

## Process/Product Audit Checklist

Cust #: <u>3591</u> Customer: <u>HUNTER ENGINEER</u> GRP/Size/GRD/Width: <u>POS/0.239/HS50/60</u>				
PWC: <u>BB1</u> W/O#: <u>72514</u> Date: <u>1/16/2026</u> Part #(s): <u>546572</u> Auditor: <u>B. CLEM</u>				
Gauge Range: <u>0.239-0.261</u> Actual Gauge: <u>0.245</u> Width Range: <u>60-60.9999</u> Width Actual: <u>60.5</u>				
Length Range: <u>127-127.5</u> Length Actual: <u>127.625</u> W-B-F Other: <u>0-0.25</u> Other Actual: <u>LESS 0.125</u>				
SQ Other: <u>0-0.37</u> Other Actual: <u>0.125</u> PCS/SKID Other: <u>15 PCS</u> Other Actual: <u>15 PCS</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			NATE
Correct raw material type and size?	X			Tag(s) to use: <u>51339</u> Tag(s) used: <u>51339</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?				
Visual Inspection performed and product meets requirements?	X			REJECTED 3 SKIDS (51339A, B and G) for pits
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) 017 MIC 5/13/2025 5/13/2026 ST 10 STEP GAGE 9/30/2025 9/30/2026 T242 25' TAPE 12/18/2025 12/18/2026
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)  DEC-CTL-001A 4/1/2024 4 DEC-CTL-001B 6/23/2022 2
Hardcopy Controlled Documents are listed on Quality Intranet by location?	X			List Documents and their Location:  DEC-BB1-CTL 6/26/2017 4

**PRODUCTION REPORT**
*Hunter*

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JOB WORK ORDER NO.	DATE	MACHINE	SHIFT	MASTER COIL NO.	Yield Strength
72514	1/16/15	BBI	1st	51339	
OPERATOR	RUN HOURS	Burr Msmt(s)	Head Scrap	Tail Scrap	
<i>WTK</i>	9:00A-10:15		22	9	

GA MIN *.239*    MAX WAVE *.250*    MAX SQUARE *.375*  
 GA MAX *.250*    MAX BOW *.250*  
*250X100X127.5*

Minimum Inspection Frequency:  
 (Unless otherwise specified on the Work Order/Part Spec)  
 CHECK PIECE ONCE LINE RUN IS ESTABLISHED + PIECE AT MIDPOINT  
 OF RUN + LAST PIECE OF RUN

FINISHED GOODS TAG NO.	PCS Required	PCS Actual	Width Actual	Length Entered	Length Actual	Gauge Actual	Wave/Bow Actual	Square Actual	Weight	Comments
51339-A	15	15	60.5	128.125	127.625	244	OK	125	8024	✓ Down pits Reject
B	15	15					OK			Reject pits
C	15	15					OK			
D	15	15	60.5		127.75	243	OK			
E	15	15					OK			
F	10	4					OK	187	2440	
G		3	60.625		127.75	245	OK	312	1605	Reject pits

Warehouse (DCT) Decatur  
 Whs Zone  
 PWC (BB1) Butech Stretch  
 Process (CTL) Cut to Length

Operator

**Job Work Order**

Job 72514 Date 1/15 06:45 PM



Gauge 0.239" - 0.261"

(dimensions in inches, if not specified)

JOB RESERVATIONS

Dimension Pcs LBS PIW ID OD CLgth Tag/Lot Ven Tag Heat Zn Loc Date Planned  
 HRPO Coil, HSS0 Mod Nb, - 1 45,304 755 895' 51339 2104621980 ✓AMN/2521712 - F24  
 0.239M x 60"

Consumption 1 Coils Theo Scrap -3.75% (-1,698.45 LBS)

CUTTING INSTRUCTIONS

Width Cons LBS PIW Produced Sheets (Pcs-Length)  
 60" 45,304 755 87-127"

PLANNED PRODUCTION

Dimension HRP0 Sheet, HSS0 Mod Nb, - Part No 546572 Customer/Next Prs Due  
 60" x 127" 0.25" -N 87 47,002.45 SO-48949-1-1 HUNTER ENGINEER(3591) 1/16  
 Carbon Scrap, -, -, - 369.66 Scrap

Gauge	Width	Length	Diag	Flms
SO-48949-1-1	0.25 [0.239 - 0.261"]	60 [60 - 60.9999"]	127 [127 - 127.5"]	0.37"
SO-48949-1-1	Cond Incl Mill Edge			0.25"

Aim for 127.5 Long, -0" +0.5" Laser application, flatness & residual stress critical "Stretch Length 1.7" -2.3" to ensure stress equalization"\*\*\*MEASURE SQUARENESS ON FIRST & LAST BUNDLE AND EVERY OTHER BUNDLE\*\*\* Burr Critical, 10% of thickness max, Measure each bundle  
 "Cut 24-36" sample at start of first bundle, end of first bundle and end of each bundle thereafter. Inspect and measure sample on the flatness table, then flip and repeat. Adjust leveler as required based on flatness observations"  
 Flat: 0.25  
 Wave: 0.25  
 Bow: 0.25  
 Square: 0.37  
 Camber: 0

SO-48949-1-1 Customer HUNTER ENGINEER(3591) Dimension 60" x 127" PCS 87 47,002.45 LBS Pc/Pkg 1 LBS Hgt # Skid/Pkg 3.5" 87 R5 - Sheet-Band to  
 PACKAGING



Warehouse	(DCT) Decatur	Operator	<b>Job Work Order</b>	
W/hs Zone			Job	72514
PWC	(BB1) Butech Stretch		Date	1/15 06:45 PM
Process	(CTL) Cut to Length			

**PACKAGING**

Customer Dimension PCS LBS Pc/Pkg LBS Hgt # Skid/Pkg  
 4"x4" Run. / RH -  
 Paper Top/Run.  
 w/Bands-EP

2 4x4 grooved runners banded to steel, paper protect on runners Paper Top & 2 Width Bands Banded to Steel Only 1 foot from ends Use edge protectors

**ORDER INFORMATION**

SO-48949 HUNTER ENGINEER(3591)/0 Denise Clayton Customer PO 604454 Sls Cat Sale  
 Due Item Product/Part/End User Label1 Process Route PCS SFT LBS +/- Shp % Cert  
 1/16 1.2390 Min X 60.0000" X 127.0000" {CTL} 87 4,603.75 45,000 - +20-10 CAA  
 A1018,HRP&O SHEET HSLAS-F GR 50 517.24/Pc

**DESTINATION**

SO-48949 Name HUNTER ENGINEERING Route/Color (RT1) Default Route Transp Zn A Divy Mthd CC Truck Carrier BEST WAY