

Process Audit Summary:

11/16/15

BB1 job #49666

Cupples JJ

All procedural coil identification checks followed.

All procedural steps were followed per DEC-CTL-001. Manual mic checks were made at stretch bed in excess of procedure. Width was also checked at stretch. Operator throwing wood checked length after first three sheets were run and signed off on work order. Surface was also inspected at this time and was found to contain a roll mark/bruising from the mill. Measurements were taken that mark was 18ft apart and repeating. Operator continued to run in order to reach 10% of coil weight. Marking did go away in coil.

Skids were built using pallet reference booklet found in woodshed.

Eleven skids produced total and recorded on production report (DEC-BB1-CTL). One skid was rejected for roll marks/bruising from the mill. Proper reject form was filled out (DEC-F-001). Pictures were taken.

No follow up required.

Measuring tools:

Micrometer- # 001 last calibration 11/25/15 calibration due 11/25/16

Tape 25'-T1013 last calibration 09/24/15 calibration due 09/24/16

Tape 25' T1015 last calibration 6/26/15 calibration due 06/26/16

Controlled documents:

DEC-CTL-001 Rev 0

DEC-BB1-CTL Rev 0

DEC-F-001 Rev 0

Part Spec/PO Audit Form

Cust #	2888	Customer	Cumple's JJ	Grp/sz/grd/width	POS 14'x4' H&SD 4'
Equip/Plant	B61	Work Order #	446406	Date	11/14/15
Work Order Information		Material to be Used		Actual	
	Tag #1	48 7x1	Tag #2	Gauge #1	1.075
	PO#	GA10-10706	PO#	% Gauge in Spec	100%
Gauge Range	.0677 - .0817	Gauge Min	.069	Low/High Gauge	.066 / .081
Width Range	48 - 50	Width	48"	Average	1.076
Length Range	96 - 96.5			Width	48.187
Rockwell		Rockwell		Length	96.25
Tensile	150000 min			Rockwell	N/A
Yield	100000 min				
% Elongation	2.2				
Chem Rqmts					
Other Rqmts	TID3 - skids must be labeled skitcrnel			Other	
Summary					
Actions					
Final Status					

Gauge measured w/ mic #001 .075
width measured w/ tape TID13 48.187
length measured w/ tape T1018 96.25

Production filled out form
DEC-BB1-CTL Rev D

Gauge measured through out run w/ AcT

11 skids produced
1 of which is reject

First few sheets had roll marks - moved off - Braving very 18A
marks continued through first bundle
2 pictures on cell phone

Rejected Op filled out for DEC-F-001 Rev 0

Skids built - 3 cross blocks 13 runners on top Nick referenced pallet book
for material copy