

Process/Product Audit Checklist

Cust #: 2719		Customer: ALTEC		GRP/Size/GRD/Width: GNS/.0635/CB40NO/48	
PWC: SRB		W/O#: 76109		Date: 11/22/2019	
				Part #(s): 970083271 990045628	
				Auditor: D. MACIAS	
Gauge Range: .0555-.0695		Actual Gauge: .056		Width Range: 48-48.9999	
				Width Actual: 48.027	
Length Range: 74-74.125		Length Actual: 74.060		Lth Other: 96-96.125	
				Other Actual: 96.060	
FLATN Other: 0-.12		Other Actual: LESS .12		Other: RESIDUAL	
				Other Actual: PASS	
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			Chris D.	
Correct raw material type and size?	X			Tag(s) to use: <u>NB63283</u> Tag(s) used: <u>NB63283</u>	
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				
Visual Inspection performed and product meets requirements?	X				
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) 8-3 25' TAPE 7/30/2019 7/30/2020 M60 1" MIC 8/13/2019 8/13/2020 ST-5 STEP GAUGE 7/1/2019 7/1/2020 63294 MEASURING TABLE 4/24/2019 4/24/2020	
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) FOP081 2/16/01 1	
Hardcopy Controlled Documents are listed on Quality Intranet by location?	X			List Documents and their Location: SMT-SRB-001 JM-OP-001 SMT-SH-001	

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 76109 Coil Number: NB63283

Customer Number: ALTEC Coil Information: NUB2910713 Supplier: NUCOR BERKLEY

Product: Steel Nov-21-19 18:32 to 19:29 (clock 57.0 min/ run 41.8 min) Shift: 2

Average Thickness and Tolerance Data

Target	62.5 mil	Average^	57.0 mil	Average - Target	-5.5000 mil (-8.80%)
				Standard Deviation^	0.3100 mil (0.50%)
Length	2615 ft	Above High Limit	69.5 mil		0 ft (0.0%)
Width	48.000 in	In Tolerance			2615 ft (100.0%)
Weight	24383 lbs	Below Low Limit	55.5 mil		1 ft (0.0%)
Max Thickness	57.8 mil at	983 ft	Min Thickness	55.6 mil at	89 ft

Statistical Process Control Data

Upper Control Limit	57.9 mil	Upper Tolerance Limit	69.5 mil
X Double Bar	57.0 mil	R Bar	0.9 mil
Lower Control Limit	56.1 mil	Lower Tolerance Limit	55.5 mil

CR 13.3% (Capability Ratio %, 100/CP)

CP 7.527 (Process Capability, HiLim-LoLim/6*Sigma)

CPK 1.613 (Capability vs Limits) TMW Ratio 0.974 (Low Limit/Avg)

Thickness Distribution Relative to the Target

+++	0.0%
+10.0	0.0%
+ 9.0	0.0%
+ 8.0	0.0%
+ 7.0	0.0%
+ 6.0	0.0%
+ 5.0	0.0%
+ 4.0	0.0%
+ 3.0	0.0%
+ 2.0	0.0%
+ 1.0	0.0%
+ 0.0	0.0%
--1.0	0.0%
--2.0	0.0%
--3.0	0.0%
--4.0	0.0%
--5.0	4.8% *****
--6.0	90.2% *****>
--7.0	4.9% *****
--8.0	0.0%
--9.0	0.0%
-10.0	0.0%
---	0.0%

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

0.0% is within ± 2.0000 mil of the target 4.8% is within ± 5.0000 mil of the target
100.0% is within ± 10.0000 mil of the target 100.0% is within ± 20.0000 mil of the target

Thickness vs Length (Coil Number NB63283)

