

Process Audit Summary:

10/15/15 Sumter Cut to Length PN 58507

Performed by: Patrick Macias

Multi blanking job to produce 26" x 16" and 27" lengths for South East Stamping.

All procedural coil identification checks followed.

One blank each of 26" x 27" and 26" x 16" produced side by side out of a 48.5" coil. All skids produced within max lifts and to piece counts on job packaged and identified correctly per W/O instructions. CA 8744 inspection and skid preparation followed.

All procedural dimensional checks (Gauge-width-length-square) were done at required intervals and recorded. All measurements fell within customer tolerances.

Surface checks and shape checks done at required interval based on flatness requirements, all checks within tolerance.

Follow up; Document in case 8744.

Part Spec/PO Audit Form

Cust #	2858	Customer	Southeast Stamping			Grp/Sz/Grd/Wdth	CRS/18/DSENT1/26		
Equip/Plant	Red Bud	Work Order #	58507	Date	10/15/2015	Part No.	9000401791/9000401801		
Work Order Information		Material to be Used				Actual			
		Tag #1	648223	Tag #2		Gauge #1	.047"	Gauge #2	
		PO#	SMT-17659-1	PO#		% Gauge In Spec	100	% Gauge In Spec	
Gauge Range	.044-.052	Gauge Min	0.0440	Gauge Min		Low/High Gauge	.0457/.0475	Low/High Gauge	
Width Range	25.97-26.3	Width	48.5000	Width		Average	0.0468	Average	
Length Range	15.97-16.03/26.97-27.03					Width	25.9970	Width	
Rockwell	NA	Rockwell	NA	Rockwell		Length	15.993/27.009	Length	
Tensile	NA					Rockwell	NA	Rockwell	
Yield	NA								
% Elongation	NA								
Chem Rqmts	NA								
Other Rqmts	SHAPE SQUARE-0-.12"								
						Other			
Summary									
Actions									
Final Status									

# AGT400 Coil Summary Report

## JEMISON METALS --

Job Number: 58507    Coil Number: 648223

Customer Number: SOUTH EAST    Coil Information: S62908    Supplier: WESTBOCA

Product: Steel    Oct-15-15    8:15 to 12:07 (clock 231.4 min/ run 74.3 min)    Shift: 1

### Average Thickness and Tolerance Data

Target	Average^	Average - Target	-0.0014 in (-3.00%)
		Standard Deviation^	0.0003 in ( 0.63%)
Length	4046 ft	Above High Limit	0.0520 in    0 ft ( 0.0%)
Width	48.500 in	In Tolerance	
Weight	31134 lbs	Below Low Limit	0.0440 in    0 ft ( 0.0%)
Max Thickness	0.0475 in at 3436 ft	Min Thickness	0.0446 in at 7 ft

### Statistical Process Control Data

Upper Control Limit	0.0475 in	Upper Tolerance Limit	0.0520 in
X Double Bar		R Bar	0.0009 in
Lower Control Limit	0.0457 in	Lower Tolerance Limit	0.0440 in
CR	22.5% (Capability Ratio %, 100/CP)		
CP	4.444 (Process Capability, HiLim-LoLim/6*Sigma)		
CPK	2.844 (Capability vs Limits)	TMW Ratio	0.945 (Low Limit/Avg)

### Thickness Distribution Relative to the Target

+++	0.0%
+0.0050	0.0%
+0.0045	0.0%

-0.0045	0.0%
-0.0050	0.0%
---	0.0%

0    3    6    9    12    15    18    21    24    27    30    33    %

7.4% is within  $\pm 0.0010$  in of the target    99.8% is within  $\pm 0.0025$  in of the target  
 100.0% is within  $\pm 0.0050$  in of the target    100.0% is within  $\pm 0.0100$  in of the target

Thickness vs Length (Coil Number 648223)

