

# Assessment Report

## PEERLESS OF AMERICA PO BOX 850

Assessment dates	08/26/2020 to 08/28/2020 (Please refer to Appendix for details)
Assessment Location(s)	Effingham (001)
Report Author	Steven Fuller
Assessment Standard(s)	ISO 9001:2015



## Executive Summary

The Management Team is focus on development of new business from the effort to become a AS 9001 organization and expand into to making Aviation Coil for that industry by a line of site of the market effort and project success

### Changes in the organization since last assessment

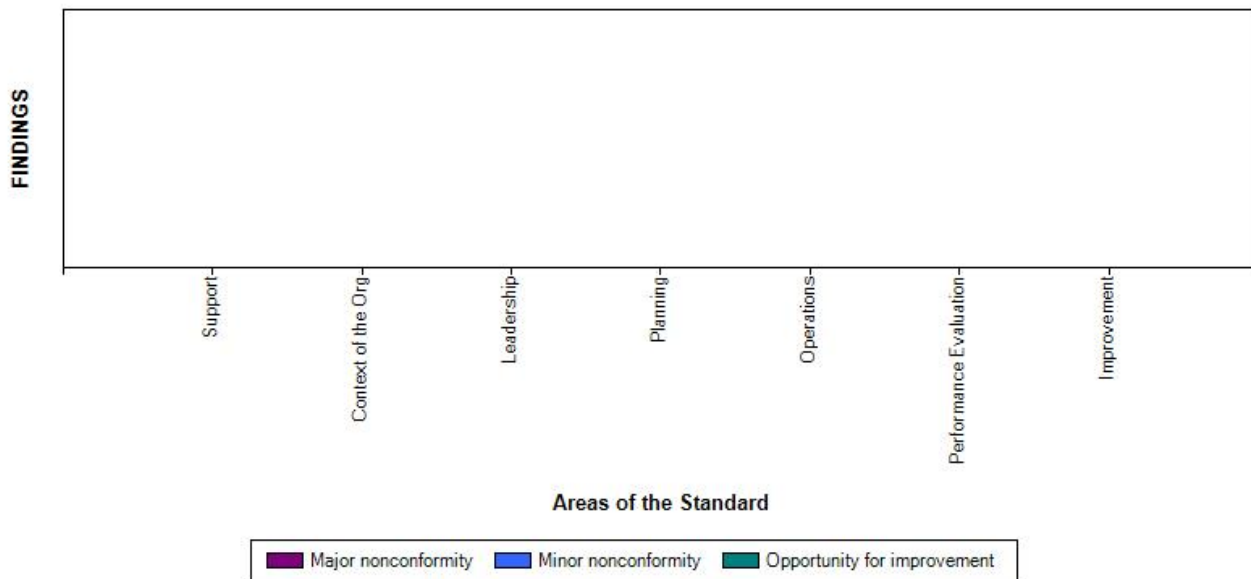
There is no significant change of the organization structure and key personnel involved in the audited management system.

No change in relation to the audited organization’s activities, products or services covered by the scope of certification was identified.

There was no change to the reference or normative documents which is related to the scope of certification.

### NCR summary graphs

#### Areas of the standard(s) where BSI recorded findings



#### Which standard(s) BSI recorded findings against



**Where BSI recorded findings**



Your next steps

**NCR close out process**

There were no outstanding nonconformities to review from previous assessments.  
 No new nonconformities were identified during the assessment. Enhanced detail relating to the overall assessment findings is contained within subsequent sections of the report.

Please refer to Assessment Conclusion and Recommendation section for the required submission and the defined timeline.

## Assessment objective, scope and criteria

The objective of the assessment was to conduct a re-assessment of the existing certification to ensure the elements of the scope of registration and the requirements of the management standard are effectively addressed by the organization's management system.

If this visit is part of a multi-location assessment, the final recommendation will be contingent on the findings from all assessments.

The scope of the assessment is the documented management system with relation to the requirements of ISO-9001-2015 and the defined assessment plan provided in terms of locations and areas of the system and organization to be assessed.

ISO-9001-2015  
 Pearlless 2 of America management system documentation

## Statutory and regulatory requirements

OSHA,EPA

## Assessment Participants

Name	Position	Opening Meeting	Closing Meeting	Interviewed(processes)
Hope Yinpt	Quality engineer	X	X	X
Brian Miller	President	X	X	X
Geoff Milleville	Quality Supervisor	X	X	X
Mike Began	CFO	X	X	
Rachel Collins	HR	X	X	X
Dave Esker	Extrusion	X	X	X

## Assessment conclusion

BSI assessment team

Name	Position
Steven Fuller	Team Leader
Julian Elevado	Team Member

Assessment conclusion and recommendation

The audit objectives have been achieved and the certificate scope remains appropriate. The audit team concludes based on the results of this audit that the organization does fulfil the standards and audit criteria identified within the audit report and it is deemed that the management system continues to achieve its intended outcomes.

