

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						Actual			
		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	0.00 - .12					Other			
SQ	0.00 - .12								
Summary									
Actions									
Final Status									

# AGT400 Coil Summary Report

## JEMISON METALS --

Job Number: 58851 Coil Number: NB48453

Customer Number: BSH Coil Information: NUB2513923 Supplier: NUCOR BERKLEY

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^ 0.0368 in Average - Target -0.0010 in (-2.66%)  
Standard Deviation^ 0.0003 in ( 0.69%)  
Length 2974 ft Above High Limit 0.0396 in 0 ft ( 0.0%)  
Width 62.000 in In Tolerance 2974 ft (100.0%)  
Weight 22997 lbs 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 Data

Upper Control Limit 0.0374 in Upper Tolerance Limit 0.0396 in  
X Double Bar 0.0368 in R Bar 0.0008 in  
Lower Control Limit 0.0358 in Lower Tolerance Limit 0.0356 in

CR 39.0% (Capability Ratio %, 100/CP)

CP 2.564 (Process Capability, HiLim-LoLim/6\*Sigma)

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 0.0%  
+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%  
-0.0040 0.0%  
-0.0045 0.0%  
-0.0050 0.0%  
--- 0.0%

0 3 6 9 12 15 18 21 24 27 30 33 %

61.3% is within  $\pm 0.0010$  in of the target 100.0% is within  $\pm 0.0025$  in of the target  
100.0% is within  $\pm 0.0050$  in of the target 100.0% is within  $\pm 0.0100$  in of the target

Thickness vs Length (Coil Number NB48453)

