

Process/Product Audit Checklist

Cust #: <u>10</u> Customer: <u>Heil Fab</u> GRP/Size/GRD/Width: <u>HRS 250 HS80 58.500"</u>				
PWC: <u>GL2</u> W/O#: <u>200975</u> Date: <u>3/28/2025</u> Part #(s): <u>311-6850-003</u> Auditor: <u>PHILLIP MATHIS</u>				
Gauge Range: <u>.235-.265</u> Actual Gauge: <u>.238</u> Width Range: <u>7.92-8.04</u> Width Actual: <u>7.95</u>				
Length Range: <u>57.72-57.84</u> Length Actual: <u>57.78</u> Other: _____ Other Actual: _____				
Other: _____ Other Actual: _____ Other: _____ Other Actual: _____				
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			
Correct raw material type and size?	X			Tag(s) to use: <u>380749</u> Tag(s) used: <u>380749</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: <u>0</u> , W/O Rev: <u>0</u> , Part Spec Rev: <u>NA</u>] (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) C005 LAST 2/6/2025 DUE 2/6/2026 M024 LAST 5/29/2024 DUE 5/29/2025 TM045 LAST 2/11/2025 DUE 2/11/2026 *NOTE M021 [LOST] FOUND AT PWC AND REMOVED
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) JDM -F 014 - JDM -F-014
Hardcopy Controlled Documents are listed on Quality Intranet by location?	X			List Documents and their Location: GAD-LA-001 LOC ON OP. DESK

Laser / Plasma

[illegible]

Mar25 10:39

J O B W O R K O R D E R

GAD 200905

Jemison Metals - Gadsden
3001 Hickory Street
Gadsden, AL 35902
Tel: 800-235-1086 Fax: 205-986-6604

Job Type SHR Process PWC GL6
Metric N Cust
Desc P-1 HEIL BUGGY 311-6850-003
Due Date 21Mar25 Whs GFG
Setup 00:00 Run 03:05 Prtd By jmathis

<<< JOB SPECIFICATIONS >>>

Group HRS Grade HS80 Gauge 0.2500 (0.2500 to 0.2500) ID 0.0000

PROGRAM 30104

<<< ORDER SPECIFICATIONS >>>

Part HRS/250/HS80/17.9700"X69.99/.2370N HSLA GRADE 80
Part 10/311-6850-003 Ga 0.2370 Wth 17.9700 Lth 69.9900
Ga Rng 0.2350to 0.2650 Pc/Tag
WthTol + 0.0600 - 0.0600 Wt/Skd 2500
LthTol + 0.0600 - 0.0600 Ty JD0 Pk
YLD:80000.00 TENS:90000.00 ELONG:23.00

<<< PROCESSING INSTRUCTIONS >>>

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
HRS/250/HS80>								
180749	GPW	0.2500N	58.5000	157.5000	8	5226	NUDPQ0519	F21M
Spec: YLD=<92.4>/TENS=<102.7>/ELONG=<20.9>					Total: 8 5226			

<<< MATERIAL TO STOCK >>>

Cons Tg	Spc	Prod Tg	Whs	Ty	Gauge	Width	Length	OD	PCS<Prn>Wt	PCS<Res>Wt
180749										
1	384183	GFG F	0.2370	17.9700	69.9900	40	3381			
1	384184	GFG F	0.2370	17.9700	69.9900	40	3381			
Total:									80	6,762

<<< JOB RECAP >>>

	PCS	Weight	Scrap	Scrap %	Unactd Scr
Material Allocated	8	5,226			
Master Returns					
Returns to Stock					
Work in Process					
Material to be Shipped	80	6,762			
Rejects					
Net Weight to be Produced	80	6,762			1,536- 29.39

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21Mar25 10:39

T A G P I C K I N G L I S T

GAD 200905

Jemison Metals - Gadsden
3001 Hickory Street
Gadsden, AL 35902

Job Type SHR Process PWC GLR
Metric N Cust
Desc P-1 HEIL BUGGY 311-6850-003
Due Date 21Mar25 Whs GFG
Setup 00:00 Run 03:05 Prtd By jmathis

