

# **Audit Review and Evaluations OF**

**JEMISON METALS**

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

Dates of Audit: 12/21-23/22

Date of Submittal: 12/30/22

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-LA-001 Rev 1 12/21/21 Laser 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

SM2 PB-001 Rev 1 12/21/21 Press Brake Procedure,

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 Tech PO 30125180-2108 due date 12/12/22 requested on 12/8/22 order acknowledged by Dean Burley 12/8/22 Sales order SM2-8527-4 entered on 12/8/22 due 12/12/22

#### 8.4 Control of externally provided processes, products, and services

PO SM2 649-01 for master coil NB788 from Nucor Berkley. Bucket GVC 19 CB90CD Trane Tech Clarksville. Met all PO requirements and bucket parameters.

#### 8.5-Production & Service Provisions

Production:

1<sup>st</sup> shift

Laser 2: W/O 16949 Trane, (WIP part) Laser documentation reviewed, Part # W436689730001. Jem Print first article completed correctly, doc JDM-F-014 Rev 0 filled in correctly. Jonas Douglas operator, showed competency on job, located and understood procedure, documentation, and document requirement.

Brake Press 2 W/O 16882 Trane (S/O 8455-1) Press Brake Documentation reviewed, Part #436686160110. Jem Print first article completed correctly, doc JDM-F-015 Rev 0, and JDM-F-060 Rev 2 filled in correctly. Operators Travis Harris showed competency on job, located and understood procedure, documentation, and documents requirement.

#### 2<sup>nd</sup> Shift

Laser 2: W/O 16578 Trane (WIP part) Laser Documentation reviewed, Part #W4366657500110. Jem Print first article completed correctly, doc JDM-F-014 Rev 0 filled in correctly. Operators John Smithson showed competency on job, located and understood procedure, documentation, and document requirement.

#### Shipping:

B/L 3917(S/O 8567) reviewed during shipping. All tags were Matched (scanned). Paperwork was signed and material was loaded on the truck.

Preventive Maintenance: Reviewed with Dennis Stewart, Schedule calendar for November reviewed. All schedule maintenance is marked as performed. December calendar in progress.

### 7.1.5 Monitoring and Measuring Resources

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

Micrometer:

M3 Calibration date 1/8/22, due 2/8/23

Calipers:

C5 Calibration 7/21/2022, due 7/21/23

Romer arm:

Calibration 4/3/2020, due 4/3/2023

### 8.7 Control of Nonconforming Product

Nonconforming areas were well defined and neat. Traced tags 739, 740, in reject with note to sort in tag info, moved from finished goods to reject on 11/14/2022 (OBS 1 Was not dispositioned within normal 14-day disposition period)

### 10.2 Nonconformity and Corrective Action

Open CA:

24161 reviewed, Case was entered on 10/27 to address skidding issues with customer Blue Bird material. Corrective action not yet completed. (MF 1 Corrective action not performed or closed in a timely fashion)

Closed CA:

21703 Blue Bird, opened 11/14/21 audited and closed 2/25/2022

21804 Internal audit findings, opened 10/26/21 procedure change, training verified and closed 12/21/21

## 10. Improvement

1. Best project, TV/viewing stations installed with real time data on all in process jobs. Strong visual aid for real time data.

### Observations and findings from previous ISO audit

Internal 10/2/2021:

MF-1 Jem Print First article not filled in.

OFI-1 Instructions to initial back of tag could be documented in procedure.

OFI-2 PPAP was not visibly a PAPP order on shipping board.

All addressed in CA 21804

## 2.0 Overview

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

Travis Harris-Press Brake Operator Jonas Douglas-Laser Operator John Smithson-Laser	Tarvis Stewart-Shipper Dean Burley-Inside Sales Dennis Stewart-Maintenance
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### 2.2 Audited Requirements

<p><b>4 Context of the Organization</b></p> <p>4.4 Quality Management System and its processes</p> <p><b>5 Leadership</b></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><b>6 Planning</b></p> <p><b>7 Support</b></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><b>8 Operation</b></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><b>9 Performance evaluation</b></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><b>10 Improvement</b></p> <p>10.2 Nonconformity and corrective action</p>
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## 2.3 APPROVAL/SIGN-OFF

Report Prepared by Patrick Macias

Date 12/23/22

Nonconforming Corrective Action Report (CAR) for Jemison  
Metals

<b>CAR #</b>	<b>ISO 9001: 2015 Clause / Sub-Clause</b>	<b>Findings/Requirements</b>	<b>Observati on</b>	<b>Mino r</b>	<b>Major</b>
24604	10.2	Corrective action not performed or closed in a timely fashion		1	
24604	8.7	Reject tag was not dispositioned within normal 14-day disposition period	1		