

Process/Product Audit Checklist

Cust #: 1744 Customer: Laserform GRP/Size/GRD/Width: GVC/.0456/C90CDR/48				
GALV-048-4 X 8				
PWC: SRB W/O#: 92821 Date: 2/19/2024 Part #(s): _____ Auditor: B. Clem				
Gauge Range: .046-.052 Actual Gauge: .047 Width Range: 48-48.250 Width Actual: 48.077				
Length Range: 96-96.250 Length Actual: 96.125 W-B-F Other: 0-.12 Other Actual: Less .12				
SQ Other: 0-.25 Other Actual: .060 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 <u>frequency</u> and <u>sampling</u> required?		X		Sam - No shape check or square check noted on inspection report
Correct raw material type and size?	X			Tag(s) to use: <u>678308</u> Tag(s) used: <u>678308</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?			X	
Non-conforming material put into reject warehouse and physically put into non-conforming area?			X	
Required gages available & functional?	X			
All Gages Calibrated (List in Comments)	X			Gages Observed (list last calibration and when due) 8-3 25" Tape 4/29/2023 4/29/2024 M50 1" Mic 1/19/2024 1/19/2025 ST-4 Step Gauge 6/28/2023 6/28/2024 63294 Measuring Table 4/26/2022 4/26/2025
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	X			
Required PPE being worn?	X			
Forms are the latest revision per Quality Intranet?	X			List Forms (Observed Rev vs Intranet Rev) FOP081 2/16/01 1
Hardcopy Controlled Documents are listed on Quality Intranet by location?	X			List Documents and their Location: SMT-SRB-001 JM-OP-001



Material Inspection Report

LOCATION

Sumter

DATE

5/15/2024

CUSTOMER

LASERFORM

JOB # SMT

92821

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	Order Dim	Tolerances	Tolerances	Low Limit	High Limit
Gauge	0.046	-0.001	0.006	0.047	0.052
Width	48.000	0.000	0.250	48.000	48.250
Length	96.000	0.000	0.250	96.000	96.250

	Set up Target	Side Type	Skid Type Error	Skid Code	0	2	3
Gauge	0.049						
Width	48.125						
Length	96.125						

Finished Goods Tag	LA57407	LA57408	LA57409	LA57410	LA57411
Master Coil Number					
Heat					
Enhanced Weight					
Gross Weight	3760	3760	3760	3760	3760
Tare	125	125	125	125	125
Net Weight	3635	3635	3635	3635	3635
Bundle Status					
Good Pcs.	59	59	59	59	59
Scraped Pcs.					
Rockwell					
Gauge Head	E 0.047	0.047	0.047	0.047	0.047
	C 0.048	0.048	0.048	0.048	0.048
	E 0.047	0.047	0.047	0.047	0.047
Body	E				
	C				
	E				
Tail	E				
	C				
	E				
Surface					
Width Head	48.077	48.077	48.077	48.077	48.077
Body	48.077	48.077	48.077	48.077	48.077
Tail	48.077	48.077	48.077	48.077	48.077
Shape					
Residual Check					
Length Head	96.125	96.125	96.125	96.125	96.125
Body	96.125	96.125	96.125	96.125	96.125
Tail	96.125	96.125	96.125	96.125	96.125
Squareness					
Camber					
Operator					
Setup Approval					
Run Time	S	F	Down Time	S	F
Total Run Time	0:00	Cost	\$0.00	Cst/Hour	\$400.00
Comments					

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 92821 Coil Number: 678308

Customer Number: LASER FORM Coil Information: 352405 Supplier: CLEVELAND CLIFF

Product: Steel Feb-19-24 7:53 to 9:14 (clock 81.1 min/ run 27.6 min) Shift: 1

Average Thickness and Tolerance Data

Target	Average^	48.1 mil	Average - Target	-0.9200 mil (-1.88%)
			Standard Deviation^	0.1200 mil (0.25%)
Length	3506 ft	Above High Limit	52.0 mil	0 ft (0.0%)
Width	48.000 in	In Tolerance		
Weight	27577 lbs	Below Low Limit	46.0 mil	0 ft (0.0%)
Max Thickness	48.5 mil at 3393 ft	Min Thickness	47.3 mil at 3468 ft	

Statistical Process Control Data

Upper Control Limit	48.4 mil	Upper Tolerance Limit	52.0 mil
X Double Bar	48.1 mil	R Bar	0.4 mil
Lower Control Limit	47.7 mil	Lower Tolerance Limit	46.0 mil
CR	12.0% (Capability Ratio %, 100/CP)		
CP	8.333 (Process Capability, HiLim-LoLim/6*Sigma)		
CPK	5.778 (Capability vs Limits)	TMW Ratio	0.957 (Low Limit/Avg)

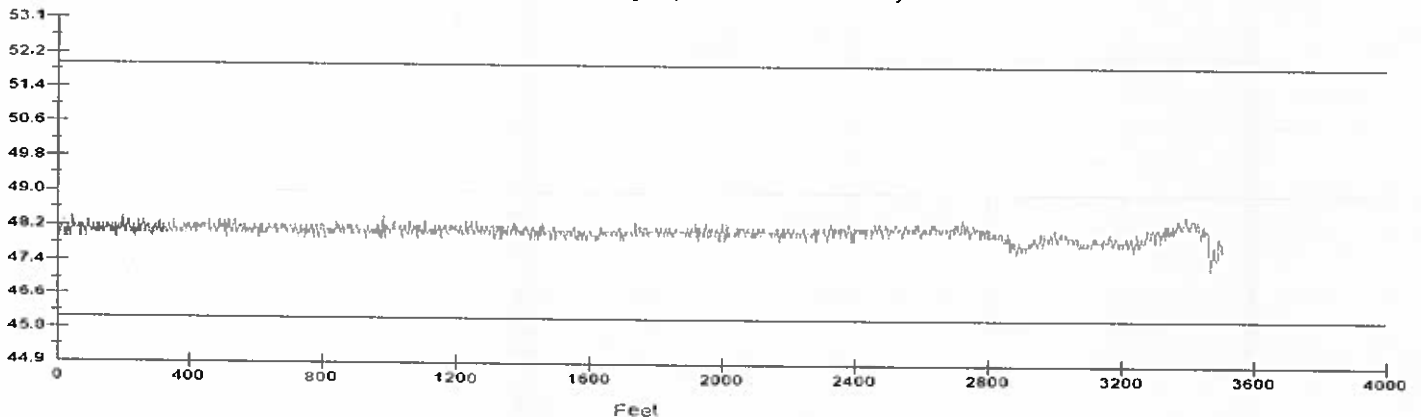
Thickness Distribution Relative to the Target

+++ 0.0%
+ 5.0 0.0%
+ 4.5 0.0%
+ 4.0 0.0%
+ 3.5 0.0%

--3.5 0.0%
--4.0 0.0%
--4.5 0.0%
--5.0 0.0%
--- 0.0%

88.5% is within ± 1.0000 mil of the target 100.0% is within ± 2.5000 mil of the target
100.0% is within ± 5.0000 mil of the target 100.0% is within ± 10.0000 mil of the target

Thickness vs Length (Coil Number 678308)



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