

Process Audit Summary:

2/26/15 Sumter Cut to Length PN 55206

Performed by: Patrick Macias

Leveling job to produce 48" x 96" sheets for GE Selmer from master tag 162576B.

All procedural coil identification checks followed.

Three skids produced. All skids produced within max lifts and packaged and identified correctly per W/O instructions.

All procedural dimensional checks (Gauge-width-length-square) were done at required intervals. All measurements fell within customer tolerances.

Residual stress check performed, all measurements within customer tolerances.

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

Operator in training. Although Quality personnel witnessed all checks and noted that they were done at the correct intervals and all checks met requirements, checks were not all recorded properly or on right documents.

Follow up: Job to be reviewed with operator trainee to insure correct recording of measurements.

Part Spec/PO Audit Form

Cust #	2366	Customer	GE Selmer	Grp/Sz/Grd/Width	POS/.071"/CSBTP/48"
Equip/Plant	CTL	Work Order #	55206	Part No.	CDES3003
		Date	2/27/2015		
Work Order Information		Material to be Used		Actual	
		Tag #1	1625768	Gauge #1	.074"-.075"-.074"
		PO#	SMT-15924-1	% Gauge In Spec	100 (NO GAMMA)
Gauge Range	.071"-.078"	Gauge Min	.070"	Low/High Gauge	.074"/.075"
Width Range	48"-49.5"	Width	48"	Average	.0747"
Length Range	96"-96.25"			Width	48.119"
Rockwell	NA	Rockwell	NA	Length	96.125"
Tensile	NA			Rockwell	NA
Yield	NA				
% Elongation	NA				
Chem Rqmts	NA				
Other Rqmts	WAVE/FLATNESS .12"				
	SQUARE .25"			Other	W/F<.12", SQ .125"
	Residual stress checks				RESIDUAL <.12"
Summary					
Actions					
Final Status					