

# Process/Product Audit Checklist

Cust #: <u>1795</u> Customer: <u>BSH</u>		GRP/Size/GRD/Width: <u>GVS.0372 DD30CD 24.6248</u>		
PWC: <u>SRB</u> W/O#: <u>64598</u> Date: <u>2-15-17</u> Part #(s): <u>9001025577</u> Auditor: <u>B. Clem</u>				
Gauge Range: <u>.0356 - .0389</u> Actual Gauge: <u>.036</u> Width Range: <u>24.5933 - 24.6563</u> Width Actual: <u>24.627</u>				
Length Range: <u>26.668 - 26.732</u> Length Actual: <u>26.685</u> Other: <u>Flat</u> Other Actual: <u>24.624</u>				
Width Other: <u>24.5929 - 24.6567</u> Other Actual: <u>24.628</u> Length Other: <u>29.6685 - 29.7315</u> Other Actual: <u>29.703</u>				
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?	<input checked="" type="checkbox"/>			<u>James &amp; Sam J.</u>
Correct raw material type and size?	<input checked="" type="checkbox"/>			Tag(s) to use: <u>NB53468</u> Tag(s) used: <u>NB53468</u>
Setup performed according to W/O?	<input checked="" type="checkbox"/>			
Product is acceptable according to customer-specific requirements? [Fab: Is the Part Print Present & the correct Revision? Are required measurements documented?]	<input checked="" type="checkbox"/>			[Fab: Print Rev: <u>N/A</u> , W/O Rev: <u>N/A</u> , Part Spec Rev: <u>N/A</u> ] (Leave blank if non-Fab audit)
Packaging is acceptable according to customer-specific requirements?	<input checked="" type="checkbox"/>			
Visual Inspection performed and product meets requirements?	<input checked="" type="checkbox"/>			
Out of spec noted, with actions taken?			<input checked="" type="checkbox"/>	
Non-conforming material put into reject warehouse and physically put into non-conforming area?			<input checked="" type="checkbox"/>	
Required gages available & functional?	<input checked="" type="checkbox"/>			
All Gages Calibrated (List in Comments)	<input checked="" type="checkbox"/>			<u>63294 Meas Table 4-26-16 4-26-17</u> Gages Observed (list last calibration and when due) <u>8-3 25' Tape 7-21-16 7-21-17</u> <u>M-44 1" Mic 6-28-16 6-28-17</u> <u>ST-5 Step Gauge 7-3-16 7-3-17</u>
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	<input checked="" type="checkbox"/>			
Required PPE being worn?	<input checked="" type="checkbox"/>			
Forms are the latest revision per Quality Intranet?	<input checked="" type="checkbox"/>			List Forms (Observed Rev vs Intranet Rev) <u>SMT-SRB-001 11-8-16 5</u> <u>Jm-OP-001 4-21-15 0</u> <u>FOP081 2-16-01 1</u>
Hardcopy Controlled Documents are listed on Quality Intranet by location?			<input checked="" type="checkbox"/>	List Documents and their Location:

# AGT400 Coil Summary Report

## JEMISON METALS --

Job Number: 64598 Coil Number: NB53468

Customer Number: BSH Coil Information: NUB2617804 Supplier: NUCORBERKELY

Product: Steel Feb-15-17 12:09 to 13:38 (clock 89.1 min/ run 65.7 min) Shift: 1

### Average Thickness and Tolerance Data

Target	0.0375 in	Average^	0.0371 in	Average - Target	-0.0004 in (-1.04%)
				Standard Deviation^	0.0002 in ( 0.48%)
Length	4496 ft	Above High Limit	0.0390 in		0 ft ( 0.0%)
Width	50.100 in	In Tolerance			4496 ft (100.0%)
Weight	28487 lbs	Below Low Limit	0.0360 in		0 ft ( 0.0%)
Max Thickness	0.0376 in at	640 ft	Min Thickness	0.0361 in at	21 ft

### Statistical Process Control Data

Upper Control Limit	0.0377 in	Upper Tolerance Limit	0.0390 in
X Double Bar	0.0371 in	R Bar	0.0005 in
Lower Control Limit	0.0366 in	Lower Tolerance Limit	0.0360 in
CR	36.0% (Capability Ratio %, 100/CP)		
CP	2.778 (Process Capability, HiLim-LoLim/6*Sigma)		
CPK	2.056 (Capability vs Limits)	TMW Ratio	0.970 (Low Limit/Avg)

### Thickness Distribution Relative to the Target

+++	0.0%
+0.0050	0.0%
+0.0045	0.0%
+0.0040	0.0%
+0.0035	0.0%
+0.0030	0.0%
+0.0025	0.0%
+0.0020	0.0%
+0.0015	0.0%
+0.0010	0.0%
+0.0005	0.0%
+0.0000	1.2% **
-0.0005	82.9% *****>
-0.0010	15.4% *****
-0.0015	0.5% *
-0.0020	0.0%
-0.0025	0.0%
-0.0030	0.0%
-0.0035	0.0%
-0.0040	0.0%
-0.0045	0.0%
-0.0050	0.0%
---	0.0%

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

99.5% is within  $\pm 0.0010$  in of the target 100.0% is within  $\pm 0.0025$  in of the target  
100.0% is within  $\pm 0.0050$  in of the target 100.0% is within  $\pm 0.0100$  in of the target

Thickness vs Length (Coil Number NB53468)

