

Process/Product Audit Checklist

Cust #: <u>3377</u> Customer: <u>EATON-MEX</u> GRP/Size/GRD/Width: <u>POC/0920/CSBTP/60.2500</u>				
PWC: <u>BB1</u> W/O#: <u>188970</u> Date: <u>10/15/2024</u> Part #(s): <u>47-63707-12</u> Auditor: <u>B. CLEM</u>				
Gauge Range: <u>.093-.1050</u> Actual Gauge: <u>.095</u> Width Range: <u>60.25-61.2499</u> Width Actual: <u>61.0</u>				
Length Range: <u>120.625-120.8125</u> Length Actual: <u>120.689</u> Other: <u>Wave 0-.12</u> Other Actual: <u>.062</u>				
Other: <u>Square 0-.37</u> Other Actual: <u>.062</u> Other: <u>N/A</u> Other Actual: <u>N/A</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			<u>Note</u>
Correct raw material type and size?	X			Tag(s) to use: <u>81597</u> Tag(s) used: <u>81597</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?			X	Quality not present for packaging
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) 015 1" Mic 4/24/2024 4/24/2025 ST 10 Step Gage 9/26/2024 9/26/2025 T231 16" Tape 1/5/2024 1/5/2025 T232 25" Tape 1/5/2024 1/5/2025 63332 Measuring Table 2-16/2024 2/16/2026
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-BB1-CTL Production Report 4/1/2024 4
Hardcopy Controlled Documents are listed on Quality Intranet by location?				List Documents and their Location: DEC-BB1-CTL Production Report DEC-CTL-001A DEC-CTL-004 DEC-CTL-001B DEC-CTL-003

PRODUCTION REPORT

PAGE 1 OF 1

JOB WORK ORDER NO.	DATE	MACHINE	SHIFT	MASTER COIL NO.	Yield Strength
188970	10/15	B81	1 st	81597	CSB
OPERATOR	RUN HOURS	Burr Msmt(s)	Head Scrap	Tail Scrap	
Mark Hand	8:35A-9:55		20'	12'	

(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		Square Actual	Weight	Comments
							Actual	MAX			
950775	23	23	101.0	120.937	120.681	.085	.062	.062	.062	4563	
76	23	23					.062				
77	23	23					.062				
78	23	23					.062				
79	23	23			120.687	.095	.062	.062	.062		
80	23	23					.062				
81	23	23					.062				
82	23	23					.062				
83	23	23					.062			4563	
84	4	9			120	.095	.062	.062	.062	312	1795
371234		7				.062	.062	.062	.062	375"	1389

15Oct24 10:49

J O B W O R K O R D E R
(R E P R I N T)

GAD 188970

Jemison Metals - Gadsden

3001 Hickory Street

Gadsden, AL 35902

Tel: 800-235-1086 Fax: 205-986-6604

Job Type LEV Process PWC BB1

Metric N Cust

Desc EATON MX-12

Due Date 06Jul24 Whs DFG

Setup 00:00 Run 01:30 Prtd By decline

=====
<<< JOB SPECIFICATIONS >>>

Group POS Grade CSBTP Gauge 0.1050 (0.1050 to 0.1050) ID 0.0000

=====
<<< ORDER SPECIFICATIONS >>>

F 01 POS/13E/CSBTP/60.2500"X120.62/.1050N CS TYPE B TEMP PASS
Part 3337/47-63707-12 Ga 0.1050 Wth 60.2500 Lth120.6250

Ga Rng 0.0930to 0.1050 Pc/Tag

WthTol + 0.9999 - 0.0000 Wt/Skd 5000

LthTol + 0.1875 - 0.0000 Ty JD6 Pk

WAVE:0.00-.12

FLATN:0.00-.06

SQUA:0.00-.37

Eaton processing instructions for Decatur

Check first sheets to get Material in spec

Cut 36" to 40" sample every 2 bundles and check on
flatness table, flip sample over repeat check.

