

Audit Review and Evaluations OF

JEMISON METALS

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

Dates of Audit 9/23/2025
Date of Submittal: 9/29/2025

Auditor: 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 Rev. 3 (Quality Intranet-No Hard Copy Present), LYN-PB-001 Press Brake Procedure Rev. 3 (Quality Intranet-No Hard Copy Present), LYN-FAB-001 Rev. 3 Fabrication FP Inspection Procedure (Quality Intranet-No Hard Copy Present), LYN-LA-001 Laser Procedure Rev. 4 (Quality Intranet-No Hard Copy Present), LYN-LRB-001 Redbud Procedure Rev. 1 (Quality Intranet-No Hard Copy Present), JDM200 Quality Policy Rev. 1, GAD 059 Rev. 0 Press Brake check sheet, LYN-F-001 Rev. 1 CTL QA form.

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

Reviewed Training Status Matrix:

Confirmed training status:

William Bersch, Punch Combo Operator - Trained

Vincent Coles, Press Brake Operator-Trained

Brandon Coffey, Press Brake Operator-Trained

Lacey Rush, Red Bud Operator-Trainer

Frank Simms, Receiving - Trained, Shipping -Trainer

Noel Regio, Shipping – Trained

Jason Zimney-Trumpf Fiber Operator-In training

8.2 Requirements for products and services

Nordfab purchase order 8030492-1 due 9/24/2025

Received by Paula Loveless 9/18/2025

Confirmation email sent 9/21/2025

S/O 32674-1 entered 9/21/2025

Order filled 9/24/2025

8.4 Control of externally provided processes, products and services.

Mill Coil #1970372 from Nucor Gallatin received off PO 2312-1-1-1. Receiver 7275 dated 9/23/2025. Bucket GNC DCSB A40 NCTO .0950" X 60" met all requirements for customer parts in that bucket. Receiver stamped and signed By Frank Simms.

8.5-Production & Service Provisions

Receiving:

Mill Coil #1970372 from Nucor Gallatin received off PO 2312-1-1-1. Receiver 7275 dated 9/23/2025. Bucket GNC DCSB A40 NCTO .0950" X 60" met all requirements for customer parts in that bucket. Receiver stamped and signed By Frank Simms

Shipping:

B/L 15093 S/O 32674-1 and 32674-2 Nordfab shipped 9/23/2025. All tags were matched, and all material was shipped and checked off. Bill of Lading signed and dated in all appropriate spots. Shipper – Tyrese Chambers. Quality inspection sign off -Nathan Ragland per CA 40589

Production:

Punch: Currently non-operational due to a maintenance issue. Reviewed GAD 059 (OBS 1 from 2024 audit) for other production processes, laser, press brake-all documentation correctly filled in.

Press Brake: W/O 49217 HP Fab part F87260GGU, documentation reviewed Controlled Document GAD 059 filled in correctly. Sampling check frequency met all requirements of Procedure LYN-PB-001. Operator: Vincent Coles and Brandon Coffey. Both operators were able to locate their procedure (OBS 2 from 2024 audit) and demonstrate familiarity with the procedural requirements.

Red Bud: W/O LYN 48483 Nordfab parts 8090115, 809117, 809121, 809705 to fulfill S/O 32674-1 and 32674-2 as well as floor stock production. All checks performed and documented on LYN-F-001 by operator Lacey Rush per procedure LYN-LRB-00. The operator displayed proficiency and ability to locate procedures.

Laser: W/O 44873 Trane Clarksville Fab part 43690031001. All checks performed and documented on Jem print and GAD059 by operator Jason Zimney, met all requirements of Procedure LYN-LA-001. The operator displayed proficiency and ability to locate procedures and demonstrate familiarity with the procedural requirements.

7.1.3 Infrastructure

Preventive Maintenance: Reviewed with Bill Huffman and Jerry Jones Monthly PM schedule and status for July 2025 and August 2025 internal preventative maintenance reviewed.

All scheduled maintenance documented as performed for September. All documents initialed, dated, and approved.

7.1.5 Monitoring and Measuring Resources

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

Measuring Equipment:

Micrometer 03, due 10/30/2025

Protractor 48, due 10/30/2025

Caliper 1, due 10/30/2025

Caliper 2, due 10/30/2025

Measuring Standards:

Gage Block 232126, due 9/15/2028

Gage Block 237137, due 9/13/2028

Gage Block 220153, due 2/8/2028

Romer Arm, due 1/31/2027

8.7 Control of Nonconforming Product

The nonconforming area was well defined and neat. All product identified as nonconforming. (OBS 1 the reject area had material that should have been physically scrapped based on inventory adjustment dates)

Tags:

593124*

593125*

593126*

*All tags returned on FIT case 27931. Not yet in Invex inventory due to shipping out in Stelplan. Mill claim 27929 accepted for these tags and all material to be scrapped out of system once received in against credit 27931

10.2 Nonconformity and Corrective Action

Open Corrective Actions:

40524-VFP-Customer ordered green painted parts, but received gray painted parts.

Audit performed:

7/29/2025-Passed

Need two more audits performed before closing. No production performed to audit since 7/29/2025 audit.

40589- Nordfab-Shipping errors on Nordfab loads. Examples include leaving BOL tags off the truck and tags being incorrectly placed on the material.

Audits performed:

8/17/2025 Passed

9/01/2025 Passed

9/03/2025 Passed

Need to note the completed 15-shipment inspection by Quality/Plant Manager before closing

40691-Hill Phoenix-Leaving BOL tags off the trucks for Hill Phoenix Fab loads.

Audit performed:

9/3/2025 Passed

Need to complete two more audits and note the completion of 15-shipment inspection by Quality/Plant Manager before closing

Corrective Actions closed since the last audit:

26918 Indention same location on Hill Phoenix part P117366F

Audited:

8/8/2024

8/14/2024

8/19/2024

9/03/2024

9/05/2024

Passed all audits.

Closed 10/28/2024

10. Improvement

Operating system update to Invex system

Observations and findings from previous audit:

Observation 1 Operator did not include part number on GAD 059 [Reviewed GAD 059 on Laser and Press Brake-Correctly filled in on both](#)

Observation 2 Operator needed assistance to locate procedures in FIT [All operators interviewed could locate procedure and demonstrated familiarity with the requirements.](#)

2.0 Overview

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

Vincent Coles-Press Brake Operator	Lacey Rus-Red Bud Operator
Brandon Cffey-Press Brake Operator	Paula Loveless-Inside Sales
	Bill Huffman-Plant Manager
	Noel Regio-Shipper

Frank Simms-Receiver Jerry Jones-Maintenance	Jason Zimney-Laser Trainee
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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
Quality Manager-Eastern Division

Date 9/29/2025

Nonconforming Corrective Action Report (CAR) for Jemison
Metals

CAR #	ISO 9001: 2015 Clause / Sub-Clause	Findings/Requirements	Observati on	Mino r	Major
NA	8.7	Reject area had tags that should have been physically scrapped based on inventory adjustment dates on individual tags but were not due to new system and unfamiliarity with inventory reports	1		