

Process/Product Audit Checklist

Cust #: <u>10</u> Customer: <u>HEIL FAB</u> GRP/Size/GRD/Width: <u>HRS 250 HS80 X 58.5 X 157.5</u>				
PWC: <u>G10</u> W/O#: <u>58021</u> Date: <u>10/31/25</u> Part #(s): <u>W093-2461-001</u> Auditor: <u>C MATHIS</u>				
Gauge Range: <u>235/.265</u> Actual Gauge: <u>250</u> Width Range: <u>8.00</u> Width Actual: <u>8.60</u>				
Length Range: <u>56.2</u> Length Actual: <u>56.2</u> Other: <u>5.63</u> Other Actual: <u>5.63</u>				
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?	X			
Correct raw material type and size?	X			Tag(s) to use: <u>39805B AND 38805C</u> Tag(s) used: <u>39805B AND 398805C</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: <u>E</u> , W/O Rev: <u>E</u> , Part Spec Rev: <u>E</u>] (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)	X			Gages Observed (list last calibration and when due) <u>TM050: 3/28/2025 - 3/28/2026</u> <u>C028: 3/28/2025 - 3/28/2026</u> <u>M030: 3/28/2025 - 3/28/2026</u>
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	X			
Required PPE being worn?				
Forms are the latest revision per Quality Intranet?	X			List Forms (Observed Rev vs Intranet Rev) <u>JDM-F-014 VS JDM-F-14</u>
Hardcopy Controlled Documents are listed on Quality Intranet by location?	X			List Documents and their Location: <u>GAD-LA-001 OPERATOR DESK</u>

FABRICATION PRODUCTION REPORT

[illegible]

Warehouse (GAD) Gadsden		Operator		Job Work Order	
Whs Zone				Job 58021	Date 10/30 06:00 AM
PWC	(G10) Laser 10				
Process	(AS-) As-Is				

PROGRAM 30102						JOB INSTRUCTIONS	
Dimension	D	Pcs	LBS	SFT Tag/Lot	Ven Tag	Heat	(dimensions in inches, if not specified)
HR Sheet, HSFm80, -							
58.5" x 157.5" 0.235-M		13	8,246.33	832 39805B	5380582.000	✓NUD/SQ6501	
58.5" x 157.5" 0.235-M		1	634.33	64 39805C	5380582.000	✓NUD/SQ6501	
Theo Scrap 24.27% (2,086.83 LBS)							
Dimension		Pcs	LBS	SFT			
58.5" x 157.5" 0.235" -M		14	8,596.83	896			

PLANNED CONSUMPTION			
Dimension	Pcs	LBS	
58.5" x 157.5" 0.235" -M	14	8,596.83	

PLANNED PRODUCTION			
Customer/Next Prs	Due		
HEIL ENVIRONMEN(10)	11/10		
SO-38944-1-1	Length	Diag	Ftns
	[-0.06 +0.06"]		
SO-38944-1-1	Width		
	[-0.06 +0.06"]		
SO-38944-1-1	Cond Incl Mill Edge		
Flat: 0 Wave: 0 Bow: 0 Square: 0 Camber: 0			

PACKAGING			
Customer	Dimension	LBS Pcs/Pkg	# Skid/Pkg
HEIL ENVIRONMEN(10)	26.3552" x 17.0654" Irregular	6,510 40	6 S3 - Sht Lifter 2x4 Top Boards / SC -Paper Top/Bot-2"EP w/Bands
SO-38944-1-1			

Legend: ✓ QDS approved ☒ Modified Specs	
Job Set 58622	10/29/2025 01:48 PM
	1

Warehouse (GAD) Gadsden	Operator	Job Work Order		
Whs Zone		Job 58021	Date 10/30 06:00 AM	
PWC	(G10) Laser 10			
Process	(AS-) As-Is			
ORDER INFORMATION				
SO-38944	HEIL ENVIRONMEN(10)/0	Customer PO STOCK	Sls Cat Sale	
Due 11/10	Item Product/Part/End User Label1	PCS SFT	LBS +/- Shp % Cert	
	1 HR ASTM A1011 - HSLA-Forming Gr 80	210 672.61	6,510	CAA
	0.237 N x 26.3552 x 17.0654		31/Pc	
	093-2461-001			
	Charles Love/Vicki Fontcuberta			
	Process Route			
	{AS-}			
Legend: ✓ QDS approved 10/29/2025 01:48 PM Modified Specs 2				