RECOMMENDED - The audited organization can be recommended for certification / recertification / continued certification to the above listed standards, and has been found in general compliance with the audit criteria as stated in the above-mentioned audit plan.

Use of certification documents, mark / logo or report

The use of the BSI certification documents and mark / logo is effectively controlled.

## Findings from this assessment

### Incoming Receiving/Inspection/Storage/Shipping: Interviewee: Richard Milanec - Shipping/Receiving

:

The site continues to implement a process to ensure that externally provided and outsourced processes remain within the control of its quality management system. The receiving process was found as defined and documented in SOP 8.4, Purchasing, Rev. 9, 2/18/2020

Inputs to the Process: copper tubing (3/4 sizes, wall thicknesses) - 3-4K for delivery; aluminum billets (7" - 30"L and 6" - 24.25" and 27"L) - Alloys (1100, 1435, 3003, 6063, 31104, 3102, 3065) - Placed by the extrusions - 3

Bill of Lading, Packing Slip and C of A

Copper Tubing Supplier - Cerro Flow Products LLC

Packing List - PO # 4303000000, 06/12/2020 - 3/8 x .0160 LWC Reel LA

Straight Bill of Lading 00577159

QA Mill Test Report -

Aluminum Billets Suppliers - Century Aluminum and Alcan (Rio Tinto)

Outputs of the Process: Supplied Products

Controls of the Process: QMS Documentation - Use of GSS to account for the products received, review of C of As by Quality. Product not made available for use until approved by Quality in GSS.

Incoming product documentation sampled included:

a) Copper Tubing Supplier - Cerro Flow Products LLC

- Packing List - PO # 4303000000, 06/12/2020 - 3/8 x .0160 LWC Reel LA

Straight Bill of Lading 00577159

QA Mill Test Report - PN 2080, Mechanical and Chemical Properties (ASTM/ASME B-743, B-75 and/or B-68), 6/12/20

b) Cerro Flow Products LLC

- Packing List - PO # 4290600002, 03/20/20 - 3/8 x .0160 LWC Reel LA

- Straight Bill of Lading 00572986

c) Cerro Flow Products LLC

- Packing List - PO # 4288500000, 02/19/20 - 7/8 x .0450 x 15" ES LA

- Straight Bill of Lading 00571403

Material Handlers --> Provide products to manufacturing

Shipping:

GSS - Shipping Dashboard - Open Orders Dashboard - Items for shipment coils and aluminum extrusions

Lot Assignment

Sampling of shipped products:

- Bill of Lading 000000487, Traulsen & Company, Inc., Customer PO # 1070237

- Packing List 579, 8/27/2020

- Bill of Lading 000000488, Johnston Supply, Customer PO # 223-223036

- Packing List 580, 8/27/2020

- Bill of Lading 000000490, Refrigeration Hardware Supply, Customer PO # 257091

- Packing List 582, 8/27/2020

- Bill of Lading 000000491, MGR Equipment Corp, Customer PO # R200826P

- Packing List 583, 8/27/2020

- Bill of Lading 000000475, Mobile Climate Control, Customer PO #s 113272, 114250, 003495

- Packing List 566, 8/26/2020

- Bill of Lading 000000, Johnston Supply, Customer PO # 223-223036

- Packing List 580, 8/27/2020

Review of snapshots of the storage areas for the aluminum billets as well as the coiled copper tubings indicated that they were effectively identified with bar coded labels and other labels. Nonconforming products were segregated or returned to vendors (RTV).

Based on interview with pertinent personnel involved in the process and review of documented information, in general, it was indicated that the control and implementation of the receiving, inspection, warehousing and shipping processes continues to be effective.

## **Purchasing Process:**

**Interviewee: Dave Eskew, Materials**

:

It was verified that the site continues to implement the process to ensure that externally provided products for use in production conform to specified requirements by utilizing the site's quality management system for control.

