Process/Product Audit Checklist

Cust #: 7447 Customer: MTD martin GRP/Size/GRD/Width: POS .1196 DSB 69

PWC: SRB W/O#: 70799 Date: 11-27-18 Part #(s): 0003-0112-69000 Auditor: B. Clem

Gauge Range: .1120-.1256 Actual Gauge: .114 Width Range: 68.95-69.05 Width Actual: 69.000

Length Range: 39.70 – 39.80 Length Actual: 39.758 Other: wt/skid 4000 lbs. Other Actual: 3830 lbs.

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?	✓			1st - James 2nd - mike B.
Correct raw material type and size?	✓			Tag(s) to use: NB60357 Tag(s) used: NB60357
Setup performed according to W/O?	✓			
Product is acceptable according to customer-specific requirements? [<u>Fab:</u> Is the Part Print Present & the correct Revision? Are required measurements documented?]	✓			Flatness not specified on Work Order. Patrick ok'd up to .25 [<u>Fab:</u> Print Rev:____, W/O Rev:____, Part Spec Rev:____] (Leave blank if non-Fab audit)
Packaging is acceptable according to customer-specific requirements?	✓			
Visual Inspection performed and product meets requirements?		✓		Light Coil Breaks ok'd by Patrick. Could see but not feel.
Out of spec noted, with actions taken?	✓			Flatness ok'd by Patrick up to .25
Non-conforming material put into reject warehouse and physically put into non-conforming area?		✓		
Required gages available & functional?	✓			
All Gages Calibrated (List in Comments)	✓			Gages Observed (list last calibration and when due) 8-3 25' Tape 3-30-18 3-30-19 m-50 1" mic 8-31-18 8-31-19 ST-5 Step Gauge 7-5-18 7-5-19 63394 meas. Table 4-20-18 4-20-19
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	✓			
Required PPE being worn?	✓			
Forms are the latest revision per Quality Intranet?	✓			List Forms (Observed Rev vs Intranet Rev) FOP081 2-16-01 1
Hardcopy Controlled Documents are listed on Quality Intranet by location?	✓			List Documents and their Location: SMT-SRB-001 JM-OP-001

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 70799 Coil Number: NB60357

Customer Number: MARTIN Coil Information: NUB2816895 Supplier: NUCORBERKELY

Product: Steel Nov-27-18 12:43 to 14:18 (clock 94.4 min/ run 30.1 min) Shift: 2

Average Thickness and Tolerance Data

Average^ 115.3 mil	Average - Target	-3.7200 mil	(-3.[illegible])
	Standard Deviation^	0.6800 mil	(0.[illegible])
	Above High Limit 126.0 mil	0 ft	([illegible])
	In Tolerance	1765 ft	(100.[illegible])
	Below Low Limit 112.0 mil	0 ft	(0.[illegible])

[illegible] [illegible].8 mil at 1586 ft Min Thickness 112.7 mil at 1739 [illegible]