10/29/2025 1:43:12 PM

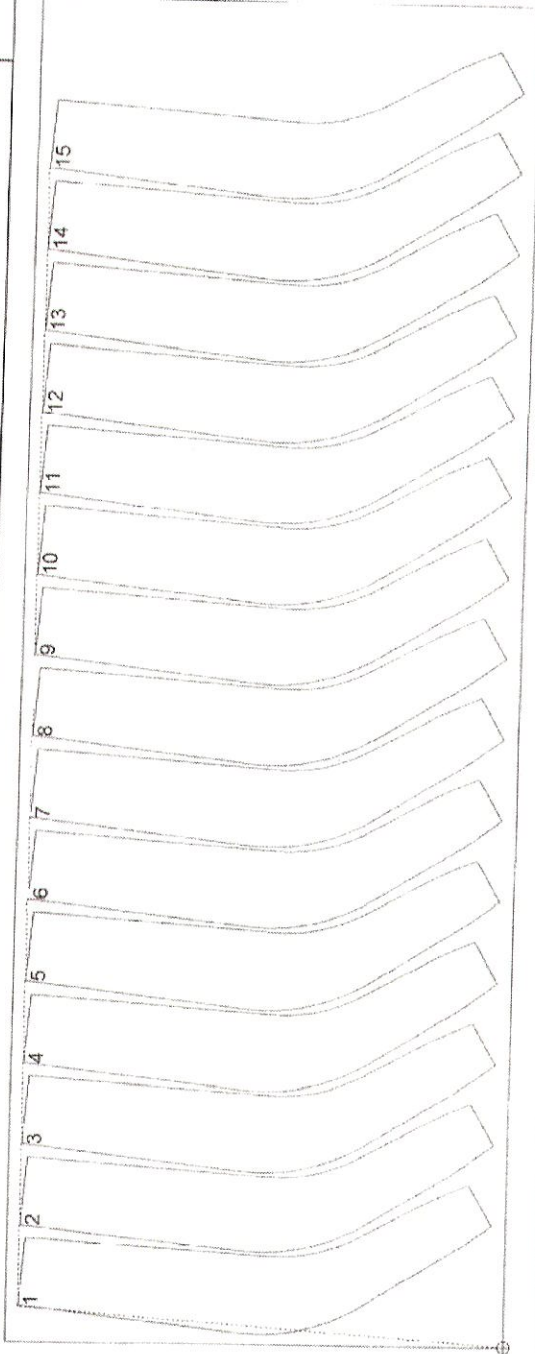
Layout Detail

Machine Amada_ENSIS4020AJZ

Task Name : HEIL FAB PN 093-2461-001 Program Name : 30102

Number of Sheets with Same Layout		14	True Scrap	24.335	Qty Required	99999999
Stack Quantity		1	Rect Scrap	-65.829	Qty Nested	15

Layout 1 of 1



Material	MS	Sheet Length	157.500"	Sheet X Used	152.032"	Heat Number	Mill
Thickness	0.250	Sheet Width	58.500"	Sheet Y Used	56.769"	Sheet Location	Prime Code
Sheet Name		Cutting Time	00:07:18	Cutting Length	1897.923"	Bin Number	Parameters N2
Part ID	Part Name	Qty Req	Qty Nested	Net Weight	Drawing Number	Revision Number	Work Order Number
1	093-2461-001	99999999	210	31.89lb	093-2461-001	E	
							Customer
							HEIL
							Cutting Time
							00:07:18



Layout Report

10/29/2025 1 43:13 PM

Task Name : HEIL FAB PN

Program Name :30102

Layout 1 of 1

Number of Sheets with Same Layout : 14

Sheet Parameters

Material : MS

Thickness : 0.250"

Sheet Length : 157.500"

Sheet Width : 58.500"

Sheet Name :

Bin Number :

Heat Number :

Location :

Mill :

Prime Code :