Contracts with Suppliers - Yearly ---> PO Releases

Inputs to the Process: Demand from Production - Aluminum Fin Stock, Packaging (Crate - Automotive/Aerospace), aluminum billets,

Outputs of the Process: Purchased Products

Controls of the Process: QMS Documentation

SOP 8.4, Purchasing, Rev. 9, 2/18/2020

Tool: GSS ---> Transitioning ---> PO Based on Demand

Supplier Monitoring Process

Score Card System

- Vendor Quality Certificate Tracking

Most suppliers tracked for current certifications to ISO 9001:2015

GSS ---> Transitioning ---> PO Based on Demand

Manual Planning for purchase - Utilization - Safety Stock Kept for Raw Material - Spreadsheet

Work Orders - Production Schedule -->

Physical Inventory - Monthly - Cycle Count

POs to Suppliers - E-mail w/ PDF Attached

Outsourced Process - E- Coating --> CreeLighting - PO 117, aluminum coil - Prevent Corrosion

COVID-19 Impact Supply Chain

- Wood (HT) - Crates Shortage - #3 replaces # 2 Lumber

- No impact to aluminum & copper

- Redundancy

No disruption to supply chain.

POs also provided to Receiving when sent to suppliers.

Based on interview with pertinent personnel involved in the process and review of documented information, in general, it was indicated that the purchasing process, including the management/monitoring of supplier performance continues to be effectively implemented.

## Extrusion Process

### - Manufacture Aluminum Tubing and Profiles (Includes Skyve):

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Interviewees: Mike Began - Scheduling; Rob Knierim – Extrusion Lead; Shane Bales - Extruder Operator;

Kyle Lucier - Quality Inspector, Hope Yingst

0500-1500 (One Shift)

E-Mail ----> PN, Qty, Bill To; Customer Service (Review) ---> GSS ---> Extrusion (Quoted by Sales) -->

3 Presses - Flavors, Width Restriction, Alloy (Presses 60, 100, 140)

Press Operator - Drawing (QC - Kyle Lucier; Justin Levitt) - 2 Die - Pre-heated in Oven

Assistant

Helper

Inputs to the Process: Aluminum Billets, Extrusion Dies, Production Schedule

Tooling: Extruding Die (Die Shop)

Outputs of the Process: 10-14 feet Lengths

Controls of the Process: QMS Documentation (SOIs and Boundary Samples)

Equipment/Tooling/Work Centers:

Tooling: Extruding Die (Die Shop)

Press 100 - Parameters

QF1200 Cut to Length Report

SD1146 Quality Checklist, 4/21/2016

QF1105 Scale Weight Sheet

Boundary Board - Visual Aid

7326 - Data recorded in GSS for the First Piece and other inspections done for the product run

Measuring Equipment: Caliper, Micrometer, Steel Tape

Documented Information Reviewed:

- Document #: SOI1122, Press 60 Operation, Rev. A, 9/11/2015
- Document #: SOI1158, Extrusion Coil Testing , Rev. A, 12/18/2019
- Document #: SOI1103, Extrusion Die Set-Up Reporting, Rev. None, 01/10/2001
- Document #: SOI1108, PRESS 60 POWER COILER, Rev. B, 02/28/2020
- Document #: SOI1120, Press 100 - Finish Saw, Rev. F, 4/20/2015
- Document #: SOI1119, Extrude Press 100, Machine Operation, Rev. A, 07/10/2020
- Document #: SOI1120, Press 100 - Finish Saw, Rev. F, 4/20/2015
- Document #: SOI1105, Press 100 - Initial Cut, Rev. E, 06/19/2020
- Document #: SOI1106, Press 100 - Lead Stretcher, Rev. E, 4/07/2015
- Document #: SOI1601, Wood Crate Packing Instructions, Rev. F, 4/24/2015

Press 60 - Laser micrometer

1435 Alloy

7123 Alloy

7440 Alloy

Scrap Target: 70% Yield ; Actual: 75% (Approximate)

It was indicated that the monitoring and measuring equipment used in the production lines and testing equipment were in current calibrations.

The identification and status of the raw materials, in-process and finished goods were indicated as effectively implemented.

Based on the audit of processes against the documented information that included Drawings w/BOMs, SOIs and boundary boards, etc. it was indicated that processes and test were being implemented in accordance with the documented information. Evidence of the execution of the required test and inspections were kept and maintained as documented information as hard copy or electronically (GSS).

Based on the foregoing, it was indicated that production processes were being implemented and controlled effectively.

