

Process/Product Audit Checklist

Cust #: <u>1913</u>		Customer: <u>Prince</u>		GRP/Size/GRD/Width: <u>CRS.0598CSB 48</u>	
PWC: <u>SRB</u>		W/O#: <u>64792</u>		Date: <u>3-1-17</u>	
Part #(s): <u>CAAD014A</u>		Auditor: <u>B. Clem</u>			
Gauge Range: <u>.0548-.0648</u>		Actual Gauge: <u>.056</u>		Width Range: <u>48-48.1875</u>	
Length Range: <u>100-100.1250</u>		Length Actual: <u>100.030</u>		Other: <u>Lth 120-120.1250</u>	
Other: <u>W-B-F 0-18</u>		Other Actual: <u>.060</u>		Other: <u>SQ 0-.25</u>	
Other Actual: <u>.125</u>					
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?	✓			<u>Leguon & Chris m.</u>	
Correct raw material type and size?	✓			Tag(s) to use: <u>507977</u> Tag(s) used: <u>507977</u>	
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: <u>N/A</u> , W/O Rev: <u>N/A</u> , Part Spec Rev: <u>N/A</u>] (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) <u>8-3 25' Tape 7-21-16 7-21-17</u> <u>m-44 1" mic 6-28-16 6-28-17</u> <u>ST-5 Step Gauge 7-5-16 7-5-17</u> <u>63294 meas. Table 4-26-16 4-26-17</u>	
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) <u>SMT-SRB-001 11-8-16 5</u> <u>Jm-OP-001 4-21-15 0</u> <u>FOP081 2-16-01 1</u>	
Hardcopy Controlled Documents are listed on Quality Intranet by location?			✓	List Documents and their Location:	

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 64792 Coil Number: 507977

Customer Number: PRINCE Coil Information: NUB2700199 Supplier: NUCOR BERKELY

Product: Steel Mar-1-17 22:11 to 22:49 (clock 38.0 min/ run 16.4 min) Shift: 2

Average Thickness and Tolerance Data

Target 0.0598 in Average^ 0.0567 in Average - Target -0.0031 in (-5.23%)
Standard Deviation^ 0.0003 in (0.55%)

Length 1604 ft Above High Limit 0.0648 in 0 ft (0.0%)
Width 48.000 in In Tolerance 1604 ft (100.0%)
Weight 14867 lbs Below Low Limit 0.0548 in 0 ft (0.0%)

Max Thickness 0.0575 in at 22 ft Min Thickness 0.0553 in at 81 ft

Statistical Process Control Data

Upper Control Limit 0.0577 in Upper Tolerance Limit 0.0648 in
X Double Bar 0.0567 in R Bar 0.0010 in
Lower Control Limit 0.0557 in Lower Tolerance Limit 0.0548 in

CR 19.8% (Capability Ratio %, 100/CP)

CP 5.051 (Process Capability, HiLim-LoLim/6*Sigma)

CPK 1.889 (Capability vs Limits) TMW Ratio 0.967 (Low Limit/Avg)

Thickness Distribution Relative to the Target

+++	0.0%
+0.0100	0.0%
+0.0090	0.0%
+0.0080	0.0%
+0.0070	0.0%
+0.0060	0.0%
+0.0050	0.0%
+0.0040	0.0%
+0.0030	0.0%
+0.0020	0.0%
+0.0010	0.0%
+0.0000	0.0%
-0.0010	0.0%
-0.0020	0.0%
-0.0030	42.2%
-0.0040	57.4%
-0.0050	0.4%
-0.0060	0.0%
-0.0070	0.0%
-0.0080	0.0%
-0.0090	0.0%
-0.0100	0.0%
---	0.0%

0.0% is within ± 0.0020 in of the target 100.0% is within ± 0.0050 in of the target
100.0% is within ± 0.0100 in of the target 100.0% is within ± 0.0200 in of the target

Thickness vs Length (Coil Number 507977)

