

Process/Product Audit Checklist .0666

Cust #: <u>1697</u> Customer: <u>GE Mebane</u> GRP/Size/GRD/Width: <u>GVS/16C/FB40NO/60.00</u>				
PWC: <u>SRB</u> W/O#: <u>72573</u> Date: <u>1-10-19</u> Part #(s): <u>30466A174</u> Auditor: <u>Michael Barnett</u>				
Gauge Range: <u>0.0606-0.0726</u> Actual Gauge: <u>0.061-0.062</u> Width Range: <u>33.172-33.177</u> Width Actual: <u>33.183</u>				
Length Range: <u>45.070-46.030</u> Length Actual: <u>46.000</u> Other: <u>W-B-F.12</u> Other Actual: <u><.12</u>				
Other: <u>Se .06</u> Other Actual: <u>.046/.052/.050</u> Other: <u>Residual</u> Other Actual: <u><.12</u>				
Item	YES	NO	N/A	Comments/Action Taken (Required for NO)
Process Inspection Sheets filled out according to <u>frequency</u> and <u>sampling</u> required?	✓			LaBuron Moses - 60x96 + 1 pass 3367 Chris Maple - Remainder of Job
Correct raw material type and size?	✓			Tag(s) to use: <u>NB60648</u> Tag(s) used: <u>NB60648</u>
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?			X	
Non-conforming material put into reject warehouse and physically put into non-conforming area?	✓		X	
Required gages available & functional?	✓			
All Gages Calibrated (List in Comments)	✓			m-501" Mic 8-31-18 8-31-19 Gages Observed (list last calibration and when due) Tape Measure (25') - 8-3 3-3-18 3-30-19 Measuring table - 63294 4-20-18 4-20-19 Step Gauge - St-5 7-5-18 7-5-19
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	✓/✓			
Required PPE being worn?	✓			
Forms are the latest revision per Quality Intranet?	✓			List Forms (Observed Rev vs Intranet Rev) Form 1 2-16-01 1 FMA045 5-23-14 0
Hardcopy Controlled Documents are listed on Quality Intranet by location?	✓			List Documents and their Location: SMT SRB 001 3M-OP-001 SMT-SH-001

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 72573 Coil Number: NB60648

Customer Number: GE MEBANE Coil Information: NUB1817094 Supplier: NUCOR BERKELEY

Product: Steel Jan-10-19 11:57 to 14:40 (clock 162.7 min/ run 50.2 min) Shift: 2

Average Thickness and Tolerance Data

Average	60.6 mil	Average	61.1 mil	Average - Target	-5.4900 mil (-
				Standard Deviation	0.2800 mil (
Length	3465 ft	Above High Limit	72.6 mil		0. ft
Width	60.000 in	In Tolerance			3377 ft
Weight	40906 lbs	Below Low Limit	60.6 mil		91 ft
Thickness	62.1 mil at	21 ft	Min Thickness	60.1 mil at	246

Statistical Process Control Data

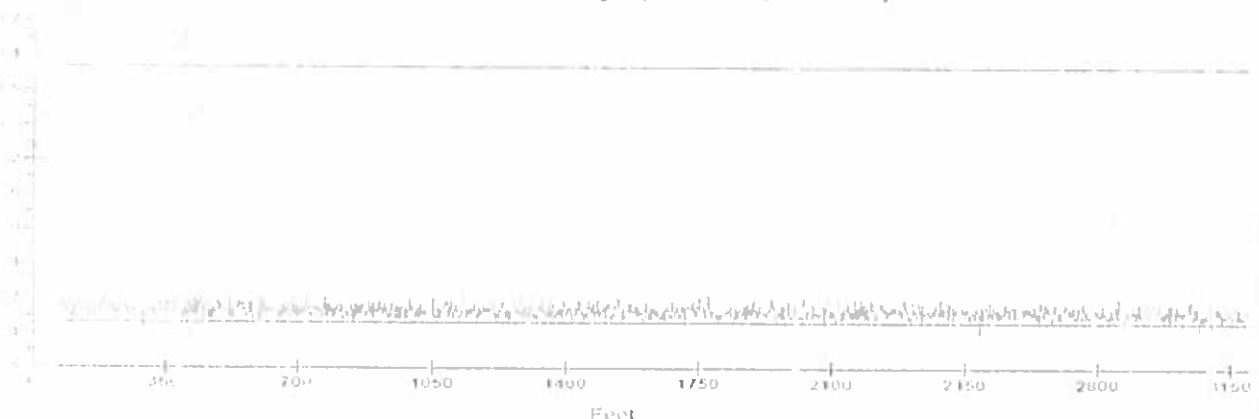
Upper Control Limit	62.0 mil	Upper Tolerance Limit	72.6 mil
Mean	61.1 mil	P Bar	0.8 mil
Lower Control Limit	60.3 mil	Lower Tolerance Limit	60.6 mil
Cp (Capability Ratio %, 100/CP)			
Cpk (Process Capability, HiLim-LoLim/6*Sigma)			
Cpk (Capability vs Limits) TMW Ratio 0.992 (Low Limit/Avg)			

Thickness Distribution Relative to the Target



6.1% is within ± 2.0000 mil of the target
 100.0% is within ± 10.0000 mil of the target
 100.0% is within ± 5.0000 mil of the target
 100.0% is within ± 20.0000 mil of the target

Thickness vs Length (Coil Number NB60648)



GE sheet checklist (To be filed with W.O.)

Job Number: 72573

Part Number(s): 1697/B8A66A1P9

(Enter "X" to signify meets requirements per Work Order or meets check off requirements.)

Any nonconforming material to be immediately segregated and reported to supervisor or quality representative.

☒ Gauge, width, length, shape and square meets customer requirement per W.O. and recorded on form FOP 081.

☒ Burr less than 10% thickness of steel.

☒ Skid type matches customer requirement per W.O.

☒ Shape monitored throughout run per the procedural checks.

Leveler Operator (print name): Laquan Moses

Initial: Lm

☒ Packed to customer requirements stated on W.O.

☒ Sheets stacked neatly.

☒ Gauge, width, length and max weight/piece count meet customer requirement per and recorded on JDM 5

☒ Tag hung on skid.

☒ Tag number written on skid.

Packer (print name): Terrence Singleton

Initial: TJS

Doc. # FMA045 Revision 0 date 5/23 /14

GE sheet checklist (To be filed with W.O.)

Job Number: 72573

Part Number(s): 1697/CDB0376

(Enter "X" to signify meets requirements per Work Order or meets check off requirements.)

Any nonconforming material to be immediately segregated and reported to supervisor or quality representative.

☒ Gauge, width, length, shape and square meets customer requirement per W.O. and recorded on form FOP 081.

☒ Burr less than 10% thickness of steel.

☒ Skid type matches customer requirement per W.O.

☒ Shape monitored throughout run per the procedural checks.

Leveler Operator (print name): Chris Meyer

Initial: CM

☒ Packed to customer requirements stated on W.O.

☒ Sheets stacked neatly.

☒ Gauge, width, length and max weight/piece count meet customer requirement per and recorded on JDM 5

☒ Tag hung on skid.

☒ Tag number written on skid.

Packer (print name): Marion Simms

Initial: MS