## Coil Assembly Processes

### - Assembly of Refrigeration Coils (Copper/Aluminum

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Interviewees: Sheri Klein - Head Lead, Coil Assembly, Hope Yingst

22 employees (0500-1500) (Mon-Thu)

Subzero Area - Working during the audit



Inputs to the Process: Copper & Aluminum Tube Coils, Machine Load (Production Schedule, Packet (Drawings w/ BOM, Traveler/Work Orders)

Outputs of the Process: Refrigeration Coils/Evaporators

8 Work Centers

Sales Orders ---> E-mail ---> GSS ---> Spread Sheet --> Orders according to Due date (Daily Update)

Machine Load in Work Center (Weekly) - Packet (Traveler) - Drawing with BOM

Barcode Work Order # 000335-003, PN 89460, 1354 Serpentine

Cut Straight Lengths/Bend Serpentine ----> 1st Piece Inspection ---> In-Process Inspection ----> Trim

Serpentine Tails/Ream ID ---> ...----> Eutectic Welding ---> ...----> Leak Testing ----> Final Assembly

Leak Tester - Tube Leak Test

- Verified Calibrated Metal Orifice, SN 14-105, PN 750-152 by Vic Leak Detection Using Helium Gas, 12/3/2019 using traceable standard to NIST - Tester # 09

- Document #: QF4209, SNIFFER QUALITY REPORT, Rev Date: 01/16/2020

Drawings:

- 1354 Evaporator, PN 13540000, Rev. L, 1/23/2020

- Sub Zero Serpentine Assembly 1354, PN 88288, Rev. C, 1/2/2020

- 3/8 Eutectic Spin Down 2 15/16 x .091 ID, PN 022060611, Rev. B, 1/12/05

- 3/8 Copper Stub, Suction Eutectic Joint, PN 022060612, Rev. -, 7/6/05

- 6 Fin for Machine # 900, 901, PN G-Fin Tab, Rev. -, 7/7/2020

- 1354 Left-End Plate, PN 89020, Rev. -, 9/22/04

- 1354 Right-End Plate, PN 89021, Rev. -, 9/22/04

Controls of the Process: QMS Documentation

- Document #: SOI3210, Machine Setup for #341 Tube Cutter, Rev. B, 9/29/2011

- Document #: SOI3211, Serpentine Bending from Straight Tube, Rev. F, 9/29/2011

- Document #: SOI3212, Gatling Fin Press and Spanker Operation, Rev. A, 9/29/2011

- Document # SOI3204, Smart Charge / 490s Turbo-Test Leak Test, Rev. B, 01/17/2020

- Document #: SOI4200, EUTECTIC WELD INSPECTION, Rev. E, 2/15/2012

- Document # SOI3107, Reaming, Rev. C, 11/12/12

- Document #: SOI3109, Off Center & Sub Zero Tube Flattener, Rev. J, 7/20/2015

- Document #: SOI3119, Double Eutectic Welder, Rev. G, 3/27/2015

- Document #: SOI3203, End Plate Assembly Sub Zero, Rev. A, 11/30/2011

- Document #: SOI3205, Tail Bending, Sub Zero, Rev. A, 9/21/2011

It was indicated that the monitoring and measuring equipment used in the production lines and testing equipment were in current calibrations.

The identification and status of the raw materials, in-process and finished goods were indicated as effectively implemented.

Based on the audit of processes against the documented information that included Drawings w/ BOMs, SOIs and boundary boards, etc. it was indicated that processes and test were being implemented in accordance with the documented information. Evidence of the execution of the required test and inspections were kept and maintained as documented information as hard copy or electronically (GSS).

Based on the foregoing, it was

## **Management Review/Senior Management Bryan Miller ,Hope Y, :**

Management Review Senior Management 8-20-20

No objective other than these not meant for objectives

Weekly meeting covers current operational issues and Senior Management and team leads for review of QMS and issues related to meeting the plant QMS actions and review the requirements to drive improvement in plants functions and product metrics  
 Corrective actions and continual improvement is focus of team  
 Employee's - Hiring issues due to turn over with new employees  
 Customer satisfaction remains positive  
 Scorecard-  
 Customer feedback very positive most at 100%  
 Weekly review  
 Standing agenda for meeting  
 Agenda for daily for present conditions and corrective actions  
 Weekly meeting – covered weekly 8/19/20  
 RGA Improving  
 Attendance Improving  
 OTD Working out ERP issues  
 Recovery Improving  
 Other topics based on present situations  
 Review of agenda  
 GSS new computer software  
 Risk of start up data reporting been challenge to get report that are useable  
 The Management team focus on customer Quality including OTD,RGA,Customer satisfaction is effective  
 the processes for weekly reviews and action associated with them indicate effective focus The process is effective

