

Process/Product Audit Checklist

Cust #: 3031		Customer: INNOVATED		GRP/Size/GRD/Width: CRC/12L/CSB/48	
PWC: LRB		W/O#: 28453		Date: 12/12/2022	
		Part #(s): 12GACRS48X96		Auditor: NATHAN RAGLAND	
Gauge Range: 0.0986-0.1106		Actual Gauge: 0.0993		Width Range: +0.250/-0.000 Width Actual: 48.0625	
Length Range: +0.125/-0.000		Length Actual: 120.0625		Other: N/A Other Actual: N/A	
Other: N/A		Other Actual: N/A		Other: N/A Other Actual: N/A	
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				
Correct raw material type and size?	X			Tag(s) to use: NB16895 Tag(s) used: NB16895	
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) MIC-02 9/22 - 12/22 TP-04 9/22 - 12/22	
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) LYN-LRB-001 Rev. 1	
Hardcopy Controlled Documents are listed on Quality Intranet by location?			X	List Documents and their Location:	

AGT400 Coil Summary Report

Jemison Metals - 72 Red Bud Multi-Blanking

Work Order: 28453 Coil Number: 16895

Customer Name: INNOVATED Heat Number: 2215898 Vendor: NUB

Product: Cold-Rolled Steel Dec-12-22 10:26 AM to 10:57 AM (clock 30.7 min/ run 10.9 min) Shift: 1

Average Thickness and Tolerance Data

Target 0.1046 in Average* 0.0993 in Average - Target -0.0054 in (-5.12%)
Standard Deviation* 0.0004 in (0.40%)

Length 400 ft Above High Limit 0.1106 in 0 ft (0.0%)
Width 48.000 in In Tolerance 376 ft (93.9%)
Weight 6497 lbs Below Low Limit 0.0986 in 25 ft (6.1%)

Max Thickness 0.1002 in at 100 ft Min Thickness 0.0979 in at 261 ft
Head Scrap 0 ft Tail Scrap 0 ft

Statistical Process Control Data

Upper Control Limit 0.1005 in Upper Tolerance Limit 0.1106 in
X Double Bar 0.0993 in R Bar 0.0013 in
Lower Control Limit 0.0980 in Lower Tolerance Limit 0.0986 in

CR 21.0% (Capability Ratio %, 100/CP)

CP 4.762 (Process Capability, HiLim-LoLim/6*Sigma)

CPK 0.516 (Capability vs Limits) TMW Ratio 0.994 (Low Limit/Avg)

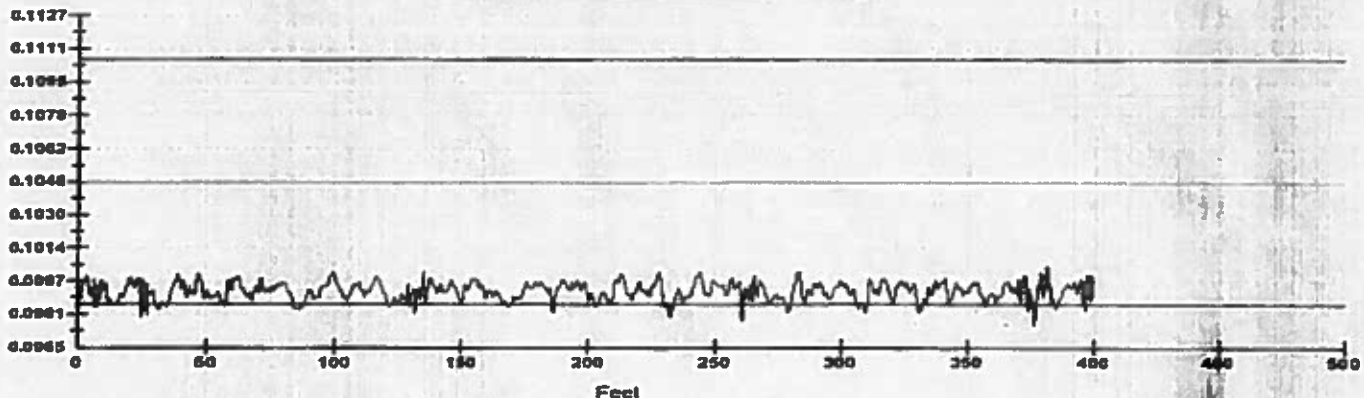
Thickness Distribution Relative to the Target

+++	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	26.9%
-0.0060	66.9%
-0.0070	6.1%
-0.0080	0.0%
-0.0090	0.0%
-0.0100	0.0%
---	0.0%

0 3 6 9 12 15 18 21 24 27 30 33 %

0.0% is within ± 0.0020 in of the target 26.9% 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 16895)



Gauge readings provided by Advanced Gauging Technologies, L.L.C. Plain City, OH 43064 USA Tel: (614) 873-6691