

Process/Product Audit Checklist

Cust #: <u>2996</u> Customer: <u>BUSH HOG</u> GRP/Size/GRD/Width: <u>HRS/7/CSB 73X152</u>				
PWC: <u>GL5</u> W/O#: <u>74774</u> Date <u>1/30/2026</u> Part #(s): <u>50083903</u> Auditor: <u>PHILLIP E. MATHI^S</u>				
Gauge Range: <u>1713-1873</u> Actual Gauge: <u>172</u> Width Range: <u>37.37/37.39</u> Width Actual: <u>37.37</u>				
Length Range: <u>18.05/18.07</u> Length Actual: <u>18.06</u> 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?		✓		Fabrication production report not filled out correctly. No Date; shift; Operator Name. Failed to record Gauge min. fgs tag number; part number; pcs req/pcs actual. Meet with Operator and Team lead to review failures and requirements
Correct raw material type and size?	✓			Tag(s) to use: <u>19580A/19580B</u> Tag(s) used: <u>19580A/19580B</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: <u>B.6</u>, W/O Rev: <u>B.6</u>, Part Spec Rev: <u>B.6</u>] (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?		✓		T501 FROM PACKAGING LINE FOUND AT GL8 [RETURNED] C025 PRESS BRAKE FOUND AT GL8 [RETURNED]
All Gages Calibrated (List in Comments)	✓			Gages Observed (list last calibration and when due) C012 9/17/2025 - 9/17/2026 M026 1/30/2026 - 1/30/2027 *CALIBRATED TODAY TM047M - 1/30/2026 - 1/30/2027 *ISSUED TODAY
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?		✓		FLOOR AREA - TAGS ON FLOOR AROUND PWC BROKEN SKID BLOCKING FIRE EXTINGUISHER SAFETY MADE TEAM LEAD COREY POWELL AWARE
Required PPE being worn?			✓	
Forms are the latest revision per Quality Intranet?	✓			List Forms (Observed Rev vs Intranet Rev) JDM-F-014 JDM-F-014
Hardcopy Controlled Documents are listed on Quality Intranet by location?		✓		List Documents and their Location: GAD-LA-001 REV 5 REPLACED WITH REV 6 PROMPTED AUDIT OF ALL PWCS-REPLACING REV 5 WITH REV 6

FABRICATION PRODUCTION REPORT

Laser / Plasma

JOB NO.	DATE	SHIFT	OPERATOR	MACHINE	2nd PIECE INSPECTION			
71774				1028	EPR			
MASTER WIDTH	MASTER LENGTH	GAUGE MIN	GAUGE MAX	SHEETS / JOB	PAINTS / SHEET	Feed Rate	Axis Speed	
73	x 152			70				
MASTER BUNDLE	MIC READING	FINISHED TAG NUMBER	PART NUMBER		PIECES REQUIRED	PIECES ACTUAL		
19380A B								

# of Parts Scrapped (Tally)	DOWNTIME TYPE	DOWNTIME ESTIMATED IN (MINUTES)	OPERATOR COMMENTS / REASON FOR DOWNTIME
Was shift lead notified of issues? YES <input type="checkbox"/> NO <input type="checkbox"/>	LUNCH		
Were issues resolved? YES <input type="checkbox"/> NO <input type="checkbox"/>	MAINTENANCE		
START TIME	STOP TIME	PROCESS - MATL. HANDLING & MACHINE SETUP	
		ORDER - ALL MACHINE ISSUES & ERRORS	
		ORDER - ALL MACHINE ISSUES & ERRORS	
		ORDER - ALL MACHINE ISSUES & ERRORS	

Warehouse (GAD) Gadsden	Operator		Job Work Order	
Whs Zone (GL5) Laser 5	Job 74774	Date 1/30 07:00 AM		
Process (AS-) As-Is				

Program: 41004
Office Use: T45337

PLANNED CONSUMPTION

Dimension	D	Pcs	LBS	SFT Tag/Lot	Ven Tag	Heat	Zn	Loc	Date Planned
HR Sheet, CSB, , -									
73" x 152" 0.1713-M		19	10,444	1,464 19580A	1301964400	✓AMN/2511052	-	RECEIVE	
73" x 152" 0.1713-M		1	549.68	77 19580B	1301964400	✓AMN/2511052	-	RECEIVE	

Theo Scrap 21.64% (2,332.82 LBS)