Sheet X Used : 152.032

Sheet Y Used : 56.769

Plate Used : 96.77%

Plate Recovered : 3.23%

Nesting Task Results

Qty Required : 99999999

Qty Nested : 15

Total Cutting Time : 30:07:18

Total Net Weight : 478.300b

True Scrap : 24.34%

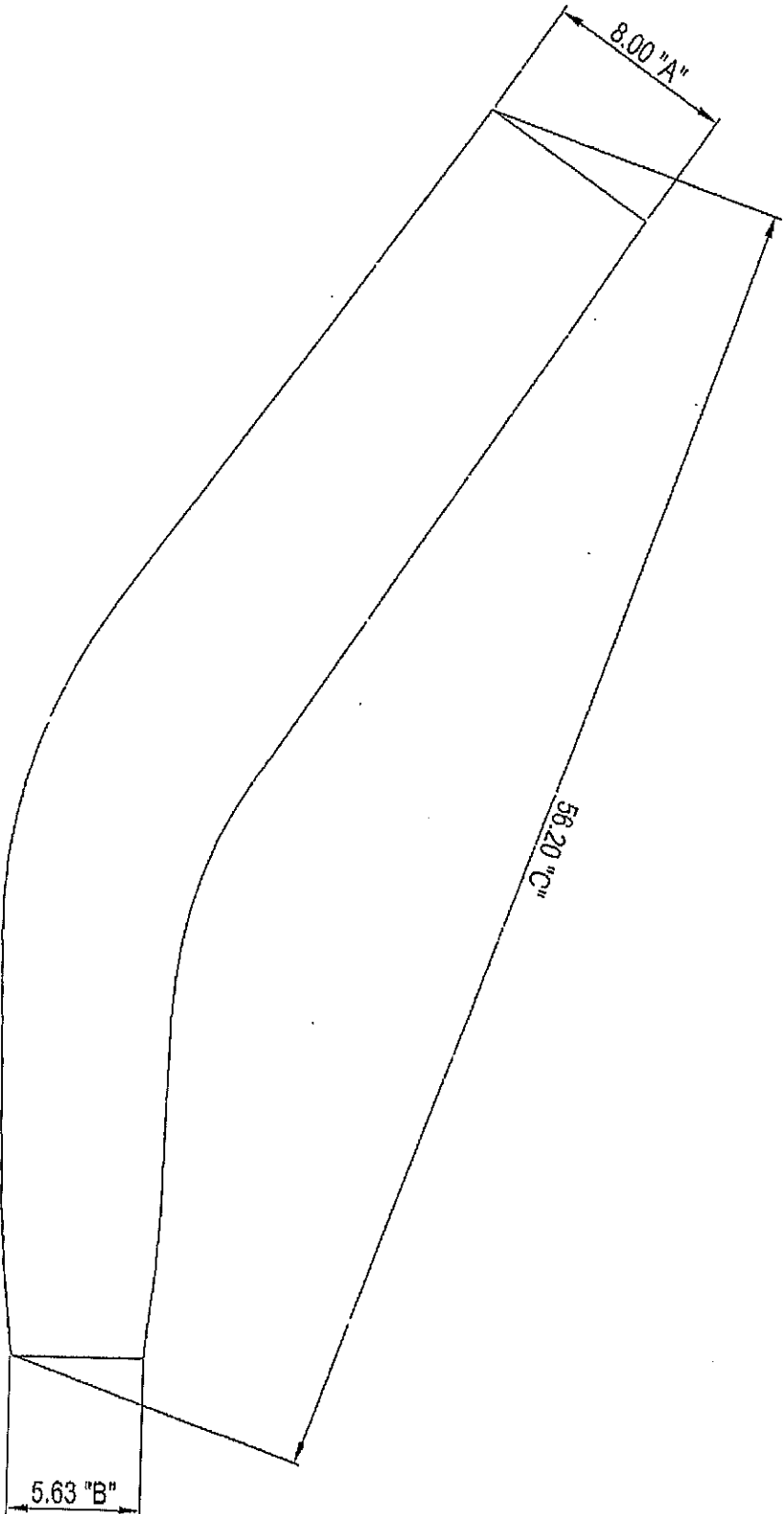
Rectangular Scrap : -65.83%

Total Cutting Length : 1897.923"

Number of Pierces : 5

Part ID	Part Name	Qty Req	Qty Nested	Net Weight	Drawing Number	Revision Number	Work Order	Customer	Cutting Time
1	093-2461-001	9999	15	31.89	C93-2461	E		HEIL	00:07:18

JANSON REVISION		CUSTOMER REVISION	
REV.	DESCRIPTION	DATE	REV.
		E	



CUT/BURST FIRST ARTICLES				TOLERANCES DIMENSIONS OTHERWISE SPECIFIED	CUSTOMER HEIL	METALS
	NOMINAL	TOLERANCE	ACTUAL			
WTL THICKNESS	.25	.235-.265	1.25	LINEAR	M2 SIDE PLATE - ARM REAR HALF PACK DATE/LOT 1/4" HB80	
TOL. "A"	B.00	7.94-B.06	8.00	XX = +/- .06 XXX = +/- .090 ANGULAR = +/- 1°		
TOL. "B"	5.63	5.57-5.69	5.63			
TOL. "C"	56.20	56.14-56.28	56.20	WEIGHT:		



Jenison
METALS