

## Process/Product Audit Checklist

Cust #: <b>3591</b>		Customer: <b>HUNTER ENGINEER</b>		GRP/Size/GRD/Width: <b>POS/0.239/HSF5N/40.3</b>	
PWC: <b>BB1</b>		W/O#: <b>75999</b>		Date: <b>2/4/2026</b>	
Part #(s): <b>546577</b>		Auditor: <b>B. CLEM</b>			
Gauge Range: <b>0.239-0.261</b>		Actual Gauge: <b>0.242</b>		Width Range: <b>40.3-41.2999</b>	
Width Actual: <b>41.0</b>					
Length Range: <b>219-219.63</b>		Length Actual: <b>219.375</b>		W-B-F Other: <b>0-0.25</b>	
Other Actual: <b>LESS 0.25</b>					
SQ Other: <b>0-0.63</b>		Other Actual: <b>0.125</b>		PCS/TAG Other: <b>12 PCS</b>	
Other Actual: <b>12 PCS</b>					
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			NATE	
Correct raw material type and size?	X			Tag(s) to use: <u>55029</u> Tag(s) used: <u>55029</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	NOT PRESENT FOR PACKING	
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) 017 - MIC 5/13/2026 5/13/2026 3305 - LASER GAUGER 1/16/2026 7/31/2026 ST 10 - STEP GAGE 9/30/2025 9/30/2026 T242 - TAPE MEASURE 12/18/2025 12/18/2026	
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) DEC-CTL-001A 4/1/2024 4 DEC-CTL-001B 6/23/2022 2	
Hardcopy Controlled Documents are listed on Quality Intranet by location?	X			List Documents and their Location: DEC-BB1-CTL 6/26/2017 4	

Warehouse (DCT) Decatur Operator

Whs Zone (BB1) Butech Stretch  
 PWC (CTL) Cut to Length  
 Process (CTL) Cut to Length

**Job Work Order**  
 Job 75999 Date 2/3 07:00 AM



Gauge 0.239" - 0.261" (dimensions in inches, if not specified) **JOB RESERVATIONS**

Dimension Pcs LBS PIW ID OD CLgth Tag/Lot Ven Tag Heat Zn Loc Date Planned  
 HRPO Coil, HSS50 Mod Nb, - 1 45,459 1128 1,332' 55029 2104661530 ✓AMN/2532490 - C28  
 0.239M x 40.3"

Consumption 1 Coils Theo Scrap -3.24% (-1,471.66 LBS) **CUTTING INSTRUCTIONS**

Width Cons LBS PIW Produced Sheets (Pcs-Length)  
 40.3" 45,459 1128 75-219"

**PLANNED PRODUCTION**

Dimension	Pcs	LBS	FT Assign To	Customer/Next Prs	Due
HRPO Sheet, HSS50 Mod Nb, -	Part No 546577				
40.3" x 219" 0.25" -N	31	19,398.01	SO-51740-2-1	HUNTER ENGINEER(3591)	2/4
40.3" x 219" 0.25" -N	44	27,532.65	SO-51757-1-1	HUNTER ENGINEER(3591)	2/22
Carbon Scrap, , , -		593.29	Scrap		


	Gauge	Width	Length	Diag	Films
SO-51740-2-1	0.25 [0.239 - 0.261"]	40.3 [40.3 - 41.2999"]	219 [219 - 219.63"]	0.63"	0.25"
SO-51757-1-1	0.25 [0.239 - 0.261"]	40.3 [40.3 - 41.2999"]	219 [219 - 219.63"]	0.63"	0.25"
SO-51740-2-1	Cond Incl Mill Edge	242	41.0		219.375

*Laser application, flatness & residual stress critical "Stretch Length 1.4" - 2.0" to ensure stress equalization "Measure Squareness First & Last bundle and every other Bundle "Width ok up to 40.50" wide" Burr Critical, 10% of thickness max, Measure each bundle "Cut 24-36" sample at start of first bundle, end of first bundle and end of each bundle thereafter. Inspect and measure sample on the flatness table, then flip and repeat. Adjust leveler as required based on flatness observations"*

