Process/Product Audit Checklist

Cust #: 14325 Customer: LJS GRP/Size/GRD/Width: LRS-16-CSB- 60				
PWC: SBD W/O#: 72570 Date: 1-7-19 Part #(s): 2871/16x60x120 Auditor: DM				
Gauge Range: .0548-.0638 Actual Gauge: .056 Width Range: 60.0-61.00 Width Actual: 60.15				
Length Range: 119.875-120.125 Length Actual: 120.00 Other: 5000 MH Other Actual: 2270				
Other: 18 pc skid Other Actual: 18 pc. Other: NA Other Actual: NA				
Item	**YES**	**NO**	**N/A**	**Comments/Action Taken (Required for NO)**
Process Inspection Sheets filled out according to frequency and sampling required?	X			Chris M
Correct raw material type and size?	X			Tag(s) to use: 529883 Tag(s) used: 529883
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			S.3 25' tape 3-30-18 3-30-19 Gages Observed (list last calibration and when due) M.50 1" mic 8-31-18 8-31-19 ST.5 Step Gauge 7-5-18 7-5-19 632941 Meas. Table 4-20-18 4-20-19
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) Fop081 2-16-01 1
Hardcopy Controlled Documents are listed on Quality Intranet by location?	X			List Documents and their Location: SMT'SRB.001 TM 08-001

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 72530 Coil Number: 529883

Customer Number: LJS Coil Information: 2816057 Supplier: NUCORBERKELY

Product: Steel Jan-7-19 22:55 to 23:08 (clock 13.4 min/ run 4.7 min) Shift: 2

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Average Thickness and Tolerance Data
Target      59.8 mil     Average^  56.0 mil      Average - Target     -3.7600 mil (-6
                                                 Standard Deviation^   0.2500 mil ( 0

Length        210 ft                Above High Limit     63.8 mil          0 ft (  0
Width       60.010 in               In Tolerance                         183 ft ( 87
Weight        2412 lbs              Below Low Limit      55.8 mil         27 ft ( 12

Max Thickness   56.7 mil at       2 ft        Min Thickness    55.4 mil at     119

Statistical Process Control Data
Upper Control Limit        56.8 mil    Upper Tolerance Limit          63.8 mil
X Double Bar               56.0 mil    R Bar                           0.8 mil
Lower Control Limit        55.3 mil    Lower Tolerance Limit          55.8 mil

CR     18.6% (Capability Ratio %, 100/CP)
CP     5.333  (Process Capability, HiLim-LoLim/6*Sigma)
CPK    0.320  (Capability vs Limits)          TMW Ratio      0.996(Low Limit/Avg)
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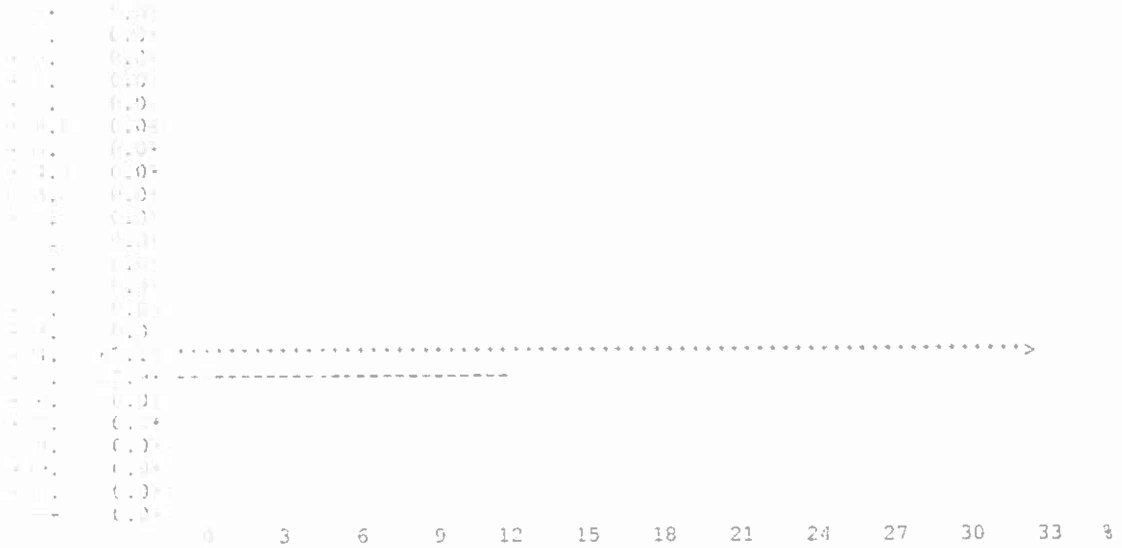
Thickness Distribution Relative to the Target

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... is within ± 2.0000 mil of the target  100.0% is within ± 5.0000 mil of the target
... is within ± 10.0000 mil of the target 100.0% is within ± 20.0000 mil of the target
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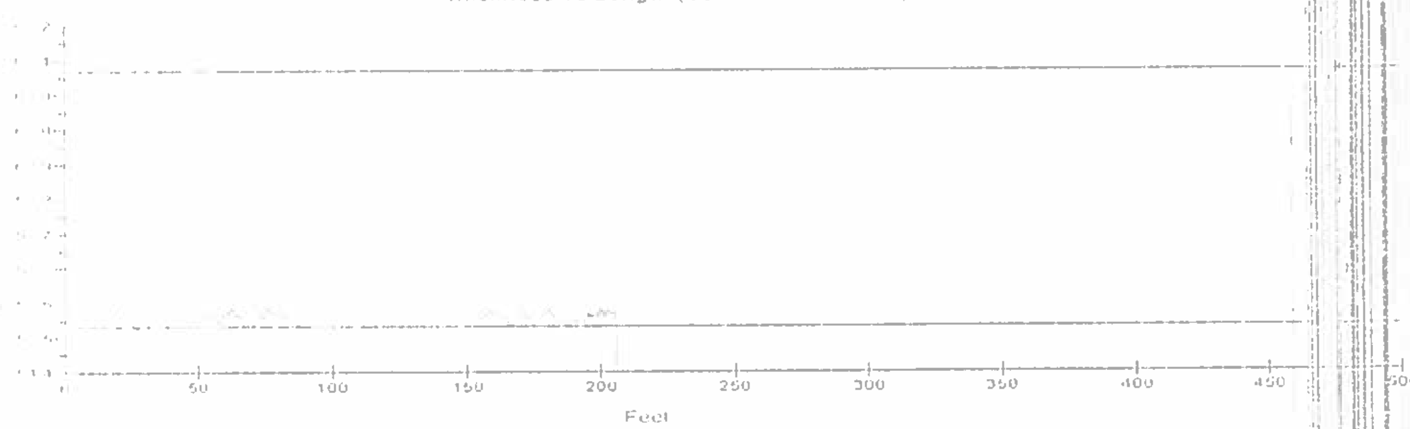
Thickness vs Length (Coil Number 529883)



Gauge readings provided by Advanced Gauging Technologies, L.L.C. Plain City, OH 43064 USA Tel (614) 873-669