 9/17/26
- 0 ~~AGT 2201~~ AGT 400 7/18/25 due 1/18/26

Documentation

- ✓ JDM011 Rev 2 4/11/16 Width Worksheet

Minor Finding

Part Description doesn't match

Raw Material. Part is A653 CSB G90

Painted Bucket
at Master coil
is

Non Chem Treat Light 0:1
Chem Treat Dry

Receiving

Eric Hedgeworth @ Quality Policy

2 Master Coils Received on Form GAD009 9/18/17 Rev.2
Audited the First

#1 Nucor	PO # : 3832	PO Agmts	Actual
	Receiver # 8375	✓ 24" ID	24"
	B/L # F140686	✓ 36-43 K lbs	40,140 lbs
	40,140 lbs	✓ .215" min Thickness	.215"
	Mill Tag 5405739.000	✓ 47.92" wide	47.92"
	Master Tag 44915	✓ 36 ksi min Yield	44.4 ksi
	Purchased for Gorbet	✓ 53 ksi min Tensile	59.7 ksi
	Placed in location C2LR4	✓ HRPO SS36 T2	A1011 SS36 T2 HRPO

Preventive Maintenance

PM's for GLS Reviewed in emaint. Software

Weekly PM Reviewed Next Due : 11/3/25
5 Inside Tasks + 4 Inside Tasks

Monthly PM Next Due 11/3/25

4 Operator Tasks + 2 Maintenance Tasks

Main Crane Inspections last performed
by outside company on ~~11/9/23~~ 10/23/23
Crane inspections not performed in 2024.

MF #2

Shipping

Arturo Escamilla @ Quality Policy

Loading List 17320 for Bush Hog was reviewed

Tags on loading list compared to Packing List/BOL 17320-1

19 part numbers, 39 Tags, 10,286 lbs.

All tags on loading list + Packing List matched.

Purchasing Cade Tittle - Materials Manager

PO# 3832, from Receiving. Customer Gorbai

Issued 9/15/25

~~At~~ Acknowledged by Nucor on 9/18/25

Gauge/Grade/width/Quantity All Matched

Inside Sales Denise Clayton

BOL 17320-1 from shipping.

Sales Order 37543 ~~from~~ for Bush Hog

PO Received 10/20 PO# 2453607

Phone Conversation on 10/20 Regarding piece counts. Acknowledgement email
to customer on 10/21.