Audit Review and Evaluations of JEMISON METALS

3001 Hickory Street Gadsden, AL 35954

> Dates of Audit: 9/20/22 – 9/21/22 Date of Submittal: 11/2/22

Auditors: Rick Rowland - SR VP QA & Engineering

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, JDM200 Quality Policy 7.21.18 Rev-1, GAD-VA-009 5.7.20 Rev 1 at laser, GAD020 1/5/21 Rev 2 at laser, Jemison created part print GFI02 Rev 0. Electronic GAD-VA-008 4.5.19 Rev 0 in shipping.

7 Support

Employees appeared competent and well trained. Adequate resources (gauges, safety equipment, operating equipment, and environment) were observed during the audit with the following observation: OBS#1 Micrometers, tape measures & calipers could be better organized with additional measuring tools located strategically throughout the plant. It was noted that some operators were sharing measuring tools and would sometimes have to go find measuring tools to perform first piece inspections.

7.2 Competence

Interviewed Adam Ryan 1st shift in receiving, Kenneth Kuzmicki on 1st shift Laser 5, Bobby Lowe on 2nd shift Laser 3, Jayden Flores on 2nd shift shipping, Phillip Mathis regarding preventive maintenance, Sarah Stanford regarding Purchasing, and Denise Clayton regarding sales. Phillip, Sarah & Denise are all veteran employees and are familiar with the quality policy and their roles. Adam Ryan has been in receiving for approximately 3 months and was previously a laser operator. Adam was familiar with and could pull up the electronic receiving procedure. Kenneth, Bobby, and Jayden each have 1-2 years' experience in their roles and appeared competent with their respective responsibilities.

8.2 Requirements for products and services

<u>Contract Review/Order Acknowledgement</u>: Kirby PO 106505 (copy included in notes) for Part GFI02 (which was audited on laser 5) was received by Denise Clayton, in sales. The PO was acknowledged via email on 8/24/22.

<u>Purchasing</u>: Receiver 61209, material from Phoenix Metals, was reviewed with Purchasing (Sarah Stanford). This material was purchased on PO GAD-22425. This material supports a "spot buy" bucket, which means it is low enough volume that Jemison does not purchase master coil directly from a steel mill. Sarah stated that the size (gauge, width, length) and grade were dictated by the WIP sheet size for the final part. 8.4 Control of externally provided processes, products and services <u>Receiving</u>: Receiver# 61209 was received in against PO GAD-22425 to Phoenix Metals. 65 pieces of .0747 48x120 material was received and became Jemison Tag 76566, mill tag 2187780.

8.5-Production & Service Provisions

Production:

1st Shift, Laser 5: Work Order GAD 162992, Kirby Building, Part GFI02, Program 32427 was observed. Kenneth Kuzmicki was the operator. First piece inspection was documented (see notes). All measurements except for material thickness were in tolerance. Material thickness was out of tolerance per the JemPrint, but was in tolerance on the work order (from Stelplan). Minor Finding #1: JemPrint Rev 0 had thickness as .1795-.1955 (fixed same day), while the Part spec/Stelplan had .179 +/- .008" 2nd Shift, Laser 3: Work Order GAD 163029, Heil Fab, Part 311-5107-001, Program 31501 was observed. Bobby Lowe was the operator.

<u>Shipping</u>: 2nd shift shipping personnel (Jayden Flores) was interviewed. Jayden has been with Jemison 1.5-2 years. Loading Order 117256 for Bush Hog was being prepared. Line 1 was for part 50080053 calling for Tag 321443 (3pcs) was observed and verified as being staged for 1st shift loading tomorrow.

7.1.3 Infrastructure

Preventive Maintenance: Gadsden is the first Jemison location to implement eMaint maintenance software. Preparations began in Q4 2021 and went live in Q2 2022. Gadsden also went from 2 maintenance technicians to 4 maintenance technicians and represents the significant resource investment to maintain all of the machines and improve uptime.

GL5 (Gadsden Laser 5) weekly PM schedule was reviewed on eMaint. Last completed on 9/20/22 by Logan Shinn. Previous PM dates for GL5 were 9/12/22, 9/8/22 and 9/1/22. The 9/12/22 work order reported Y&Z axis bellows torn and needed replacement. This was reported on 9/14/22 and work order #797 was created to do this replacement and was completed the same day.

eMaint utilizes a schedule and work order system for PM and a work order request and work order system for Maintenance Requests from Operations.

