

Process Audit Summary:

3/6/15 Sumter Red Bud PN 55059

Performed by: Patrick Macias

Multi-blanking job to produce 7.661" x 30.551" blanks for BSH Home Appliance from master tag NB45461.

All procedural coil identification checks followed.

Six cuts of 7.661" taken out of the width of a 46.466" coil. Eighteen skids produced, two at a time with three stacks of blanks on each. All skids produced within max lifts and packaged and identified correctly per W/O instructions.

All procedural dimensional checks (Gauge-width-length) were done at required intervals and recorded on FOP081. All measurements fell within customer tolerances. Widths varied from 7.646" to 7.675".

Surface check showed no irregularities.

Shape checks done at required interval based on tight tolerance per procedure and recorded. No shape specs on job. All measurements of .125" or less.

Follow up: Sales made aware of missing flatness spec.

Spec entered on part spec of .125" max off of a flat surface. 3/6/15 PVM

Part Spec/PO Audit Form

Cust #	1795	Customer	BSH Home Appliances		Grp/Sz/Grd/Width	GVS/20L/ED30CD/7.661"	
Equip/Plant	RED BUD	Work Order #	55059	Date	3/6/2015	Part No.	9000892413
Work Order Information		Material to be Used			Actual		
		Tag #1	NB45461	Tag #2		Gauge #1	.037"-.036"-.037"
		PO#	SMT-16124	PO#		% Gauge In Spec	100
Gauge Range	.0356"-.0396"	Gauge Min	.0352"	Gauge Min		Low/High Gauge	% Gauge In Spec
Width Range	7.646"-7.676"	Width	46.466"	Width		Average	Low/High Gauge
Length Range	30.519"-30.5830					Width	Average
Rockwell	NA	Rockwell	NA	Rockwell		Length	Width
Tensile	NA					Rockwell	Length
Yield	NA						Rockwell
% Elongation	NA						
Chem Rqmts	NA						
Other Rqmts	NA					Other	NA
Summary							
Actions							
Final Status							

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 55059 Coil Number: NB45461

Customer Number: BSH Coil Information: 171605200 Supplier: NUCOR BERKLEY

Product: Steel Mar-6-15 11:12 to 15:23 (clock 250.6 min/ run 75.9 min) Shift: 1

Average Thickness and Tolerance Data

Target 0.0376 in Average^ 0.0370 in Average - Target -0.0006 in (-1.57%)
Standard Deviation^ 0.0001 in (0.37%)

Length 3829 ft Above High Limit 0.0396 in 0 ft (0.0%)
Width 46.466 in In Tolerance 3829 ft (100.0%)
Weight 22439 lbs Below Low Limit 0.0356 in 0 ft (0.0%)

Max Thickness 0.0375 in at 793 ft Min Thickness 0.0362 in at 28 ft

Statistical Process Control Data

Upper Control Limit 0.0374 in Upper Tolerance Limit 0.0396 in
X Double Bar 0.0370 in R Bar 0.0004 in
Lower Control Limit 0.0366 in Lower Tolerance Limit 0.0356 in

CR 21.0% (Capability Ratio %, 100/CP)

CP 4.762 (Process Capability, HiLim-LoLim/6*Sigma)

CPK 3.357 (Capability vs Limits) TMW Ratio 0.962 (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	10.0%
-0.0010	35.0%
-0.0015	5.0%
-0.0020	0.0%
-0.0025	0.0%
-0.0030	0.0%
-0.0035	0.0%
-0.0040	0.0%
-0.0045	0.0%
-0.0050	0.0%
---	0.0%

99.6% is within ± 0.0010 in of the target 100.0% is within ± 0.0025 in of the target
100.0% is within ± 0.0050 in of the target 100.0% is within ± 0.0100 in of the target

Thickness vs Length (Coil Number NB45461)

