Process/Product Audit Checklist

Cust #: 2951 Customer: Rocktenn GRP/Size/GRD/Width: CRC .0700 CSB 3.36	
PWC: SSL W/O#: 73272 Date: 3-8-19 Part #(s): 0076-1927 Auditor: B. Clem	
Gauge Range: .0700-.076 Actual Gauge: .071	Width Range: 3.355 - 3.365 Width Actual: 3.362
Length Range: N/A Length Actual: N/A	Other: Camb. 0-.12 Other Actual: Not Done
Other: Wth 5.579- 5.589 Other Actual: 5.583	Other: Wth 5.279-5.289 Other Actual: 5.283

Item	YES	NO	N/A	Comments/Action Taken (Required for NO)
Process Inspection Sheets filled out according to frequency and sampling required?		✓		Farron - No Camber check done.
Correct raw material type and size?	✓			Tag(s) to use: 530955 Tag(s) used: 530955
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:____, W/O Rev:____, Part Spec Rev:____] (Leave blank if non-Fab audit)
Packaging is acceptable according to customer-specific requirements?			✓	Quality Not Present For Pkg.
Visual Inspection performed and product meets requirements?	✓			
Out of spec noted, with actions taken?		✓		1 Coil - Belled Edge
Non-conforming material put into reject warehouse and physically put into non-conforming area?	✓			
Required gages available & functional?	✓			
All Gages Calibrated (List in Comments)	✓			D-~~2~~ 40" Caliper 8-29-18 8-29-19 Gages Observed (list last calibration and when due) 13-01 25' Tape 8-16-18 8-16-19 11-03 12' Tape 1-7-19 1-7-20 MSS 1" Mic 12-18-18 12-18-19 D-5 24" Caliper 1-14-19 1-14-20
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) FOP015
Hardcopy Controlled Documents are listed on Quality Intranet by location?	✓			List Documents and their Location: SMT-SL-001 JM-OP-001

Manual Inspection Report

FOA033 Rejection Codes

JDOP005 JDOP006
JDOP007 JDOP049

Job # SMT-	73272	Page #	1				Horizontal Clearance		
Location:	Sumter	Operator:	FM	Machine:	Slitter	CQ	HS	10b38	Date: 3/8/2019
Gauge Spec	0.07000	Limits	0.07000	0.07600	Target	0.07300	0.01050	0.01400	0.01750

Cut	Set Up	Actual	Cut	Set Up	Actual	Cut	Set Up	Actual	Cut	Set Up	Actual	Cut	Set Up	Actual
1	5.288	5.283	6	3.364	3.362	11			16			21		
2	5.288	5.282	7			12			17			22		
3	5.288	5.283	8			13			18			23		
4	5.588	5.584	9			14			19			24		
5	5.588	5.582	10			15			20			25		

Set Up Comments:

	Coil #	Olsen	Rb		Gauge: Head	1/4	Center	3/4	Tail	Camber	Linear Ft	Burr Hgt	Good PC	Bad PC	Comment
1	530955			E	0.07200	0.07200	0.07200	0.07200	0.07200						
				C	0.07100	0.07100	0.07100	0.07100	0.07100						
				E	0.07100	0.07000	0.07000	0.07000	0.07000						
2				E											
				C											
				E											
3				E											
				C		#									
				E											
4				E											
				C											
				E											
5				E											
				C											
				E											

Start Time	12:00 AM	Stop Time		Start Down Time		Stop Down Time		Total Down Time	0:00	Total Run Time	###########	Cut/Hour Cost	$550.00 #NUM!

Comment:

AGT400 Coil Summary Report

Jemison Metals -- 60 Inch Pro-Eco Slitter

Work Order: 73272 Coil Number: 530955

Customer Name: ROCKTEN Heat Number: NLMNLK1769824 Vendor: NUB

Product: Cold-Rolled Steel Mar-8-19 13:11 to 13:19 (clock 8.7 min/ run 5.0 min) Shift: 1

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Average Thickness and Tolerance Data
Target    73.0 mil    Average^  71.3 mil    Average - Target    -1.7300 mil (-2.37%)
                                            Standard Deviation^  0.2700 mil ( 0.37%)

Length       781 ft              Above High Limit     76.0 mil        0 ft (  0.0%)
Width     30.950 in              In Tolerance                        781 ft (100.0%)
Weight      5870 lbs             Below Low Limit      70.0 mil        0 ft (  0.0%)

Max Thickness    71.9 mil at     11 ft       Min Thickness   70.6 mil at    134 ft
Head Scrap              0 ft                 Tail Scrap              0 ft

Statistical Process Control Data
Upper Control Limit      72.1 mil    Upper Tolerance Limit      76.0 mil
X Double Bar             71.3 mil    R Bar                       0.8 mil
Lower Control Limit      70.5 mil    Lower Tolerance Limit      70.0 mil

CR     27.0% (Capability Ratio %, 100/CP)
CP     3.704  (Process Capability, HiLim-LoLim/6*Sigma)
CPK    1.568  (Capability vs Limits)          TMW Ratio        0.982(Low Limit/Avg)

Thickness Distribution Relative to the Target
  +++    0.0%
+10.0    0.0%
+ 9.0    0.0%
+ 8.0    0.0%
+ 7.0    0.0%
+ 6.0    0.0%
+ 5.0    0.0%
+ 4.0    0.0%
+ 3.0    0.0%
+ 2.0    0.0%
+ 1.0    0.0%
+ 0.0    0.0%
--1.0    0.0%
--2.0   81.5% *****************************************************************>
--3.0   18.5% *************************************
--4.0    0.0%
--5.0    0.0%
--6.0    0.0%
--7.0    0.0%
--8.0    0.0%
--9.0    0.0%
-10.0    0.0%
  ---    0.0%
              0    3    6    9   12   15   18   21   24   27   30   33  %

 81.5% 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 100.0% is within ± 20.0000 mil of the target
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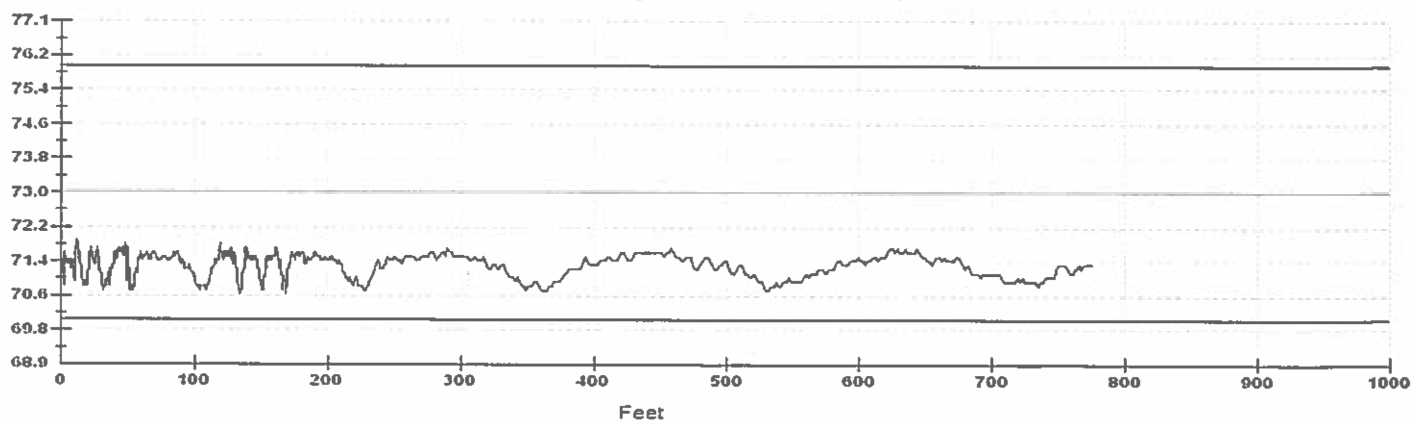
Thickness vs Length (Coil Number 530955)



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