

Process Audit Summary:

12/28/15 Sumter Cut to Length Job# 59416

Performed by: Beverly Clem

Leveling job to produce 48" X 96" and 48" X 120" length sheets for Container Products from master tag NB48045.

All procedural coil identification checks followed.

Two skids produced at 48" X 120" and 2 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) and shape checks (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, Step gauge ST-5, 25' tape-8-3 and flatness table 63294. All procedural checks fell within customer tolerances.

No follow up required.

Measuring Tools:

Micrometer – M-50 last calibration 3/10/15 calibration due 3/10/16

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

Flatness table – last calibration 4/20/15 calibration due 4/20/16

25' Tape – last calibration 12/22/15 calibration due 12/22/16

Controlled Documents:

SMT-CTL-001 Cut To Length Line Procedure REV 3 – 6/13/12

FOP 081 Cutline/Shear Inspection REV 1 – 2/16/01

JM-OP-001 Tagging Procedure REV 0 – 4/21/15

Part Spec/PO Audit Form

Cust #	1822	Customer	CONTAINER PRODUCTS		
Equip/Plant	SCT	Work Order #	59416	Date	12/28/2015
Work Order Information					
		Tag #1	NB48045	Tag #2	
		PO#	017452-001	PO#	
Gauge Range	0.1713 - 0.1873	Gauge Min	0.1710	Gauge Min	
Width Range	48.0000 - 48.9990	Width	48.0000	Width	
Length Range	120.0000-120.1250/96.0000-96.1250				
Rockwell	N/A	Rockwell	N/A	Rockwell	N/A
Tensile	N/A				
Yield	N/A				
% Elongation	N/A				
Chem Rqmts	N/A				
Other Rqmts	N/A				
W-B	0.00 - .12				
SQ	0.00 - .06				
Summary					
Actions					
Final Status					

Part Spec/PO Audit Form

Grp/Sz/Grd/Wdth	HRS/0.1793/SS36-1/48.000/96.0000		
Part No.	7GA X 48 X 120/7GA X 48 X 96		
Actual			
Gauge #1	.174 .175 .176	Gauge #2	.175 .176 .176
% Gauge In Spec	100%	% Gauge In Spec	100%
Low/High Gauge	.174/.176	Low/High Gauge	.175/.176
Average	0.175	Average	0.1755
Width	48.8750	Width	49.0000
Length	120.0000	Length	96.0000
Rockwell	N/A	Rockwell	N/A
W-B	> .12	W-B	> .12
SQ	> .06	SQ	> .06
Other			