

Process/Product Audit Checklist

Cust #: <u>3337</u> Customer: <u>Eaton-MX</u> GRP/Size/GRD/Width: <u>POS/0.0730/CSBTP/60.25</u>				
PWC: <u>BB1</u> W/O#: <u>194665</u> Date: <u>11/8/2024</u> Part #(s): <u>47-63707-14</u> Auditor: <u>B. Clem</u>				
Gauge Range: <u>.066 - .073</u> Actual Gauge: <u>.071</u> Width Range: <u>60.25 - 61.2499</u> Width Actual: <u>60.626</u>				
Length Range: <u>120.625 - 120.8125</u> Length Actual: <u>120.75</u> Wave Other: <u>0 - .12</u> Other Actual: <u>Less .12</u>				
Flatn Other: <u>0 - .06</u> Other Actual: <u>Less .06</u> Square Other: <u>0 - .37</u> Other Actual: <u>.187</u>				
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			None
Correct raw material type and size?	x			Tag(s) to use: <u>82668</u> Tag(s) used: <u>82668</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	Not present for packaging
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) 015 - Mic 4/24/2024 4/24/2025 ST 10 Step Gage 9/26/2024 9/26/2025 T231 25' Tape 1/5/2024 1/5/2025 T232 25' Tape 1/5/2024 1/5/2025
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) DEC-BB1-CTL
Hardcopy Controlled Documents are listed on Quality Intranet by location?	x			List Documents and their Location: DEC-CTL-001A CTL DEC-CTL-001B CTL DEC-CTL 003



PRODUCTION REPORT

PAGE 1 OF 1

JOB WORK ORDER NO.	DATE	MACHINE	SHIFT	MASTER COIL NO.	Yield Strength	<i>Expo w</i>	
194665	11/8	881	1 ST	82668	658	GA MIN	MAX WAVE
OPERATOR	RUN HOURS	Burr Msmt(s)	Head Scrap	Tail Scrap	GA MAX	MAX SQUARE	KEYED BY
<i>Wade Hany</i>	9:54-9:35		20'	10'	.0660	.06	CKD. BY

Minimum Inspection Frequency:
 (Unless otherwise specified on the Work Order/Part Spec)
 CHECK PIECE ONCE LINE RUN IS ESTABLISHED + PIECE AT MIDPOINT
 OF RUN + LAST PIECE OF RUN

FINISHED GOODS TAG NO.	PCS Required	PCS Actual	Width Actual	Length Entered	Length Actual	Gauge Actual	Wave/Bow Actual	Square Actual	Weight	Comments
970455	33	33	100.625	120.937	120.75	.071	.725	187	4934	
56	33	33					1			
57	33	33					.062			
58	33	33					1	187		
59	33	33	100.687		120.75	.070	.062	197		
60	33	33					1			
61	33	33					.062			
62	28	23	100.657		120.75	.071	1	125	3439	

08Nov24 10:37

J O B W O R K O R D E R
(R E P R I N T)

GAD 19466

Jemison Metals - Gadsden
3001 Hickory Street
Gadsden, AL 35902
Tel: 800-235-1086 Fax: 205-986-6604

Job Type LEV Process PWC BB1
Metric N Cust
Desc EATON MX-14
Due Date 07Dec24 Whs DFG
Setup 00:00 Run 01:30 Prtd By declin

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<<< JOB SPECIFICATIONS >>>

Group POS Grade CSBTP Gauge 0.0730 (0.0730 to 0.0730) ID 0.0000

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<<< ORDER SPECIFICATIONS >>>

F 01 POS/14/CSBTP/60.2500"X120.62/.0730N CS TYPE B TEMP PASS
Part 3337/47-63707-14 Ga 0.0730 Wth 60.2500 Lth120.6250
Ga Rng 0.0660to 0.0730 Pc/Tag
WthTol + 0.9999 - 0.0000 Wt/Skd 5000
LthTol + 0.1875 - 0.0000 Ty JD6 Pk
WAVE:0.00-.12 FLATN:0.00-.06 SQUA:0.00-.37

Eaton processing instructions for Decatur
Check first sheets to get Material in spec
Cut 36" to 40" sample every 2 bundles and check on
flatness table, flip sample over repeat check.
Last bundle must be checked on every order
Any material that you cannot see the .125 on the s
tep gage must be put in reject
Frequency for visual flatness checks to be dictate
d by frequency of square checks on document DEC-PK
G-001. Adjust leveler set up if needed based on t
hese checks

Stretch Required, Laser Flatness, Residual Stress
Critical, Min Stretch is 1.5 inches,
Aim Stretch is 1.7 - 2.0 inches

Operator Initials_____

Actual Stretch Length_____

INSPECT SAMPLE SURFACE FOR NONCONFORMITY TOP AND B
OTTOM.