7.1.5 Monitoring and Measuring Resources

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

Receiving:

25' Tape Measure T3060 calibrated 3/25/22, due 3/25/23 0-1" Micrometer M007 calibrated 5/26/22, due 5/26/23 Scale S/N C007008257, Model TND246, calibrated 8/12/22, due 11/22

Laser 5:

0-1" Mic M003, calibrated 2/17/22, due 2/17/23 12" Caliper C006, calibrated 5/26/22, due 5/26/23

Laser 3:

16' Tape Measure TM014 calibrated 11/19/21, due 11/19/22 0-1" Mic M008, calibrated 11/30/22, due 11/30/23 12" Caliper C005, calibrated 11/20/21, due 11/20/22

8.7 Control of Nonconforming Product

Nonconforming area was well delineated and identified. 3 tags from the non-conforming area were researched. Tag 321916, .056 x 55.00" coil 4,760 lbs dated 9/13/22. This tag was being claimed back to the steel mill. Original coil was overweight causing this part of the slit coil to drag in the slitter. Mill received approval to ship this overweight coil knowing a portion would be claimed. Tags BH46831 (7pcs) & BH46832 (13pcs). These 2 tags were a customer return for 20 pieces over shipped due to a sales error. They will be put back into finished goods pending finalization of the receiver (RMA Case 23870).

10.2 Nonconformity and Corrective Action

External DPPM performance YTD is 2513, which is below the stated goal of <3000DPPM. There was a spike in April (9685) & May (5618). The issue in April was a packaging issue with Daimler trucks, material was ok. The May issue was rolled edges on slit coil for Daimler.

Corrective Action 22126 from internal audit 9/29/21 was closed on 12/10/21.

10. Improvement

Lighting switched to LED to improve visibility, safety and cost.

Implementation of eMaint maintenance software and adding 2 maintenance techs.

2 additional fiber lasers and 2 additional press brakes

Moved away from 24/7 "McDonald's" schedule due to increased machine uptime and able to reduce number of shifts and reduce overtime hours.

2.0 Overview

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

Adam Ryan - Receiving	Phillip Mathis – Maintenance
Kenneth Kuzmicki – Laser	Sarah Stanford - Purchasing
Bobby Lowe – Laser 2 nd Shift	Denise Clayton – Inside Sales
Jayden Flores – Shipping 2 nd	
Shift	

2.2 Audited Requirements

4 Context of the Organiz	
4.4 Quality Management Sys	stem 8.1 Operational planning and
and its processes	control
5 Leadership	8.2 Requirements for products and
5.1 Leadership and commitm	
5.1.2 Customer Focus	8.3 Design and development of
5.2 Policy	products and services (N/A)
5.6 Management review	8.4 Control of externally provided
6 Planning	processes, products and
7 Support	services
7.1.1 General	8.5 Production and service
7.2 Competence	provision
7.1.3 Infrastructure	8.7 Control of nonconforming
7.1.4 Environment for the	outputs
operation of processes	9 Performance evaluation
7.1.5 Monitoring and measur	ing 9.1 Monitoring, measurement,
resources	analysis and evaluation
7.5 Documented information	
	9.1.3 Analysis and evaluation
	10 Improvement
	10.2 Nonconformity and corrective
	action

2.3 APPROVAL/SIGN-OFF

Report Prepared by Rick Rowland

Date 11.2.22

Nonconforming Corrective Action Report (CAR) for Jemison Metals

CAR	ISO 9001:	Findings/Requirements	Observation	Minor	Major
#	2015 Clause /				_
	Sub-Clause				
n/a	7.1.5	OBS#1: Micrometers, tape measures & calipers could be better organized with additional measuring tools located strategically throughout the plant. It was noted that some operators were sharing measuring tools and would sometimes have to go find measuring tools to perform first piece inspections.	Х		
1	8.5	Minor Finding #1: JemPrint Rev 0 had thickness as .1795- .1955 (fixed same day), while the Part spec/Stelplan had .179 +/008"		Х	



