Process/Product Audit Checklist

Cust #: 2719 Customer: Altec GRP/Size/GRD/Width: GNS .1084 CB40NO60				
PWC: SRB W/O#: 63646 Date: 12-8-16 Part #(s): 970061512 9703801216 Auditor: B. Clem				
Gauge Range: .0974 - .1174 Actual Gauge: .098 Width Range: 60 - 60.9999 Width Actual: 60.107				
Length Range: 120 - 120.1250 Length Actual: 120.050 Other: 159 - 159.1250 Other Actual: 159.030				
Other: Fltn 0 - .12 Other Actual: 0.125 Other: Wght. 5312 lbs. Other Actual: 5015 lbs.				
Item	**YES**	**NO**	**N/A**	**Comments/Action Taken (Required for NO)**
Process Inspection Sheets filled out according to frequency and sampling required?	✓			Laquwon & Sam
Correct raw material type and size?	✓			Tag(s) to use: 504444 Tag(s) used: 504444
Setup performed according to W/O?	✓			
Product is acceptable according to customer-specific requirements? [Fab: Is the Part Print Present & the correct Revision? Are required measurements documented?]	✓			[Fab: Print Rev: N/A, W/O Rev: N/A, Part Spec Rev: N/A] (Leave blank if non-Fab audit)
Packaging is acceptable according to customer-specific requirements?	✓			
Visual Inspection performed and product meets requirements?	✓			
Out of spec noted, with actions taken?			✓	
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) T-3 25' Tape 7-21-16 7-21-17 M-44 1" mic 6-28-16 6-28-17 ST-5 Step Gauge 7-5-16 7-5-17 63294 Meas. Table 4-26-16 4-26-17
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) SMT-SRB-001 11-8-16 4 SMT-SH-001 10-26-11 0 JM-OP-001 4-21-15- 0 FOP081 2-16-01 1
Hardcopy Controlled Documents are listed on Quality Intranet by location?			✓	List Documents and their Location:

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 63646 Coil Number: 504444

Customer Number: ALTEC Coil Information: NUB1614408 Supplier: NUCOR BERKLEY

Product: Steel Dec-8-16 18:00 to 18:49 (clock 49.3 min/ run 16.7 min) Shift: 2

Average Thickness and Tolerance Data

```
Target  0.1074 in    Average^ 0.0993 in     Average - Target     -0.0081 in (-7.54
                                            Standard Deviation^   0.0005 in ( 0.49

Length      1078 ft              Above High Limit    0.1174 in         0 ft (  0.0
Width     60.000 in              In Tolerance                       1078 ft (100.0
Weight     21881 lbs             Below Low Limit     0.0974 in         0 ft (  0.0

Max Thickness  0.1006 in at    382 ft        Min Thickness  0.0974 in at    789 ft
```

Statistical Process Control Data

```
Upper Control Limit    0.1009 in    Upper Tolerance Limit      0.1174 in
X Double Bar           0.0993 in    R Bar                      0.0016 in
Lower Control Limit    0.0977 in    Lower Tolerance Limit      0.0974 in

CR    15.9% (Capability Ratio = 100/CP)
CP    6.289  (Process Capability, HiLim-LoLim/6*Sigma)
CPK   1.195  (Capability vs Limits)          TMW Ratio      0.981(Low Limit/Avg)
```

Thickness Distribution Relative to the Target

```
    +++    0.0%
+0.0100    0.0%
+0.0090    0.0%
+0.0080    0.0%
+0.0070    0.0%
+0.0060    0.0%
+0.0050    0.0%
+0.0040    0.0%
+0.0030    0.0%
+0.0020    0.0%
+0.0010    0.0%
+0.0000    0.0%
-0.0010    0.0%
-0.0020    0.0%
-0.0030    0.0%
-0.0040    0.0%
-0.0050    0.0%
-0.0060    0.0%
-0.0070    1.3% ***
-0.0080   46.8% **********************************************************************>
-0.0090   47.6% **********************************************************************>
-0.0100    4.4% *********
    ---    0.0%
            0     3     6     9    12    15    18    21    24    27    30    33    36

  0.0% is within ± 0.0020 in of the target     0.0% is within ± 0.0050 in of the target
100.0% is within ± 0.0100 in of the target   100.0% is within ± 0.0200 in of the target
```

Thickness vs Length (Coil Number 504444)