USE INDUSTRIAL GRAY COLOR SPRAY PAINT TO VERIFY AN
Y POTENTIAL SURFACE ISSUES.

PACKERS TO CHECK SURFACE ON TOP SHEET ON EVERY SKI
D PRIOR TO PUTTING PAPER ON TOP OF SHEET. DOCUMEN
T EACH SKID CHECKED BY INITIALLING NEXT TO TAG NUM
BER ON PRODUCTION REPORT DOCUMENT # DEC-BB1 CTL PR
ODUCTION REPORT.

step gage must be put in reject

Frequency for visu

Jemison Metals - Gadsden

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al flatness checks to be dictated by frequency of square checks on document DEC-PKG-001. Adjust leveler set up if needed based on these checks.

Stretch Required, Laser Flatness, Residual Stress Critical, Min Stretch is 1.5 inches, Aim Stretch is 1.7 - 2.0 inches
Operator Initials _____

Actual Stretch Length _____

"Cut a 40" sample from head and middle of coil to check underside for roll marks"

HEAT TREATED SKIDS FOR SHIPMENT TO MEXICO

utilize adhesive sleeves for tags

Stretch Required, Laser Flatness
Residual Stress Critical

-both sides surface critical-see picture at operator station

-Clean leveler, feed and steering roll before running. Lightly grind if needed

PLACE TAG ON THE LEFT CORNER OF THE SKID FACING THE FORKLIFT AS YOU LOAD THE TRAILER

"Any visual surface issues found during inspection must be reviewed by Justin Pate or Brian Smith before further processing."

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<<< PROCESSING INSTRUCTIONS >>>

<Step 1>
Level To: 60.2500 X 120.6250 259 Pcs 39021 LBS 999 Pcs/Tag

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<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<POC/14/CSBTP>								
82668	DPW	0.0690M	60.2500		1	39021	MTLA072176	B23R4
		Rmks: EATON-MEXICO						

Total: 1 39021

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<<< MATERIAL TO STOCK >>>

Cons Tg

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J O B W O R K O R D E R
(R E P R I N T)

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Spc Prod Tg Whs Ty Gauge Width Length OD PCS<Prn>Wt PCS<Res>W
82668
1 970455 DFG F 0.0730 60.2500 120.6250 33 4865
1 970456 DFG F 0.0730 60.2500 120.6250 33 4865
1 970457 DFG F 0.0730 60.2500 120.6250 33 4865
1 970458 DFG F 0.0730 60.2500 120.6250 33 4865
1 970459 DFG F 0.0730 60.2500 120.6250 33 4865
1 970460 DFG F 0.0730 60.2500 120.6250 33 4865
1 970461 DFG F 0.0730 60.2500 120.6250 33 4865
1 970462 DFG F 0.0730 60.2500 120.6250 28 4213
Total: 259 38,268
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<<< JOB RECAP >>>

	PCS	Weight	Scrap	Scrap %	Unactd	Scr %
Material Allocated	1	39,021				
Master Returns						
Returns to Stock						
Work in Process						
Material to be Shipped	259	38,268				
Rejects						
Net Weight to be Produced	259	38,268			753	1.93

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T A G P I C K I N G L I S T
(R E P R I N T)

GAD 19466

Jemison Metals - Gadsden
3001 Hickory Street
Gadsden, AL 35902

Job Type LEV Process PWC BB1
Metric N Cust
Desc EATON MX-14
Due Date 07Dec24 Whs DFG.
Setup 00:00 Run 01:30 Prtd By declin

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<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
82668	DPW	0.0690M	60.2500		1	39021	MTLA072176	B23R4
		Rmks: EATON-MEXICO						
				Total:	1	39021		