

Process/Product Audit Checklist

Cust #: <u>5257</u> Customer: <u>Falls Stamping</u> GRP/Size/GRD/Width: <u>POC/1.76/CSB/9.76</u>				
PWC: <u>C10</u> W/O#: <u>67485</u> Date: <u>1-26-18</u> Part #(s): <u>W. 1.76 x 9.76</u> Auditor: <u>Patrice Macias</u>				
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?	X			
Correct raw material type and size?	X			Tag(s) to use: <u>D012819</u> Tag(s) used: <u>D012819</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			<u>WIP to ship to what field</u>
Visual Inspection performed and product meets requirements?	X			
Out of spec noted, with actions taken?			X	
Non-conforming material put into reject warehouse and physically put into non-conforming area?			X	
Required gages available & functional?	X			
All Gages Calibrated (List in Comments)	X			Gages Observed (list last calibration and when due) <u>120 Caliper Dec 17 - Mar 18</u> <u>RBI 21 micrometer Jan 18 - Feb 18</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>JDM 3 - Rev 4</u> <u>JDM 4 Rev 7</u>
Hardcopy Controlled Documents are listed on Quality Intranet by location?	X			List Documents and their Location: <u>Quality Intranet</u> <u>C10 - SL-001 Loop Co Procedure</u>

AGT400 Coil Summary Report

Jemison Metals -- 60 Inch Loopco Slitter

Work Order: CLV 67485 Coil Number: DU12819

Customer Name: FALLS Heat Number: NLMNLK1763784

Product: H.R.P.O. Steel Jan-26-18 8:31 AM to 9:05 AM (clock 34.1 min/ run 9.2 min) Shift: 1

Average Thickness and Tolerance Data

Target	0.1820 in	Average^	0.1823 in	Average - Target	0.0003 in (0.16%)
				Standard Deviation^	0.0011 in (0.60%)
Length	1453 ft	Above High Limit	0.1880 in		0 ft (0.0%)
Width	49.750 in	In Tolerance			1453 ft (100.0%)
Weight	44898 lbs	Below Low Limit	0.1760 in		0 ft (0.0%)
Max Thickness	0.1861 in at	1453 ft	Min Thickness	0.1783 in at	88 ft
Head Scrap	0 ft		Tail Scrap	0 ft	

Statistical Process Control Data

Upper Control Limit	0.1856 in	Upper Tolerance Limit	0.1880 in
X Double Bar	0.1823 in	R Bar	0.0033 in
Lower Control Limit	0.1790 in	Lower Tolerance Limit	0.1760 in

CR 54.5% (Capability Ratio %, 100/CP)
 CP 1.835 (Process Capability, HiLim-LoLim/6*Sigma)
 CPK 1.746 (Capability vs Limits) TMW Ratio 0.966(Low Limit/Avg)

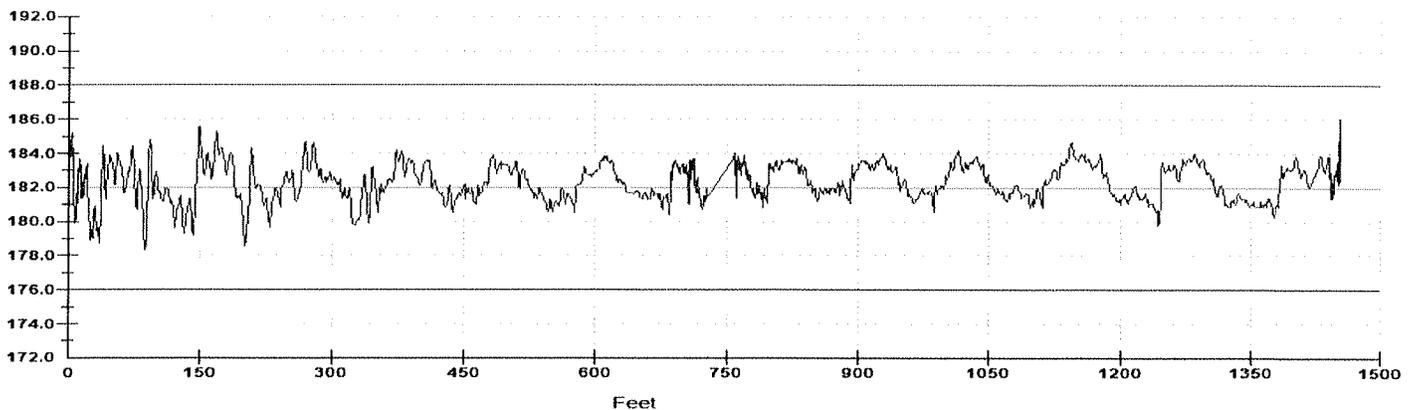
Thickness Distribution Relative to the Target

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+++ 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 0.3% *
+0.0020 3.5% *****
+0.0010 28.7% *****
+0.0000 25.1% *****
-0.0010 33.1% *****>
-0.0020 7.1% *****
-0.0030 1.7% ***
-0.0040 0.5% *
-0.0050 0.0%
-0.0060 0.0%
-0.0070 0.0%
-0.0080 0.0%
-0.0090 0.0%
-0.0100 0.0%
--- 0.0%
    
```

97.5% is within ± 0.0020 in of the target 100.0% 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 DU12819)



Slitting Order

Date: 1/12/18	Customer: Falls
Work Order #: 021167485	Date Run: Jan. 26. 2018

Incoming Inspection Checklist

Tag #	Gauge & Width	Type	Tag Wgt.	RB	Olsen	Actual Wgt.	Width	Mic
D412819	.174 x 49.400	Doc	46.200	—	—	46.200	50 ³ / ₁₆	.182
								.184

Cutting Instructions: 5 cuts - 9.780

Slit Tolerance: ±.005	Max O.D: Spht we half	Max Skid Wgt: 6.971	I.D: 20"
Gauge Range: .174 / .188	Salesman:		

Special Instructions:

1 Cuts with some defect but okay to ship

N/A

	Cut Size
	Cut Weight
	Defect
	Approved By

2 Cuts Rejected

N/A

	Cut Size
	Cut Weight
	Tag No. or No.'s
	Reason for Reject

3 Ok to move material for shipment or to Stock

JA

	Name
1-26-18	Date

