

Process/Product Audit Checklist

Cust #: <u>10</u> Customer: <u>HEIL FAB</u> GRP/Size/GRD/Width: <u>HRS 250 A36 X 60.00</u>				
PWC: <u>G10</u> W/O#: <u>68078</u> Date: <u>12/26/25</u> Part #(s): <u>W126-6789</u> Auditor: <u>Phillip Mathis</u>				
Gauge Range: <u>.215-.263</u> Actual Gauge: <u>.242</u> Width Range: <u>20.57-20.69</u> Width Actual: <u>20.69</u>				
Length Range: <u>143.94-144.06</u> Length Actual: <u>144.00</u> Other: <u>.72-.84</u> Other Actual: <u>.77.5</u>				
Other: _____ Other Actual: _____ Other: _____ Other Actual: _____				
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: <u>23439E</u> Tag(s) used: <u>23439E</u>
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?]	X			[Fab: Print Rev: <u>G</u> , W/O Rev: <u>G</u> , Part Spec Rev: <u>G</u>] (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?				
All Gages Calibrated (List in Comments)	X			Gages Observed (list last calibration and when due) TM050 3/28/25 - 3/28/26 C028 3/28/25 - 3/26/26 M030 3/28/25 - 3/26/26
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	X			
Required PPE being worn?				
Forms are the latest revision per Quality Intranet?	X			List Forms (Observed Rev vs Intranet Rev) JDM -F 014 - JDM -F-014 REV 0
Hardcopy Controlled Documents are listed on Quality Intranet by location?	X			List Documents and their Location: LASER PROCEDURE GAD-LA-001 REV 5 3/21/24 @ OPERATOR WORKSTATION GL9/G10

FABRICATION PRODUCTION REPORT

Laser / Plasma

[illegible]

# of Parts Scrapped (Tally)		DOWNTIME TYPE	DOWNTIME ESTIMATED IN (MINUTES)	OPERATOR COMMENTS / REASON FOR DOWNTIME
		BREAK		
Were there issues?	YES ☐ NO ☐	LUNCH		
Was shift lead notified of issues?	YES ☐ NO ☐	MAINTENANCE		
Were issues resolved?	YES ☐ NO ☐	QUALITY - PART CHECKS		
START TIME	STOP TIME	PROCESS - MATL. HANDLING & MACHINE SETUP		
		ORDER - ALL MACHINE ISSUES & ERRORS		
		ORDER - ALL MACHINE ISSUES & ERRORS		
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Warehouse (GAD) Gadsden		Operator		Job Work Order		
Whs Zone				Job 68078 Date 12/19 10:23 AM		
PWC (G10) Laser 10						
Process (AS-) As-Is						
PROGRAM 40845						
JOB INSTRUCTIONS						
(dimensions in inches, if not specified)						
Dimension		D	Pcs	LBS	Ven Tag	Heat
HR Sheet, A36 SS, -						
60" x 157.5" 0.24-M		3	1,960.5		131596	2 M/25013462
THEO SCRAP 10.00% (196.05 LBS)						
Dimension		Pcs	LBS	SFT		
60" x 157.5" 0.24" -M		3	1,960.50	197		
PLANNED CONSUMPTION						
PLANNED PRODUCTION						
Dimension		Pcs	LBS	SFT	Assign To	Customer/Next Prs
HR Sheet, SS Gr 50, - Part No W126-6789						
20.4277" x 144" Irregular		9	1,764.45		SO-46006-1-1	HEIL ENVIRONMEN(10)
SO-46006-1-1		Gauge	Width	Length	Diag	Ft/tns
		0.235 [0.215 - 0.263"]	[-0.06 +0.06"]	[-0.06 +0.06"]		
SO-46006-1-1 Cond Incl Mill Edge						
PACKAGING						
Customer		Dimension	PCS	LBS	Pc/Pkg	Hgt # Skid/Pkg
HEIL ENVIRONMEN(10)		20.4277" x 144" Irregular	9	1,764.45	10	1
ORDER INFORMATION						
SO-46006 HEIL ENVIRONMEN(10)/0		Customer PO STOCK Sls Cat Sale				
Due 12/29		Process Route {AS-}		PCS 9	SFT 183.85	LBS 1,764.45
1 HR ASTM A1011 - SS Gr 50		196.05/PC				
0.2350" Min x 20.4277" x 144" Irregular						
W126-6789						
Legend: 2 QDS review 12/17/2025 12:29 PM 1						