### Internal Audits:

Schedule Calendar  
 8/26/2020  
 Green is 2020 plan with dates  
 All processes plan by Sept 202 time frame  
 Green indicate scheduled and in process or completed  
 Process control for July 2020  
 Measurement for June  
 7/22/2020  
 Extrusion  
 Cpar on spread sheets 2020-15  
 CPAR- 2020-14 Back up of Department laptop on server  
 OFI Data collection review after 90 days  
 June 2020 several Capr opening  
 17025 requirements for calibration  
 Gage Pak software  
 CPAR issues on use of Calibration software and procedures  
 Action Request form log  
 2020-15

2020-14

2020-13

-14 Old laptop to back up press is not capable due to age and software

Maintenance got a laptop and back up data to server completed on 7/15/2020

The assessment of the internal process indicated effective audit method and evidence audit documentations and audit trails the process is effective

### **Corrective Action :**

Cpar-17 July 29 th 2020

Rework unit at customer sites

Quality Alert 133

Operator working not aware of SO/I for assy cell

SOI issues for Cell and operator train to SOL

Production leader verified next

Run of product and Quality verified

auditor verified process Aug 15 2020

Cpar -2020-12 June 3 2020

Procedure update to address holding of Billet for testing and release

Signed off Jul 30 2020 by H Yingst[

The assessment of the indicated effective root cause and corrective action taken to resolve c/a documented The process is effective

### **Swat Meeting Risk analysis:**

Actions list out to process owners

Actions list and process owner responsibility

Management Review and Swat analysis performed back to back

New Swat reviewed is being planned for aprox 30 days out

With follow up The actions are part of the summary of Management Review meeting

Some Risk will require financial impact being proactive in discussing this will give value

Rewrite Core Procedure for AS 9100 to apply for new Standard

Risk based culture changes to Conv19

First Swat meeting Aug 20 risk assessment started

US opportunities on coil side for US made coil assembly

The assessment of the Swat analysis would an effective process for evaluating and reporting risk and appropriate action or mediation. The process is effective

### **Sales Jorden Sammons:**

Focus on Aviation opportunities for new business aerospace industries

Social Media Facebook, Linkin, Marketing ,

Team Dev of Quote feast ability review and determine the business fit  
 Quotation process  
 IEA Kenosha Wi 7/24/2020  
 New tooling new profile not currently running  
 Terms and condition note on Quotation  
 New tooling need built for new profile  
 Coil Business growth for refrigeration business residential side  
 The terms are based on normal conditions  
 New growth for medical storage increase for  
 Distribution customer list on Web site for dist for smaller volume to eliminate smaller product runs  
 Sales forecast and budget for sale under prediction for sales  
 Score card review by upper management and Quality and discuss during weekly operation meeting part  
 of agenda for  
 discussion  
 Webx meeting with customer meeting to discuss issues and new opportunities and New Risk to  
 growth of business and focus on business opportunities  
 No Manufacturer Rep being used for outside sales activity  
 Some Distributors working with for coil side  
 Hope GSS Delivery Performance  
 OTD switch over from previous 79%  
 Pending Gss getting data in form to use in calculating OTD  
 With improved data output  
 The assessment of the sales process found the process to be effective at managing the customer  
 interaction to product sales for the company. The process is effective

## Maintenance :

Maintenance or MER process for requesting Maintenance  
 To service the equipment Risk or serious of issue is identified  
 On Document or MER request for Risk of issue  
 Looked at replace critical parts for presses a part inventory /in warehouse for critical spares  
 Maintenance Equipment Failure Request for unplanned  
 Down time on critical equipment  
 Long term operators running machine  
 Spare parts process being Developed  
 GSS ERP system partial implemented module for maintenance can be pt in place to handle PM activity  
 Sheets on file for week PM checks on presses no analysis are links to MER request  
 QF-350 REV Date 12/20/1999  
 Forms for recording operator PM  
 Team lead give feed back to operator on none filled out forms  
 Or incomplete forms  
 Back up of Press data automatically  
 By server  
 The assessment of the Maintenance PM process found it to be effective at assuming equipment reliability  
 and effective operations The process is effective

**Calibration Nicole Calibration Receiving policy for incoming inspection****Check all material for Quality requiring Organization own sampling**

:

0Gage Pak backed up to server

27-EL3

20-EZ12

20-EE22

Past due gage in possession off site engineer await them to forward

I gage investigate due to extreme h

high cost to calibrate investigation into lower cost equipment with lower maintenance and calibration cost