DATE:	9/20	Tues.	
TO:	Internal	Audit	GAD
FROM:		2	

Adam Ryan - Rova Morch 2022 in Roug n 3 mos. Previously Laser Operator Found Ravy Procedure Receiver # 61209 PO GAN 22425 DA from Phoenix we tals 48×120 .0747 105 Des Became Tay 76566, Will Tay 2187780 2 Bundles Both Jag 76566 Jue 3/2 5/23 3/25/22 ape Mensure - Adam 1St 5/26/22 due 5/261. T3060 Kenneth KUZMICKI Lasir 5 Swift \oslash Mic D-MOO Job/62992 - Kisby Building Scale 8/12/22 due 11/23 Part GFI62, Program 324271 5/N L00700825 Model TA A572 61 50 Tem Print Rev. D Cost Rev Thickness (.1795-.1955) .179 Nour 7- 008 76 2/17/22 in Stelplan. "Mic M003615 \$ 8.006 7.88-8.12 due 2/17/23 MF#1 Jenorat + Part 5/26/22 - Fixed Same day 2.444 12" Caliper COOG 615 2.36-2.50 7,504 (7,36-7.62) 085#1 Revision A O aser 3 2 dyrs Bobby owe 10 90 HalFab 10/311-5107-001 to yet WO Getting Program 31501 Run Calipurs 5550 Tag 322425 ONO Jean Print DChristina NSC 62.5 × 90 26.50' Length ,06) 235-. 265), 2.00 Width (200-4.03) 1/22 (100-12) 1120/22 235" thick 26.5 11/30/22 Jue 11/30/23 NO-12" Caliper 6005 GL2 Mic 16 Tape M008. and Jayden Flores Shipping 1.5- 2yes. Shift 50080053 loading Order 256 Bush Hog Linel 321443 Staging for 1st Shift. Bocs v

3001 HICKORY STREET GADSDEN, AL 35904 PHONE: 256-549-5555 FAX: 256-549-5564



DATE: 9/21 Wed,

TO: Day 2 Internal Audit GAD

FROM:

Preventive Maintenance	
G-15 Weekly PM Schedule	Gadsden is the first location to implement emaint. Software, Prep began Q4 2021 + went
Last completed 9/20/22 by Logan Shin	n Liver in Q2 2022. Also went from 2
Previous Dates; 9/12/22, 9/8,22, 9/1/22.	
9/12/22 Work order reported 4+2 axis 9/14/22 WO# 797 created to do this repli	bellows torn + needed replaced, Reported on 9/14/2 accoment, Completed Same days
Sales - Kirby GFIO2 from Laser	5 Denise Clayton Inside Sales
Pott 106505 emailed on 8/23/22	. Acknowledged on 8/24/22
Due	
Purchasing - Sarah Stanford vi	a email Re: Phoenix Metals
reviewed at receiving Rec	ceiver # 61209 PO GAD 22425
Bucket is a spot buy bucke	et due to low Volume, Size +
grade dictated by WIP She	et size, although had to buy a longer
length due to availabili	ty,
Non Conforming Area - Well delined	rfedat Identified
Tag 321916 in GRJ overwe	ight Coil in GMC ,056×55.00 Coil
Grade 5555, 4,670 lbs.	Tag date 9/13/22, Mill Shipped
Coil over PO, Weight. Coording	ted with Mill to scrap a portron
of Coil prior to running.	This weight (Lincor footage) would
<u>cause</u> some material to	bottom out in Slifter looping pit,
Tags BH 46831 (7pcs) of BH.	46832 (13pcs), costomer return for
20 pc. overshipment due te	o sales error. In GRJ pending
receiver + Return. PMA	Case# 23870
CA 22126 from internal audit 9/29/21. Closed o	

3001 HICKORY STREET GADSDEN, AL 35904 PHONE: 256-549-5555 FAX: 256-549-5564

PURCHASE ORDER

PO Number: PO106505 V

Date: 8/23/2022

This PO number must appear on all packages, invoices and packing lists. Receiving Hours are M-F 6:00 AM - 2:00 PM For Steel Receiving Appointments call 615-745-6095