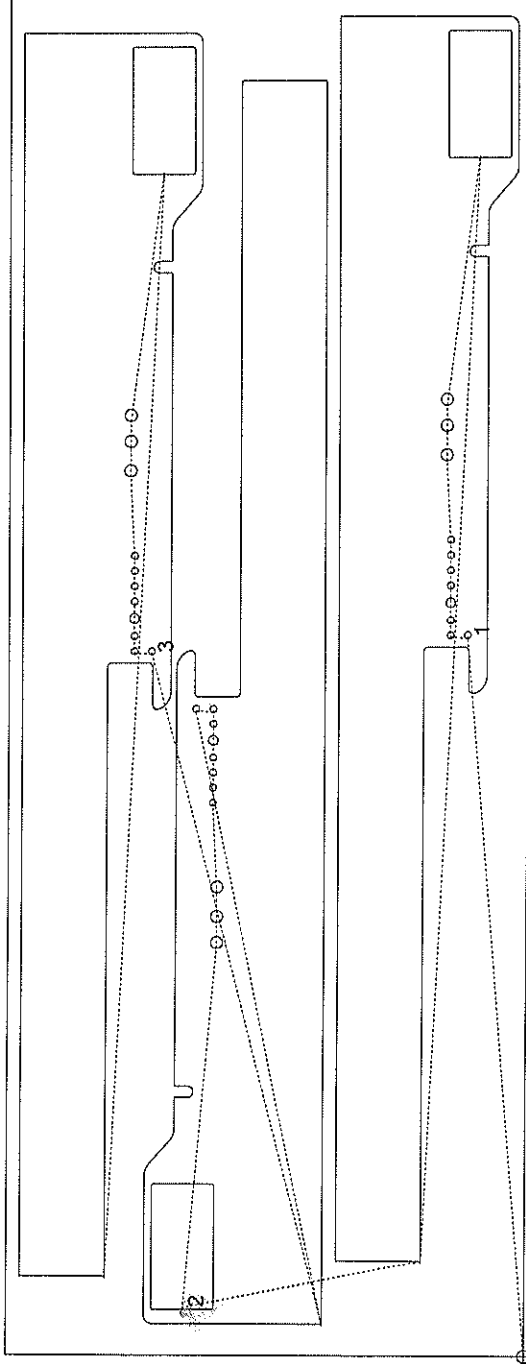


Layout Detail

Machine TRUMPF TruLaser_5040 S

Task Name : W126-6789- 60X157.5 Program Name : 40845

Number of Sheets with Same Layout Stack Quantity	3	True Scrap	37.447	Qty Required	999999	Layout 1 of 1
	1	Rect Scrap	2.795	Qty Nested	3	



Material	MS	Sheet Length	157.500"	Sheet X Used	154.986"	Heat Number	Mill
Thickness	0.250	Sheet Width	60.000"	Sheet Y Used	58.786"	Sheet Location	Prime Code
Sheet Name		Cutting Time	00:16:30	Cutting Length	1257.284"	Bin Number	Parameters NITROGEN
Part ID	Part Name	Qty Req	Qty Nested	Net Weight	Drawing Number	Revision Number	Work Order Number

1	W126-6789	999999	9	135.52lb	HEIL	00:16:30
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(50)10



Layout Report

Task Name : W126-6789- 60X157.5 Program Name :40845

Layout 1 of 1

Number of Sheets with Same Layout : 7

Sheet Parameters**Nesting Task Results**

Material : MS

Thickness : 0.250"

Sheet Length : 157.500"

Sheet Width : 60.000"

Sheet Name :

Bin Number :

Heat Number :

Location :

Mill :

Prime Code :

