

Audit Review and Evaluations OF

JEMISON METALS

**2630 US 15,
Sumter, SC 29154**

Dates of Audit: 10/29/2024
Date of Submittal: 11/14/2024

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:

SM2-RC-001 Rev0 12/19/19 Receiving Procedure (Quality Intranet - no hard copy present)

SM2-PB-001 Rev 1 12/21/21 Press Brake Procedure, (Quality Intranet - no hard copy present) [MF 1 Link to obsolete check sheet document GAD 059 \(Corrected 11/11/2024 and recorded on Document change request/notice\)](#)

SM2-Fab-001 Rev 0 12/19/19 First Piece Inspection Procedure (Quality Intranet computer - no hardcopy present),

JDM-F-015 Rev 0 2/19/2021 SM2 Press Brake Production Report

JDM 200 Rev 1, 8/13/18 Quality Policy

JDM-F-014 Rev 0, 2/19/21 Laser Production Report

JDM-F-060 Rev 2, 9/2/20 Press Brake Checklist

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 documentation:

Current and up-to-date training matrix

8.2 Requirements for products and services

Blue Bird PO FPL335155-10 due date 11/02/2024 requested on 9/26/2024. Order acknowledged by Charles Love 9/26/2024. Sales order SM2-13497-1 for part 1070653 entered on 9/26/24 due date 11/02/2024. Shipped 10/25/2024

8.4 Control of externally provided processes, products, and services

PO SM2 959-1 for master painted coil 2195252 from Nucor Precoat. Bucket PGVC 20 BB2Y 52” Blue Bird. Met all PO requirements and bucket parameters.

8.5-Production & Service Provisions

Production:

Laser 2: W/O 27142 Trane, S/O 13692-21 Laser documentation reviewed, Part # 436903711001. Jem Print first article completed doc JDM-F-014 Rev 0 filled in correctly. Antoine Daes - Operator, showed competency on job, located and understood procedure, documentation, and document requirement.

Press Brake: 1 W/O 27031 Blue Bird (S/O 13541-1) Part #3554/10070570. Jem Print first article completed correctly, doc JDM-F-015 Rev 0, and JDM Press Brake Documentation reviewed, -F-060 Rev 2 filled in correctly. Terrel Carter/Francisco Zaragoza – Operators, showed competency on job, located and understood procedure, documentation, and documents requirement.

Amada Punch Combo: W/O 27159 Trane Clark finished goods stock Laser Documentation reviewed, Part #3488/438791661001. Jem Print first article completed correctly; Doc JDM-F-014 Rev 0 filled in correctly. Sonny Brown – Operator, showed competency on job, located and understood procedure, documentation, and document requirement.

Shipping:

B/L 6910 (S/O 13583-23) reviewed during shipping. All tags were matched (scanned). Paperwork was signed and material was loaded on the truck.

Preventive Maintenance: Reviewed with Steven Smiling, Schedule calendar for September reviewed. All schedule maintenance is marked as performed. October calendar in progress.

7.1.5 Monitoring and Measuring Resources

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

Micrometer:

M-2 Calibration date 5/9/2024, due 5/9/2025

Calipers:

C-1 Calibration 3/25/2024, due 3/25/2025

Protractor:

P-4 Calibration 10/15/2024, due 10/15/2025

8.7 Control of Nonconforming Product

Nonconforming areas were well defined and neat. Nothing currently in nonconforming warehouses (FRJ, FMC, FMD)

10.2 Nonconformity and Corrective Action

Open CA:

No open CA's

Closed CA:

25754 Continual Improvement project. Opened 10/3/2023, final verification 2/27/2024 closed

26465 Trane wrong holes size opened 4/10/2024 last verification 5/30/2024 closed

10. Improvement

1. Further Best project implementation. Real time job status available at all floor and supervisory computer stations.

Observations and findings from previous ISO audit

Internal audit 9/13/2024

OBS 1 Measurements were taken for the first part inspection but not recorded at halfway point on first skid.

All inspection documentation found to be completed in full, during current audit.

2.0 Overview

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

Terrel Carter-Press Brake Operator Francisco Zaragoza- Press Brake Operator Antoine Daes-Laser Operator Sonny Brown-Amada Punch Combo	Tarvis Stewart-Shipper Charles Love-Inside Sales Steven Smiling-Maintenance
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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 11/11/2024

Nonconforming Corrective Action Report (CAR) for Jemison
Metals

CAR #	ISO 9001: 2015 Clause / Sub-Clause	Findings/Requirements	Observati on	Mino r	Major
	7.5.2	SM2-PB -001 Press Brake procedure: Link to obsolete form (GAD 059)		1	