

Process/Product Audit Checklist

Cust #: 3070 Customer: HILL PHOENIX GRP/Size/GRD/Width: GNS/24D/C40CDH
 PWC: LRB W/O#: 18644 Date: 01/19/21 Part #(s): PO82992A Auditor: N. RAGLAND
 Gauge Range: .026-.030 Actual Gauge: .027 Width Range: 48.00-48.1875 Width Actual: 48.06
 Length Range: 155.97-156.03 Length Actual: 156.0 Other: SQ .120 MAX Other Actual: .090, .120
 Other: FLAT .250 Other Actual: <.250 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: <u>NR12409</u> Tag(s) used: <u>NR12409</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?			✓	
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) TP 04 DUE 10/20 > WILL CALIBRATE ON 1/20/2021 MICOZ DUE 10/20 AGT DUE 4/21 ✓ COMPLETED - DOCUMENTS ATTACHED <u>NR</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>LYN-F-001 REV 1</u>
Hardcopy Controlled Documents are listed on Quality Intranet by location?			✓	List Documents and their Location:

AGT400 Coil Summary Report

Jemison Metals -- 72 Red Bud Multi-Blanking

Work Order: 18644 Coil Number: NB12409

Customer Name: HILLP Heat Number: 1014917 Vendor: NUCOR

Product: Galvannealed Jan-19-21 12:34 PM to 1:12 PM (clock 37.8 min/ run 37.8 min) Shift: 1

Average Thickness and Tolerance Data

Target 0.0280 in Average* 0.0274 in Average - Target -0.0006 in (-2.07%)
Standard Deviation* 0.0003 in (1.00%)

Length* 1640 ft Above High Limit 0.0300 in 0 ft (0.0%)
Width 48.000 in In Tolerance 1640 ft (100.0%)
Weight 7358 lbs Below Low Limit 0.0260 in 0 ft (0.0%)

Max Thickness 0.0281 in at 53 ft Min Thickness 0.0267 in at 357 ft
Head Scrap 0 ft Tail Scrap 0 ft

Statistical Process Control Data

Upper Control Limit 0.0283 in Upper Tolerance Limit 0.0300 in
X Double Bar 0.0274 in R Bar 0.0008 in
Lower Control Limit 0.0266 in Lower Tolerance Limit 0.0260 in

CR 42.0% (Capability Ratio %, 100/CP)

CP 2.381 (Process Capability, HiLim-LoLim/6*Sigma)

CPK 1.691 (Capability vs Limits) TMW Ratio 0.948 (Low Limit/Avg)

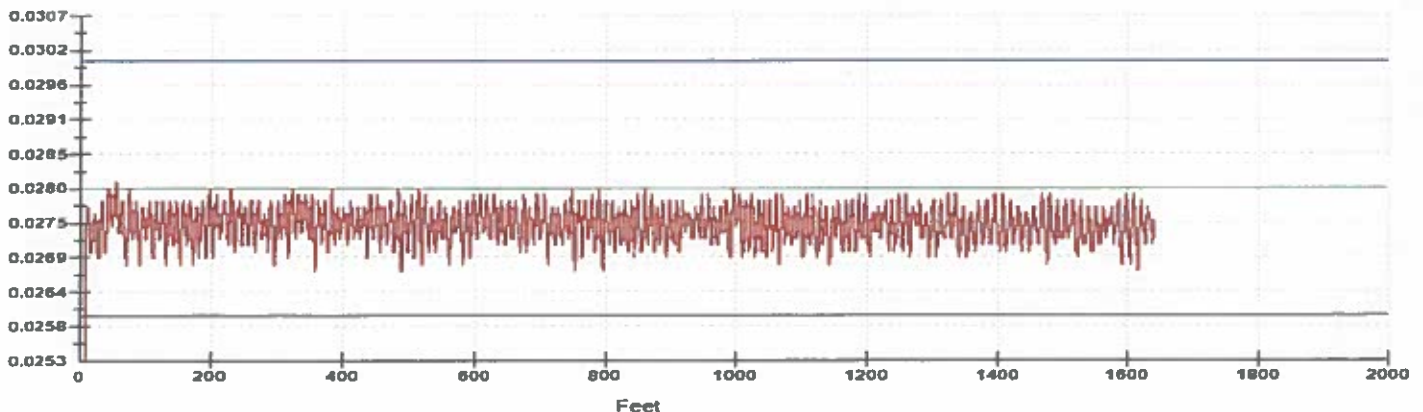
Thickness Distribution Relative to the Target

+++	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	0.8% **
-0.0005	47.6% *****>
-0.0010	46.5% *****>
-0.0015	5.1% *****
-0.0020	0.0%
-0.0025	0.0%
-0.0030	0.0%
-0.0035	0.0%
-0.0040	0.0%
-0.0045	0.0%
-0.0050	0.0%
---	0.0%

0 3 6 9 12 15 18 21 24 27 30 33 %

94.9% is within ± 0.0010 in of the target 100.0% 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 NB12409)





JEMISON
METALS

CALIBRATION/ VERIFICATION SHEET

INSTRUMENT

CALIBRATED/ VERIFIED: Tape 25'

*indicate appropriate action(s)

INSTRUMENT ID# 4

AS FOUND PHYSICAL Good
CONDITION:

ACTION TAKEN: Calibration

STANDARD
SERIAL #:

KNOWN VALUE:

AS FOUND READINGS:

VERIFICATION

LM005-001

6"

6"

6"

LM001

1"

1"

1"

TEMPERATURE: 60°

HUMIDITY: 8-15%

VERIFIED BY Patrick Macias

DATE: 1-20-21

ISSUED TO: LRT

DUE DATE 1-20-22

Allowable Deviation:

Calipers = $\pm .001"$

Micrometers = $\pm .001"$

Tape Measure = $\pm .03125"$

Extra Caliper Measurements where applicable

*Inside

**depth

***step



JEMISON METALS

CALIBRATION/ VERIFICATION SHEET

INSTRUMENT
CALIBRATED/ VERIFIED: 1" Micrometer
*indicate appropriate action(s)

INSTRUMENT ID# 02 MIC-02

AS FOUND PHYSICAL Good
CONDITION:

ACTION TAKEN: CALIBRATION

STANDARD SERIAL #:	KNOWN VALUE:	AS FOUND READINGS:	VERIFICATION
<u>LM 005</u>	<u>0.500"</u>	<u>0.500"</u>	<u>0.500"</u>
<u>LM 007</u>	<u>0.250"</u>	<u>0.250"</u>	<u>0.250"</u>
*			

TEMPERATURE: 60°

HUMIDITY: 0-15%

VERIFIED BY NATHAN RAGLAND

DATE: 01/20/2021

ISSUED TO: LRT

DUE DATE 01/20/2022

Allowable Deviation:
Calipers = $\pm .001"$
Micrometers = $\pm .001"$
Tape Measure = $\pm .03125"$

Extra Caliper Measurements where applicable
*Inside
**depth
***step