Org chart reviewed for lean organization

Incoming inspection

Fasco Regal Beloit Motors 100 pcs check to po requirements

6/27/20 L41514B

Bilot 3003 Central Aluminum 80068283 BOL

374 Pcs Spec C311 7" Bilot

COA for Bilot attached review to assure it meets spec received Aug 23 2020 C of A received and approved

he assessment of the calibration process found the process to be effective at assuring all measurement device are functioning at design and have trackability to a know standard The process is effective

**Design and Del:**

3

0Gage Pak backed up to server

27-EL3

20-EZ12

20-EE22

Past due gage in possession off site engineer await them to forward

I gage investigate due to extreme h

high cost to calibrate investigation into lower cost equipment with lower maintenance and calibration cost

Org chart reviewed for lean organization

Incoming inspection

Fasco Regal Beloit Motors 100 pcs check to po requirements

6/27/20 L41514B

Bilot 3003 Central Aluminum 80068283 BOL

374 Pcs Spec C311 7" Bilot

COA for Bilot attached review to assure it meets spec received Aug 23 2020 C of A received and approved

Design process  
 Design changes  
 Handling Sales Opportunities  
 8.2 Rev 13  
 New Product Dev Rolling item action list (Rail)  
 Thermo Fisher RAIL for evaluation for Post Quote process to assure all the requirements are understood and actioned  
 Sea Freeze Feasibility turnover to production commercially Availability on coil  
 DFMEA  
 APQP being used in aviation  
 Step thru similar to gate process document in different format than the Rail process  
 Engineer Manager working off site all engineer that work off site during the pandemic  
 Customer time line is critical with Rail process  
 Rail not to production level were product has been released to production for delivery  
 Process analysis Capability studies  
 And Rail work in conjunction with each other to assure customer requirements are understood and validates  
 Control of Engineering documents and storage and retention of Documents .  
 Some customer create a drawing of drawing for customer become a quote to assuring  
 Start from customer drawing or sketch and document goes back to customer for approval  
 Customaries product family were customize to customer needs  
 Document approval for approval on a peerless  
 Vault is store for drawings release drawing on w drive  
 Engineer only access to vault released drawing on w drive  
 For inter company access  
 Software used is solid works  
 ECR would issue ECN and process be approved by core stake holders (members of RAIL team)  
 Standards each customer will have a file for appropriate documents to be stored including ECN, Standard associated with a customer will be retained in customer file  
 The Design process using tools such as RAIL process to define the risk and opportunities of a project and follow project thru the gate processes to assure scope is meant to customer satisfaction. The process is effective

## Document Control:

with rev history at Excell spread sheet with Rev levels and change control  
 But revision history at bottom of page  
 Person with most knowledge of process  
 Approve the documents  
 Archive old revision of document  
 For history and access in future for needs  
 7.5-1 Rev 11  
 Document control procedure  
 Purpose

Definition

Ref Documents

Procedure

Revision History

Defining a document

Use excel spreadsheet to manage the Rev levels of documents Quality Engineer has only assesses to the spread sheet

The assessment of the Document control indicated effective monitoring of document release and approval of document using a excel spread sheet and specific overview on a regular bases The process is effective

## Training Hope Y:

Shared drive under training

New hire overview

30 day overview Checklist

FOB

40 hrs on job before acceptance

SOI Book form were lead can go over SOI

Matrix form

SOI

Review with all employees to grandfather with

Rewrite SOI on saw were operator injured

Operator

Training

Supervisor notification or customer issue will require retraining of process

30 review of new hire

12/12/19 sign in sheet for safety Sexual Haz, Awareness

Training attendance overview

Jene Thompson overview of SOI/ for senior employee for competence of employee

Employee Training matrix for training needs to cross training

Train the trainer with leads for extrusion Jene Thompson training

Skyve Production 5 employee typical

SOI Forming Coil

SO 14247 Set up procedure for 2 sided coil set up and gage setting using feeler gages

Set up correction and feed speed accuracy

The assessment of the training process found a great improvement of the training process sense last visit the organization and effectiveness is noted.