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<IRS/250/HS80>								
280749	GPW	0.2500N	58.5000	157.5000	8	5226	NUDPQ0519	F21M
Spec: YLD=<92.4>/TENS=<102.7>/ELONG=<20.9>								
Total:					8	5226		

Page: 1 Last



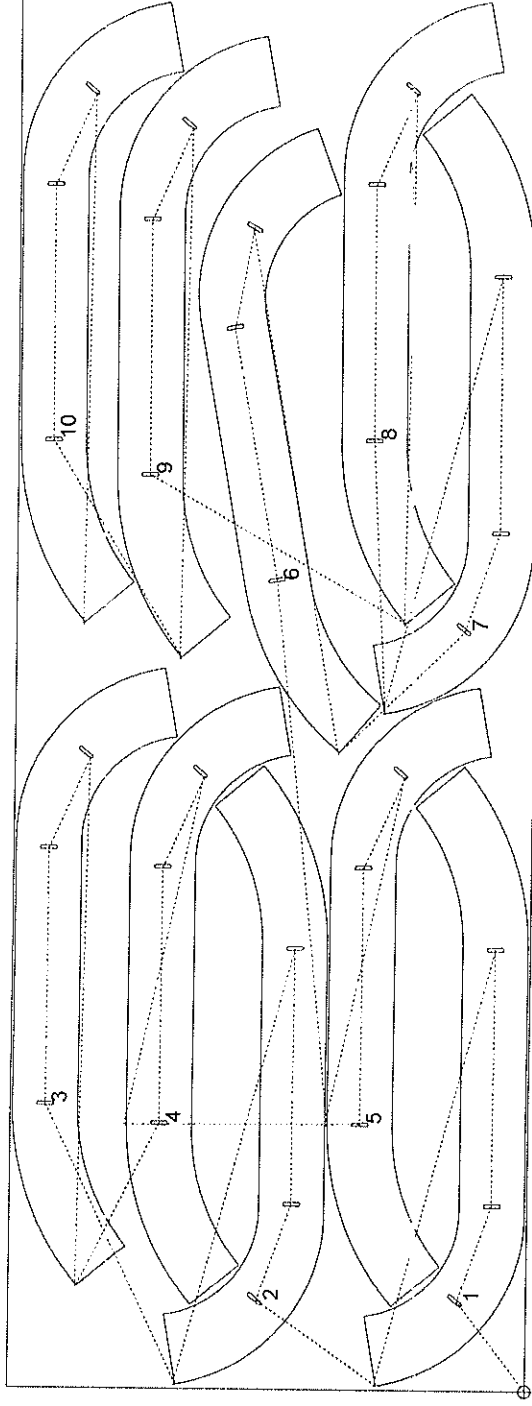
01/10/2015 00:12:21

Layout Detail

Machine TRUMPF TruLaser 5040 S

Task Name : HEIL FAB PN 311-6850-003 Program Name : 30104

Number of Sheets with Same Layout		True Scrap	Qty Required	Layout 1 of 1	
Stack Quantity		Rect Scrap	Qty Nested		
		1	-41.699	49	10



Material	MS	Sheet Length	157.500"	Sheet X Used	156.825"	Heat Number	Mill
Thickness	0.250	Sheet Width	58.500"	Sheet Y Used	58.250"	Sheet Location	Prime Code
Sheet Name		Cutting Time	00:22:21	Cutting Length	1731.102"	Bin Number	Parameters NITROGEN
Part ID	1	Part Name	311-6850-003	Qty Req	49	Qty Nested	80
				Net Weight	38.00lb	Drawing Number	
				Revision Number		Work Order Number	
				Customer	MAINTENANCE	Cutting Time	00:22:21

200975



Layout Report

Task Name : HEIL FAB PN

Program Name :30104

Layout 1 of 1

Number of Sheets with Same Layout : 8

Sheet Parameters

Material : MS

Thickness : 0.250"

