

Process/Product Audit Checklist

Cust #: 2719 Customer: Altec GRP/Size/GRD/Width: GNS .0635 CB40 No 48

PWC: SRB W/O#: 63027 Date: 10-17-16 Part #(s): 970083438

Gauge Range: -0555 - .0695 Actual Gauge: .057 Width Range: 48 - 48.9999 Width Actual: 48.101

Length Range: 105 - 105.1250 Length Actual: 105.050 Flatn Other: 0 - .12 Other Actual: .060

Other: 5446 lbs Other Actual: 4880 lbs Other: 60 pcs/Tag Other Actual: 60 pcs/Tag

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?	✓			<u>Leguwan & Chris</u>
Correct raw material type and size?	✓			Tag(s) to use: <u>971399</u> Tag(s) used: <u>971399</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>N/A</u> W/O Rev: <u>N/A</u> Part Spec Rev: <u>N/A</u>]
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?	✓			
All Gages Calibrated (List in Comments)	✓			Gages Observed (list last calibration and when due) 8-3 25' Tape 7-21-16 7-21-17 m-44 1" mic 6-28-16 6-28-17 ST-5 Step Gauge 7-5-16 7-5-17 63294 Meas. Table 4-26-16 4-26-17
Housekeeping: Machine/Floor clean?	✓			
Loose tags & paperwork cleaned up?	✓			
Required PPE being worn?	✓			
Forms are the latest revision per Quality Intranet?	✓			List Forms (Observed Rev vs Intranet Rev) SMT-SRB-001 3-7-13 4 SMT-SH-001 10-26-11 0 Jm-OP-001 4-21-15 0 FOP081 2-16-01 1
Hardcopy Controlled Documents are listed on Quality Intranet by location?			✓	List Documents and their Location:

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 63027 Coil Number: 971399

Customer Number: ALTEC Coil Information: NUB1611852 Supplier: NUCOR BERKLEY

Product: Steel Oct-17-16 20:32 to 21:43 (clock 71.1 min/ run 19.3 min) Shift: 2

Average Thickness and Tolerance Data

Target	0.0625 in	Average^	0.0568 in	Average - Target	-0.0057 in (-9.1%)
				Standard Deviation^	0.0003 in (0.43%)
Length	3195 ft	Above High Limit	0.0695 in	0 ft (0.0%)	
Width	48.000 in	In Tolerance			
Weight	29667 lbs	Below Low Limit	0.0555 in	0 ft (0.0%)	
Max Thickness	0.0576 in at 2494 ft	Min Thickness	0.0558 in at 16 ft		

Statistical Process Control Data

Upper Control Limit	0.0576 in	Upper Tolerance Limit	0.0695 in
X Double Bar	0.0568 in	R Bar	0.0008 in
Lower Control Limit	0.0560 in	Lower Tolerance Limit	0.0555 in
CR	11.6% (Capability Ratio %, 100/CP)		
CP	8.642 (Process Capability, HiLim-LoLim/6*Sigma)		
CPK	1.568 (Capability vs Limits)	TMW Ratio	0.978 (Low Limit/Avg)

Thickness Distribution Relative to the Target

+++	0.0%
+0.0100	0.0%
+0.0090	0.0%
+0.0080	0.0%
+0.0070	0.0%
+0.0060	0.0%
+0.0050	0.0%
+0.0040	0.0%
+0.0030	0.0%
+0.0020	0.0%
+0.0010	0.0%
+0.0000	0.0%
-0.0010	0.0%
-0.0020	0.0%
-0.0030	0.0%
-0.0040	0.0%
-0.0050	0.0%
-0.0060	0.0%
-0.0070	0.0%
-0.0080	0.0%
-0.0090	0.0%
-0.0100	0.0%
---	0.0%

0.0% is within ± 0.0020 in of the target 0.4% is within ± 0.0050 in of the target
 100.0% is within ± 0.0100 in of the target 100.0% is within ± 0.0200 in of the target

Thickness vs Length (Coil Number 971399)