40 hrs on job before acceptance

SOI Book form were lead can go over SOI

Matrix form

SOI

Review with all employees to grandfather with

Rewrite SOI on saw were operator injured

Operator

Training

Supervisor notification or customer issue will require retraining of process  
 30 review of new hire  
 12/12/19 sign in sheet for safety Sexual Haz, Awareness  
 Training attendance overview  
 Jene Thompson overview of SOI/ for senior employee for competence of employee  
 Employee Training matrix for training needs to cross training  
 Train the trainer with leads for extrusion Jene Thompson training  
 Skyve Production 5 employee typical  
 SOI Forming Coil  
 The process is effective

<b>Finding Reference</b>	1949817-202008-01	<b>Certificate Reference</b>	FM 54179
<b>Certificate Standard</b>	ISO 9001:2015	<b>Clause</b>	7.2
<b>Category</b>	Observation		
<b>Area/Process:</b>	Training Hope Y		
<b>Details</b>	The present training process is a greatly improvement over past training systems The process is effective.		

### Skyve Production Documents Hope Y:

SO 14247 Set up procedure for 2 sided coil set up and gage setting using feeler gages  
 Set up correction and feed speed accuracy  
 The assessment of the Skyve process in the extrusion area is well documented and planned. The process is effective at assure customer requirements are controlled. The process is effective

### Next visit objectives, scope and criteria

The objective of the assessment is to conduct a surveillance assessment and look for positive evidence to ensure the elements of the scope of certification and the requirements of the management standard are effectively addressed by the organisation's management system and that the system is demonstrating the ability to support the achievement of statutory, regulatory and contractual requirements and the organisations specified objectives, as applicable with regard to the scope of the management standard, and to confirm the on-going achievement and applicability of the forward strategic plan.



The scope of the assessment is the documented management system with relation to the requirements of ISO-9001-2015 and the defined assessment plan provided in terms of locations and areas of the system and organisation to be assessed.

ISO-9001-2015  
Peerless 2 of America management system documentation

Please note that BSI reserves the right to apply a charge equivalent to the full daily rate for cancellation of the visit by the organization within 30 days of an agreed visit date. It is a condition of Registration that a deputy management representative be nominated. It is expected that the deputy would stand in should the management representative find themselves unavailable to attend an agreed visit within 30 days of its conduct.

## Next Visit Plan

Date	Auditor	Time	Area/Process	Clause
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## Appendix: Your certification structure & ongoing assessment programme

### Scope of Certification

#### FM 54179 (ISO 9001:2015)

The design, manufacture and assembly of refrigeration coils and manufacture of aluminum tubing and profiles and secondly operation such as Skyve .

### Assessed location(s)

The audit has been performed at Central Office, Permanent Locations.

#### Effingham / FM 54179 (ISO 9001:2015)

<b>Location reference</b>	<b>0009900218-001</b>
<b>Address</b>	Peerless of America 2 Inc. 1201 West Wabash Avenue Effingham Illinois 62401 USA

<b>Visit type</b>	Re-certification Audit (RA Opt 2)
<b>Assessment reference</b>	3010510
<b>Assessment dates</b>	08/26/2020
<b>Deviation from Audit Plan</b>	No
<b>Total number of Employees</b>	90
<b>Effective number of Employees</b>	90
<b>Scope of activities at the site</b>	The design, manufacture and assembly of refrigeration coils and manufacture of aluminum tubing and profiles and secondly operation such as Skyve
<b>Assessment duration</b>	5 Day(s)

## Certification assessment program

**Certificate Number - FM 54179**

**Location reference - 0009900218-001**

		<b>Audit 1</b>	<b>Audit 2</b>	<b>Audit 3</b>	<b>Audit 4</b>	<b>Audit 5</b>	<b>Audit 6</b>	<b>Audit 7</b>
<b>Business area/Location</b>	<b>Date (mm/yy):</b>	4/18	10/18	4/19	10/19	4/20	9/20	9/17
	<b>Duration (days):</b>	2.0	2.0	2.0	2.0	2.0	4.0	4.0
Training			X	X	X		X	X
Shipping				X			X	X
Sales			X		X		X	X
Receiving			X				X	X
QA, Calibration,		X		X		X	X	X
Purchasing		X		X		X	X	X
Management Rev/Objectives		X	X	X	X	X	X	X
Maintenance			X				X	X
Extruding		X		X		X	X	X
Design			X		X		X	X

Coil/ Assy		X		X		X	X
Audits	X	X	X	X	X	X	X
Complaint, Corrective actions	X	X	X	X	X	X	X

### Justified exclusions / non applicable clauses

There are no justified exclusions / non applicable clauses of the standard for certificate : FM 54179

### Mandatory requirements – re-certification.

Review of assessment finding regarding conformity, effectiveness and relevance of the management system:

The QMS system has indicated to have a effective processes and no trends of nonconformity the history during the 3 year cycle in dictated training as the only document issue

Management system strategy and objectives:

The strategy of the Management team is to become AS 9100 certified so a focus on achieving new business in that industry

Review of progress in relation to the organization's objectives:

The organization is 3 months away from achieving the AS9100 certification which is the primary target

Review of assessment progress and the re-certification plan:

The assessment progress is on target as far as continual assessment and recertification's

BSI Client Management Impartiality and Surveillance Strategy:

The CM is impartial and the surveillance stragy is effective

Continue with the current Total assessment days / Cycle.