Email Invoices to ap@kirbybuildingsystems.com

Ship To: KIRBY BUILDING SYSTEMS 124 KIRBY DRIVE PORTLAND, TN 37148

Contact: 615-325-4165

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В	Buyer Payment Terms		-Job	Number		Job Nar	ne
Jaska Ward NET 30							
Line	Item Number Description	r	Required Date	Qty Ordered	U7M	Unit Price	Extended Price
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	WELDED FL	JSH INSET GIRT CLIP					

1300-03 INVENTORY - STEEL - STRUCTURAL

ORDER TOTAL \$25,0

Sales Tax Exempt No. SR KH 101-049183

Authorized Signature

Gaora Ward

Notice: OSHA from OMB NO. 44-R1387 Material Safety Data Sheet is Required for all pertinent Material(s) ordered on this Purchase Order. By acceptance and acknowledgement of this order, vendor agrees to furnish materials and/or services in accordance with all terms on the obverse and final page.



PO Box 390 Portland TN 37148 J0044 Vendor: JEMISON METALS P.O. BOX 2153 DEPARTMENT 3137 BIRMINGHAM, AL 35287-3137

\$25,000.00

Rick Rowland

From: Sent: To: Subject: Attachments:

Denise Clayton Wednesday, September 21, 2022 8:57 AM Rick Rowland FW: PO106505 PO106505.pdf

See attached po and confirmation back. Let me know if you need anything else, Thanks

Denise Clayton | Inside Sales Representative Jemison Metals 3001 Hickory St. Gadsden, AL 35904 Direct / M (256) 393-3868 F (205) 449-9941 dclayton@jemisonmetals.com

Informed when we buy. Transparent when we sell.

-----Original Message-----From: Ward, Jaska (KBS) <jaska.ward@kirbybuildingsystems.com> Sent: Wednesday, August 24, 2022 10:21 AM To: Denise Clayton <dclayton@jemisonmetals.com> Subject: RE: PO106505

Thank you!

-----Original Message-----From: Denise Clayton <dclayton@jemisonmetals.com> Sent: Wednesday, August 24, 2022 10:18 AM To: Ward, Jaska (KBS) <jaska.ward@kirbybuildingsystems.com> Subject: [EXT] RE: PO106505

Activo whedged Next day

This message came from outside of Nucor.

Good morning, confirming receipt of PO, and will advise on ready date. Thanks

Denise Clayton | Inside Sales Representative Jemison Metals 3001 Hickory St. Gadsden, AL 35904 Direct / M (256) 393-3868 F (205) 449-9941 dclayton@jemisonmetals.com Informed when we buy. Transparent when we sell.

-----Original Message-----From: Ward, Jaska (KBS) <jaska.ward@kirbybuildingsystems.com> Sent: Tuesday, August 23, 2022 4:27 PM To: Denise Clayton <dclayton@jemisonmetals.com> Subject: PO106505

Denise,

Please see attached PO106505.

Thanks,

Jaska Ward Buyer

Kirby Building Systems 124 Kirby Drive . Portland, TN 37148 Phone: 615.745.6022 Jaska.Ward@kirbybuildingsystems.com

ALL INVOICES MUST BE SENT TO AP@KIRBYBUILDINGSYSTEMS.COM

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Work Order	
WO No: 673 WO Date 09/08/2022 WO Time: 01:08:23	Open / History:H Job Status:Completed WO Type:PM
Project # Sched Date:	Problem Type: Completed Date:09/08/202:
Est Hours: 2.00	Downtime:0.50
Asset ID:LASER_05_TR Asset Description:LASER Cutter 5 – TruLASER 3040 / TruDis	
Department: Site: Gadsden	Building: Plant 1 Floor:
Request #: Requested By:P.M. Schedule	Req. Telephone: Req. E-mail:
Assign To Type: Techniclan Assign To: Jemison Metals (Logan Shinn)	Perform For Type:Employee Perform For: Jemison Metals (Phillip Mathis)
Brief Description: WEEKLY PM SCHEDULE- TRUMPF Work Description: 1. BLOW OUT OR REPLACE BOTH CHILLER FILTERS 2. CHECK WATER LEVE BOTH THE CHILLER CABINET AND THE RESONATOR CABINET 3. CHECK THE HYDRALIC OIL LEVEL FOR THE PALLET CHANGER 4. CHECK TO MAKE SUR BOTH LUBES, THE GREASE AND OIL, CONTAINERS ARE AT GOOD LEVELS THAT THEY WILL NOT RUN OUT BEFORE THE NEXT CHECK IS DONE. 5. CHE MAKE SURE FLOOR PLATES ARE IN-PLACE FOR SAFETY 6. CHECK TO MAK SURE ALL COVERS ARE IN PLACE ON THE ENCLOSURE. ALSO THAT THE T DOOR AND FRONT DOOR, ALSO THE PALLET DOOR WORKS PROPERLY AN MACHINE WILL NOT OPERATE IF ONE IS OPEN. 7. CHECK TO MAKE SURE TH NO DAMAGE TO ANY OF THE CONDIT, PIPING AND FAN CORDS THAT ARE IN THE AREA. AS TO LEAVE ANY UNSAFE CONDITION OR LEAKS. 8. VISUA CHECK TO MAKE SURE THERE ARE NO PREVENTABLE TRIP HAZARDS THA BE CORRECTED BY HOUSEKEEPING OR REARRANGE OF WORK MATERIAL VISUALLY, CHECK BELLOWS FOR TEARS OR CRACKS Comments: Scheduled PM check was complete.	E RE 3 SO ECK TO KE TOP ND THE HERE IS E USED ALLY ALLY
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Rick Rowland

