

Audit Review and Evaluations of JEMISON METALS

**3001 Hickory Street
Gadsden, AL 35954**

Dates of Audit: 11/13/20
Date of Submittal: 11/13/20

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, GAD-VA-009 5.7.20 Rev 0 at laser, GAD020 9.3.15 Rev 1 at laser, Jemison created part print 113-8707-016 4.7.16 Rev E. GAD-VA-010 2.28.20 Rev 0 in shipping.

- OFI: GAD020 removal of square spec/actual column. These types of requirements are now captured on the Jemison prints.

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

Spoke with Mike Cantrell in receiving. He is not the full time receiver and is classified as “in training” on the training status matrix (JDM-F-014 11.26.18 Rev 0). He was able to complete inspections and correctly fill out the inbound inspection report GAD009.

However he was not completely trained on step 4 of the receiving procedure “Enter all information into Stelplan including chemistries and physicals, if available.” At this point of the receiving procedure he took his information to a competent employee (Mark Clough) who entered the required information into Stelplan and printed the tag to be applied to the coil for Mike. Renee Bertram was interviewed as the operator at laser 2 as well as William Jenkins and Scott Houk in shipping department. All were clearly identified on the Gadsden training status matrix.

- OBS1: While speaking with shipping team I asked them to pull quality intranet and quality policy – they were able to. However it was found that there is not a shipping procedure present on the quality intranet.

8.2 Requirements for products and services

Heil PO# 24250174 was sent on 11.4.20 with a due date of 11.20.20 to Vicki Fontcuberta. Sales order 103771 was entered by Vicki and was shipped on 11.20.20 on BOL 92260.

8.4 Control of externally provided processes, products and services

Coil 4040970.000 was received by Mike with the aid of Mark Clough under receiver number 52143 from Gadsden PO number 17753.

The bucket in FIT POC/4L/SS36TP/47.9200 met customer requirements.

8.5-Production & Service Provisions

Production job number 127911 for Heil fab was observed on the laser 2. Quality checks were being performed and documented in accordance with the requirements of the Jemison part print and laser operator procedure GAD-LA-001. Parts met all dimensional requirements.

BOL 92055 for Heil fab was reviewed in shipping during shipment preparations. Part number 234-1336 had to be referenced back to visual aid GAD-VA-008 4.5.19 Rev 0 to lookup the correct color coding required by customer which is Blue. The blue zip-tie was added to the seven pieces that were referenced on the bill.

7.1.3 Infrastructure

Preventive Maintenance: Wayne Angle and Chris Ellis are the Maintenance team. We specifically investigated the PM records for laser 3. Some documented records were missing from May 2020. We then decided to look at some press brake (PB2) records and there were also some files missing from the folder.

- **M1: Missing PM records, checked two machine records and both were missing some documented records.**

7.1.5 Monitoring and Measuring Resources

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

Receiving:

Micrometer serial number JMATHIS June 2020 calibration due June 2021

Tape Measure serial number TM012 November 2020 due November 2021

Laser 2:

Micrometer serial number M005 March 2020 calibration due March 2021

Tape Measure serial number TM005 November 2020 calibration due November 2021

Caliper serial number C005 November 2020 calibration due November 2021

8.7 Control of Nonconforming Product

Nonconforming area was cluttered but identified with tags that had descriptions in the comments about the defect.

10.2 Nonconformity and Corrective Action

Corrective Action 19771 reviewed. Renee Bertram was able to describe the issue and provide details about how the scrap can be quickly inspected. If there are no breaks or missing sections around the outside the parts were cut correctly (laser did not run off the sheet). Also pulled the Jemison print 113-7013-001 Rev A/Jem Rev 2 and was able to verify the notation was present on the current file print.

10. Improvement

Amada Fabrivation scanner added to facility.

Observations and findings from previous internal audit

Observations from previous internal audit:

1. Reviewed: OBS1 – Quality policy is present at all locations listed.
2. Reviewed: OBS2 – GAD-VA-009 is available on quality intranet.
3. Reviewed: OBS3 – tarp material notation removed from spec remarks.
4. Reviewed: OBS4 – PM records scanned to public folder.

2.0 Overview

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

Mike Cantrell – Receiving Scott Houk – Shipping William Jenkins – Shipping Renee Bertram – Laser 2 operator	Wayne Angle – Maintenance Chris Ellis – Maintenance Vicki Fontcuberta – Inside Sales
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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 Brian P. Smith

Date 11.13.20

Nonconforming Corrective Action Report (CAR) for Jemison Metals

CAR #	ISO 9001: 2015 Clause / Sub-Clause	Findings/Requirements	Observation	Minor	Major
OF1	7.5	Unused column of controlled document GAD020.	OFI		
OBS1	7.2	No shipping procedure on Quality intranet.	X		
M1	7.1.3	Missing PM records.		X	