Dimension	Pcs	LBS	SFT
73" x 152" 0.1713" -M	20	10,781.02	1,541

PLANNED PRODUCTION

Dimension	Pcs	LBS	SFT Assign To	Customer/Next Prs	Due
Part No 50083903 41.24" x 44.69" Irregular	140	7,291.20	SO-47870-14-1	BUSH HOG INC(2996)	2/5
Part No 50084136 11.36" x 25.7" Irregular	100	1,157.00	SO-47870-66-1	BUSH HOG INC(2996)	2/5

Gauge	Width	Length	Diag	Fltns
SO-47870-14-1	0.1793 [0.1713 - 0.1873"]	[-0.03 +0.03"]		
SO-47870-66-1	0.1793 [0.1713 - 0.1873"]	[-0.03 +0.03"]		

SO-47870-14-1 Cond Incl Mill Edge

Flat: 0
Wave: 0
Bow: 0
Square: 0
Camber: 0

SO-47870-66-1 Cond Incl Mill Edge

Flat: 0



Job Work Order

Job 74774 Date 1/30 07:00 AM

Operator

Warehouse (GAD) Gadsden
Whs Zone (GL5) Laser 5
PWC (AS-) As-Is
Process

PLANNED PRODUCTION

Wave: 0
Bow: 0
Square: 0
Camber: 0

PACKAGING

Customer	Dimension	PCS	LBS Pc/Pkg	LBS	Hgt	# Skid/Pkg
SO-47870-14-1 BUSH HOG INC(2996)	41.24" x 44.69" Irregular	140	7,291.2	35 <= 1,307	4	F2 -FAB - Pallet -Sheet Lifter / FB - Shrink Wrap
SO-47870-66-1 BUSH HOG INC(2996)	11.36" x 25.7" Irregular	100	1,157	216 <= 2,500	1	F2 -FAB - Pallet -Sheet Lifter / FB - Shrink Wrap

JD0

ORDER INFORMATION

Customer PO 2491845 Sls Cat Sale

Process Route	PCS	SFT	LBS	+/- Shp %	Cert
{AS-}	140	995.74	7,291.2	+10-0	
{AS-}	100	158.01	1,157		
			11.57/Pc		

Due 2/5 14 HOT ROLL SHEET CS-TYPE B - REV B:V 6
0.1793 N x 41.24 x 44.69
1793 Nom X 41.2400" X 44.6900"
50083903

66 HR ASTM A1011 - CSB
0.1793 N x 11.36 x 25.7
50084136

DESTINATION

Name	Route/Color	Transp Zn	Divvy Mthd	Carrier
SO-47870 BUSH HOG INC	(RT1) Default Route	A	Customer Pickup	168



Layout Report

Task Name : T45337

Program Name :41004

Layout 1 of 5

Number of Sheets with Same Layout : 20

Sheet Parameters

Nesting Task Results

Material : MS
 Thickness : 0.179"
 Sheet Length : 152.000"
 Sheet Width : 73.000"
 Sheet Name :
 Bin Number :
 Heat Number :
 Location :
 Mill :
 Prime Code :
 Sheet X Used : 151.389
 Sheet Y Used : 72.264
 Plate Used : 98.90%
 Plate Recovered : 1.10%

Qty Required : 2220
 Qty Nested : 12
 Total Cutting Time : 00:11:32
 Total Net Weight : 421.795lb
 True Scrap : 24.41%
 Rectangular Scrap : -36.69%
 Total Cutting Length : 1752.842"
 Number of Pierces : 83

Part ID	Part Name	Qty Req	Qty Nested	Net Weight	Drawing Number	Revision Number	Work Order	Customer	Cutting Time
14	50083903 REV	130	7	52.01				BUSH HOG	00:08:49
16	50084136 Rev	140	5	11.55				BUSH HOG	00:02:40

