

## Process/Product Audit Checklist

Cust #: <u>1660</u>		Customer: <u>Hitachi - Bland</u>		GRP/Size/GRD/Width: <u>POS/0.3120/A36MOD/60</u>	
PWC: <u>BB1</u>		W/O#: <u>38674</u>		Date: <u>3/14/2025</u>	
		Part #(s): <u>1ZBA131012A0019</u>		Auditor: <u>B. Clem</u>	
Gauge Range: <u>0.2999-0.3190</u>		Actual Gauge: <u>0.304</u>		Width Range: <u>60-60.5</u>	
				Width Actual: <u>60.437</u>	
Length Range: <u>120-120.5</u>		Length Actual: <u>120.125</u>		FLATN	
				Other: <u>0-.25</u>	
				Other Actual: <u>LESS .25</u>	
SQ		PCS/TAG			
Other: <u>0-.25</u>		Other Actual: <u>0.125</u>		Other: <u>8</u>	
				Other Actual: <u>8</u>	
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			NATE	
Correct raw material type and size?	x			Tag(s) to use: <u>ND20790</u> Tag(s) used: <u>ND20790</u>	
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			[Fab: Print Rev: _____, W/O Rev: _____, Part Spec Rev: _____] (Leave blank if non-Fab audit)	
Packaging is acceptable according to customer-specific requirements?			x	NOT PRESENT FOR PACKAGING	
Visual inspection performed and product meets requirements?	x				
Out of spec noted, with actions taken?			x		
Non-conforming material put into reject warehouse and physically put into non-conforming area?			x		
Required gages available & functional?	x				
All Gages Calibrated (List in Comments)	x			Gages Observed (list last calibration and when due) 016-1" MIC - 3/4/2025 3/4/2026 ST 10 9/26/2024 9/26/2025 T232 25' TAPE MEASURE 2/11/2025 2/11/2026 63332 FLATNESS TABLE 2/16/2024 2/15/2026	
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) DEC-CTL-001A CTL 4/1/24 4 DEC-CTL 001B CTL 5/23/22 2 DEC-CTL 004 10/8/19 1	
Hardcopy Controlled Documents are listed on Quality Intranet by location?	x			List Documents and their Location: DEC-BB1-CTL 5/26/17 4	



## PRODUCTION REPORT

HT-BL-2

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JOB WORK ORDER NO.	DATE	MACHINE	SHIFT	MASTER COIL NO.	Yield Strength				
LYJ-38674	3-14-25	BB1	1st	ND20790	100.7				
OPERATOR	RUN HOURS	Burr Msm(t/s)	Head Scrap	Tail Scrap	GA MIN	MAX WAVE	MAX SQUARE	KEYED BY	CKD. BY
AWFL	12:40-1:25		201	101	.399	25	25		

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**Minimum Inspection Frequency:**  
(Unless otherwise specified on the Work Order/Part Spec)  
CHECK PIECE ONCE LINE RUN IS ESTABLISHED + PIECE AT MIDPOINT  
OF RUN + LAST PIECE OF RUN

[illegible]