

Process/Product Audit Checklist

0359

Cust #: 1634	Customer: KICK	GRP/Size/GRD/Width: CRS/20/HSS0-60		
PWC: SRD	W/O#: 7328	Date: 3/12/19		
	Part #(s): HSLA 036 X 60 X 60	Auditor: JIM		
Gauge Range: 033-034	Actual Gauge: 034	Width Range: 60-60.25		
	Width Actual: 60.28			
Length Range: 120-170-175	Length Actual: 120.062	Other: SQRT-2.25		
	Other Actual: 2.135			
Other: 4000 max lift	Other Actual: 3990 lbs.	Other: NA		
	Other Actual: NA			
Item	YES	NO	N/A	Comments/Action Taken (Required for NO)
Process Inspection Sheets filled out according to frequency and sampling required?	X			Chris M.
Correct raw material type and size?	X			Tag(s) to use: NB61320 Tag(s) used: NB61320
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		over width but ok per P.V.M. on previous WD [Fab: Print Rev: ____, W/O Rev: ____, Part Spec Rev: ____] (Leave blank if non-Fab audit)
Packaging is acceptable according to customer-specific requirements?		X		Danced 3 incorrectly fixed 2+ line
Visual Inspection performed and product meets requirements?	X			
Out of spec noted, with actions taken?	X			over max width ok P.V.M.
Non-conforming material put into reject warehouse and physically put into non-conforming area?	X			ID of coil h2D B2D edges 1020 skid 533154
Required gages available & functional?	X			
All Gages Calibrated (List in Comments)	X			Gages Observed (list last calibration and when due) 3-7-19 3-7-20 M. 30 18 M. 18 8-31-18 8-31-19 ST. 5 steel 6209 7-5-18 7-5-19 3294 measuring table 4-20-18 4-20-19
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) FOP81 2-16-01 1
Hardcopy Controlled Documents are listed on Quality Intranet by location?	X			List Documents and their location: SMT - SRP.001 JM.08.001

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 73289 Coil Number: NB61320

Customer Number: K TEK Coil Information: NUB2901634 Supplier: NUCORBERKELY

Product: Steel Mar-12-19 16:25 to 18:06 (clock 101.0 min/ run 23.2 min) Shift: 2

Average Thickness and Tolerance Data

Target	35.5 mil	Average	34.3 mil	Average - Target	-1.2000 mil (-)
				Standard Deviation	0.1500 mil ()
Length	3567 ft	Above High Limit	38.0 mil	0 ft ()	
Width	60.000 in	In Tolerance		3567 ft (10)	
Weight	25001 lbs	Below Low Limit	33.0 mil	0 ft ()	
Max Thickness	34.8 mil at	634 ft	Min Thickness	33.7 mil at	241

Statistical Process Control Data

Upper Control Limit	34.7 mil	Upper Tolerance Limit	38.0 mil
X Double Bar	34.3 mil	R Bar	0.5 mil
Lower Control Limit	33.8 mil	Lower Tolerance Limit	33.0 mil
CP	18.0 (Capability Ratio %, 100/CP)		
CP	5.556 (Process Capability, HiLim-LowLim/6*Sigma)		
CPK	2.844 (Capability vs Limits)	TMW Ratio	0.963 (Low Limit/Ave

Thickness Distribution Relative to the Target

++	0.0%
5.0	0.0%
4.5	0.0%
4.0	0.0%
3.5	0.0%
3.0	0.0%
2.5	0.0%
2.0	0.0%
1.5	0.0%
1.0	0.0%
0.5	0.0%
0.0	0.0%
-0.5	0.0%
-1.0	12.6%
-1.5	85.9%
-2.0	1.5%
-2.5	0.0%
-3.0	0.0%
-3.5	0.0%
-4.0	0.0%
-4.5	0.0%
-5.0	0.0%
---	0.0%

12.6% is within ± 1.0000 mil of the target 100.0% is within ± 2.0000 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 NB61320)

