Process/Product Audit Checklist

Cust #: 1795 Customer: BSH NEWBERN GRP/Size/GRD/Width: GVS .0396 DD30CD 30.75

PWC: SRB W/O#: 68968 Date: 2-21-18 Part #(s): 9000286520 Auditor: B. Clem

Gauge Range: .0356-.0396 Actual Gauge: .036 Width Range: 30.735 – 30.765 Width Actual: 30.760

Length Range: 24.768 – 24.832 Length Actual: 24.780 Other: W-B-F 0-.12 Other Actual: .030

Other: SQ 0-.12 Other Actual: .001 Other: Wt. 2912 lbs. Other Actual: 2665 lbs.

Item	YES	NO	N/A	Comments/Action Taken (Required for NO)
Process Inspection Sheets filled out according to frequency and sampling required?		✓		Chris M.
Correct raw material type and size?	✓			Tag(s) to use: NB57661 Tag(s) used: NB57661
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?]	✓			[Fab: Print Rev:____, W/O Rev:____, Part Spec Rev:____] (Leave blank if non-Fab audit)
Packaging is acceptable according to customer-specific requirements?	✓			
Visual Inspection performed and product meets requirements?	✓			
Out of spec noted, with actions taken?			✓	
Non-conforming material put into reject warehouse and physically put into non-conforming area?			✓	
Required gages available & functional?	✓			
All Gages Calibrated (List in Comments)	✓			Gages Observed (list last calibration and when due) 8-3 25' Tape 7-31-17 7-31-18 m-44 1" mic 6-27-17 6-27-18 ST-5 Step Gauge 7-5-17 7-5-18 63294 meas. Table 4-19-17 4-19-18
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	✓			
Required PPE being worn?		✓		No Safety Glasses
Forms are the latest revision per Quality Intranet?	✓			List Forms (Observed Rev vs Intranet Rev) SMT-SRB-001 11-8-16 5 JM-OP-001 4-21-15 0 FOP081 2-16-01 1
Hardcopy Controlled Documents are listed on Quality Intranet by location?			✓	List Documents and their Location:

No middle check done on 1st Skid.

Squareness check was only done on 1st Skid.

Tagging Procedure not followed. Skids taken out of the area with no tags.

No Shape checks noted on FOP081.

Material Inspection Report

LOCATION	Sumter			DATE	2/22/2018
CUSTOMER	BSH		JOB # SMT	68968	Page 1

	Order Dim		Tolerances		Tolerances	Low Limit	High Limit
Gauge	0.035	-	0.000	+	0.004	0.035	0.039
Width	30.750	-	0.015	+	0.015	30.735	30.765
Length	24.800	-	0.032	+	0.032	24.768	24.832

	Set up Target
Gauge	0.037
Width	30.750
Length	24.800

Side Type | Skid Type Error

Skid Code | 0 I 1

SOP'S

JDOP008	JDOP016	JDOP046
JDOP014	JDOP034	JDOP032

Finished Goods Tag	26185	26186	520101	520103	
Master Coil Number	NB57661				
Heat					
Enhanced Weight					
Gross Weight	2665	2665	2665	2665	
Tare	30	30	30	30	
Net Weight	2635	2635	2635	2635	0
Bundle Status					
Good Pcs.	340	340	340	340	
Scraped Pcs.					
Rockwell					
Gauge Head E	0.036	0.036	0.036	0.036	
Gauge Head C	0.036	0.036	0.036	0.036	
Gauge Head E	0.036	0.036	0.036	0.036	
Body E					
Body C					
Body E					
Tail E					
Tail C					
Tail E					
Surface					
Width Head	30.760	30.740	30.760	30.740	
Body	30.760	30.740	30.760	30.740	
Tail	30.760	30.740	30.760	30.740	
Shape					
Residual Check					
Length Head	24.780	24.780	24.780	24.780	
Body	24.780	24.780	24.780	24.780	
Tail	24.780	24.780	24.780	24.780	
Squareness	.001	.014	.001	.014	
Camber					
Operator	CM	CM	CM	CM	
Setup Approval					
Run Time S		F	Down Time S		F
Total Run Time	0:00	Cost	$0.00	Cst/Hour	$400.00
Comments					