

Process/Product Audit Checklist

Cust #: 1913 Customer: PRINCE GRP/Size/GRD/Width: GVS/.035/CB90CD/48				
<div style="text-align: right; font-size: small;">CACT001A CACT010A CACT011A</div> PWC: SRB W/O#: 76161 Date: 11/22/2019 Part #(s): Auditor: B. CLEM				
Gauge Range: .0335-.0396 Actual Gauge: .035 Width Range: 48-48.1875 Width Actual: 48.107				
Length Range: 60-60.125 Length Actual: 60.027 Lth Other: 48-48.125 Other Actual: 48.034				
Lth Other: 39.875-40.125 Other Actual: 40.029 SQ 0-.25 W-B-F 0-.12 Other Actual: SQ .007 W-B-F LESS .12				
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			Sam J.
Correct raw material type and size?	x			Tag(s) to use: <u>540273</u> Tag(s) used: <u>540273</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			Width a little high toward the end of the coil but was ok'd by Quality
Non-conforming material put into reject warehouse and physically put into non-conforming area?		x		High width ok'd by Quality
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 M50 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

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 76161 Coil Number: 540273

Customer Number: PRINCE Coil Information: NUB2913293 Supplier: NUCOR BERKELEY

Product: Steel Nov-22-19 8:16 to 10:28 (clock 131.4 min/ run 53.8 min) Shift: 1

Average Thickness and Tolerance Data

Target	36.0 mil	Average^	35.7 mil	Average - Target	-0.3000 mil (-0.83%)
				Standard Deviation^	0.3300 mil (0.92%)
Length	3624 ft	Above High Limit	39.0 mil	0 ft (0.0%)	
Width	48.000 in	In Tolerance		3624 ft (100.0%)	
Weight	21166 lbs	Below Low Limit	33.0 mil	0 ft (0.0%)	
Max Thickness	36.5 mil at	9 ft	Min Thickness	34.9 mil at	424 ft

Statistical Process Control Data

Upper Control Limit	36.7 mil	Upper Tolerance Limit	39.0 mil
X Double Bar	35.7 mil	R Bar	1.0 mil
Lower Control Limit	34.7 mil	Lower Tolerance Limit	33.0 mil

CR 33.0% (Capability Ratio %, 100/CP)

CP 3.030 (Process Capability, HiLim-LoLim/6*Sigma)

CPK 2.727 (Capability vs Limits) TMW Ratio 0.924 (Low Limit/Avg)

Thickness Distribution Relative to the Target

+++	0.0%
+ 5.0	0.0%
+ 4.5	0.0%
+ 4.0	0.0%
+ 3.5	0.0%
+ 3.0	0.0%
+ 2.5	0.0%
+ 2.0	0.0%
+ 1.5	0.0%
+ 1.0	0.0%
+ 0.5	0.4% *
+ 0.0	23.0% *****
--0.5	54.2% *****>
--1.0	22.2% *****
--1.5	0.1%
--2.0	0.0%
--2.5	0.0%
--3.0	0.0%
--3.5	0.0%
--4.0	0.0%
--4.5	0.0%
--5.0	0.0%
---	0.0%

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

99.9% 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 540273)

