

Process Audit Summary:

11/19/15 Sumter Red Bud Job# 58990

Performed by: Beverly Clem

Leveling job to produce 48" X 96" length sheets for Wrico Stamping from master tag 491644.

All procedural coil identification checks followed.

Three skids produced at 48" X 96" 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, 25' tape-8-3 and flatness table 63294. All procedural checks fell within customer tolerance except for gauge and it was ok per Stephen.

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

25' Tape – last calibration 11/3/15 calibration due 11/3/16

Controlled Documents:

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

FOP 081 Cutline/Shear Inspection REV 1 – 2/16/01

Part Spec/PO Audit Form

Cust #	1670	Customer	WRICO STAMPING			Grp/Sz/Grd/Wdth	CRS/0.0598/HS50-1		
Equip/Plant	SRB	Work Order #	58990	Date	11/19/2015	Part No.	T34368/HSLA060		
Work Order Information						Actual			
		Tag #1	491644	Tag #2		Gauge #1	.054 .054 .054	Gauge #2	
		PO#	016826-001	PO#		% Gauge In Spec	0%	% Gauge In Spec	
Gauge Range	0.0548 - 0.0600	Gauge Min	0.0552	Gauge Min		Low/High Gauge	.0531/.0545	Low/High Gauge	
Width Range	48.0000 - 48.2500	Width	48.0000	Width		Average	0.054	Average	
Length Range	96.0000 - 96.1250					Width	48.2370	Width	
Rockwell	N/A	Rockwell	N/A	Rockwell	N/A	Length	96.0300	Length	
Tensile	N/A					Rockwell	N/A	Rockwell	
Yield	N/A					W-B-F	> .12		
% Elongation	N/A					SQ	0.048		
Chem Rqmts	N/A								
Other Rqmts	N/A								
W-B-F	0.00 - .12					Other			
SQ	0.00 - .37								
Summary									
Actions	Low guage was approved by Stephen.								
Final Status									

