

Process/Product Audit Checklist

Cust #: <u>1697</u> Customer: <u>GE MEBANE</u> GRP/Size/GRD/Width: <u>POS .1046 CBTPCE 48</u>				
PWC: <u>SRB</u> W/O#: <u>64204</u> Date: <u>1-17-17</u> Part #(s): <u>B8A3AP252</u> Auditor: <u>B. Clem</u>				
Gauge Range: <u>0950 - 1110</u>		Actual Gauge: <u>097</u>		Width Range: <u>48 - 48.1275</u> Width Actual: <u>48.123</u>
Length Range: <u>32 - 32.2500</u>		Length Actual: <u>32.145</u>		Other: <u>48 - 48.2500</u> Other Actual: <u>48.125</u>
Other: <u>96 - 96.1250</u>		Other Actual: <u>96.060</u>		Other: <u>W-B-F</u> Other Actual: <u>0</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>Leguon & Chris M.</u>
Correct raw material type and size?	✓			Tag(s) to use: <u>NB53357</u> Tag(s) used: <u>NB53357</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 4</u> <u>Jm-OP-001 4-21-15 0</u> <u>FOP081 2-16-01 1</u>
Hardcopy Controlled Documents are listed on Quality Intranet by location?	✓			List Documents and their Location: <u>FMA045 Quality Intranet</u>

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 64204 Coil Number: NB53357

Customer Number: GE MEBANE Coil Information: NUB1616150 Supplier: NUCOR BERKLEY

Product: Steel Jan-17-17 21:15 to 22:55 (clock 99.3 min/ run 35.5 min) Shift: 2

Average Thickness and Tolerance Data

Target	0.1030 in	Average^	0.0986 in	Average - Target	-0.0044 in (-4.30%)
				Standard Deviation^	0.0005 in (0.52%)
Length	3088 ft	Above High Limit	0.1110 in	0 ft (0.0%)	
Width	48.000 in	In Tolerance		3088 ft (100.0%)	
Weight	49795 lbs	Below Low Limit	0.0950 in	0 ft (0.0%)	
Max Thickness	0.1011 in at 3088 ft	Min Thickness	0.0950 in at 2694 ft		

Statistical Process Control Data

Upper Control Limit	0.1002 in	Upper Tolerance Limit	0.1110 in
X Double Bar	0.0986 in	R Bar	0.0016 in
Lower Control Limit	0.0970 in	Lower Tolerance Limit	0.0950 in
CR	20.3% (Capability Ratio %, 100/CP)		
CP	4.938 (Process Capability, HiLim-LoLim/6*Sigma)		
CPK	2.204 (Capability vs Limits)	TMW Ratio	0.964 (Low Limit/Avg)

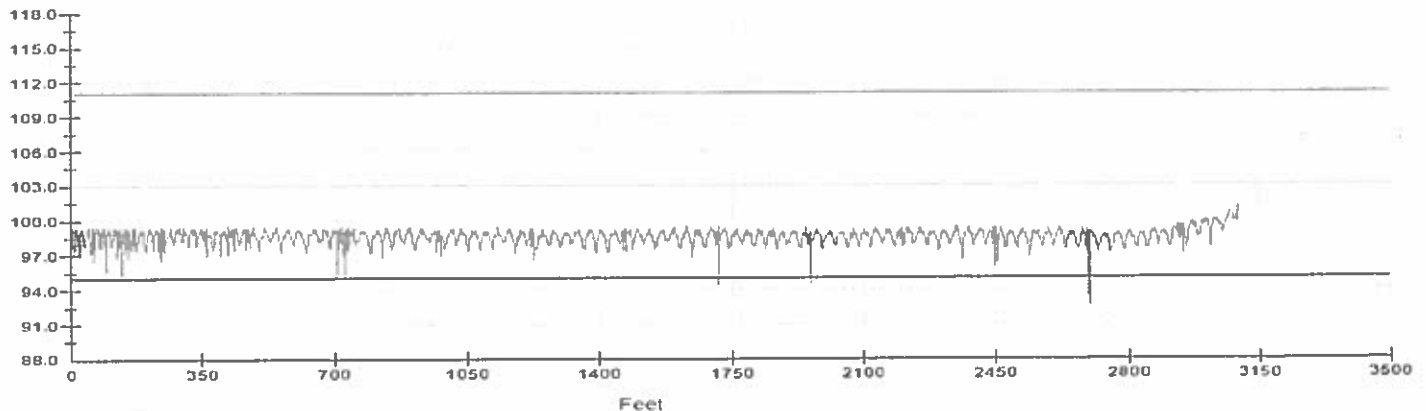
Thickness Distribution Relative to the Target

+++	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	0.0%
-0.0010	0.0%
-0.0020	0.0%
-0.0030	1.0% **
-0.0040	23.1% *****
-0.0050	61.5% *****>
-0.0060	14.0% *****
-0.0070	0.4% *
-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 %

0.0% is within ± 0.0020 in of the target 85.6% is within ± 0.0050 in of the target
100.0% is within ± 0.0100 in of the target 100.0% is within ± 0.0200 in of the target

Thickness vs Length (Coil Number NB53357)



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