Process Audit Summary:

11/12/15 Sumter Red Bud Job# 58851

Performed by: Beverly Clem

Leveling job to produce 30.7500" X 24.8000" length sheets for BSH Home Appliance from master tag NB48453.

All procedural coil identification checks followed.

Ten skids produced at 30.7500" X 24.8000" sheets. All skids produced within max lifts and packaged and identified correctly per W/O instructions.

All procedural dimensional checks (Gauge-Width-Length-Square) and shape checks (Wave-Bow-Flatness) were done per SMT-SRB-001 procedure and recorded on the FOP 081 in excess of required intervals. Measurements were performed with micrometer M-44, Step gauge ST-5, and flatness table 63294. All measurements fell within customer tolerances.

No follow up required.

Measuring Tools:

Micrometer – M-44 last calibration 10/1/15 calibration due 10/1/16

Step gauge – ST-5 last calibration 7/7/15 calibration due 7/7/16

Flatness table – last calibration 4/20/15 calibration due 4/20/16

Controlled documents:

SMT-SRB-001 Red Bud Procedure REV 4 -3/7/13

FOP081 Cutline/Shear Inspection Rev 1 -2/16/01

Part Spec/PO Audit Form

Cust #	1795	Customer	BSH HOME APPLIANCE		Grp/Sz/Grd/Wdth	GVS/0.0356/DD30CD/30.7500		
Equip/Plant	SRB	Work Order #	58851	Date	11/12/2015	Part No.	9000286520	
	Work Order Information						Actu	ual
		Tag #1	NB48453	Tag #2		Gauge #1	.037 .036 .036	Gauge #2
		PO#	017675-001	PO#		% Gauge In Spec	100%	% Gauge In Spec
Gauge Range	0.0356 - 0.0396	Gauge Min	0.0352	Gauge Min		Low/High Gauge	.0357/.0384	Low/High Gauge
Width Range	30.735 - 30.765	Width	62.0000	Width		Average	0.0366	Average
Length Range	24.768 - 24.832					Width	30.7550	Width
Rockwell	N/A	Rockwell	N/A	Rockwell		Length	24.8010	Length
Tensile	N/A					Rockwell	N/A	Rockwell
Yield	N/A					W-B	> .120	
% Elongation	N/A					SQ	0.018	
Chem Rqmts	N/A							
Other Rqmts	N/A							
W-B	0.0012					Other		
SQ	0.0012							
Summary								
Actions								
Final Status								

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 58851 Coil Number: NB48453 <u>Customer Number: BSH _ Coil Information: NUB2513923 Supplier: NUCOR BERKLEY</u>

Product: Steel Nov-12-15 23:00 to 0:37 (clock 96.6 min/ run 52.4 min) Shift: 2

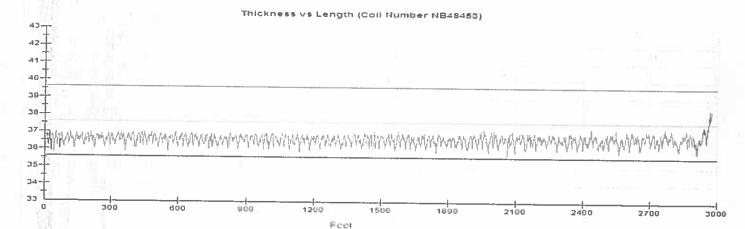
Average Thickness and Tolerance Data

Target Average^	Average - Target -0.0010 in (-2.66%) Standard Deviation^ 0.0003 in (0.69%)
Width 62.000 in	Above High Limit 0.0396 in 0 ft (0.0%) In Tolerance Below Low Limit 0.0356 in 0 ft (0.0%)
Max Thickness 0.0384 in at 2969	ft Min Thickness 0.0357 in at 2061 ft
Statistical Process Control DataUpper Control Limit0.0374 inX Double Bar0.0358 in	R Bar
CR 39.0% (Capability Ratio %, 1 CP 2.564 (Process Capability,	00/CP)

CPK 1.282 (Capability vs Limits) TMW Ratio 0.973(Low Limit/Avg)

Thickness Distribution Relative to the Target

0.0% +++ +0.0050 0.0% +0.0045 0.08 +0.0040 0.0% +0,0035 0.0% +0.0030 0.0% +0.0025 0.0% -0.0025 0.0% -0.0030 0.0% -0.0035 0.0% -0.00400.0% -0.0045 0.0% -0.0050 0.0% ---0.0% 0 3 б 9 12 15 18 21 24 27 30 33 8 61.3% is within ± 0.0010 in of the target 100.0% is within ± 0.0025 in of the target 100.0% is within ± 0.0050 in of the target 100.0% is within ± 0.0100 in of the target



Gauge readings provided by Advanced Gauging Technologies, L.L.C. Plain City, OH 43064 USA Tel:(614) 873-6691