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 guage 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

Cust #	1670	Customer	WRICO STAMPING				Grp/Sz/Grd/Wdth	CRS/0.0598	3/HS50-1		
Equip/Plant	SRB	Work Order #	58990	Date	11/19/2015		Part No.	T34368/H	SLA060		
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	0.0012						Other				
SQ	0.0037										
Summary				<u> </u>	I						
Actions	Low guage was approved by Stephen.										
Final Status											

AGT400 Coil Summary Report

JEMISON METALS --

Coil Number: 491644 Job Number: 58990

Customer Number: WRICO Coil Information: NUB1506394 Supplier: NUCOR BERKLEY

Nov-19-15 17:15 to 18:02 (clock 47.2 min/ run 13.2 min) Shift: 2 F net: Steel

Average Thickness and Tolerance Data

	Avernae'			0.0034 in 0.0002 in	
liength	804: F	Above High Limit In Tolerance	0.0600 in	0 ft	(0.0%)
tinigat	; 7094 lbs	Below Low Limit	0.0548 in	804 ft	(100.0%)
Dax ita	ness 0.0345 in at	627 ft Min Thi	ckness 0.053	31 in at	129 ft

Statistical Process Control Data

+C+0

 ± 0

+0

-0 -0 -0 -0 -0 -0 -0

-0

101

62

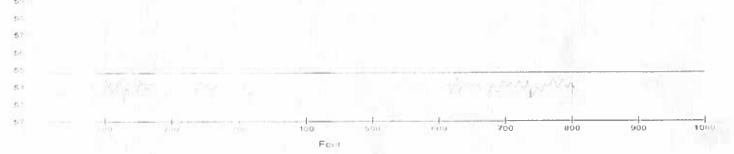
thin d

	ltrol Bar	Limis		Upper R Bar	Tolerance	Limit	0.0600	
	trol		0.0 33		Tolerance	Limit	0.0548	
			ity Balda					
8 8			s Capacili lity - Li				1.015(Low	Limit/Avg)

Distribution Relative to the Target

27 30 21 24 33 100.0% is within ± 0.0050 in of the target thin 1 .0020 is of the target. 100.0% is within ± 0.0200 in of the target 5.0100 is of the target

Thickness vs Length (Coll flumber 491644)



es provided by Advanced Gauging Technologies, L.L.C. Plant City, OH 43064 USA Tel: (614) 873-6691