Process/Product Audit Checklist

Cust #: 2285 Customer: Flanders		GRP/Size/GRD/Width: GVS.0635CB90CDX60	
PWC: SRB W/O#: 68461 Date: 1-10-18		Part #(s): 02046200	Auditor: B. Clem
Gauge Range: .0569-.0635	Actual Gauge: .058	Width Range: 60-60.2500	Width Actual: 60.104
Length Range: 119.875-120.125	Length Actual: 120.060	Other: W-B 0-.12	Other Actual: .125
Other: Flatn 0-.25	Other Actual: .125	Other: 23 pcs./Tag	Other Actual: 23 pcs/Tag

Item	YES	NO	N/A	Comments/Action Taken (Required for NO)
Process Inspection Sheets filled out according to frequency and sampling required? Chris M.		✓		Width & Gauge not checked end of 1st Skid. Length not checked end of run.
Correct raw material type and size?	✓			Tag(s) to use: NB56435 Tag(s) used: NB56435
Setup performed according to W/O?	✓			
Product is acceptable according to customer-specific requirements? [Fab: Is the Part Print Present & the correct Revision? Are required measurements documented?]	✓			[Fab: Print Rev:_____, W/O Rev:_____, Part Spec Rev:_____] (Leave blank if non-Fab audit)
Packaging is acceptable according to customer-specific requirements?	✓			
Visual Inspection performed and product meets requirements?	✓			
Out of spec noted, with actions taken?			✓	
Non-conforming material put into reject warehouse and physically put into non-conforming area?			✓	
Required gages available & functional?	✓			
All Gages Calibrated (List in Comments)	✓			Gages Observed (list last calibration and when due) 8-3 25' Tape 7-31-17 7-31-18 M44 1" Mic 6-27-17 6-27-18 ST-5 Step Gauge 7-5-17 7-5-18 63294 Meas. Table 4-19-17 4-19-18
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	✓			
Required PPE being worn?		✓		No Safety Glasses
Forms are the latest revision per Quality Intranet?	✓			List Forms (Observed Rev vs Intranet Rev) SMT-SRB-001 11-8-16 5 JM-OP-001 4-21-15 0 FOP081 2-16-01 1
Hardcopy Controlled Documents are listed on Quality Intranet by location?			✓	List Documents and their Location:

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 68461   Coil Number: NB56435B

Customer Number: FLANDERS   Coil Information: NUB2713975   Supplier: NUCORBERKELY

Product: Steel   Jan-10-18   18:00 to 18:50 (clock 50.4 min/ run 14.2 min)   Shift: 2

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Average Thickness and Tolerance Data
Target  0.0602 in    Average^ 0.0594 in     Average - Target      -0.0003 in (-1.38%)
                                            Standard Deviation^  0.0003 in ( 0.42%)

Length       799 ft             Above High Limit    0.0635 in        0 ft (  0.0%)
Width     60.000 in             In Tolerance                       799 ft (100.0%)
Weight      9700 lbs            Below Low Limit     0.0569 in        0 ft (  0.0%)

Max Thickness  0.0602 in at      6 ft      Min Thickness  0.0586 in at    104 ft

Statistical Process Control Data
Upper Control Limit     0.0601 in    Upper Tolerance Limit       0.0635 in
X Double Bar            0.0594 in    R Bar                       0.0[illegible]8 in
Lower Control Limit     0.0586 in    Lower Tolerance Limit       0.0[illegible] in

CR    22.7% (Capability Ratio %, 100/CP)
CP    4.400  (Process Capability, HiLim-LoLim/6*Sigma)
CPK   3.293  (Capability vs Limits)          TMW Ratio       0.958(Low Limit/Avg)

Thickness Distribution Relative to the Target
    +++    0.0%
+0.0100    0.0%
+0.0090    0.0%
+0.0080    0.0%
+0.0070    0.0%
+0.0060    0.0%
+0.0050    0.0%
+0.0040    0.0%
+0.0030    0.0%
+0.0020    0.0%
+0.0010    0.0%
+0.0000    0.1%
-0.0010   81.1%  ..............................................................>
-0.0020   18.9%  ..................................
-0.0030    0.0%
-0.0040    0.0%
-0.0050    0.0%
-0.0060    0.0%
-0.0070    0.0%
-0.0080    0.0%
-0.0090    0.0%
-0.0100    0.0%
    ---    0.0%
                 0    3    6    9    12    15    18    21    24    27    30    33

100.0% is within ± 0.0020 in of the target    100.0% is within ± 0.0040 in of the target
100.0% is within ± 0.0100 in of the target    100.0% is within ± 0.0200 in of the target
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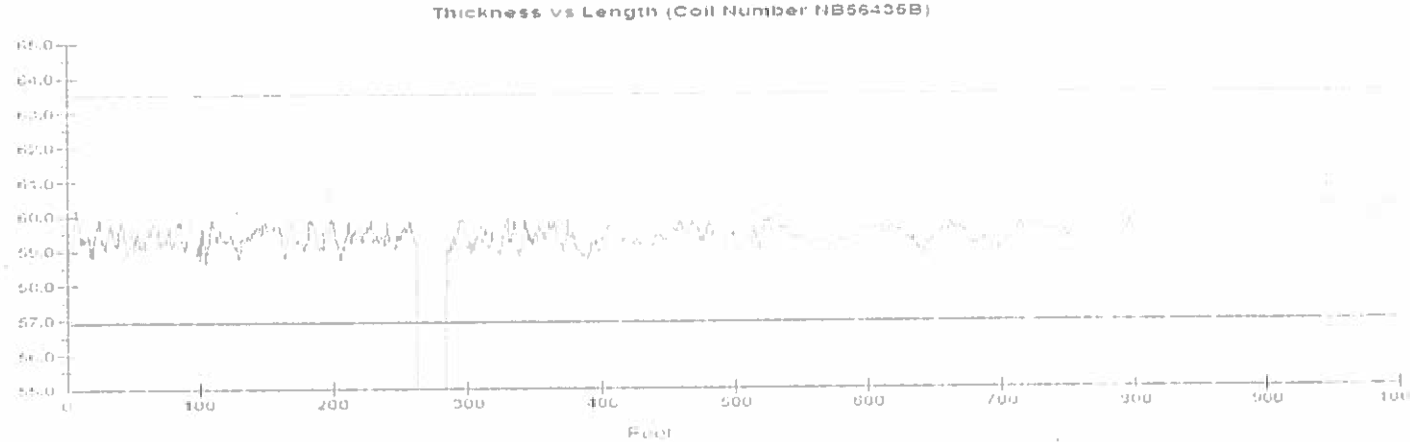
Thickness vs Length (Coil Number NB56435B)



Gauge readings provided by Advanced Gauging Technologies, L.L.C.   Plain City, OH 43064 USA   Tel:(614) 873-6691