

Audit Review and Evaluations

OF

JEMISON METALS

1255 North gate Drive, Sumter, SC 29154

Dates of Audit: 12/21/22
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: SMT –SRB-001 Red Bud Procedure (Quality Intranet Red Bud computer-no hardcopy present) FOP 081 Inspection REV 1, SMT-CTL-001 Cut to length procedure (Quality Intranet cut to length computer-no hardcopy present) JDM200 Quality Policy Rev-1

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 Current up to date training Matrix listing competency status for all employees interviewed.

8.2 Requirements for products and services

Altec PO 872815-25215 sent on 12/20/2022, due date 12/21/22 order acknowledged by Sandi Watkins on 12/20/22 Sales order 185005-1 entered on 12/20/2022 due 12/21/22. Shipped 12/21/22 on B/L 124350

8.4 Control of externally provided processes, products, and services

Mill coil #725196.000 received on PO SMT-29728-001 for Altec on Receiver 66463, mill cert number 1666609. All information entered correctly. Incoming inspection report MF032 rev 7 not used. Information entered directly into the computer receiving program.

8.5-Production & Service Provisions

2nd shift:

Production: W/O 88013Eaton TN (Stock job) was observed in Production on Red Bud. All checks performed per procedural frequency; material met W/O tolerance requirements. Recorded on FOP 081. Operator Chris Davis

1st shift

Production: W/O 8050 BSH TN (Stock job) was observed in Production on Red Bud. All checks performed per procedural frequency; material met W/O tolerance requirements. Recorded on FOP 081. Operator Sam Jackson

Production: W/O 87871 Altec SMT (Stock job) was observed in Production on Cut to Length. All checks performed per procedure; material met W/O tolerance requirements. Recorded on FOP 081. One skid of nonconforming material identified, segregated, and

rejected by quality personnel. Tag 573253 moved into SMC warehouse and claimed on MC 24528 for rust. Operator Armando Brown.

Shipping: Shipped to customer Altec order185005-1 on B/L 124350 Shipped 12/21/22 on Jemison Truck. Loaded per loading order instructions.

Preventive Maintenance: Reviewed with Dennis Stewart, Schedule calendar for November reviewed. All schedule maintenance 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:

03-03 25' Tape - Last: 10/19/2022 Due: 10/19/2023

M50 1" Mic - Last: 6/14/2022 Due: 6/14/2023

8-3 25' Tape - Last: 10/19/2022 Due: 10/19/2023

63294 Raytec Table - Last: 7/8/2020 Due: 7/8/2023

M55 1" Mic - Last: 12/5/2022 Due: 12/5/2023

D-5 24" Caliper - Last: 5/5/2022 Due: 5/5/2023

Standards:

Ruler 135 (Last Cal 7/20/2020, Due 7/20/2025)

Gauge Block .100" Z2714 (Last Cal 12/10/2020, Due 12/10/2025)

8.7 Control of Nonconforming Product

Both sheet and coil nonconforming areas were found to be adequate to current needs.

Tag 6426210 in coil area: PGVC 24 x 25.75" dated 11/23/22 to be dispositioned ([OBS 1 Was not dispositioned within normal 14-day disposition period](#))

Tag 572396 in sheet area: GVS 16 x 30" x 48" bow over allowed amount of .125" per part spec: Disposition to move to SBR within (broker warehouse) within 14 days of move to reject warehouse per Materials department

10.2 Nonconformity and Corrective Action

No current open Corrective Actions to review.

Corrective Actions closed since last audit:

22084 FHP external Broken skid on truck and runner sticking out past sheet on a different skid. Opened 12/21/202, closed 2/25/22

10. Improvement

1. Cut to length line leveler upgrade. Upgraded Pro Eco 3" roll leveler to a Herr Voss 3.5" roll leveler.

Improve efficiency and expand ability on the leveling of heavier gauge material.

Observations and findings from previous Internal audit

Observation 1-Operator failed to meet all sampling frequency requirements. **Checked sampling frequency on all jobs observed during 2022 audit. All were met.**

Observation 2- Out of date Calibration sticker on Measuring table (63924). **Sticker removed during audit.**

2.0 Overview

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

Sam Jackson-Red Bud Operator Armando Brown CTL Operator Ken Scott- Receiver	Chris Davis-Red Bud Operator Sandi Watkins-Inside sales Lori Seamon-Logistic Coordinator Dennis Stewart-Maintenance
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2.2 Audited Requirements

4 Context of the Organization 4.4 Quality Management System and its processes 5 Leadership 5.1 Leadership and commitment 5.1.2 Customer Focus 5.2 Policy 5.6 Management review 6 Planning 7 Support 7.1.1 General 7.2 Competence 7.1.3 Infrastructure 7.1.4 Environment for the operation of processes 7.1.5 Monitoring and measuring resources 7.5 Documented information 8 Operation 8.1 Operational planning and control	8.2 Requirements for products and services 8.3 Design and development of products and services (N/A) 8.4 Control of externally provided processes, products and services 8.5 Production and service provision 8.7 Control of nonconforming outputs 9 Performance evaluation 9.1 Monitoring, measurement, analysis and evaluation 9.1.1 General 9.1.3 Analysis and evaluation 10 Improvement 10.2 Nonconformity and corrective action
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2.3 APPROVAL/SIGN-OFF

Report Prepared by Patrick Macias

Date 12-21-22

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	Tag 6426210 was not dispositioned within normal 14-day disposition period	1		