

Process/Product Audit Checklist

Cust #: <u>2951</u> Customer: <u>Rock Ten</u> GRP/Size/GRD/Width: <u>CRS/16L/CSD/4800</u>				
PWC: <u>SRB</u> W/O#: <u>72997</u> Date: <u>2-28-19</u> Part #(s): <u>0076-1705</u> Auditor: <u>SM</u>				
Gauge Range: <u>0.54 - 0.58</u> Actual Gauge: <u>0.55</u> Width Range: <u>48 - 48.99</u> Width Actual: <u>48.090</u>				
Length Range: <u>96 - 96.125</u> Length Actual: <u>96.060</u> Other: <u>30pc min</u> Other Actual: <u>30 or less</u>				
Other: <u>None</u> Other Actual: <u>Done</u> Other: <u>NA</u> Other Actual: <u>NA</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?	X			<u>Chris M</u>
Correct raw material type and size?	X			Tag(s) to use: <u>NB60109</u> Tag(s) used: <u>ND60109</u>
Setup performed according to W/O?	X			
Product is acceptable according to customer-specific requirements? [Fab: Is the Part Print Present & the correct Revision? Are required measurements documented?]	X			[Fab: Print Rev: _____, W/O Rev: _____, Part Spec Rev: _____] (Leave blank if non-Fab audit)
Packaging is acceptable according to customer-specific requirements?	X			
Visual Inspection performed and product meets requirements?	X			
Out of spec noted, with actions taken?			NA	
Non-conforming material put into reject warehouse and physically put into non-conforming area?			NA	
Required gages available & functional?	X			
All Gages Calibrated (List in Comments)	X			Gages Observed (list last calibration and when due) <u>8" 2.5" + 2.5" 3-30-18 3-30-19</u> <u>1" m.c. M.5B 8-31-18 8-31-19</u> <u>Star 6203e ST.5 7-5-18 7-5-19</u> <u>M.5.5.5 + 2.61e 63244 4-21-18 4-21-19</u>
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	X			
Required PPE being worn?		X		<u>M. S.M. N6441, Glasses, Vetho) worn</u> <u>other size</u>
Forms are the latest revision per Quality Intranet?				List Forms (Observed Rev vs Intranet Rev) <u>FOP041 2-16-01 1</u>
Hardcopy Controlled Documents are listed on Quality Intranet by location?	X			List Documents and their Location: <u>SMT - SRB-001</u> <u>SM. DP-001</u>

Marion had glasses, but was in a bit of a hurry when I told
him to put them on he did.

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 72897 Coil Number: NB60109

Customer Number: ROCKTENN Coil Information: NUB2814427 Supplier: NUCOR BFKI

Product: Steel Feb-25-19 18:17 to 19:55 (clock 97.8 min/ run 46.8 min) Shift: 2

Average Thickness and Tolerance Data

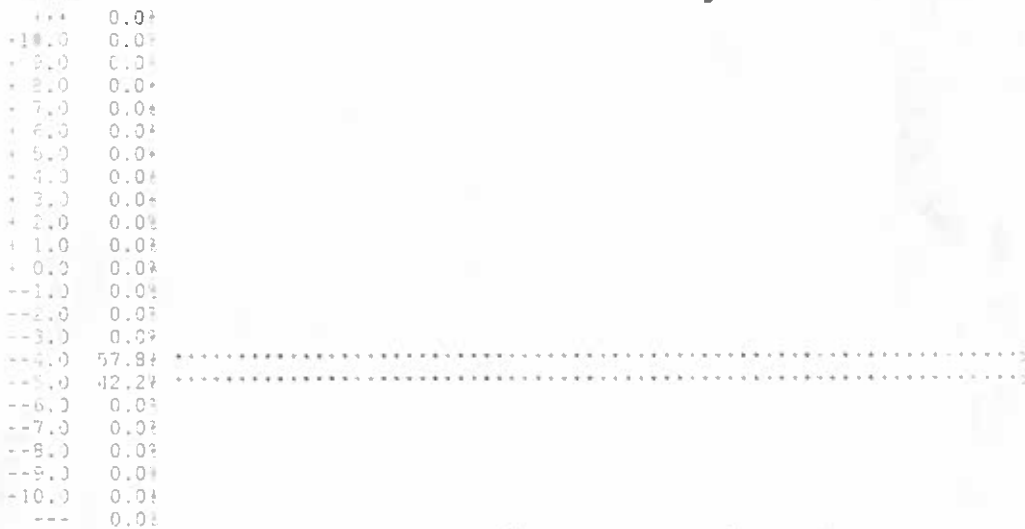
Target	59.5 mil	Average^	55.5 mil	Average - Target	-4.0300 mil
				Standard Deviation^	0.2300 mil
Length	6485 ft	Above High Limit	65.0 mil	0 ft	
Width	48.000 in	In Tolerance		6485 ft	100.0%
Weight	58843 lbs	Below Low Limit	54.0 mil	0 ft	
Max Thickness	56.2 mil at	1857 ft	Min Thickness	54.0 mil at	1487 ft

Statistical Process Control Data

Upper Control Limit	56.2 mil	Upper Tolerance Limit	65.0 mil
X Double Bar	55.5 mil	R Bar	0.8 mil
Lower Control Limit	54.7 mil	Lower Tolerance Limit	54.0 mil

CP 13.6% (Capability Ratio %, 100/CP)
 CP 7.333 (Process Capability, HiLim-LoLim/6'Sigma)
 CPK 1.960 (Capability vs Limits) TMW Ratio 0.974 (Low Limit Av.)

Thickness Distribution Relative to the Target



Thickness vs Length (Coil Number NB60109)

