

Process/Product Audit Checklist

Cust #: 1795 Customer: BSH-NEW BERN GRP/Size/GRD/Width: GVC/.0356/DD30CD/28.5600				
PWC: SSL W/O#: 76185 Date: 11/18/2019 Part #(s): 9000913790 Auditor: B. CLEM				
Gauge Range: .0356-.0387		Actual Gauge: .038		Width Range: 28.529-28.591 Width Actual: 28.562 28.559
Length Range: N/A		Length Actual: N/A		MxOD Other: 33.10 Other Actual: 31.25
Other: N/A		Other Actual: N/A		Other: N/A Other Actual: N/A
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?	X			Farron - Gauge check at the tail was noted on the FOP015 but the check was not done.
Correct raw material type and size?	X			Tag(s) to use: NB63692 Tag(s) used: NB63692
Setup performed according to W/O?	X			
Product is acceptable according to customer-specific requirements? [Fab: Is the Part Print Present & the correct Revision? Are required measurements documented?]	X			[Fab: Print Rev: _____, W/O Rev: _____, Part Spec Rev: _____] (Leave blank if non-Fab audit)
Packaging is acceptable according to customer-specific requirements?			X	Quality not present at packaging
Visual Inspection performed and product meets requirements?	X			Light drag mark at tail of the coil. OK'd by Patrick.
Out of spec noted, with actions taken?			X	
Non-conforming material put into reject warehouse and physically put into non-conforming area?			X	
Required gages available & functional?	X			
All Gages Calibrated (List in Comments)	X			Gages Observed (list last calibration and when due) 13-01 25' TAPE 7/11/2019 7/11/2020 11-03 12' TAPE 7/11/2019 7/11/2020 M55 1" MIC 12/18/2018 12/18/2019 D-5 24" CALIPER 4/18/2019 4/18/2020 D-2 40" CALIPER 8/27/2019 8/27/2020
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	X			
Required PPE being worn?	X			
Forms are the latest revision per Quality Intranet?	X			List Forms (Observed Rev vs Intranet Rev) FOP015 2/16/01 1
Hardcopy Controlled Documents are listed on Quality Intranet by location?	X			List Documents and their Location: SMT-SL-001 JM-OP-001



Manual Inspection Report

FOA033 Rejection Codes

JDP0605

JDP0606

JDP0607

JDP0649

Date

11/18/2019

Job # SMT-	76185	Page #	1	Machine	Sitter	CQ	HS	10b38
Location:	Summer	Operator:	PM	Target	0.03650	0.00525	0.00700	0.00875
Gauge Spec	0.03500	Limits	0.03500	0.03800				
Cut	Set Up	Actual	Cut	Set Up	Actual	Cut	Set Up	Actual
1	28.560	28.562	6			16		21
2	28.560	28.559	7			17		22
3			8			18		23
4			9			19		24
5			10			20		25

Set Up Comments:

	Coil #	Olsen	Rb	Head	1/4	Center	3/4	Tail	Camber	Linear Ft	Burr Hgt	Good PC	Bad PC	Comment
1	NB63692			E 0.03800	0.03700	0.03700	0.03700	0.03700						
				C 0.03800	0.03600	0.03600	0.03600	0.03600						
				E 0.03800	0.03600	0.03600	0.03600	0.03600						
2				E										
				C										
				E										
3				E										
				C										
				E										
4				E										
				C										
				E										
5				E										
				C										
				E										
Start Time		Step Time		Start Down Time		Step Down Time		Total Down Time	0:00	Total Run Time	0:00	Cost Hour	\$550.00	\$0.00
Comment														

AGT400 Coil Summary Report

Jemison Metals -- 60 Inch Pro-Eco Slitter

Work Order: 76185 Coil Number: NB63692

Customer Name: BSH Heat Number: NUB1913812 Vendor: NUB

Product: G30 Galvanized Nov-18-19 12:30 to 13:02 (clock 31.8 min/ run 19.7 min) Shift: 1

Average Thickness and Tolerance Data

Target 36.5 mil Average^ 37.0 mil Average - Target 0.4600 mil (1.26%)
Standard Deviation^ 0.2000 mil (0.55%)

Length 1952 ft Above High Limit 38.0 mil 0 ft (0.0%)
Width 58.000 in In Tolerance 1952 ft (100.0%)
Weight 14261 lbs Below Low Limit 35.0 mil 0 ft (0.0%)

Max Thickness 37.6 mil at 597 ft Min Thickness 36.3 mil at 160 ft
Head Scrap 0 ft Tail Scrap 0 ft

Statistical Process Control Data

Upper Control Limit 37.6 mil Upper Tolerance Limit 38.0 mil
X Double Bar 37.0 mil R Bar 0.6 mil
Lower Control Limit 36.4 mil Lower Tolerance Limit 35.0 mil

CR 40.0% (Capability Ratio %, 100/CP)

CP 2.500 (Process Capability, HiLim-LoLim/6*Sigma)

CPK 1.733 (Capability vs Limits) TMW Ratio 0.947 (Low Limit/Avg)

Thickness Distribution Relative to the Target

+++	0.0%
+5.0000	0.0%
+4.5000	0.0%
+4.0000	0.0%
+3.5000	0.0%
+3.0000	0.0%
+2.5000	0.0%
+2.0000	0.0%
+1.5000	0.0%
+1.0000	0.7%
+0.5000	51.5%
+0.0000	47.1%
-0.5000	0.7%
-1.0000	0.0%
-1.5000	0.0%
-2.0000	0.0%
-2.5000	0.0%
-3.0000	0.0%
-3.5000	0.0%
-4.0000	0.0%
-4.5000	0.0%
-5.0000	0.0%
---	0.0%

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

100.0% is within ± 1.0000 mil of the target 100.0% is within ± 2.5000 mil of the target
100.0% is within ± 5.0000 mil of the target 100.0% is within ± 10.0000 mil of the target

Thickness vs Length (Coil Number NB63692)