SO-51757-1-1 Cond Incl Mill Edge

*Laser application, flatness & residual stress critical "Stretch Length 1.4" - 2.0" to ensure stress equalization "Measure Squareness*

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Warehouse	(DCT) Decatur	Operator	<b>Job Work Order</b>	
Whs Zone			Job	75999
PWC	(BB1) Butech Stretch		Date	2/3 07:00 AM
Process	(CTL) Cut to Length			
<b>PLANNED PRODUCTION</b>				

First & Last bundle and every other Bundle "Width ok up to 40.50" wide" Burr Critical, 10% of thickness max, Measure each bundle  
 "Cut 24-36" sample at start of first bundle, end of first bundle and end of each bundle thereafter. Inspect and measure sample on the flatness table, then flip and repeat. Adjust leveler as required based on flatness observations"  
 Flat: 0.25  
 Wave: 0.25  
 Bow: 0.25  
 Square: 0.63  
 Camber: 0

<b>SO-51740-2-1</b>	<b>Customer</b>	<b>Dimension</b>	<b>PCS</b>	<b>LBS Pct/Pkg</b>	<b>LBS</b>	<b>Hgt</b>	<b># Skid/Pkg</b>	<b>PACKAGING</b>
	HUNTER ENGINEER(3591)	40.3" x 219"	31	19,398.01	12	<= 8,000	3	R5 - Sheet-Band to 4"x4" Run. / RH - Paper Top/Run. w/Bands-EP

<b>SO-51757-1-1</b>	<b>Customer</b>	<b>Dimension</b>	<b>PCS</b>	<b>LBS Pct/Pkg</b>	<b>LBS</b>	<b>Hgt</b>	<b># Skid/Pkg</b>	<b>PACKAGING</b>
	HUNTER ENGINEER(3591)	40.3" x 219"	44	27,532.65	12	<= 8,000	4	R5 - Sheet-Band to 4"x4" Run. / RH - Paper Top/Run. w/Bands-EP

2 4x4 grooved runners banded to steel, paper protect on runners Paper Top & 2 Width Bands Banded to Steel Only 1 foot from ends Length Tolerance: Aim for -0, +0.5 Use edge protectors  
 2 4x4 grooved runners banded to steel, paper protect on runners Paper Top & 2 Width Bands Banded to Steel Only 1 foot from ends Length Tolerance: Aim for -0, +0.5 Use edge protectors

**ORDER INFORMATION**

<b>SO-51740</b>	<b>HUNTER ENGINEER(3591)/0</b>	<b>Denise Clayton</b>	<b>Customer PO</b>	604455	<b>Sls Cat Sale</b>	
<b>Due</b>	<b>Item Product/Part/End User Label1</b>	<b>Process Route</b>	<b>PCS</b>	<b>SFT</b>	<b>LBS</b>	<b>+/- Shp % Cert</b>
2/4	2.2390 Min X 40.3000" X 219.0000" A1011 HRP&O SHEET HSLA GRADE 50 546577	{CTL}	31	1,899.98	20,000	+20-10 CAA
<b>SO-51757</b>	<b>HUNTER ENGINEER(3591)/0</b>	<b>C-Suite/Denise Clayton</b>	<b>Sls Cat Sale</b>			
2/22	1.2390 Min X 40.3000" X 219.0000" A1011 HRP&O SHEET HSLA GRADE 50 546577	{CTL}	44	2,696.74	27,532.65	+20-10 CAA

Warehouse	(DCT) Decatur	Operator	<b>Job Work Order</b>	
Whs Zone	(BB1) Butech Stretch		Job	75999
PWC	(CTL) Cut to Length		Date	2/3 07:00 AM
Process				

SO-51740      **Name** HUNTER ENGINEERING      **Route/Color** (RT1) Default Route      **Transp Zn** A      **Divy Mthd** CC Truck      **Carrier** BEST WAY      **DESTINATION**

Legend: ✓ QDS approved    ☐ Scaling required	
Job Set 76660	2/3/2026 07:37 AM