

Process/Product Audit Checklist

Cust #: 3410		Customer: Doosan		GRP/Size/GRD/Width: GNS/.0785/CB40NO/60	
PWC: SRB		W/O#: 83459		Date: 11/9/2021	
		Part #(s): 54494745		Auditor: B. Clem	
Gauge Range: .0685-.0865		Actual Gauge: .0685		Width Range: 60-60.250	
				Width Actual: 60.058	
Length Range: 120-120.125		Length Actual: 120.060		W-B-F	
SQ		Other: 0-.12		Other Actual: Less .12	
Other: 0-.25		Other Actual: .030		Other: Residual Stress	
				Other Actual: Good	
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: NB69547 Tag(s) used: NB69547	
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 10/18/2020 10/18/2021 M50 1" Mic 1/8/2021 1/8/2022 ST-4 Step Gauge 6/21/2021 6/21/2022 Measuring Table 7/8/2020 4/30/2022	
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	



Material Inspection Report

LOCATION

Sumter

DATE

12/21/2021

CUSTOMER

DOOSAN

JOB # SMT

83459

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	Order Dim		Tolerances		Tolerances		Low Limit		High Limit
Gauge	0.067	-	-0.001	+	0.019		0.068		0.086
Width	60.000	-	0.000	+	0.250		60.000		60.250
Length	120.000	-	0.000	+	0.125		120.000		120.125

	Set up Target		Side Type		Skid Type Error		Skid Code	
Gauge	0.077				SOPS			
Width	60.125							
Length	120.063							
			JDOP008		JDOP016		JDOP046	
			JDOP014		JDOP034		JDOP032	

Finished Goods Tag	163493	163500						
Master Coil Number	NB69547							
Heat								
Enhanced Weight								
Gross Weight	3015	3015	1170					
Tare	205	205	180					
Net Weight	2810	2810	990	0	0			
Bundle Status								
Good Pcs.	20	20	7					
Scraped Pcs.								
Rockwell								
Gauge Head	E 0.067	L 0.068						
	C 0.068	0.069						
	E 0.068	0.068						
Body	E							
	C							
	E							
Tail	E							
	C							
	E							
Surface								
Width Head	60.058	60.040						
Body								
Tail								
Shape	0.000							
Residual Check	GOOD							
Length Head	120.060	120.060						
Body								
Tail								
Squareness	.03							
Camber								
Operator	CD							
Setup Approval								
Run Time	S	F	Down Time	S	F			
Total Run Time	0:00	Cost	\$0.00	Cst/Hour	\$400.00			
Comments								