74774

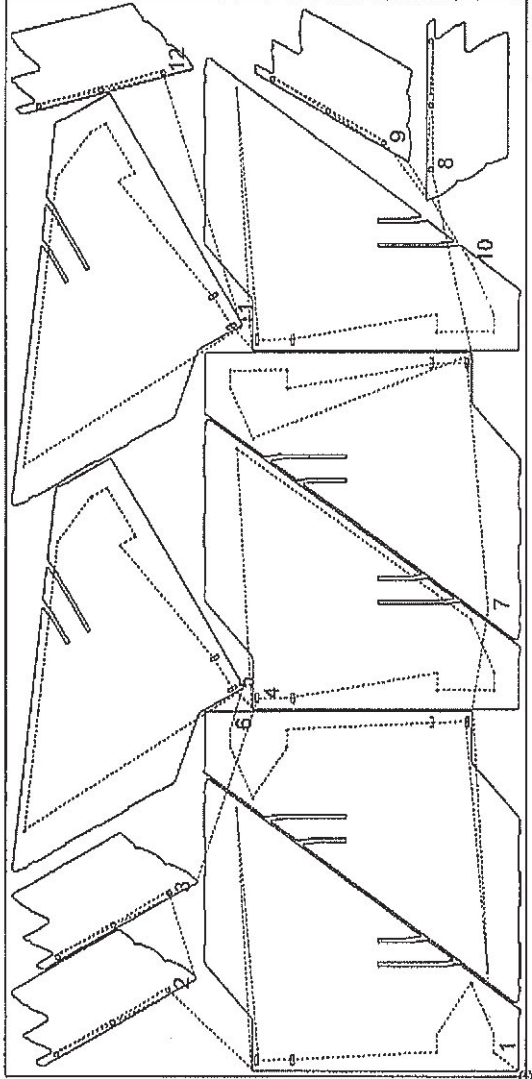


Layout Detail

Machine TRUMPF_TruLaser_5040_S

Task Name : T45337 Program Name : 41004

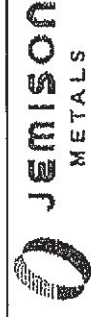
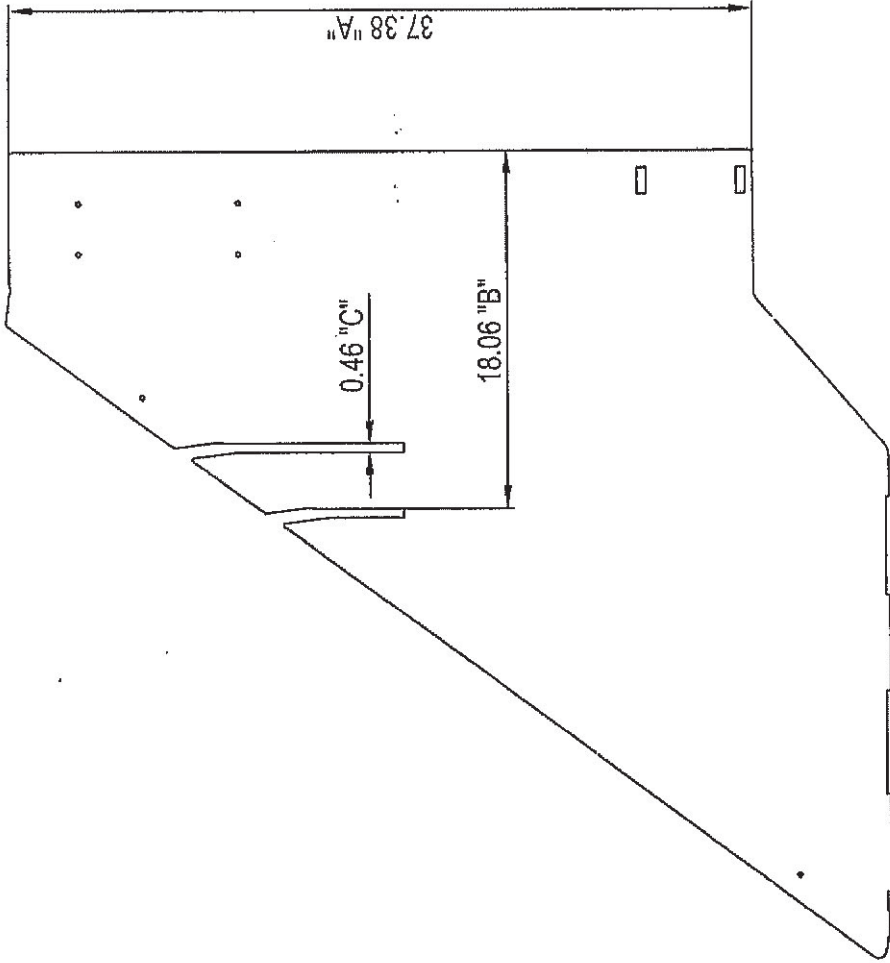
Number of Sheets with Same Layout	20	True Scrap	24.414	Qty Required	2220	Layout 1 of 5
Stack Quantity	1	Rect Scrap	-36.694	Qty Nested	12	



Material	MS	Sheet Length	152.000"	Sheet X Used	151.389"	Heat Number	Mill
Thickness	0.179	Sheet Width	73.000"	Sheet Y Used	72.264"	Sheet Location	Prime Code
Sheet Name		Cutting Time	00:11:32	Cutting Length	1752.842"	Bin Number	Parameters NITROGEN

