

Process/Product Audit Checklist

Cust #: <u>2671</u> Customer: <u>FHP</u>		GRP/Size/GRD/Width <u>GVS.03964B60CD 48</u>		
PWC: <u>SRO</u> W/O#: <u>72655</u> Date: <u>1-24-19</u> Part #(s): <u>2671/740</u> Auditor: <u>SM</u>				
Gauge Range: <u>035-043</u> Actual Gauge: <u>037</u>		Width Range: <u>48.0-48.75</u> Width Actual: <u>48.118</u>		
Length Range: <u>96.0-96.25</u> Length Actual: <u>96.125</u>		Other: <u>WZREL 12</u> Other Actual: <u>⊖</u>		
Other: <u>66R 129 MZX</u> Other Actual: <u>66</u>		Other: <u>NA</u> Other Actual: <u>NA</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?	X			<u>Chris M.</u>
Correct raw material type and size?	X			Tag(s) to use: <u>NP 6054</u> Tag(s) used: <u>NP 6054</u> <u>D.D. Not Run NP 6055</u> <u>Shift ends</u>
Setup performed according to W/O?	X			
Product is acceptable according to customer-specific requirements? [Fab: Is the Part Print Present & the correct Revision? Are required measurements documented?]	X			[Fab: Print Rev: _____, W/O Rev: _____, Part Spec Rev: _____] (Leave blank if non-Fab audit)
Packaging is acceptable according to customer-specific requirements?	X			
Visual Inspection performed and product meets requirements?	X			<u>Rust on 1st skid</u>
Out of spec noted, with actions taken?	X			<u>Placed on Hold</u>
Non-conforming material put into reject warehouse and physically put into non-conforming area?	X			<u>skid # 531166</u>
Required gages available & functional?	X			
All Gages Calibrated (List in Comments)				Gages Observed (list last calibration and when due) <u>83 25" +26" 3-30-18 3-30-19</u> <u>M-50 1" mic 8-31-18 8-31-19</u> <u>51-5 Stop Gauge 7-5-18 7-5-19</u> <u>632 4" mic +26" 4-20-18 4-20-19</u>
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	X			
Required PPE being worn?	X			
Forms are the latest revision per Quality Intranet?	X			List Forms (Observed Rev vs Intranet Rev) <u>FOP 081 - 2-16-01 1</u>
Hardcopy Controlled Documents are listed on Quality Intranet by location?	X			List Documents and their Location: <u>SM - SKA - 001</u> <u>JM - OP - 001</u>

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 72655 Coil Number: NB60541

Customer Number: FHP Coil Information: NUB1816751 Supplier: NUCOR BERKLEY

Product: Steel Jan-24-19 22:36 to 23:21 (clock 45.9 min/ run 22.6 min) Shift: 2

Average Thickness and Tolerance Data

Target:	36.0 mil	Average:	36.9 mil	Average - Target	-2.0300 mil (-)
				Standard Deviation:	0.2700 mil ()
Length:	3398 ft	Above High Limit:	43.0 mil		0 ft ()
Width:	60.500 in	In Tolerance			3398 ft (100%)
Weight:	5866 lbs	Below Low Limit:	35.0 mil		0 ft ()
Max Thickness	37.6 mil at 2974 ft	Min Thickness	36.0 mil at 674 ft		

Statistical Process Control Data

Upper Control Limit	37.7 mil	Upper Tolerance Limit	43.0 mil
Target	36.9 mil	R Bar	0.8 mil
Lower Control Limit	36.1 mil	Lower Tolerance Limit	35.0 mil
Cp = 20.3% (Capability Ratio % 100/Cp)			
Cpk = 6.93% (Process Capability, HiLim-LowLim/6*Sigma)			
Cpk = 2.370 (Capability vs Limits) TMW Ratio 0.948 (Low Limit/Avg)			

Thickness Distribution Relative to the Target



1.0% is within ± 1.0000 mil of the target 93.1% is within ± 2.5000 mil of the target
 100.0% is within ± 5.0000 mil of the target 100.0% is within ± 10.0000 mil of the target

Thickness vs Length (Coil Number NB60541)

