

## Process/Product Audit Checklist

Cust #: <u>5257</u> Customer: <u>Falls Stamping</u> GRP/Size/GRD/Width: <u>100/1.76/CSB/9.76</u>				
PWC: <u>C10</u> W/O#: <u>67485</u> Date: <u>1-26-18</u> Part #(s): <u>W. 176 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>DU12819</u> Tag(s) used: <u>DU12819</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 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 LoopCo 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)

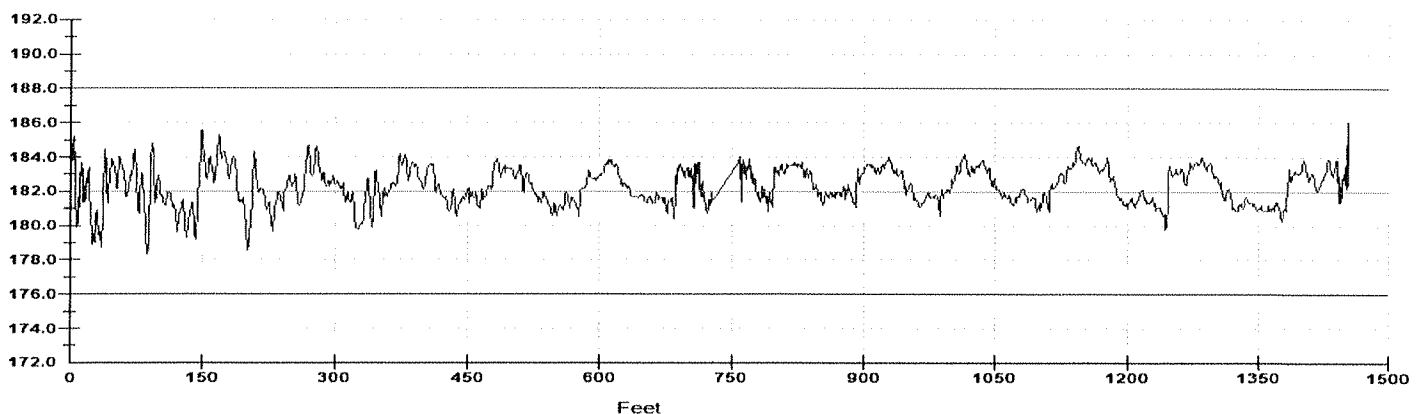
### Thickness Distribution Relative to the Target

+++ 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%

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

97.5% is within  $\pm 0.0020$  in of the target 100.0% is within  $\pm 0.0050$  in of the target  
100.0% is within  $\pm 0.0100$  in of the target 100.0% is within  $\pm 0.0200$  in of the target

Thickness vs Length (Coil Number DU12819)



# Slitting Order

Date: 1/12/18	Customer: Falls
Work Order #: CLV 67485	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 <sup>3</sup> / <sub>16</sub>	.182
								.184

Cutting Instructions: 5 cuts - 9.780

Slit Tolerance: ± .005	Max O.D: Split re 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

# Slit Size Inspection

Date: Jan. 26, 2018

Work Order: AW67485

Size of Cuts	Beginning Width	Mics	(Paxson Only) Middle Mics	End Width	Mics
9.780	9.785		Sph @ 14 5/8	9.785	
	9.784	.182		9.784	.1815
	9.784			9.784	
	9.785	.184		9.785	.183
	9.785			9.785	

Non-Conformance

Surface Defects  
Burs Shape Defects

Yes\*/No\*\* (If Yes, Description)

No  
No  
No

Initials

\*Need Resolution, OK'd or Segragated

\*\*No Non-Conformance Present

Operator	Helper
J.S.	A.M. Town