

Process Audit Summary:

3/1/16 Sumter Redbud Job# 60228

Performed by: Beverly Clem

Leveling job to produce 60" X 120" length sheets for BSH Home Appliance from master tag NI49614.

All procedural coil identification checks followed.

Six skids produced at 60" X 120" sheets. All skids produced within max lifts and packaged and identified correctly per W/O instructions.

All procedural dimensional checks (Gauge-Width-Length) were done per SMT-SRB-001 procedure and recorded on the FOP 081. Measurements were performed with micrometer M-44, 25' tape and flatness table 63294. Low gauge of .0343 ok per Joe Merrit.

No follow up required.

Measuring Tools:

Micrometer – M-44 last calibration 10/1/15 calibration due 10/1/16

Flatness table – last calibration 4/20/15 calibration due 4/20/16

25' Tape – 8-3 last calibration 11/3/2015 calibration due 11/3/2016

Controlled Documents:

SMT-SRB-001 Redbud Procedure REV 4 – 3/7/13

FOP 081 Cutline/Shear Inspection REV 1 – 2/16/01

JM-OP-001 Tagging Procedure REV 0 – 4/21/15

## Part Spec/PO Audit Form

Cust #	1795	Customer	BSH HOME APPLIANCE		
Equip/Plant	SRB	Work Order #	60228	Date	3/1/2016
Work Order Information					
		Tag #1	NI49614	Tag #2	
		PO#	018187-001	PO#	
Gauge Range	0.0356 - 0.0396	Gauge Min	0.0352	Gauge Min	
Width Range	60.0000 - 60.2500	Width	60.0000	Width	
Length Range	120.0000 - 120.7500				
Rockwell	N/A	Rockwell	N/A	Rockwell	N/A
Tensile	N/A				
Yield	N/A				
% Elongation	N/A				
Chem Rqmts	N/A				
Other Rqmts	N/A				
Summary	Low gauge of .0343 ok per Joe Merrit				
Actions					
Final Status					

## Part Spec/PO Audit Form

Grp/Sz/Grd/Wdth	AZS/0.0396/CSB125/60.0000		
Part No.	9001161247		
Actual			
Gauge #1	.035 .036 .035	Gauge #2	
% Gauge In Spec	66%	% Gauge In Spec	
Low/High Gauge	.0343/.0363	Low/High Gauge	
Average	0.0353	Average	
Width	60.1980	Width	
Length	120.5000	Length	
Rockwell	N/A	Rockwell	
Other			

# AGT400 Coil Summary Report

## JEMISON METALS --

Job Number: 60228 Coil Number: NI49614

Customer Number: BSH Coil Information: M F20205 Supplier: METAL ONE-WN

Product: Steel Mar-1-16 17:58 to 19:23 (clock 85.4 min/ run 15.2 min) Shift: 2

### Average Thickness and Tolerance Data

Target	0.0376 in	Average^	0.0353 in	Average - Target	-0.0023 in (-6.09%)
				Standard Deviation^	0.0004 in (1.04%)
Length	2231 ft	Above High Limit	0.0396 in	0 ft ( 0.0%)	
Width	60.000 in	In Tolerance			
Weight	16111 lbs	Below Low Limit	0.0356 in	1464 ft ( 65.6%)	
Max Thickness	0.0363 in at	50 ft	Min Thickness	0.0343 in at	8 ft

### Statistical Process Control Data

Upper Control Limit	0.0365 in	Upper Tolerance Limit	0.0396 in
X Double Bar	0.0353 in	R Bar	0.0012 in
Lower Control Limit	0.0341 in	Lower Tolerance Limit	0.0356 in
CR	58.5% (Capability Ratio %, 100/CP)		
CP	1.709 (Process Capability, HiLim-LoLim/6*Sigma)		
CPK	-0.248 (Capability vs Limits)	TMW Ratio	1.008 (Low Limit/Avg)

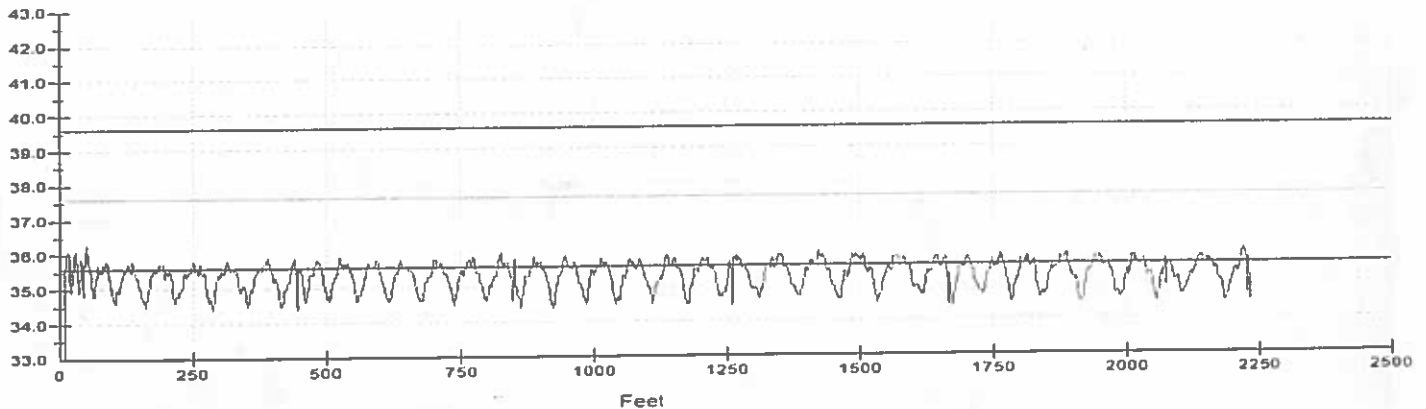
### Thickness Distribution Relative to the Target

+++	0.0%
+0.0050	0.0%
+0.0045	0.0%
+0.0040	0.0%
+0.0035	0.0%
+0.0030	0.0%
+0.0025	0.0%
+0.0020	0.0%
+0.0015	0.0%
+0.0010	0.0%
+0.0005	0.0%
+0.0000	0.0%
-0.0005	0.0%
-0.0010	0.0%
-0.0015	0.5%
-0.0020	34.1%
-0.0025	38.0%
-0.0030	25.0%
-0.0035	2.6%
-0.0040	0.0%
-0.0045	0.0%
-0.0050	0.0%
---	0.0%

0 3 6 9 12 15 18 21 24 27 30 33 %

0.0% is within  $\pm 0.0010$  in of the target 72.4% is within  $\pm 0.0025$  in of the target  
100.0% is within  $\pm 0.0050$  in of the target 100.0% is within  $\pm 0.0100$  in of the target

### Thickness vs Length (Coil Number NI49614)



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