

Process/Product Audit Checklist

Cust #: <u>3023</u> Customer: <u>Custom Metal</u> GRP/Size/GRD/Width: <u>GNS.063SCB60CD</u>				
PWC: <u>SRB</u> W/O#: <u>67697</u> Date: <u>11-1-17</u> Part #(s): <u>16 GAGNS 42x90</u> Auditor: <u>B. Clem</u>				
Gauge Range: <u>.0575 - .0635</u> Actual Gauge: <u>.058</u> Width Range: <u>42-42.1875</u> Width Actual: <u>42.056</u>				
Length Range: <u>90-90.1250</u> Length Actual: <u>90.074</u> Other: <u>W-F 0-.12</u> Other Actual: <u>.050</u>				
Other: <u>WT: 4833 lbs.</u> Other Actual: <u>4410 lbs.</u> Other: <u>71 pcs/Tag</u> Other Actual: <u>71 pcs. Tag</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?		✓		All checks not recorded on FOP081 - Leguwan → Back
Correct raw material type and size?	✓			Tag(s) to use: <u>516348</u> Tag(s) used: <u>516348</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: _____, W/O Rev: _____, Part Spec Rev: _____] (Leave blank if non-Fab audit)
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?	✓			2 Bundles put in SRJ edges not coated.
Required gages available & functional?	✓			
All Gages Calibrated (List in Comments)	✓			Gages Observed (list last calibration and when due) R-3 25' Tape 7-31-17 7-31-18 M-44 1" Mic 6-27-17 6-27-18 ST-5 Step Gauge 7-5-17 7-5-18 63094 Meas. Table 4-19-17 4-19-18
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	✓			
Required PPE being worn?		✓		Leguwan & Chris M. - No Safety Glasses
Forms are the latest revision per Quality Intranet?				List Forms (Observed Rev vs Intranet Rev) SMT-SRB-001 11-8-16 5 SMT-SH-001 10-26-11 0 - Per Corrective Acti Jm-PP-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:

No Residual Checks recorded on FOP081.
Residual Checks were required for a corrective action.

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 67697 Coil Number: 516348

Customer Number: CUSTOM METAL Coil Information: NUB1712030 Supplier: NUCOR BERKELEY

Product: Steel Nov-1-17 20:21 to 22:04 (clock 102.3 min/ run 26.3 min) Shift: 2

Average Thickness and Tolerance Data

Target 0.0605 in Average^ 0.0589 in Average - Target -0.0016 in (-2.66%)
Standard Deviation^ 0.0002 in (0.40%)

Length 3628 ft Above High Limit 0.0635 in 0 ft (0.0%)
Width 42.000 in In Tolerance 3628 ft (100.0%)
Weight 30580 lbs Below Low Limit 0.0575 in 0 ft (0.0%)

Max Thickness 0.0606 in at 3597 ft Min Thickness 0.0583 in at 378 ft

Statistical Process Control Data

Upper Control Limit 0.0596 in Upper Tolerance Limit 0.0635 in
X Double Bar 0.0589 in R Bar 0.0007 in
Lower Control Limit 0.0582 in Lower Tolerance Limit 0.0575 in

CR 24.0% (Capability Ratio %, 100/CP)

CP 4.167 (Process Capability, HiLim-LoLim/6*Sigma)

CPK 1.931 (Capability vs Limits) TMW Ratio 0.976 (Low Limit/Avg)

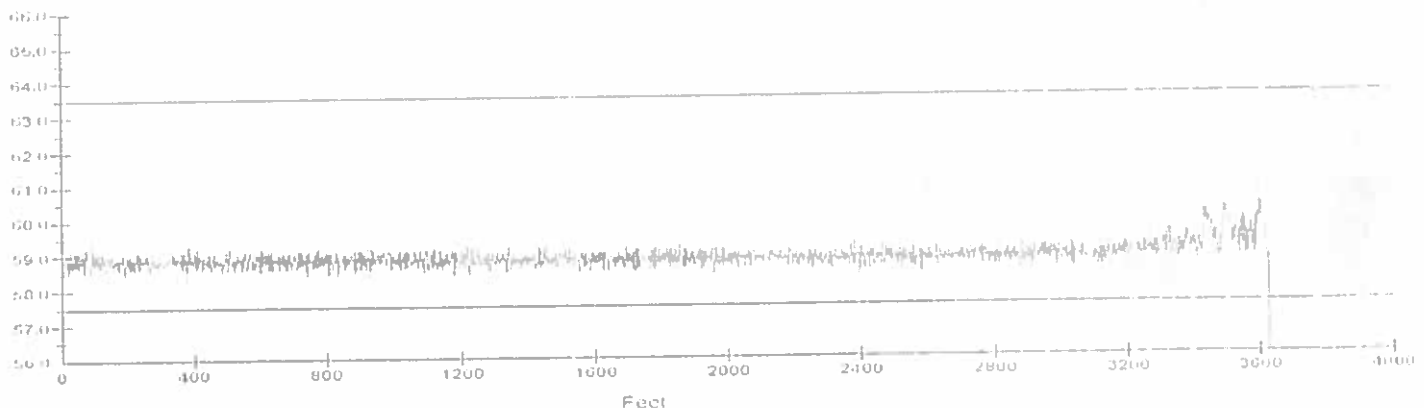
Thickness Distribution Relative to the Target

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+++ 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 3.3% .....
-0.0020 96.2% .....
-0.0030 0.5% .....
-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%
    
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99.5% is within ± 0.0020 in of the target 100.0% 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 516348)



Gauge readings provided by Advanced Gauging Technologies, L.L.C. Plain City, OH 43064 USA Tel: (514) 873-6691



Material Inspection Report

LOCATION

Sumter

DATE

11/2/2017

CUSTOMER

CUSTOM METAL

JOB # SMT

67697

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	Order Dim		Tolerances		Tolerances		Low Limit		High Limit
Gauge	0.037	-	-0.001	+	0.007		0.058		0.064
Width	42.000	-	0.000	+	0.188		42.000		42.188
Length	90.000	-	0.000	+	0.125		90.000		90.125

	Set up Target		Side Type	Skid Type Error		Skid Code	0 2 3
Gauge	0.061						
Width	42.094						
Length	90.063						
SOPS							
			JDOP008	JDOP016	JDOP046		
			JDOP014	JDOP034	JDOP032		

Finished Goods Tag	14172	14176					
Master Coil Number	516348						
Heat							
Enhanced Weight							
Gross Weight	4510	4510					
Tare	100	100					
Net Weight	4410	4410	0	0	0		
Bundle Status							
Good Pcs.	71	71					
Scraped Pcs.							
Rockwell							
Gauge Head	E	0.058					
	C	0.059					
	E	0.058					
Body	E	0.058	0.058				
	C	0.059	0.059				
	E	0.058	0.058				
Tail	E	0.058					
	C	0.059					
	E	0.058					
Surface	050/050/050	0.05					
Width Head	42.056						
Body	42.062	42.055					
Tail	42.055						
Shape	050/050/050	0.050					
Residual Check							
Length Head	90.074						
Body	90.064	90.095					
Tail	90.065						
Squareness							
Camber							
Operator	LM	LM					
Setup Approval							
Run Time	S	F	Down Time	S	F		
Total Run Time	0:00	Cost	\$0.00	Cst/Hour	\$400.00		

Comments	
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