Sheet Length : 157.500"

Sheet Width : 58.500"

Sheet Name :

Bin Number :

Heat Number :

Location :

Mill :

Prime Code :

Sheet X Used : 156.825

Sheet Y Used : 58.250

Plate Used : 98.04%

Plate Recovered : 1.96%

Nesting Task Results

Qty Required : 49

Qty Nested : 10

Total Cutting Time : 00:22:21

Total Net Weight : 379.956lb

True Scrap : 40.67%

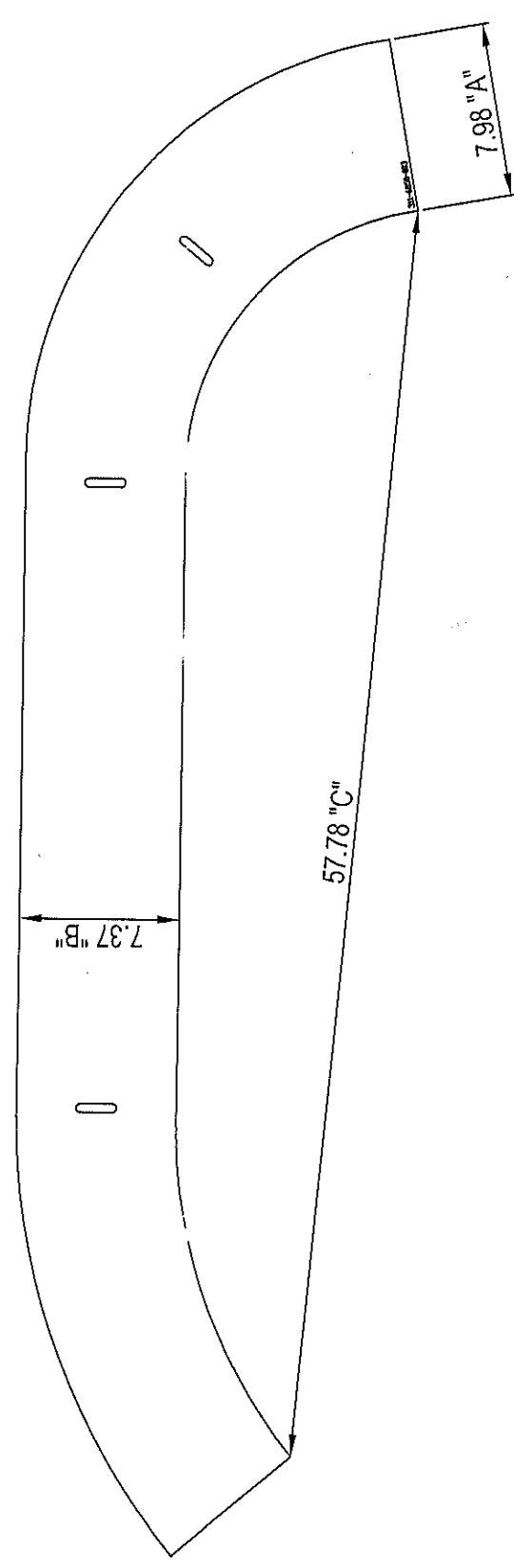
Rectangular Scrap : -41.70%

Total Cutting Length : 1731.102"

Number of Pierces : 40

Part ID	Part Name	Qty Req	Qty Nested	Net Weight	Drawing Number	Revision Number	Work Order	Customer	Cutting Time
1	311-6850-003	49	10	38.00				MAINTENANCE	00:22:21

