

Audit Review and Evaluations OF

JEMISON METALS

**188 Enterprise Dr,
Madison Heights, VA 24572**

Dates of Audit: 8/1/18
Date of Submittal: 8/3/18

Auditors: Patrick Macias – Quality Manager-Eastern Division

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: LYN-RC-001 Receiving Procedure (Quality Intranet-no hard copy present) LYN-LA-001 Laser Procedure (Quality Intranet Slitter computer-no hardcopy present), LYN-FAB-002 fabrication First Article Inspection procedure (Quality Intranet-no hard copy present), JDM200 Quality Policy Rev-1, FHR002 Training & Equipment Checklist Plant Employees Rev-6 (Current Revision 8, Already noted in CLV audit as CLV Minor #1)

7 Support

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

7.2 Competence

Reviewed Amere Pannell training documentation. New Hire training documented and turned into human resources. FHR002 Rev -6 (CLV Minor-#1)

8.2 Requirements for products and services

O'Neal Greensboro PO 4875473 sent on evening of 7/31/18 order acknowledged by Paula Loveless on 8/1/18. Sales order 11235-1 entered on 8/1/18 due 8/7/18

8.4 Control of externally provided processes, products and services

Mill Coil #2391798B from NLMK received off of PO 2197-01 for Hill Phoenix bucket GVC CB40CD 22B 48" met all requirements for customer parts in that bucket

8.5-Production & Service Provisions

B/L SMT 98273 (T/O 139573) O'Neal Greensboro. Receiving paperwork signed and dated by Stanley Gallier, Document stamped, filled in, signed and dated, per the receiving procedure.

Production: W/O 6566 JB Stamping (S/O 8955-1) was reviewed on Laser. All checks reviewed by operator per procedure LYN-LA-001

7.1.3 Infrastructure

Preventive Maintenance: Reviewed with Bill Huffman, Schedule calendar for July Internal preventive maintenance reviewed. All schedule maintenance documented as

performed. Documents did not have a supervisor approval check off ([Observation 1](#)). Calendar did not show what was completed that month, to check had to pull individual PM forms. ([Observation 2](#)). Due to lack of maintenance personnel some PM's scheduled and performed by outside service-Forklifts every sixty days, Air Compressors every ninety days, Crane PM performed during inspection annually. Maintenance documented by invoices for service.

7.1.5 Monitoring and Measuring Resources

The following gauges were verified to be calibrated in compliance with calibration records: Laser: Micrometer 045 Tape 046, Calipers 161156625

8.7 Control of Nonconforming Product

Nonconforming area was well defined and neat. All items identified.

10.2 Nonconformity and Corrective Action

CA 14900 reviewed, all three audits completed-Recommend close

CA 14741 Reviewed, two audits complete one more needed

10. Improvement

New Laser installation began. New laser will give potential to double capacity, add a backup in case of unscheduled down time, and increase versatility of scheduling.

New laser table bed slat design to be implemented. New design will lower surface area and increase time between change outs.

Observations and findings from previous ISO audit

Observations:

1 Complete 3/1/18

2 Complete 5/26/18

3 Complete 6/29/18

4 Complete 2/16/18

2.0 Overview

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

Amere Pannell-Laser Operator Stanley Gallier- Receiver Bill Huffman-Maintenance	Paula Loveless-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 Patrick Macias

Date 8/1/18

Nonconforming Corrective Action Report (CAR) for Jemison
Metals

CAR #	ISO 9001: 2015 Clause / Sub-Clause	Findings/Requirements	Observati on	Mino r	Major
NA	7.1.3	No supervisor sign off on preventative maintenance forms	X		
NA	7.1.3	No documentation on maintenance schedule of completed preventative maintenance. Only individual sheets showed completion	X		