

Process/Product Audit Checklist

Cust #: <u>2678</u> Customer: <u>Advanced</u> GRP/Size/GRD/Width: <u>CRS/.0747/CSB/48</u>				
PWC: <u>SRB</u> W/O#: <u>76645</u> Date: <u>1/6/2020</u> Part #(s): <u>300007548067</u> Auditor: <u>B. CLEM</u>				
Gauge Range: <u>.0697-.0747</u> Actual Gauge: <u>.070</u> Width Range: <u>48-48.1875</u> Width Actual: <u>48.046</u>				
Length Range: <u>67-67.2500</u> Length Actual: <u>67.125</u> LTH Other: <u>120-120.2500</u> Other Actual: <u>120.125</u>				
FLATN Other: <u>0-.12</u> Other Actual: <u>LESS .12</u> SQ Other: <u>0-.25</u> Other Actual: <u>.050</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			Chris D.
Correct raw material type and size?	X			Tag(s) to use: <u>NB64283</u> Tag(s) used: <u>NB64283</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			
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) 8-3 25' Tape 7/30/2019 7/30/2020 M50 1" Mic 8/13/2019 8/13/2020 ST-5 Step Gauge 7/1/2019 7/1/2020 63294 Measuring Table 4/24/2019 4/24/2020
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	X			
Required PPE being worn?		X		Chris M. - No Safety Glasses
Forms are the latest revision per Quality Intranet?	X			List Forms (Observed Rev vs Intranet Rev) FOP081 2/16/01 1
Hardcopy Controlled Documents are listed on Quality Intranet by location?	X			List Documents and their Location: SMT-SRB-001 JM-OP-001

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 76645 Coil Number: NB64283

Customer Number: ADVANCED Coil Information: NUB2917911 Supplier: NUCOR BERKLEY

Product: Steel Jan-6-20 14:42 to 15:37 (clock 55.7 min/ run 32.6 min) Shift: 2

Average Thickness and Tolerance Data

Target	72.2 mil	Average^	70.7 mil	Average - Target	-1.5400 mil (-2.13%)
				Standard Deviation^	0.4000 mil (0.55%)
Length	2234 ft	Above High Limit	74.7 mil	0 ft (0.0%)	
Width	48.000 in	In Tolerance		2189 ft (98.0%)	
Weight	25825 lbs	Below Low Limit	69.7 mil	47 ft (2.0%)	
Max Thickness	71.6 mil at 2221 ft	Min Thickness	68.6 mil at 1842 ft		

Statistical Process Control Data

Upper Control Limit	71.9 mil	Upper Tolerance Limit	74.7 mil
X Double Bar	70.7 mil	R Bar	1.2 mil
Lower Control Limit	69.5 mil	Lower Tolerance Limit	69.7 mil

CR 48.0% (Capability Ratio %, 100/CP)

CP 2.083 (Process Capability, HiLim-LoLim/6*Sigma)

CPK 0.800 (Capability vs Limits) TMW Ratio 0.986(Low Limit/Avg)

Thickness Distribution Relative to the Target

+++	0.0%
+10.0	0.0%
+ 9.0	0.0%
+ 8.0	0.0%
+ 7.0	0.0%
+ 6.0	0.0%
+ 5.0	0.0%
+ 4.0	0.0%
+ 3.0	0.0%
+ 2.0	0.0%
+ 1.0	0.0%
+ 0.0	0.0%
--1.0	8.2% *****
--2.0	81.5% *****>
--3.0	9.9% -----
--4.0	0.4% -
--5.0	0.0%
--6.0	0.0%
--7.0	0.0%
--8.0	0.0%
--9.0	0.0%
-10.0	0.0%
---	0.0%

89.7% is within ± 2.0000 mil of the target 100.0% is within ± 5.0000 mil of the target
 100.0% is within ± 10.0000 mil of the target 100.0% is within ± 20.0000 mil of the target

Thickness vs Length (Coil Number NB64283)

