

Process/Product Audit Checklist

Cust #: 3375		Customer: Eaton-TN		GRP/Size/GRD/Width: GVS/.0630/C60NOX/28.5	
PWC: SRB		W/O#: 89076		Date: 3/23/2023	
		Part #(s):		Auditor: B.Clem	
Gauge Range: .057-.0690		Actual Gauge: .058		Width Range: 28.48-28.515	
				Width Actual: 28.501	
Length Range: 42.485-42.515		Length Actual: 42.501		Flatn 0-.12	
				Other Actual: Less .12	
SQ Other: 0-.03		Other Actual: .003		Other: N/A	
				Other Actual: N/A	
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		Chris Davis - Squareness check was done but was not noted on the Inspection Report.	
Correct raw material type and size?	X			Tag(s) to use: NB75221 Tag(s) used: NB75221	
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				
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) 8-3 25' Tape Measure 2/15/2023 2/15/2024 M50 1" Mic 6/14/2022 6/14/2023 ST-4 Step Gauge 6/21/2022 6/21/2023 63294 Measuring Table 7/8/2020 7/8/2023	
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) FOP081 2/16/01 1	
Hardcopy Controlled Documents are listed on Quality Intranet by location?	X			List Documents and their Location: SMT-SRB-001 JM-OP-001	



Material Inspection Report

LOCATION

Sumter

DATE

3/23/2023

CUSTOMER

EATON

JOB # SMT

89076

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	Order Dim		Tolerances		Tolerances		Low Limit		High Limit
Gauge	0.056	-	-0.001	+	0.013		0.057		0.069
Width	28.500	-	0.015	+	0.015		28.485		28.515
Length	42.500	-	0.015	+	0.015		42.485		42.515

	Set up Target		Side Type		Skid Type Error		Skid Code	
Gauge	0.063				SOP'S			0 1 2
Width	28.500		JDOP008		JDOP016		JDOP046	
Length	42.500		JDOP014		JDOP034		JDOP032	

Finished Goods Tag	221350	221353						
Master Coil Number	NB75221							
Heat								
Enhanced Weight								
Gross Weight	1850	1850						
Tare	60	60						
Net Weight	1790	1790	0	0	0			
Bundle Status								
Good Pcs.	90	90						
Scraped Pcs.								
Rockwell								
Gauge Head	E 0.057	0.057						
	C 0.058	0.058						
	E 0.058	0.058						
Body	E 0.058	0.058						
	C 0.058	0.058						
	E 0.057	0.057						
Tail	E							
	C							
	E							
Surface								
Width Head	28.501	28.502						
Body	28.501	28.501						
Tail								
Shape	0.000							
Residual Check								
Length Head	42.485	42.501						
Body	42.488	42.493						
Tail								
Squareness								
Camber								
Operator								
Setup Approval								
Run Time	S	F		Down Time	S	F		
Total Run Time	0:00		Cost	\$0.00	Cst/Hour		\$400.00	
Comments								

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 89076 Coil Number: NB75221

Customer Number: EATON TN Coil Information: NUB2303162 Supplier: NUCOR BERKLEY

Product: Steel Mar-23-23 14:40 to 15:55 (clock 74.8 min/ run 24.6 min) Shift: 2

Average Thickness and Tolerance Data

Target 63.0 mil Average^ 57.7 mil Average - Target -5.2900 mil (-8.40%)
Standard Deviation^ 0.3500 mil (0.56%)

Length 662 ft Above High Limit 69.0 mil 0 ft (0.0%)
Width 57.500 in In Tolerance 658 ft (99.4%)
Weight 7485 lbs Below Low Limit 57.0 mil 4 ft (0.6%)

Max Thickness 58.6 mil at 13 ft Min Thickness 56.7 mil at 496 ft

Statistical Process Control Data

Upper Control Limit 58.8 mil Upper Tolerance Limit 69.0 mil
X Double Bar 57.7 mil R Bar 1.1 mil
Lower Control Limit 56.7 mil Lower Tolerance Limit 57.0 mil

CR 17.5% (Capability Ratio %, 100/CP)

CP 5.714 (Process Capability, HiLim-LoLim/6*Sigma)

CPK 0.676 (Capability vs Limits) TMW Ratio 0.988 (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 0.0%
-3.0 0.0%
-4.0 0.0%
-5.0 28.9%
-6.0 70.1%
-7.0 0.6%
-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 %

0.0% is within ± 2.0000 mil of the target 28.9% 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

Thickness vs Length (Coil Number NB75221)

