Process/Product Audit Checklist

Cust #: 2073	Customer: Specialty	GRP/Size/GRD/Width: PDC .0966 CSB 9.5	
PWC: SSL W/O#: 22585	Date: 1-11-19	Part #(s): 010011	Auditor: B. Clem
Gauge Range: .0966-.1126	Actual Gauge: .101	Width Range: 9.495-9.505	Width Actual: 9.501
Length Range: N/A	Length Actual: N/A	Other: Camb 0-.12	Other Actual: Not Checked.
Other: Wth 2.87-2.88	Other Actual: 2.877	Other: N/A	Other Actual: N/A

Item	YES	NO	N/A	Comments/Action Taken (Required for NO)
Process Inspection Sheets filled out according to frequency and sampling required?		✓		No Camber Check was done. Farron
Correct raw material type and size?	✓			Tag(s) to use: NB60635 Tag(s) used: NB60635
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?			✓	QA not at pack line during packaging
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)	✓			D-2 40" Caliper 8-29-18 8-29-19 Gages Observed (list last calibration and when due) 13-01 25' Tape 8-16-18 8-16-19 11-03 12' Tape 1-7-19 1-7-20 MSS 1" Mic 12-18-18 12-18-19 D-5 24" Caliper 1-15-18 1-15-19
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) FOP015 2-16-01 1
Hardcopy Controlled Documents are listed on Quality Intranet by location?	✓			List Documents and their Location: SMT-SL-001 JM-OP-001

Back

When operator was ask about physically doing a camber check his reply was, "We only do it sometimes."

Manual Inspection Report

EQA033 Rejection Codes

JDOP005 JDOP006

JDOP007 JDOP049

Job # SMT-	72585	Page #	1				Horizontal Clearance						
Location:	Sumter	Operator:	FM		Machine:	Slitter	CQ	HS	10b38	Date	1/11/2019		
Gauge Spec	0.09600	Limits	0.09600	0.11200	Target	0.10400	0.01440	0.01920	0.02400				

Cut	Set Up	Actual	Cut	Set Up	Actual	Cut	Set Up	Actual	Cut	Set Up	Actual	Cut	Set Up	Actual
1	9.504	9.502	6	2.879	2.877	11			16			21		
2	9.504	9.501	7	2.879	2.876	12			17			22		
3	9.504	9.501	8			13			18			23		
4	9.504	9.501	9			14			19			24		
5	2.879	2.877	10			15			20			25		

Set Up Comments:

	Coil #	Olsen	Rb		Gauge: Head	1/4	Center	3/4	Tail	Camber	Linear Ft	Burr Hgt	Good PC	Bad PC	Comment
1	NB60635			E	0.10100	0.10100	0.10100	0.10100	0.10100						
				C	0.10100	0.10000	0.10000	0.10000	0.10000						
				E	0.09900	0.09900	0.09900	0.09900	0.09900						
2				E											
				C											
				E											
3				E											
				C		#									
				E											
4				E											
				C											
				E											
5				E											
				C											
				E											

Start		Stop		Start		Stop		Total		Total		Cst/Hour	$550.00
Time	12:00 AM	Time		Down Time		Down Time		Down Time	0:00	Run Time	############	Cost	#NUM!

Comment