

Process/Product Audit Checklist

Cust #: <u>2671</u>		Customer: <u>FHP</u>		GRP/Size/GRD/Width: <u>GV5 0396 1060CP</u>		48
PWC: <u>SIRD</u>		W/O#: <u>72197</u>		Date: <u>12-10-18</u>		Part #(s): <u>251740</u> Auditor: <u>JM</u>
Gauge Range: <u>035-045</u>		Actual Gauge: <u>037</u>		Width Range: <u>48.00-48.125</u>		Width Actual: <u>48.125</u>
Length Range: <u>96.0-96.250</u>		Length Actual: <u>96.125</u>		Other: <u>wt. 3416 lbs</u>		Other Actual: <u>3320 lbs</u>
Other: <u>Per 66</u>		Other Actual: <u>66</u>		Other: <u>N/A</u>		Other Actual: <u>N/A</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			Chris M.		
Correct raw material type and size?	Y			Tag(s) to use: <u>NP 60403</u> Tag(s) used: <u>NP 60403</u>		
Setup performed according to W/O?	Y					
Product is acceptable according to customer-specific requirements? [Fab: Is the Part Print Present & the correct Revision? Are required measurements documented?]	Y			[Fab: Print Rev: _____, W/O Rev: _____, Part Spec Rev: _____] (Leave blank if non-Fab audit)		
Packaging is acceptable according to customer-specific requirements?	Y					
Visual Inspection performed and product meets requirements?	Y					
Out of spec noted, with actions taken?	N/A		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) Tape 8-30 3-30-18 3-30-19 mic M-50 8-31-18 8-31-19 Star Gauge table 63294 7-5-18 7-5-19 4-20-19		
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) <u>FO 1081 2-16-01 1</u>		
Hardcopy Controlled Documents are listed on Quality Intranet by location?	X			List Documents and their Location: <u>SMT - SMD - 001</u> <u>JM. OP - 001</u>		

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 72197 Coil Number: NB60403

Customer Number: FHP Coil Information: NUB2817388 Supplier: NUCORBERKELY

Product: Steel Dec-10-18 17:44 to 19:32 (clock 108.1 min/ run 56.0 min) Shift: 2

Average Thickness and Tolerance Data

39.0 mil	Average^	26.4 mil	Average - Target	-12.6400 mil	(-12.64%)
			Standard Deviation^	11.4200 mil	(29.21%)
9428 ft			Above High Limit	43.0 mil	0 ft (0.0%)
40.000 in			In Tolerance		3688 ft (39.2%)
40656 lbs			Below Low Limit	35.0 mil	5740 ft (6.1%)
37.4 mil at	6982 ft		Min Thickness	2.2 mil at	189

Statistical Process Control Data

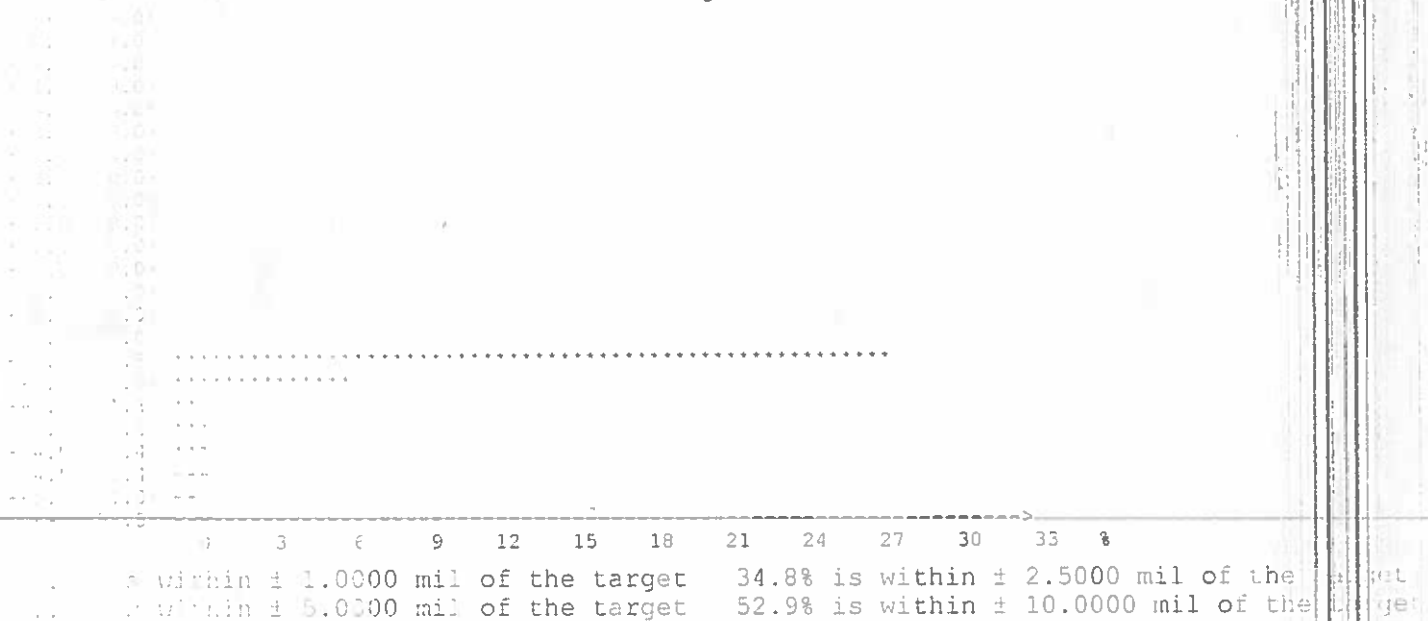
Control Limit	60.6 mil	Upper Tolerance Limit	43.0 mil
R Bar	26.4 mil	R Bar	34.3 mil
Control Limit	0.0 mil	Lower Tolerance Limit	35.0 mil

334.5% (Capability Ratio %, 100/CP)

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

0.252 (Capability vs Limits) TMW Ratio 1.328 (Low Limit/Target)

Thickness Distribution Relative to the Target



Thickness vs Length (Coil Number NB60403)