Statistical Process Control Data

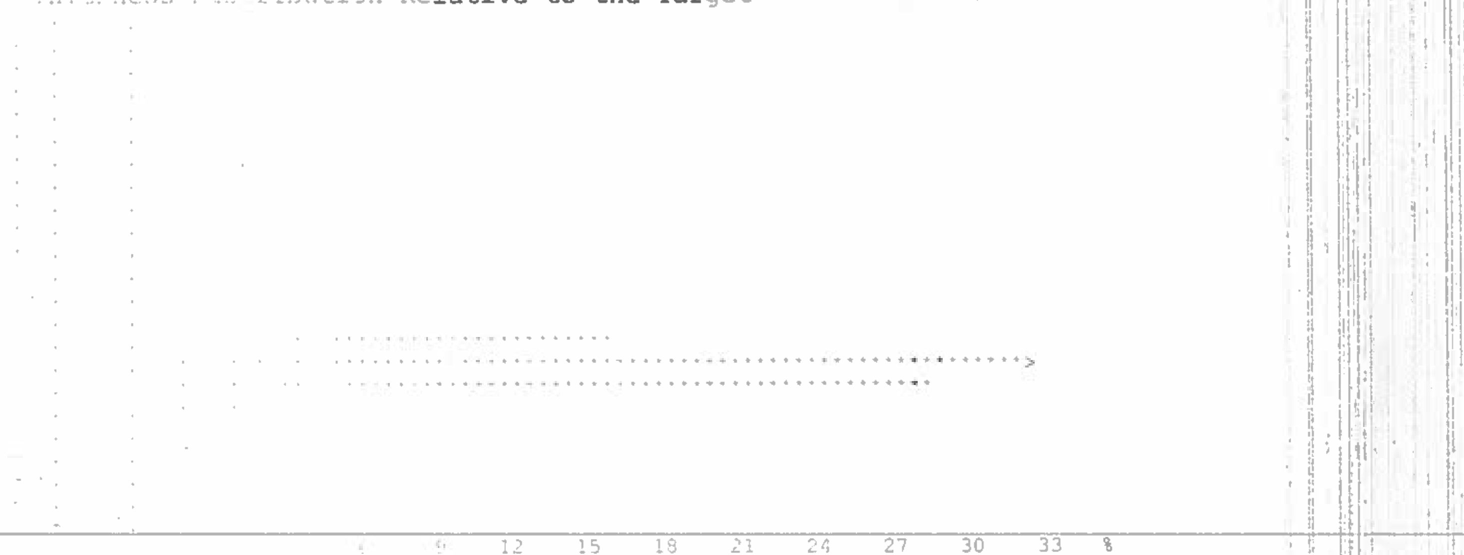
[illegible]	117.3 mil	Upper Tolerance Limit	126.0 mil
[illegible]	115.3 mil	R Bar	2.0 mil
[illegible]	113.2 mil	Lower Tolerance Limit	112.0 mil

[illegible] (Capability Ratio %, 100/CP)

[illegible] (Process Capability, HiLim-LoLim/6*Sigma)

[illegible] (Capability vs Limits) TMW Ratio 0.972(Low Limit/Avg)

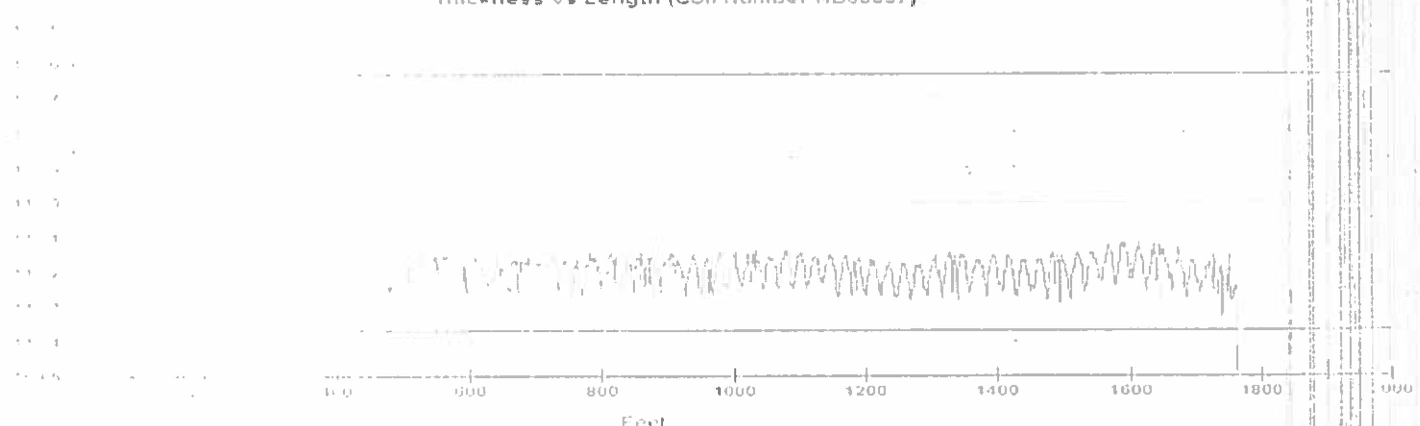
Thickness Distribution Relative to the Target



[illegible] mil of the target 96.8% is within ± 5.0000 mil of the target

[illegible] mil of the target 100.0% is within ± 20.0000 mil of the target

Thickness vs Length (Coil Number NB60357)



Coil Thickness Gauging System by Advanced Gauging Technologies, L.L.C. Plain City, OH 43064 USA Tel:(614) 873-6691