

**Process Audit Summary:**

**2/22/15 Sumter Red Bud PN 55103,**

**Performed by: Patrick Macias**

**Leveling job to produce 48" x 96" sheets for Florida Heat Pump from master tag 156957.**

**All procedural coil identification checks followed.**

**Eight skids produced for a total of 263 pieces. All skids produced within max lifts and packaged and identified correctly per W/O instructions.**

**All procedural dimensional checks (Gauge-width-length) were done at required intervals and recorded on FOP081. All measurements fell within customer tolerances.**

**Surface check showed no irregularities. Shape checks done at required interval based on flatness requirements, all checks within tolerance.**

**Gamma set up incorrectly showing wrong lower limit of .075" instead of .070". Once run is started gauge targets cannot be changed on Gamma. Operator shown mistake and correct entry method.**

**Correct entry to be done as follows;**

**Target gauge to be entered as nominal gauge in gauge range then high to be set as difference between nominal and high limit, low limit self populates with same figure as entered for high. Example; Gauge range of .070"-.085" enter .0775" as target then .0075" as high low will populate with .0075". Giving you the high limit as .085" and low as .070".**

**Follow up: Rest of today's jobs to be checked for correct entry method.**

# Part Spec/PO Audit Form

Cust #	2671	Customer	Florida Heat Pump	Grp/Sz/Grd/Wdth	GVC/14L/CB90CD/48
Equip/Plant	Red Bud/SMT	Work Order #	55103	Part No.	740-017
		Date	2/22/2015		
Work Order Information		Material to be Used		Actual	
		Tag #1	156957	Gauge #1	.070"/.071"/.070"
		PO#	SMT-15816-1	% Gauge in Spec	100
Gauge Range	.070"-.085"	Gauge Min	.069"	Low/High Gauge	.071"/.072"
Width Range	48.0"-48.1875"	Width	48"	Average	.0717"
Length Range	96.0"-96.25"			Width	48.111"
Rockwell	NA	Rockwell	NA	Length	96.125"
Tensile	NA			Rockwell	NA
Yield	NA				
% Elongation	NA				
Chem Rqmts	NA				
Other Rqmts	FLT/WAVE/BOW .12"			Other	FLT/WAVE/BOW <.12"
Summary					
Actions					
Final Status					

# AGT400 Coil Summary Report

## JEMISON METALS --

Job Number: 55103 Coil Number: 156957

Customer Number: FHP Coil Information: 156957100 Supplier: NUCOR BERKLEY

Product: Galvanize G90 Feb-22-15 10:52 to 11:50 (clock 58.3 min/ run 16.3 min) Shift: 1

### Average Thickness and Tolerance Data

Target 0.0000 in Average 0.0717 in

Average - Target -0.0083 in (10.38%)  
Standard Deviation 0.0002 in (0.24%)

Length 2061 ft  
Width 48.000 in  
Weight 24169 lbs

Above High Limit 0.0850 in 0 ft (0.0%)  
In Tolerance 0.0750 in 2061 ft (100.0%)  
Below Low Limit 0.0750 in 2061 ft (100.0%)

Max Thickness 0.0723 in at 1659 ft

Min Thickness 0.0710 in at 1931 ft

### Statistical Process Control Data

Upper Control Limit 0.0723 in Upper Tolerance Limit 0.0850 in  
X Double Bar 0.0717 in R Bar 0.0006 in  
Lower Control Limit 0.0711 in Lower Tolerance Limit 0.0750 in

CR 11.4% (Capability Ratio %, 100/CP)

CP 8.772 (Process Capability, HiLim-LowLim/6\*Sigma)

CPK -5.790 (Capability vs Limits)

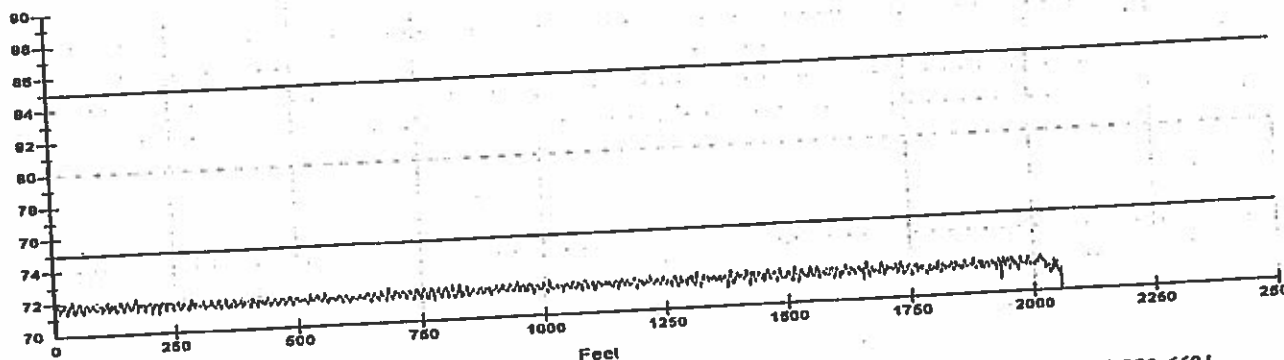
TMW Ratio 1.046 (Low Limit/Avg)

### 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 0.0%  
+0.0020 0.0%  
+0.0010 0.0%  
0.0000 0.0%  
-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 9.2%  
-0.0090 90.8%  
-0.0100 0.0%

0.0% is within  $\pm 0.0020$  in of the target  
100.0% is within  $\pm 0.0100$  in of the target  
0.0% is within  $\pm 0.0050$  in of the target  
100.0% is within  $\pm 0.0200$  in of the target

Thickness vs Length (Coil Number 156957)



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