

# Process/Product Audit Checklist

Cust #:	<b>2366</b>	Customer:	<b>ABB SELMER</b>	GRP/Size/GRD/Width:	<b>GNS/1084/CB60CD/48</b>
PWC:	<b>SCT</b>	W/O#:	<b>91954</b>	Date:	<b>12/5/2023</b>
		Part #(s):	<b>CDES3014</b>	Auditor:	<b>B. Clem</b>
Gauge Range:	<b>.097-.1130</b>	Actual Gauge:	<b>.100</b>	Width Range:	<b>48-48.1875</b>
		Width Actual:	<b>48.072</b>		
Length Range:	<b>96-96.1250</b>	Length Actual:	<b>96.062</b>	<b>Lth</b> Other:	<b>100-100.1250</b>
		Other Actual:	<b>100.062</b>		
<b>W-B-F</b> Other:	<b>0-.12</b>	Other Actual:	<b>Less .120</b>	<b>SQ</b> Other:	<b>0-.25</b>
		Other Actual:	<b>.125</b>		
<b>Item</b>	<b>YES</b>	<b>NO</b>	<b>N/A</b>	<b>Comments/Action Taken (Required for NO)</b>	
Process Inspection Sheets filled out according to <u>frequency</u> and <u>sampling</u> required?	<b>X</b>			<b>Marquez</b> <b>Residual Check done as required Less .12</b>	
Correct raw material type and size?	<b>X</b>			Tag(s) to use: <b>NB76813</b> Tag(s) used: <b>NB76813</b>	
Setup performed according to W/O?	<b>X</b>				
Product is acceptable according to customer-specific requirements? [Fab: Is the Part Print Present & the correct Revision? Are required measurements documented?]	<b>X</b>			[Fab: Print Rev:____, W/O Rev:____, Part Spec Rev:____] (Leave blank if non-Fab audit)	
Packaging is acceptable according to customer-specific requirements?	<b>X</b>				
Visual Inspection performed and product meets requirements?	<b>X</b>				
Out of spec noted, with actions taken?			<b>X</b>		
Non-conforming material put into reject warehouse and physically put into non-conforming area?			<b>X</b>		
Required gages available & functional?	<b>X</b>				
All Gages Calibrated (List in Comments)	<b>X</b>			Gages Observed (list last calibration and when due) <b>03-03 25' Tape 11/22/23 11/22/24</b> <b>CL2 25' Tape 1/10/23 1/10/24</b> <b>M50 1" Mic 5/24/23 5/24/24</b> <b>ST-4 Step Gauge 6/28/23 6/28/24</b> <b>63294 Measuring Table 4/26/22 4/26/25</b>	
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	<b>X</b>				
Required PPE being worn?	<b>X</b>				
Forms are the latest revision per Quality Intranet?	<b>X</b>			List Forms (Observed Rev vs Intranet Rev) <b>FOP081 2/16/01 1</b>	
Hardcopy Controlled Documents are listed on Quality Intranet by location?	<b>X</b>			List Documents and their Location: <b>SMT-CTL-001 11/8/16 4</b> <b>SMT-SH-001 10/26/11 0</b> <b>JM-OP-001 4/21/15 0</b>	





# Material Inspection Report

LOCATION

Sumter

DATE

12/5/2023

CUSTOMER

ABB

JOB # SMT

91954

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	Order Dim		Tolerances		Tolerances		Low Limit		High Limit
Gauge	0.098	-	0.001	+	0.015		0.097		0.113
Width	48.000	-	0.000	+	0.187		48.000		48.187
Length	96.000	-	0.000	+	0.125		96.000		96.125

	Set up Target
Gauge	0.105
Width	48.094
Length	96.063

Side Type Skid Type Error

Skid Code	0	2	3

Finished Goods Tag	GE49487	GE494990	GE49491		
Master Coil Number	NB76813	NB76813	NB76813		
Heat	NUB2311454	NUB2311454	NUB2311454		
Enhanced Weight	3966	3966	3966		
Gross Weight	4700	4700	4700		
Tare	150	150	150		
Net Weight	4550	4550	4550	0	0
Bundle Status					
Good Pcs.	28	28	28		
Scraped Pcs.					
Rockwell					
Gauge Head	E	0.101	0.100	0.101	
	C				
	E				
Body	E	0.101	0.101	0.100	
	C				
	E				
Tail	E	0.101	0.101	0.101	
	C				
	E				
Surface					
Width Head	48.069	48.079			
Body					
Tail					
Shape					
Residual Check	0.060	0.060	0.060		
Length Head	96.062	96.062			
Body					
Tail					
Squareness	.125	.125	.125		
Camber					
Operator	MR	MR	MR		
Setup Approval					
Run Time	S 12:00 AM	F 12:00 AM	Down Time	S 12:00 AM	F 12:00 AM
Total Run Time	0:00				
Comments					





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ABB

JOB # SMT

91954

Page 1

	Order Dim		Tolerances		Tolerances		Low Limit		High Limit
Gauge	0.098	-	0.001	+	0.015		0.097		0.113
Width	48.000	-	0.000	+	0.187		48.000		48.187
Length	100.000	-	0.000	+	0.125		100.000		100.125

  

	Set up Target
Gauge	0.105
Width	48.094
Length	100.063

  

Side Type	Skid Type Error
JDOP008	JDOP016
JDOP014	JDOP034
	JDOP046
	JDOP032

  

Skid Code	0	2	4

Finished Goods Tag	249492	249493				
Master Coil Number	NB76813	NB76813				
Heat	NUB2311454	NUB2311454				
Enhanced Weight	3689	3689				
Gross Weight	3405	3405				
Tare	150	150				
Net Weight	3255	3255	0	0	0	
Bundle Status						
Good Pcs.	25	25				
Scraped Pcs.						
Rockwell						
Gauge Head	E 0.100	0.100				
	C					
	E					
Body	E 0.100	0.100				
	C					
	E					
Tail	E 0.100	0.101				
	C					
	E					
Surface						
Width Head	48.072	48.080				
Body						
Tail						
Shape						
Residual Check						
Length Head	100.062	100.062				
Body						
Tail						
Squareness	.125	.125				
Camber						
Operator	MR	MR				
Setup Approval						
Run Time	S	F	Down Time	S	F	
Total Run Time	0:00	Cost	\$0.00	Cst/Hour	\$400.00	
Comments						