

Process Audit Summary:

11/05/15 Sumter Cut to Length Job# 58822

Performed by: Beverly Clem

Leveling job to produce 48" X 96" length sheets for Prince Manufacturing from master tag 491037.

All procedural coil identification checks followed.

Five 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-CTL-001 procedure and recorded on the FOP 081 in excess of required intervals. Measurements were performed with micrometer M-50, 25' tape 03-03, Step gauge ST-5, and flatness table 63294. All measurements fell within customer tolerances.

No follow up required.

Measuring tools:

Micrometer- M50 last calibration 3/10/15 calibration due 3/10/16

Tape 25'-0303 last calibration 10/29/15 calibration due 10/29/16

Step gauge-ST-5 last calibration 7/7/15 calibration due 7/7/16

Flatness table-63294 last calibration 4/20/15 calibration due 4/20/16

Controlled documents:

FOP 081 rev date 2/16/01

SMT-CTL-001 rev date 6/13/12

Part Spec/PO Audit Form

Cust #	1913	Customer	PRINCE MANUFACTURING			Grp/Sz/Grd/Wdth	CRS/0.0747/CSB/48.0000		
Equip/Plant	SCT	Work Order #	58822	Date	11/5/2015	Part No.	CABC018A		
Work Order Information						Actual			
		Tag #1	491037	Tag #2		Gauge #1	.070 .070 .070	Gauge #2	
		PO#	016114-001	PO#		% Gauge In Spec	100%	% Gauge In Spec	
Gauge Range	0.0697 - 0.0797	Gauge Min	0.0747	Gauge Min		Low/High Gauge	.070/.070	Low/High Gauge	
Width Range	48.0000 - 48.1875	Width	48.0000	Width		Average	0.07	Average	
Length Range	96.0000 - 96.2500					Width	48.1000	Width	
Rockwell	N/A	Rockwell	N/A	Rockwell		Length	96.1875	Length	
Tensile	N/A					Rockwell	N/A	Rockwell	
Yield	N/A					W-B-F	> .180		
% Elongation	N/A					SQ	0.125		
Chem Rqmts	N/A								
Other Rqmts	N/A								
W-B-F	0.00 - 0.18					Other			
SQ	0.00 - .25								
Summary									
Actions									
Final Status									