JEMISON METALS		QUANTITIES	
NO.	DESCRIPTION	QTY	DATE
1			

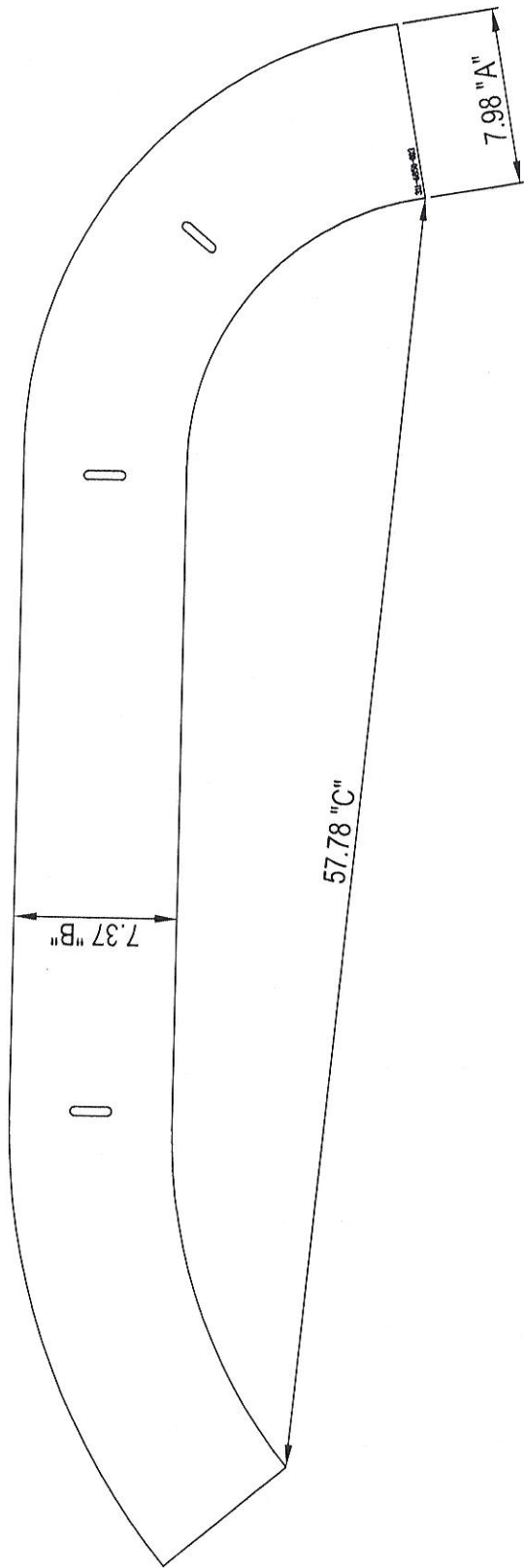


JEMISON METALS		CUSTOMER: HEIL	
TOLERANCES UNLESS OTHERWISE SPECIFIED		MATERIAL: 1/4" HRS HSLA 80	
LINEAR		DATE: 6/22/21	
XX = +/- .06		BY: 1 1	
XXX = +/- .030		JEMISON	
ANGULAR = +/- 1°		JEMISON	
WEIGHT:		JEMISON	
CUT/BURNT FIRST ARTICLES		JEMISON	
NOMINAL	TOLERANCE	ACTUAL	
MIL THICKNESS	.237	.238	
TOL "A"	7.98	7.95	
TOL "B"	7.37	7.39	
TOL "C"	57.78	57.78	

1st pc 3rd shift

5.2

JEMISON REVISION		CUSTOMER REVISION	
REV	DESCRIPTION	DATE	REV



		CUSTOMER HEIL	
		TITLE SIDE PLATE, UPPER ARM HP-2021	
TOLERANCES UNLESS OTHERWISE SPECIFIED		MATERIAL 1/4" HRS HSLA 80	
LINEAR XX = +/- .06 XXX = +/- .030 ANGULAR = +/- 1° WEIGHT:		BY UC DATE 8/22/21 STL 1 OF 1	
CUT/BURNT FIRST ARTICLES		JEMISON REV 003 REV	
MTL THICKNESS	NOMINAL	TOLERANCE	ACTUAL
TOL. "A"	.237	235-265	238
TOL. "B"	7.98	7.92-8.04	7.95
TOL. "C"	7.37	7.31-7.43	7.36
	57.78	57.72-57.84	57.78