

Process Audit Summary:

3/12/15 Sumter Slitter PN 55324,

Performed by: Patrick Macias

Slit job to rewrap two 14.8" FG tags (887151, 887152) for Precision Tool to correct egg shape. Also to be viewed by Quality personnel due to recent rejection for camber.

All procedural identification checks followed.

All procedural dimensional checks (Gauge-width) were done manually on both coils all found to be within customer requirements.

Gamma was only set up on coil 887152 and 99.6% of coil to be found within gauge. Four foot of length found to be up to .0006" over gauge Okayed by quality.

Surface check showed no irregularities.

No camber requirements were on the job. Coil 887151 was found to have >.250" of camber and put into SRJ.

Follow up:

1. Precision Tool part spec for this part and part PTS-1324 which also had a customer complaint for camber reviewed.
Follow up 1 completed: Camber spec of .12" added to both specs and verified by quality.
Camber requirements also added to open jobs by quality (3/13/15 PVM).
2. Gamma was not set by operator on first coil as this was a rewrap of a previously ran coil for the same part. Quality requested it be used on second coil. Measurements were not recorded on FOP015 for same reason. Quality to follow up with Operational Management to discuss this practice.

Process Audit Summary:

Follow up on:

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Follow up #2

Gamma was not set by operator on first coil as this was a rewrap of a previously ran coil for the same part. Quality requested it be used on second coil. Measurements were not recorded on FOP015 for same reason. Quality to follow up with Operational Management to discuss this practice.

Discussed with VP of Operations Randy Richards on 3/23/15;

As long as the respin is from a job that was cut to a part spec and is for the same spec and is not spinning to a different set of specs this is considered an acceptable practice.

JDM 500 Rev 0 2/9/15

AGT400 Coil Summary Report

Jemison Metals -- 60 Inch Pro-Eco Slitter

Work Order: SMT55324 Coil Number: 887152

Customer Name: PTS Heat Number: M52324 Vendor: NB

Product: H.R.P.O. Steel Mar-12-15 14:21 to 14:28 (clock 7.6 min/ run 2.8 min) Shift: 1

Average Thickness and Tolerance Data

Target 0.1180 in Average^ 0.1198 in Average - Target 0.0018 in (1.48%)
Standard Deviation^ 0.0006 in (0.52%)

Length 1114 ft Above High Limit 0.1210 in 4 ft (0.4%)
Width 14.800 in In Tolerance 1109 ft (99.6%)
Weight 6726 lbs Below Low Limit 0.1150 in 0 ft (0.0%)

Max Thickness 0.1213 in at 206 ft Min Thickness 0.1174 in at 686 ft
Head Scrap 0 ft Tail Scrap 0 ft

Statistical Process Control Data

Upper Control Limit 0.1216 in Upper Tolerance Limit 0.1210 in
X Double Bar 0.1198 in R Bar 0.0018 in
Lower Control Limit 0.1179 in Lower Tolerance Limit 0.1150 in

CR 61.0% (Capability Ratio %, 100/CP)

CP 1.639 (Process Capability, HiLim-LoLim/6*Sigma)

CPK 0.683 (Capability vs Limits) TMW Ratio 0.960 (Low Limit/Avg)

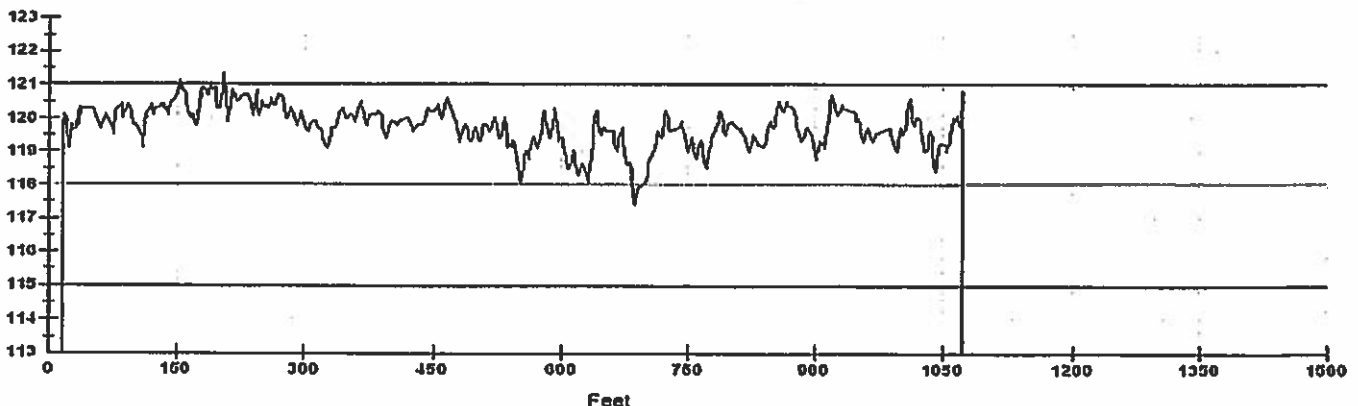
Thickness Distribution Relative to the Target

+++ 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 0.6%
+0.0020 39.2%
+0.0010 51.1%
+0.0000 8.4%
-0.0010 0.7%
-0.0020 0.0%
-0.0030 0.0%
-0.0040 0.0%
-0.0050 0.0%
-0.0060 0.0%
-0.0070 0.0%
-0.0080 0.0%
-0.0090 0.0%
-0.0100 0.0%
--- 0.0%

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

99.4% 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 887152)



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