Process/Product Audit Checklist

Cust #: 2719 Customer: Altec-NC GRP/Size/GRD/Width: BNS.0635CB40N060

PWC: SRB W/O#: 73099 Date: 2-28-19 Part #(s): 970083436 Auditor: B. Clem

Gauge Range: .0555 - .0695 Actual Gauge: .057 Width Range: 60 - 60.9999 Width Actual: 60.130

Length Range: 124 - 124.125 Length Actual: 124.060 Other: Flatn 0 - .12 Other Actual: .060

Other: 41 pcs./Skid Other Actual: 41 pcs./Skid Other: N/A Other Actual: N/A

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: 6060801 Tag(s) used: 6060801
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 3-30-18 3-30-19 M-58 1" mic 8-31-18 8-31-19 ST-5 Step Gauge 7-5-18 7-5-19 63294 Meas. Table 4-20-18 4-20-19
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	✓			
Required PPE being worn?	✓			
Forms are the latest revision per Quality Intranet?	✓			List Forms (Observed Rev vs Intranet Rev) FOP081 2.16.01 1
Hardcopy Controlled Documents are listed on Quality Intranet by location?	✓			List Documents and their Location: SMT-SRB-001 SMT-3H-001 JM-OP-001

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 730[illegible] Coil Number: 660801

Customer Number: ALTEC Coil Information: 1290794 Supplier: NUCOR BERKLEY

Product: Steel Feb-28-19 17:58 to 18:51 (clock 52.6 min run 23.6 min) Shift: 2

Average Thickness and Tolerance Data

Target 62.0 mil Average 57.2 mil Average - Target -4.8300 mil

Standard Deviation 0.2800 mil

Length 4102 ft Above High Limit 65.0 mil 0 ft

Width 60.000 in In Tolerance 4102 ft

Weight 47456 lbs Below Low Limit 55.0 mil 0 ft

Min Thickness 57.7 mil at 195 ft Max Thickness 58.6 mil at

Statistical Process Control Data

Upper Control Limit 58.0 mil Upper Tolerance Limit 65.0 mil

Average - Bar 57.2 mil + Bar 0.8 mil

Lower Control Limit 56.4 mil Lower Tolerance Limit 55.0 mil

Cp 1.14 (Capability Ratio , 100/Cp)

Cpk .978 (Process Capability, Bar- oLim/3*Sigma)

PPM .722 (Capabilit, vs Limits) PPM ratio 0.6 (Low Lim ratio)

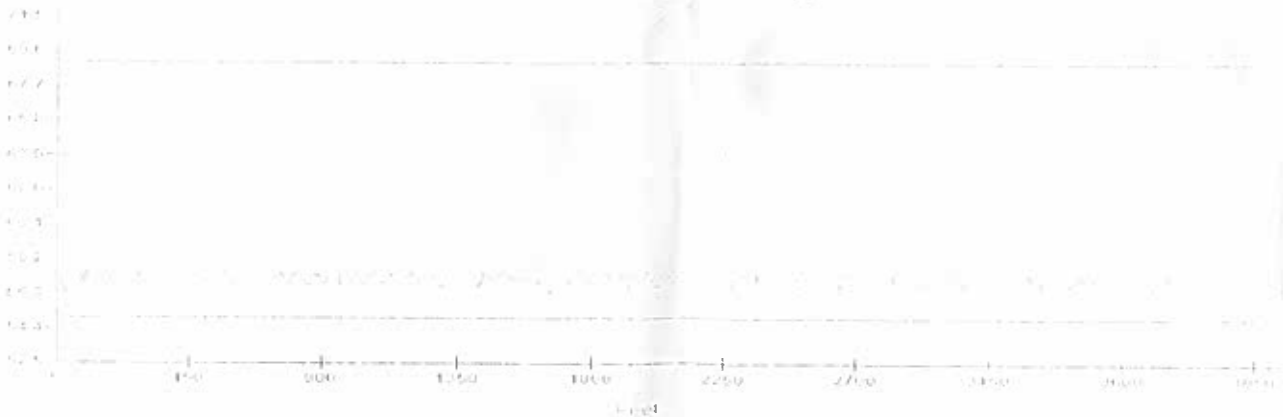
Thickness Distribution Relative to the Target

0 3 6 9 12 15 18 21 24 30 36

76.29 are within ± 2.0000 mil of the target 76.29 are within ± 5.0000 mil

100.00 are within ± 10.0000 mil of the target 100.00 are within ± 20.0000 mil

Thickness vs Length (Coil Number 660801)



Gauge readings provided by Advanced Gauging Technologies, L.L.C. Plain City, OH 43064 USA Tel (614) 873-6600