Last bundle must be checked on every order

Any material that you cannot see the .125 on the s
tep gage must be put in reject

Frequency for visual flatness checks to be dictate
d by frequency of square checks on document DEC-PK

G-001. Adjust leveler set up if needed based on t
hese checks

Stretch Required, Laser Flatness, Residual Stress

Critical, Min Stretch is 1.5 inches,

Aim Stretch is 1.7 - 2.0 inches

Operator Initials_____

Actual Stretch Length_____

INSPECT SAMPLE SURFACE FOR NONCONFORMITY TOP AND
BOTTOM.

USE INDUSTRIAL GRAY COLOR SPRAY PAINT TO VERIFY AN
Y POTENTIAL SURFACE ISSUES

PACKERS TO CHECK SURFACE ON TOP SHEET ON EVERY SKI
D PRIOR TO PUTTING PAPER ON TOP OF SHEET. DOCUMEN
T EACH SKID CHECKED BY INITIALLING NEXT TO TAG NUM
BER ON PRODUCTION REPORT DOCUMENT # DEC-BB1 CTL PR
ODUCTION REPORT.

"Cut a 40" sample from head and middle of coil to
check underside for roll marks"

HEAT TREATED SKIDS FOR SHIPMENT TO MEXICO

Stretch Required, Laser Flatness, Residual Stres

Critical, Min Stretch is 1.5 inches,

Aim Stretch is 1.7 - 2.0 inches

15Oct24 10:49

J O B W O R K O R D E R
(R E P R I N T)

GAD 188970

Jemison Metals - Gadsden

-both sides surface critical-see picture at
operator station

-Clean level er, feed and steering roll before
running. Lightly grind if needed

PLACE TAG ON THE LEFT CORNER OF THE SKID FACING TH
E FORKLIFT AS YOU LOAD THE TRAILER

"Any visual surface issues found during inspection
s must be reviewed by Justin Pate or Brian Smith b
efore processing further."

<<< PROCESSING INSTRUCTIONS >>>

<Step 1>
Level To: 60.2500 X 120.6250 211 Pcs 45679 LBS 999 Pcs/Tag

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<POC/13E/CSBTP>								
81597	DPW	0.0920M	60.2500		1	45679	MTL3096114	C23R6
Rmks: EATON-MEXICO								
Total:					1	45679		

<<< MATERIAL TO STOCK >>>

Cons	Tg	Spc	Prod	Tg	Whs	Ty	Gauge	Width	Length	OD	PCS<Prn>Wt	PCS<Res>Wt
81597												
1		371238		DRJ	R	0.1050	60.2500	120.6250			7	1389
1		950775		DFG	F	0.1050	60.2500	120.6250			23	4563
1		950776		DFG	F	0.1050	60.2500	120.6250			23	4563
1		950777		DFG	F	0.1050	60.2500	120.6250			23	4563
1		950778		DFG	F	0.1050	60.2500	120.6250			23	4563
1		950779		DFG	F	0.1050	60.2500	120.6250			23	4563
1		950780		DFG	F	0.1050	60.2500	120.6250			23	4563
1		950781		DFG	F	0.1050	60.2500	120.6250			23	4563
1		950782		DFG	F	0.1050	60.2500	120.6250			23	4563
1		950783		DFG	F	0.1050	60.2500	120.6250			23	4563
1		950784		DFG	F	0.1050	60.2500	120.6250			9	1785
Total:										223	44,241	

<<< JOB RECAP >>>

	PCS	Weight	Scrap	Scrap %	Unactd	Scr %
Material Allocated	1	45,679				
Master Returns						
Returns to Stock						
Work in Process						
Material to be Shipped	216	42,852				
Rejects	7	1,389				
Net Weight to be Produced	216	42,852			1,438	3.15

15Oct24 10:49

T A G P I C K I N G L I S T
(R E P R I N T)

GAD 188970

Jemison Metals - Gadsden
3001 Hickory Street
Gadsden, AL 35902

Job Type LEV Process PWC BB1
Metric N Cust
Desc EATON MX-12
Due Date 06Jul24 Whs DFG
Setup 00:00 Run 01:30 Prtd By decline

=====

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<POC/13E/CSBTP>								
81597	DPW	0.0920M	60.2500		1	45679	MTL3096114	C23R6
Rmks: EATON-MEXICO				Total:	1	45679		