From:Sarah StanfordSent:Wednesday, September 21, 2022 2:35 PMTo:Rick RowlandSubject:RE: PO GAD 22425-1 14ga CR 48x120 for Bluebird

Yes sir it is a spot buy bucket due to usage.

2. sorry yes I was looking at the wrong bucket – that is the only size we could find from Phoenix.

Sarah Stanford Adams | Materials Supply Chain Manager Jemison Metals 3800 Colonnade Parkway, Suite 250 Birmingham, AL 35243 O (205) 986-6620 | C (205) 527-1575 sstanford@jemisonmetals.com

2020 AMM Service Center of the Year 2018 AMM Service Center of the Year 2015 AMM Service Center of the Year 2016 S&P Platts Global Service Center of the Year

From: Rick Rowland <rrowland@JemisonMetals.com> Sent: Wednesday, September 21, 2022 11:39 AM To: Sarah Stanford <SStanford@JemisonMetals.com> Subject: RE: PO GAD 22425-1 14ga CR 48x120 for Bluebird

Follow-up questions below.

From: Sarah Stanford <<u>SStanford@JemisonMetals.com</u>> Sent: Wednesday, September 21, 2022 10:15 AM To: Rick Rowland <<u>rrowland@JemisonMetals.com</u>> Subject: RE: PO GAD 22425-1 14ga CR 48x120 for Bluebird

- 1. I Purchased based on need per the bucket we needed to buy to be able to cover orders in October/November. Am I correct in assuming this is a spot buy only bucket due to the low volume?
- 2. I knew group/size/grade/width/length based on the requisition and part specs from the wip part. Sarah, the WIP size in that bucket is 48 x 96, but we ordered 48x120. The requisition doesn't list length. So how/why did we order 120" long?

Sarah Stanford Adams | Materials Supply Chain Manager Jemison Metals 3800 Colonnade Parkway, Suite 250 Birmingham, AL 35243 O (205) 986-6620 | C (205) 527-1575 sstanford@jemisonmetals.com

2020 AMM Service Center of the Year 2018 AMM Service Center of the Year 2015 AMM Service Center of the Year 2016 S&P Platts Global Service Center of the Year From: Rick Rowland <<u>rrowland@JemisonMetals.com</u>> Sent: Wednesday, September 21, 2022 8:49 AM To: Sarah Stanford <<u>SStanford@JemisonMetals.com</u>> Subject: PO GAD 22425-1 14ga CR 48x120 for Bluebird

Sarah,

I'm performing the annual internal audit for GAD. At receiving, this material was being received in during the audit.

Can you tell me:

- 1. What told you that you needed to purchase this material?
- 2. How did you know what type (group/size/grade/width/length) to purchase?

I likely know these answers, but as part of the audit, I need purchasing to tell me so I can document.

Thanks

Rick Rowland | SR VP Quality & Engineering, Metallurgical Engineer Jemison Metals 3800 Colonnade Parkway, Suite 250 Birmingham, AL 35243 M (205) 910-0485 | O (205) 986-6627 rrowland@jemisonmetals.com

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