

Process/Product Audit Checklist

Cust #: <u>1795</u> Customer: <u>BSH Home</u> GRP/Size/GRD/Width: <u>GWS.0246CB30CD60</u>				
PWC: <u>SRB</u> W/O#: <u>67874</u> Date: <u>11-16-17</u> Part #(s): <u>9001105295</u> Auditor: <u>B. Clem</u>				
Gauge Range: <u>.0246 - .0276</u> Actual Gauge: <u>.025</u> Width Range: <u>60 - 60.1875</u> Width Actual: <u>60.078</u>				
Length Range: <u>85.875 - 86.1250</u> Length Actual: <u>86.016</u> Other: <u>Flat</u> Other Actual: <u>.060</u>				
Other: <u>74 pcs./tag</u> Other Actual: <u>74 pcs./tag</u> Other: <u>2989 lbs.</u> Other Actual: <u>2790 lbs.</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?	✓	✓		James W. - Length Check not done at beginning of 1st skid. No Check Done end of last skid of Run.
Correct raw material type and size?	✓			Tag(s) to use: <u>NB55903</u> Tag(s) used: <u>NB55903</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?	✓			End of coil edge wave .250 - .375 last skid put in SR3.
Non-conforming material put into reject warehouse and physically put into non-conforming area?	✓			Last skid .250 - .375 edge wave.
Required gages available & functional?	✓			
All Gages Calibrated (List in Comments)	✓			Gages Observed (list last calibration and when due) 8-3 25' Tape 7-31-17 7-31-18 m-44 1" mic 6-27-17 6-27-18 57-5 Step Gauge 7-5-17 7-5-18 63294 meas. Table 4-19-17 4-19-18
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	✓			
Required PPE being worn?		✓		James W. & Sam S. - No Safety Glasses
Forms are the latest revision per Quality Intranet?	✓			List Forms (Observed Rev vs Intranet Rev) SMT-SRB-001 11-8-16 S Jm-OP-001 4-21-15 O FOP081 2-16-01 I
Hardcopy Controlled Documents are listed on Quality Intranet by location?			✓	List Documents and their Location:

Details on Back

James W. - No safety glasses at all.

Sam J. - Wearing safety glasses on top of head.

No last piece of run check was done. 17 pieces was pulled off last skid ~~8~~ and placed in SR5 for visual edge wave.

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 67874 Coil Number: NB55903

Customer Number: BSH Coil Information: NUB1711638 Supplier: NUCOR BERKLEY

Product: Steel Nov-16-17 11:17 to 13:08 (clock 110.8 min/ run 32.6 min) Shift: 1

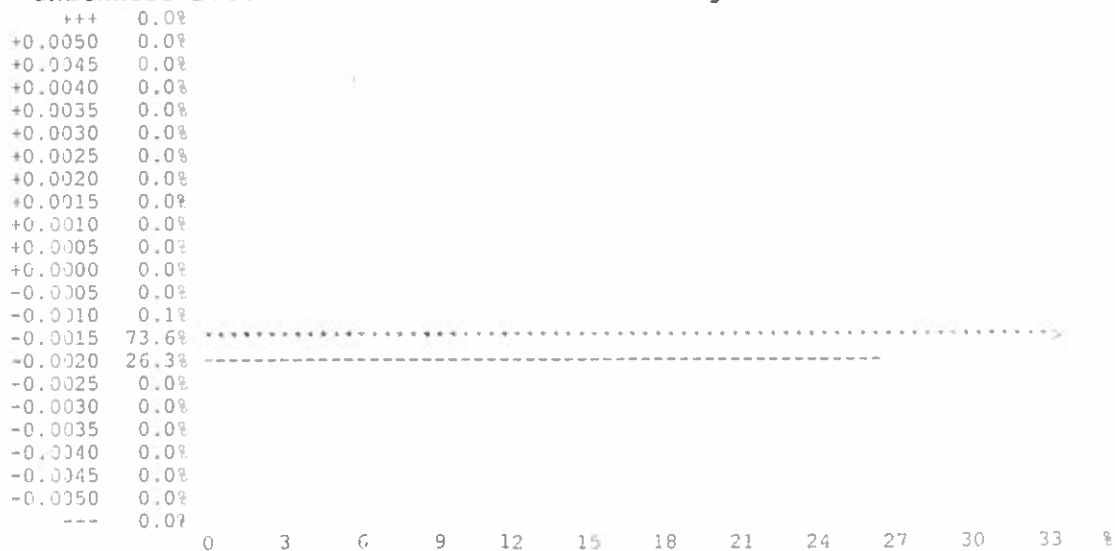
Average Thickness and Tolerance Data

Target	0.0265 in	Average^	0.0250 in	Average - Target	-0.0015 in (-5.51%)
				Standard Deviation^	0.0001 in (0.49%)
Length	5060 ft	Above High Limit	0.0280 in	0 ft	0.0%
Width	60.000 in	In Tolerance		3727 ft	73.7%
Weight	25910 lbs	Below Low Limit	0.0250 in	1333 ft	26.3%
Max Thickness	0.0255 in at 4511 ft	Min Thickness	0.0246 in at 5040 ft		

Statistical Process Control Data

Upper Control Limit	0.0254 in	Upper Tolerance Limit	0.0280 in
X Double Bar	0.0250 in	R Bar	0.0004 in
Lower Control Limit	0.0247 in	Lower Tolerance Limit	0.0250 in
CR	26.0% (Capability Ratio %, 100/CP)		
CP	3.846 (Process Capability, HiLim-LoLim/6*Sigma)		
CPK	0.103 (Capability vs Limits)	TMW Ratio	0.998 (Low Limit/Avg)

Thickness Distribution Relative to the Target



0.1% 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

Thickness vs Length (Coil Number NB55903)

