

Process/Product Audit Checklist

Cust #: 6750 Customer: Lakeside GRP/Size/GRD/Width: GVC/0.0710/S3235V/7.9150				
PWC: CLO W/O#: CLV 59694 Date: 03/30/16 Part #(s): 6750/G235GA33074BAC				
Gauge Range: 0.0710-0.0770 Actual Gauge: 0.0745-0.0765 Width Range: 7.910-7.920 Width Actual: 7.916-7.917				
Length Range: Coil Length Actual: Coil Other: Wt/Skd 10,000 Other Actual: <10,000 lbs/skd				
Other: ID 20 Other Actual: ID 20 Other: OD 45-60 Other Actual: Approx. 52 OD				
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			
Correct raw material type and size?	X			Tag(s) to use: TE69010 Tag(s) used: TE69010
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		Lost scrap toward end of coil. Sales notified and they instructed the operator to flag the coil where we lost scrap and place a tag on the coil with "Attn: Mike, coil narrows at flag". [Fab: Print Rev: _____, W/O Rev: _____, Part Spec Rev: _____]
Packaging is acceptable according to customer-specific requirements?	X			MnWgt: 2897 MxWgt: 5704
Visual Inspection performed and product meets requirements?	X			
Out of spec noted, with actions taken?	X			See note above about lost scrap.
Non-conforming material put into reject warehouse and physically put into non-conforming area?		X		Sales OK'd the coil that was affected by the loss of scrap.
Required gages available & functional?	X			
All Gages Calibrated (List in Comments)	X			Gages Observed (list last calibration and when due) Mic: Paxson12 Last Cal: 03/16 Due: 04/16 Calipers: SH-1 Last Cal: 12/15 Due: 03/16 Tape: 7 Last Cal: 09/15 Due: 09/16 Tape: 6 Last Cal: 09/15 Due: 09/16
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	X			
Required PPE being worn?	X			Operator reminded to put gloves back on after touching scrap.
Forms are the latest revision per Quality Intranet?	X			List Forms (Observed Rev vs Intranet Rev) Slit Size Inspection Observed: Level 3 11/30/15 JDM3 Intranet: Level 3 11/30/15 Slitting Order Observed: Level 7 07/21/11 JDM4 Intranet: Level 7 07/21/11
Hardcopy Controlled Documents are listed on Quality Intranet by location?	X			List Documents and their Location: Quality Policy Rev. 0 JDM200 05/15/2010

Slitting Order

Date: <u>4/6/14</u>	Customer: <u>Lake side</u>
Work Order #: <u>CHV 59694</u>	Date Run: <u>Mar. 30, 2014</u>

Incoming Inspection Checklist

Tag #	Gauge & Width	Type	Tag Wgt.	RB	Olsen	Actual Wgt.	Width	Mic
TEC9010	.071 x 48.325	GVC	22,860	—		22,860	48 ³ / ₁₆	.0745
								.0755

Cutting Instructions: 6 cuts - 7.915

Slit Tolerance: <u>4-.005</u>	Max O.D: <u>ST Thru</u>	Max Skid Wgt: <u>5,704</u>	I.D: <u>20"</u>
Gauge Range: <u>.071 / .077</u>	Salesman:		

Special Instructions:

1 Cuts with some defect but okay to ship

7.915 Cut Size
NA 3730 Cut Weight
Narrow Defect
Jim G. Approved By

2 Cuts Rejected

NA Cut Size
NA Cut Weight
NA Tag No. or No.'s
ET Reason for Reject

3 Ok to move material for shipment or to Stock

ET Name
3-31-16 Date

Slit Size Inspection

Date: Mar. 30, 2014 Work Order: CLV5009H

[illegible]

Non-Conformance

Surface Defects
Burr
Shape Defects

Yes*/No** (If Yes, Description)

No

No

No

Initials

*Need Resolution, OK'd or Segragated

**No Non-Conformance Present

5.8

AGT400 Coil Summary Report

Jemison Metals -- 60 Inch Loopco Slitter

Work Order: CLV 59694 Coil Number: TE69010

Customer Name: LAKESIDE Heat Number: METF05016

Product: G210 Galvanized Mar-30-16 11:33 AM to 11:51 AM (clock 17.9 min/ run 10.2 min) Shift: 1

Average Thickness and Tolerance Data

Target 0.0740 in Average^ 0.0742 in Average - Target 0.0002 in (0.26%)
Standard Deviation^ 0.0007 in (0.96%)
Length 1855 ft Above High Limit 0.0770 in 0 ft (0.0%)
Width 48.375 in In Tolerance 1855 ft (100.0%)
Weight 22693 lbs Below Low Limit 0.0710 in 0 ft (0.0%)

Max Thickness 0.0759 in at 1756 ft Min Thickness 0.0717 in at 1457 ft
Head Scrap 1 ft Tail Scrap 15 ft

Statistical Process Control Data

Upper Control Limit 0.0763 in Upper Tolerance Limit 0.0770 in
X Double Bar 0.0742 in R Bar 0.0021 in
Lower Control Limit 0.0721 in Lower Tolerance Limit 0.0710 in
CR 71.0% (Capability Ratio %, 100/CP)
CP 1.409 (Process Capability, HiLim-LoLim/6*Sigma)
CPK 1.319 (Capability vs Limits) TMW Ratio 0.957(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 10.1% *****
+0.0000 54.8% *****>
-0.0010 29.7% *****
-0.0020 5.0% *****
-0.0030 0.4% *
-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 %

99.6% 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 TE69010)