### Expected outcomes for accredited certification.

#### What accredited certification to ISO 9001 means

ISO 9001:2015 specifies requirements for a quality management system when an organization: needs to demonstrate its ability to consistently provide products and services that meet customer and applicable statutory and regulatory requirements; and aims to enhance customer satisfaction through the effective application of the system, including processes for improvement of the system and the assurance of conformity to customer and applicable statutory and regulatory requirements.

### **What accredited certification to ISO 9001 does not mean**

- 1) It is important to recognize that ISO 9001 defines the requirements for an organization's quality management system, not for its products and services. Accredited certification to ISO 9001 should provide confidence in the organization's ability to "consistently provide product that meets customer and applicable statutory and regulatory requirements". It does not necessarily ensure that the organization will always achieve 100% product conformity, though this should of course be a permanent goal.
- 2) ISO 9001 accredited certification does not imply that the organization is providing a superior Product or service, or that the product or service itself is certified as meeting the requirements of an ISO (or any other) standard or specification.

### **Definitions of findings:**

Nonconformity:

Non-fulfilment of a requirement.

Major nonconformity:

Nonconformity that affects the capability of the management system to achieve the intended results. Nonconformities could be classified as major in the following circumstances:

- If there is a significant doubt that effective process control is in place, or that products or services will meet specified requirements;
- A number of minor nonconformities associated with the same requirement or issue could demonstrate a systemic failure and thus constitute a major nonconformity.

Minor nonconformity:

Nonconformity that does not affect the capability of the management system to achieve the intended results.

Opportunity for improvement:

It is a statement of fact made by an assessor during an assessment, and substantiated by objective evidence, referring to a weakness or potential deficiency in a management system which if not improved may lead to nonconformity in the future. We may provide generic information about industrial best practices but no specific solution shall be provided as a part of an opportunity for improvement.

Observation:

It is ONLY applicable for those schemes which prohibit the certification body to issue an opportunity for improvement.

It is a statement of fact made by the assessor referring to a weakness or potential deficiency in a management system which, if not improved, may lead to a nonconformity in the future.

### **How to contact BSI**

'Just for Customers' is the website that we are pleased to offer our clients following successful registration, designed to support you in maximizing the benefits of your BSI registration - please go to [www.bsigroup.com/j4c](http://www.bsigroup.com/j4c) to register. When registering for the first time you will need your client reference number and your certificate number

Should you wish to speak with BSI in relation to your certification, please contact your local BSI office – contact details available from the BSI website:

<https://www.bsigroup.com/en-US/contact-us/>

## Notes

*This report and related documents are prepared for and only for BSI's client and for no other purpose. As such, BSI does not accept or assume any responsibility (legal or otherwise) or accept any liability for or in connection with any other purpose for which the Report may be used, or to any other person to whom the Report is shown or in to whose hands it may come, and no other persons shall be entitled to rely on the Report. If you wish to distribute copies of this report external to your organization, then all pages must be included.*

*BSI, its staff and agents shall keep confidential all information relating to your organization and shall not disclose any such information to any third party, except that in the public domain or required by law or relevant accreditation bodies. BSI staff, agents and accreditation bodies have signed individual confidentiality undertakings and will only receive confidential information on a 'need to know' basis.*

*This audit was conducted through document reviews, interviews and observation of activities. The audit method used was based on sampling the organization's activities and it was aimed to evaluate the fulfilment of the audited requirements of the relevant management system standard or other normative document and confirm the conformity and effectiveness of the management system and its continued relevance and applicability for the scope of certification.*

*As this audit was based on a sample of the organization's activities, the findings reported do not imply to include all issues within the system.*

## Regulatory compliance

*BSI conditions of contract for this visit require that BSI be informed of all relevant regulatory non-compliance or incidents that require notification to any regulatory authority. Acceptance of this report by the client signifies that all such issues have been disclosed as part of the assessment process and agreement that any such non-compliance or incidents occurring after this visit will be notified to the BSI client manager as soon as practical after the event.*