Sheet X Used : 154.986

Sheet Y Used : 58.786

Plate Used : 97.01%

Plate Recovered : 2.99%

Qty Required : 999999

Qty Nested : 3

Total Cutting Time : 00:16:30

Total Net Weight : 406.574lb

True Scrap : 37.45%

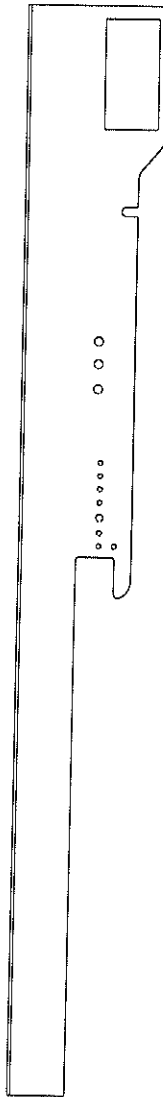
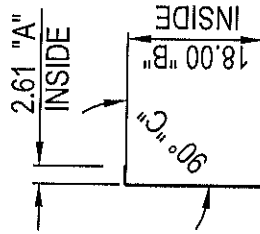
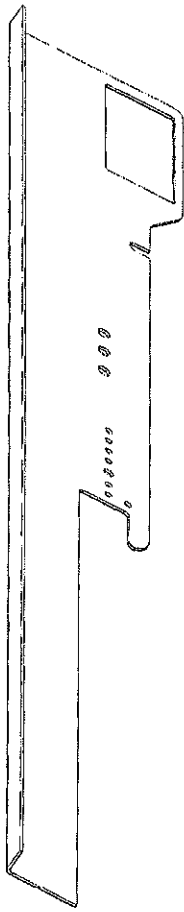
Rectangular Scrap : 2.80%

Total Cutting Length : 1257.284"

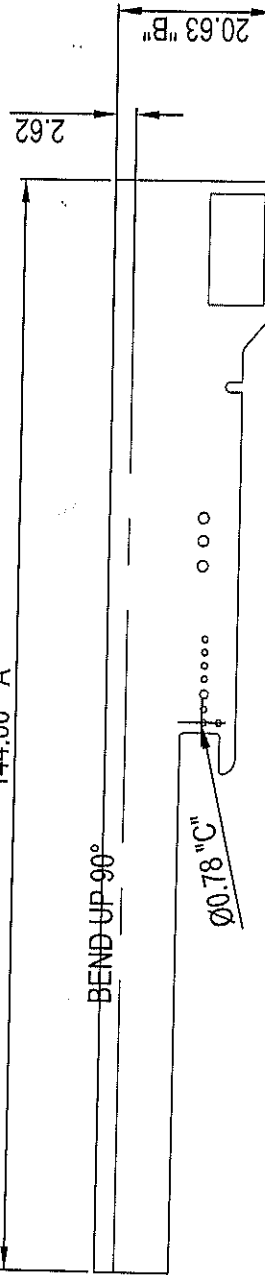
Number of Pierces : 39

Part ID	Part Name	Qty Req	Qty Nested	Net Weight	Drawing Number	Revision Number	Work Order	Customer	Cutting Time
1	W126-6789 Rev	9999	3	135.52				HEIL	00:16:30

JEMISON REVISION		CUSTOMER REVISION	
REV.	DESCRIPTION	DATE	REV.
1			G



NOTE: 90° BEND IS CRITICAL
TO QUALITY AND FITMENT.



FLAT PATTERN

BENT/FORMED FIRST ARTICLES				CUT/BURNT FIRST ARTICLES				TOLERANCES UNLESS OTHERWISE SPECIFIED		JEMISON METALS	
NOMINAL	TOLERANCE	ACTUAL	MTL THICKNESS	NOMINAL	TOLERANCE	ACTUAL	HEIL	LINEAR	TITLE	CUSTOMER	
TOL "A"	2.61	2.55-2.67		.25	.235-.265	0.242		XX = +/- .06	GUIDE TRACK, LH COMMANDER		
TOL "B"	18.00	17.94-18.06	TOL "A"	144.00	143.94-144.06	144.00		XXX = +/- .030	DURAPACK FAMILY 7000		
TOL "C"	90°	89°-91°	TOL "B"	20.63	20.57-20.69	20.69		ANGULAR = +/- 1°	MATERIAL 1/4" HI-TEN PLATE 40-45 KFSI MIN		
TOL "D"	N/A		TOL "C"	.78	.72-.84	0.775		WEIGHT: 133.95	BY CC DATE 4/12/16	SHIT. 1 OF 1	
									PART NO. 126-6789	QUANT. REV.	JUST REV. G