

Process/Product Audit Checklist

Cust #: <u>2409</u> Customer: <u>Custom</u>		GRP/Size/GRD/Width: <u>AZS.0736CSB12548</u>		
PWC: <u>SRB</u> W/O#: <u>64087</u> Date: <u>1-12-17</u> Part #(s): <u>AL24G48x96T125</u>		Auditor: <u>B. Clem</u>		
Gauge Range: <u>.0036-.0316</u>	Actual Gauge: <u>.004</u>	Width Range: <u>48-48-1875</u>	Width Actual: <u>48-111</u>	
Length Range: <u>96-96.2500</u>	Length Actual: <u>96.139</u>	Other: <u>96-96.1250</u>	Other Actual: <u>96.030</u>	
W-B-F	Other: <u>0-.12</u> Other Actual: <u>0</u>	Wt.	Other: <u>2994 lbs</u> Other Actual: <u>2495 lbs.</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?	✓			<u>Samuel J. - middle shift</u>
Correct raw material type and size?	✓			Tag(s) to use: <u>505285</u> Tag(s) used: <u>505285</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: <u>N/A</u> , W/O Rev: <u>N/A</u> , Part Spec Rev: <u>N/A</u> (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) <u>8-3 25' Tape 7-21-16 7-21-17</u> <u>m-44 1" mic 6-28-16 6-28-17</u> <u>ST-5 step Gauge 7-5-16 7-5-17</u> <u>63294 Meas. Table 4-26-16 4-26-17</u>
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) <u>SMT-SRB-001 11-8-16 S</u> <u>JM-OP-001 4-21-15 O</u> <u>FOPOR 2-16-01 I</u>
Hardcopy Controlled Documents are listed on Quality Intranet by location?			✓	List Documents and their Location:

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PWC: _____ W/O#: _____ Date: _____ Part #(s): _____ Auditor: _____				
Gauge Range: _____ Actual Gauge: _____ Width Range: _____ Width Actual: _____				
Length Range: _____ Length Actual: _____ Other: _____ Other Actual: _____				
Other: _____ Other Actual: _____ Other: _____ Other Actual: _____				
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?				
Correct raw material type and size?				Tag(s) to use: _____ Tag(s) used: _____
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)
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AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 64087 Coil Number: 505285

Customer Number: CUSTOM Coil Information: R24556 Supplier: METALONEWN

Product: Steel Jan-12-17 16:07 to 18:01 (clock 114.1 min/ run 63.1 min) Shift: 2

Average Thickness and Tolerance Data

Target	0.0270 in	Average^	0.0233 in	Average - Target	-0.0037 in (!3.63%)
				Standard Deviation^	0.0002 in (0.56%)
Length	5289 ft	Above High Limit	0.0310 in	0 ft (0.0%)	
Width	48.000 in	In Tolerance		5244 ft (99.2%)	
Weight	20176 lbs	Below Low Limit	0.0230 in	50 ft (0.8%)	
Max Thickness	0.0237 in at	29 ft	Min Thickness	0.0227 in at	3320 ft

Statistical Process Control Data

Upper Control Limit	0.0238 in	Upper Tolerance Limit	0.0310 in
X Double Bar	0.0233 in	R Bar	0.0005 in
Lower Control Limit	0.0229 in	Lower Tolerance Limit	0.0230 in

CR 11.3% (Capability Ratio %, 100/CP)
CP 8.889 (Process Capability, HiLim-LoLim/6*Sigma)
CPK 0.711 (Capability vs Limits) TMW Ratio 0.986 (Low Limit/Avg)

Thickness Distribution Relative to the Target

+++	0.0%
+0.0050	0.0%
+0.0045	0.0%
+0.0040	0.0%
+0.0035	0.0%
+0.0030	0.0%
+0.0025	0.0%
+0.0020	0.0%
+0.0015	0.0%
+0.0010	0.0%
+0.0005	0.0%
+0.0000	0.0%
-0.0005	0.0%
-0.0010	0.0%
-0.0015	0.0%
-0.0020	0.0%
-0.0025	0.0%
-0.0030	0.0%
-0.0035	20.5% *****
-0.0040	78.7% *****>
-0.0045	0.8% --
-0.0050	0.0%
---	0.0%

0.0% is within ± 0.0010 in of the target 0.0% is within ± 0.0025 in of the target
100.0% is within ± 0.0050 in of the target 100.0% is within ± 0.0100 in of the target

Thickness vs Length (Coil Number 505285)

