

Audit Review and Evaluations

OF

JEMISON METALS

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

Dates of Audit: 12/16/2025-12/17/2025

Date of Submittal: 12/19/2025

Auditor: Nathan Ragland – Quality Manager – LYN Plant

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 Rev 0 12/19/19 Receiving Procedure (Quality Intranet - no hard copy present)

SM2-PB-001 Rev 2, 11/11/2024 Press Brake Procedure, (Quality Intranet - no hard copy present)

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, 7/21/18 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

Trane PO 30125180-4014 due date 12/18/2025 requested on 12/15/2025. Order acknowledged by Dean Burley 12/15/2025. Sales order SM2-45591-1 for part 439530920200 entered on 12/15/2025. Shipped 12/18/2025.

8.4 Control of externally provided processes, products, and services

PO SM2-10807-1 for master painted coil 23575701 from Nucor Precoat. Bucket GVC / S336NOX / .0356 X 48.5". Met all PO requirements and bucket parameters.

8.5-Production & Service Provisions

Production:

Laser 2: W/O 67077 Trane, S/O 45123-1. Laser documentation reviewed, Part # X05401573010. Jem Print first article completed doc JDM-F-014 Rev 0 filled in

correctly. Rick Vogel - Operator, showed competency on job, located and understood procedure, documentation, and documentation requirement.

Press Brake: 1 W/O 64526 Eaton, S/O 43447-3, Part # WF872670GGU. JDM-F-015 Rev 0, and JDM Press Brake Documentation reviewed [OBS 1: First Article Inspection sheet was not filled out. Corrected before end of audit](#), JDM-F-060 Rev 2 filled in correctly. Steven Douglas – Operator, showed competency on job, located and understood procedure, documentation, and documents requirement.

Amada Punch Combo: W/O 67414 HP Fab S/O 45575-1, Laser Documentation reviewed, Part # WF872670GGU. 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 20754, S/O 44134-1 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 November reviewed. All schedule maintenance is marked as performed. [OBS 2: December maintenance performed, but calendar was not marked. Corrected before end of audit.](#)

7.1.5 Monitoring and Measuring Resources

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

Micrometer:

M-15 Calibration done 5/9/2025, due 5/9/2026

Calipers:

C-4 Calibration done 12/11/2025, due 12/11/2026

Protractor:

P-2 Calibration done 10/9/2025, due 10/9/2026

Tape Measure:

SL-1 Calibration done 1/22/2025, due 1/22/2026

8.7 Control of Nonconforming Product

Nonconforming areas were well defined and neat. Tags currently in nonconforming:

Tag 9002701A - moved to Reject warehouse with Reservation Hold

Tag 66186 - moved to Reject warehouse. Reserved to JS-47661 to be sorted.

Tag 64360 - moved to Reject warehouse. Reserved to JS-3735 to be sorted.

10.2 Nonconformity and Corrective Action

Open CA:

No open CA's

Closed CA:

CA 27663: SM2 Internal audit Minor Finding. Link to obsolete check sheet document GAD 059 in SM2-PB-001 Rev 1 12/21/21 Press Brake Procedure. All CA requirements met.

10. Improvement

1. Further Best and InVex implementation.

Observations and findings from previous ISO audit

Internal audit 10/29/2024

Minor Finding 1: Link to obsolete check sheet document GAD 059 in SM2-PB-001 Rev 1 12/21/21 Press Brake Procedure.

2.0 Overview

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

Steven Douglas-Press Brake Operator Rick Vogel-Laser Operator Sonny Brown-Amada Punch Combo	Tarvis Stewart-Shipper Dean Burley-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 Nathan Ragland

Date 12/17/2025

Nonconforming Corrective Action Report (CAR) for Jemison
Metals

CAR #	ISO 9001: 2015 Clause / Sub-Clause	Findings/Requirements	Observati on	Mino r	Major
	8.5	First Article Inspection sheet was not filled out.	1		
	8.5	December maintenance performed, but calendar was not marked.	2		