

Process/Product Audit Checklist

Cust #: 2886 Customer: AMC Manf. GRP/Size/GRD/Width: CRS-0480DSENT120

PWC: SRB W/O#: 72494 Date: 1-3-19 Part #(s): 9001005794 Auditor: B. Clem

Gauge Range: -0.44 - .052 Actual Gauge: .045 Width Range: 19.97 - 20.030 Width Actual: 20.004

Length Range: 16.97 - 17.030 Length Actual: 17.008 Other: 4-B-F 0-.12 Other Actual: .030

Other: SD 0-.12 Other Actual: .007 Other: 147 pcs/Tag Other Actual: 147 pcs/Tag

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?		✓		No Flatness or Square check noted on FOP081 for 2nd and last check Chris M.
Correct raw material type and size?	✓			Tag(s) to use: <u>AR60489</u> Tag(s) used: <u>AR60489</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) 9-3 25' Tape 3-30-18 3-30-19 M-50 1" mic 8-31-18 8-31-19 ST-5 Step Gauge 7-5-18 7-5-19 63294 Meas. Table 4-20-18 4-20-19
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	✓			
Required PPE being worn?		✓		No Safety Glasses-Chris M., Chris D. Marion
Forms are the latest revision per Quality Intranet?	✓			List Forms (Observed Rev vs Intranet Rev) FOP081 2-16-01 1
Hardcopy Controlled Documents are listed on Quality Intranet by location?	✓			List Documents and their Location: SMT-SRB-001 SM-CP-001



Material Inspection Report

LOCATION

Sumter

DATE

1/3/2019

CUSTOMER

AMC

JOB # SMT

72494

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	Order Dim		Tolerances		Tolerances	Low Limit	High Limit
Gauge	0.044	-	0.000	+	0.008	0.044	0.052
Width	20.000	-	0.030	+	0.030	19.970	20.030
Length	17.000	-	0.030	+	0.030	16.970	17.030

	Set up Target	Side Type	Skid Type Error	Skid Code
Gauge	0.048		SOP'S	0 1 1
Width	20.000			
Length	17.000			

Finished Goods Tag	61312	61313	61314		
Master Coil Number	AR60489				
Heat					
Enhanced Weight					
Gross Weight	690	690	690		
Tare	35	35	35		
Net Weight	655	655	655	0	0
Bundle Status					
Good Pcs.	147	147	147		
Scraped Pcs.					
Rockwell					
Gauge Head	E 0.045	0.045	0.045		
	C 0.046	0.046	0.046		
	E 0.045	0.045	0.045		
Body	E				
	C				
	E				
Tail	E				
	C				
	E				
Surface	0				
Width Head	20.004	20.005	20.010		
Body	20.004	20.005	20.010		
Tail	20.004	20.000	20.010		
Shape	0.000				
Residual Check					
Length Head	17.008	17.009	16.997		
Body	17.008	17.009	16.997		
Tail	17.008	17.009	16.997		
Squareness	00				
Camber					
Operator	CM	CM			
Setup Approval					
Run Time	S	F	Down Time	S	F
Total Run Time	0:00	Cost	\$0.00	Cst/Hour	\$400.00
Comments					

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 72494 Coil Number: AR60489

Customer Number: AMC Coil Information: S67552 Supplier: ARCELOR

Product: Steel Jan-3-19 13:05 to 16:44 (clock 218.4 min/ run 31.9 min) Shift: 2

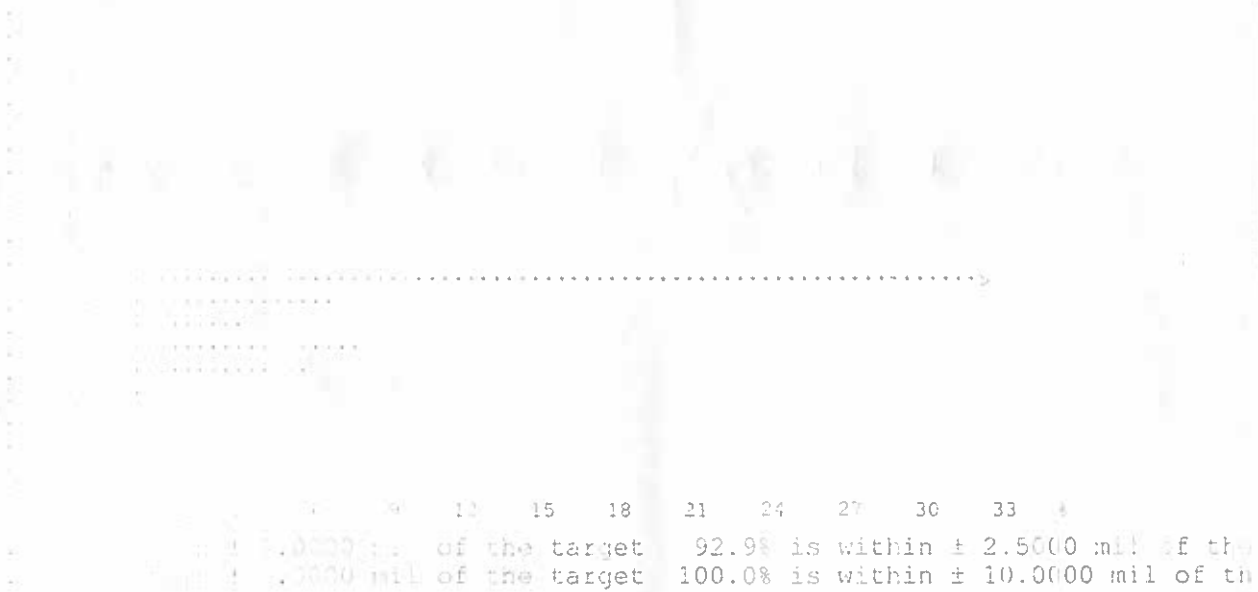
Average Thickness and Tolerance Data

Average	46.8 mil	Average - Target	-1.2000 mil (-2.00%)
Standard Deviation	0.6400 mil (1.36%)		
Above High Limit	52.0 mil	0 ft (0.00%)	
In Tolerance	1325 ft (100.00%)		
Below Low Limit	44.0 mil	0 ft (0.00%)	
Min Thickness	44.8 mil at 1279 ft		

Statistical Process Control Data

Upper Tolerance Limit	52.0 mil
R Bar	1.9 mil
Lower Tolerance Limit	44.0 mil
Capability Ratio C_p , 100/CP)	
(Process Capability, HiLim-LowLim/6*Sigma)	
Capability vs Limits)	TMW Ratio 0.940 (Low Limit/Avg)

Thickness Distribution Relative to the Target



Thickness Vs Length (Coil Number AR60489)

