

Process Audit Summary:

2/13/15 Sumter Slitter PN 55031,

Performed by: Patrick Macias

Slit job to produce two 8.78" FG mults for GE Mebane and one 12.774" mult to fill out width of 30.834" master, tag 477188.

8.78" mults set up to 8.784"-actual 8.783", 8.782"

12.774" mult set to 12.774" –actual 12.772" (no width tolerance given as this is a BIS to be cut down later)

All procedural identification checks followed.

All procedural dimensional checks (Gauge-width-camber) were done at required intervals and recorded on FOP015. All measurements fell within customer tolerances.

Surface check showed no irregularities.

Follow up: None required.

Part Spec/PO Audit Form

Cust #	1697	Customer	GE Mebane		Grp/Sz/Grd/Width	POC/14F/CSB/8.78"	
Equip/Plant	SLITTER/SMT	Work Order #	55031	Date	2/13/2015	Part No.	B8A3AP358
Work Order Information		Material to be Used		Actual			
		Tag #1	477188	Tag #2		Gauge #1	.087-.087-.085
		PO#	15171	PO#		% Gauge in Spec	100
Gauge Range	.080"-.090"	Gauge Min	.082"	Gauge Min		Low/High Gauge	.0853"/.0889"
Width Range	8.775"-8.785"	Width	30.834"	Width		Average	.0875"
Length Range	NA					Width	8.783"
Rockwell	NA	Rockwell		Rockwell		Length	NA
Tensile	NA					Rockwell	NA
Yield	NA						
% Elongation	NA						
Chem Rqmts	NA						
Other Rqmts	Camber <.125"					Other	Camber-Good
Summary	See attached word document						
Actions	NA						
Final Status	COMPLETE						

AGT400 Coil Summary Report

Jemison Metals -- 60 Inch Pro-Eco Slitter

Work Order: SMT55031 Coil Number: 477188

Customer Name: GE Heat Number: M686087 Vendor: NB

Product: H.R.P.O. Steel Feb-13-15 12:28 to 12:43 (clock 14.6 min/ run 0.2 min) Shift: 1

Average Thickness and Tolerance Data

Target 0.0850 in Average^ 0.0875 in Average - Target 0.0025 in (2.89%)
Standard Deviation^ 0.0012 in (1.45%)

Length 229 ft Above High Limit 0.0900 in 0 ft (0.0%)
Width 30.834 in In Tolerance 229 ft (100.0%)
Weight 2104 lbs Below Low Limit 0.0800 in 0 ft (0.0%)

Max Thickness 0.0889 in at 221 ft Min Thickness 0.0857 in at 79 ft
Head Scrap 0 ft Tail Scrap 0 ft

Statistical Process Control Data

Upper Control Limit 0.0912 in Upper Tolerance Limit 0.0900 in
X Double Bar 0.0875 in R Bar 0.0037 in
Lower Control Limit 0.0838 in Lower Tolerance Limit 0.0800 in

CR 73.8% (Capability Ratio %, 100/CP)
CP 1.355 (Process Capability, HiLim-LoLim/6*Sigma)
CPK 0.688 (Capability vs Limits) TMW Ratio 0.915 (Low Limit/Avg)

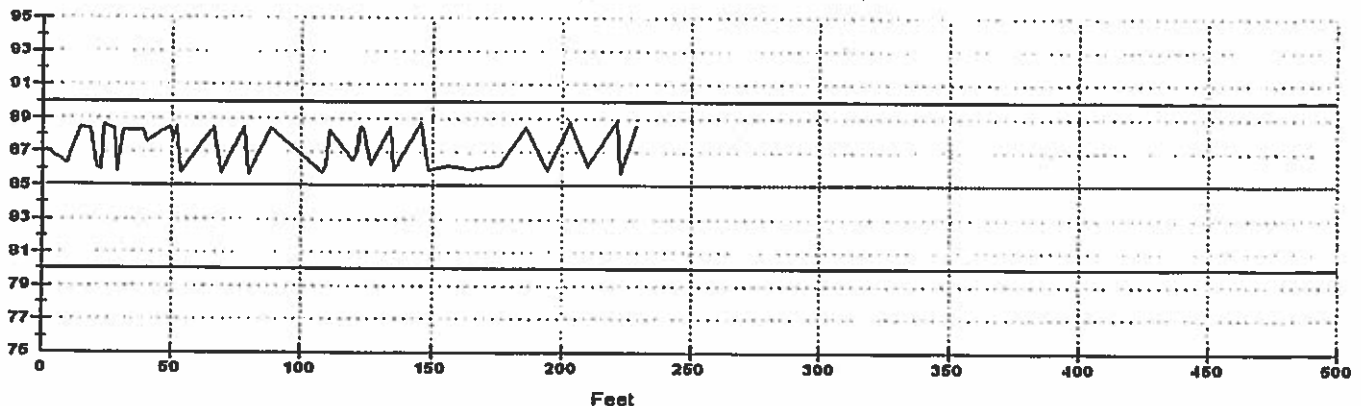
Thickness Distribution Relative to the Target

+++ 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 55.4%
+0.0020 1.7%
+0.0010 25.7%
+0.0000 17.1%
-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 0.0%
-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 %

44.6% is within ± 0.0020 in of the target 100.0% 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 477188)



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