

Process/Product Audit Checklist

Cust #: 3023 Customer: Custom Metal PR GRP/Size/GRD/Width: POC/0565/CB60CD/48				
PWC: SCT W/O#: 92298 Date: 1/9/2024 Part #(s): 16 GA GNS 48 X 86.5 Auditor: B.Clem				
Gauge Range: .055 - .063 Actual Gauge: .060 Width Range: 48 - 48.187 Width Actual: 48.058				
Length Range: 86.5 - 86.625 Length Actual: 86.562 W-F Other: 0 - .12 Other Actual: Less .12				
Other: Residual Stress Other Actual: Yes Other: N/A Other Actual: N/A				
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		Marquez - Residual check performed but not noted on inspection report.
Correct raw material type and size?	X			Tag(s) to use: NB77939 Tag(s) used: NB77939
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)				Gages Observed (list last calibration and when due) 03-03 25' Tape 3/13/2023 3/13/2024 CL-2 25' Tape 6/18/2023 6/18/2024 M50 1" Mic 1/19/2023 1/19/2024 ST-4 Step Gauge 6/28/2023 6/28/2024 63294 Measuring Table 4/28/2022 4/26/2025
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-CTL-001 SMT-SH-001 JM-OP-001



Material Inspection Report

LOCATION

Sumter

DATE

5/14/2024

CUSTOMER

CUSTOM

JOB # SMT

92298

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	Order Dim	Tolerances	Tolerances	Low Limit	High Limit
Gauge	0.056	-0.001 +	0.007	0.057	0.063
Width	48.000	0.000 +	0.187	48.000	48.187
Length	86.500	0.000 +	0.125	86.500	86.625

	Set up Target	Side Type	Skid Type Error	SOPS	Skid Code	0	2	3
Gauge	0.060							
Width	48.094							
Length	86.563							
		JDOP008	JDOP016	JDOP046				
		JDOP014	JDOP034	JDOP032				

Finished Goods Tag	252694	252696	252699			
Master Coil Number	NB77939	NB77939	NB77939			
Heat	NUB2317325	NUB2317325	NUB2317325			
Enhanced Weight	4935	4935	4935			
Gross Weight	4590	4590	4590			
Tare	150	150	150			
Net Weight	4440	4440	4440	0	0	
Bundle Status						
Good Pcs.	66	66	66			
Scraped Pcs.						
Rockwell						
Gauge Head	E 0.060	0.059	0.058			
	C					
	E					
Body	E 0.059	0.059	0.059			
	C					
	E					
Tail	E 0.058	0.058	0.058			
	C					
	E					
Surface						
Width Head	48.058	48.062	48.049			
Body						
Tail						
Shape						
Residual Check						
Length Head	86.562	86.562	86.562			
Body						
Tail						
Squareness	.187	.125	.125			
Camber						
Operator	MR	MR	MR			
Setup Approval						
Run Time	S	F	Down Time	S	F	
Total Run Time	0:00	Cost	\$0.00	Cst/Hour	\$400.00	
Comments						