Part ID	Part Name	Qty Req	Qty Nested	Net Weight	Drawing Number	Revision Number	Work Order Number	Customer	Cutting Time
14	50083903	130	140	52.01lb				BUSH HOG	00:08:49
16	50084136	140	156	11.55lb				BUSH HOG	00:02:40

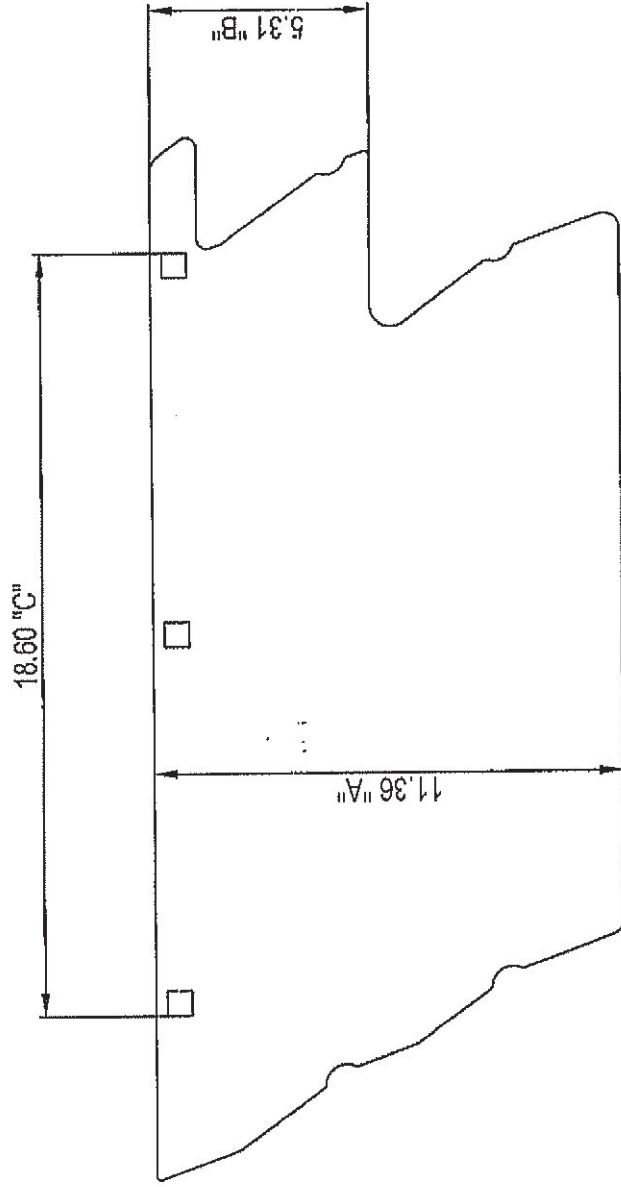
JEMISON REVISION		CUSTOMER REVISION	
REV.	DATE	REV.	DATE
		B.6	



ORDER: BUSH HOG, INC
 TITLE: REAR WIND DECK PLATE 4115-FLAT
 DRAWN: JGA HRS CSB
 BY CS: DATE: 2/23/23
 PART: ML50053905
 SHEET: 1 OF 1
 JEMISON REV: 0
 CUSTOMER REV: B.6

CUT/BURNT FIRST ARTICLES		TOLERANCES UNLESS OTHERWISE SPECIFIED	
NOMINAL	TOLERANCE	ACTUAL	LINEAR DECIMAL = +/- .010 ANGULAR = +/- .5°
MTL THICKNESS	.1783 -1713--1873	1711	
TOL "A"	37.38 37.57--37.59	37.395	
TOL "B"	18.06 18.06--18.07	18.065	
TOL "C"	.46 .45-.47	.455	
WEIGHT:			

JEMISON REVISION		CUSTOMER REVISION	
REV.	DESCRIPTION	REV.	DESCRIPTION
		A.4.	



JEMISON METALS

CUSTOMER: HUSH HOG, INC

TITLE: Z-CHANNEL, CENTER-FLAT

MATERIAL: 70CA HRS CSB

BY CC: DATE 8/21/23 SHEET 1 OF 1

PART NO: 50084138 CUSTOMER REV: 0 A.4

DR

CUT/BURNT FIRST ARTICLES		TOLERANCES UNLESS OTHERWISE SPECIFIED	
NOMINAL	TOLERANCE	ACTUAL	LINEAR DECIMAL = +/- .010 ANGULAR = +/- .5°
MTL THICKNESS	.1763 .1715-.1873	174	
TOL "A"	11.36 11.35-11.37	11356	
TOL "B"	5.31 5.30-5.32	5.303	
TOL "C"	18.60 18.59-18.61	18.606	WEIGHT: