

Process Audit Summary:

3/9/16 Sumter Cut to Length Job# 60339

Performed by: Beverly Clem

Leveling job to produce 48" X 96" length sheets for KMS INC from master tag NB49100.

All procedural coil identification checks followed.

One skid produced at 48" X 96" sheets. Skid produced within max lifts and packaged and identified correctly per W/O instructions.

All procedural dimensional checks (Gauge-Width-Length) and shape checks (Wave Bow Flatness) were done per SMT-CTL-001 procedure and recorded on the FOP 081. Measurements were performed with micrometer M-50, Step gauge ST-5, 25' tape-03-03 and flatness table 63294. All procedural checks fell within customer tolerances.

No follow up required.

Measuring Tools:

Micrometer – M-50 last calibration 3/3/16 calibration due 3/3/17

Step gauge – ST-5 last calibration 7/7/15 calibration due 7/7/16

Flatness table – last calibration 4/20/15 calibration due 4/20/16

25' Tape – last calibration 12/22/15 calibration due 12/22/16

Controlled Documents:

SMT-CTL-001 Cut To Length Line Procedure REV 3 – 6/13/12

FOP 081 Cutline/Shear Inspection REV 1 – 2/16/01

JM-OP-001 Tagging Procedure REV 0 – 4/21/15

Part Spec/PO Audit Form

Cust #	1929	Customer	KMS INC		
Equip/Plant	SCT	Work Order #	60339	Date	3/9/2016
Work Order Information					
		Tag #1	NB49100	Tag #2	
		PO#	017924-001	PO#	
Gauge Range	0.0460 - 0.0520	Gauge Min	0.0460	Gauge Min	
Width Range	48.0000 - 48.1875	Width	48.0000	Width	
Length Range	95.875 - 96.125				
Rockwell	N/A	Rockwell	N/A	Rockwell	N/A
Tensile	N/A				
Yield	N/A				
% Elongation	N/A				
Chem Rqmts	N/A				
Other Rqmts	N/A				
W-B-F	0.00 - .12				
Summary					
Actions					
Final Status					

Part Spec/PO Audit Form

Grp/Sz/Grd/Wdth	GNS/0.0520/CB40CD/48.0000		
Part No.	GALN-18GA-052-48X96		
Actual			
Gauge #1	.047 .048 .047	Gauge #2	
% Gauge In Spec	100%	% Gauge In Spec	
Low/High Gauge	.047/.048	Low/High Gauge	
Average	0.0475	Average	
Width	48.1390	Width	
Length	96.1250	Length	
Rockwell	N/A	Rockwell	
W-B-F	< .12		
Other			