

# Process/Product Audit Checklist

Cust #: 3364		Customer: Blue Bird Fab		GRP/Size/GRD/Width: HRS 250 A36 X 60.000X120.00	
PWC: GL7		W/O#: 89012		Date: 3/31/2026	
Part #(s): W10053481		Auditor: PHILLIP E. MATHIS			
Gauge Range: .240-.260		Actual Gauge: .248		Width Range: 4.44-4.56	
Length Range: 8.01-8.13		Length Actual: 8.075		Other Actual: .372	
Other: _____		Other: _____		Other Actual: _____	
Item	YES	NO	N/A	Comments/Action Taken (Required for NO)	
Process Inspection Sheets filled out according to frequency and sampling required?	✓				
Correct raw material type and size?	✓			Tag(s) to use: 27947F	Tag(s) used: 27947F
Setup performed according to W/O?			✓		
Product is acceptable according to customer-specific requirements?	✓			[Fab: Print Rev: A, W/O Rev: A, Part Spec Rev: NA ] (Leave blank if non-Fab audit)	
Product is acceptable according to customer-specific requirements?	✓				
Visual inspection performed and product meets requirements?	✓				
Out of spec noted, with actions taken?			✓		
Non-conforming material put into reject warehouse and physically put into non-conforming area?			✓		
Required gages available & functional?	✓				
All Gages Calibrated (List in Comments)	✓			Gages Observed (list last calibration and when due) C029 3/11/2026- 3/11/2027 M018 3/11/2026- 3/11/2027 TM048 3/11/2026- 3/11/2027	
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) JDM-F-014 JDM-F-014	
Hardcopy Controlled Documents are listed on Quality Intranet by location?	✓			List Documents and their Location: GAD-LA-001 LOC ON OP. DESK	

JOB NO.	DATE	SHIFT	OPERATOR	MACHINE	3RD PIECE INSPECTION	AXIS SPEED	PIECES ACTUAL	PIECES REQUIRED	MASTER WIDTH	MASTER LENGTH	GAUGE MIN	GAUGE MAX	SHEETS/JOB	PANES/SHEET	FEED RATE	PART NUMBER	FINISHED TAG NUMBER	MASTER BUNDLE	27941E
89012	2/19/21	2nd	Jeff	CLT	1080	100%	350	350	60"	126"	240	2600	3	143	100%	W10053481	68418	27941E	27941E
<p>Were there issues? YES NO</p> <p>Was shift lead notified of issues? YES NO</p> <p>Were issues resolved? YES NO</p> <p>STOP TIME</p> <p>START TIME</p> <p>1:06 PM</p> <p>3 PM</p> <p>OK</p> <p>5:03 PM</p> <p>ORDER - ALL MACHINE ISSUES &amp; ERRORS</p> <p>ORDER - ALL MACHINE ISSUES &amp; ERRORS</p> <p>ORDER - ALL MACHINE ISSUES &amp; ERRORS</p> <p>ORDER - ALL MACHINE ISSUES &amp; ERRORS</p> <p>ORDER - ALL MACHINE ISSUES &amp; ERRORS</p> <p>ORDER - ALL MACHINE ISSUES &amp; ERRORS</p> <p>MAINTENANCE</p> <p>QUALITY - PART CHECKS</p> <p>PROCESS - MATL. HANDLING &amp; MACHINE SETUP.</p> <p>BREAK</p> <p>LUNCH</p> <p>DOWN TIME TYPE</p> <p>DOWN TIME ESTIMATED IN (MINUTES)</p> <p>OPERATOR COMMENTS / REASON FOR DOWNTIME</p>																			

Warehouse: (GAD)-Gadsden  
 Whs Zone  
 PWC (GL7) Laser 7  
 Process (AS-) As-Is

Operator

**Job Work Order**  
 Job 89012 Date 3/31 06:00 AM



PROGRAM 41280  
 T45643

**JOB INSTRUCTIONS**

**JOB RESERVATIONS**  
 (dimensions in inches, if not specified)

Dimension	D	Pcs	LBS	SFT Tag/Lot	Ven Tag	Heat	Zn	Loc	Date Planned
HR Sheet, A36TL, -		3	1,515.33	150 27947F	5355267.000	✓NUD/NQ4362	-	F20	
60" x 120" 0.25"-N									
Theo Scrap 33.47% (507.18 LBS)									
Dimension		Pcs	LBS	SFT					
60" x 120" 0.25" -N		3	1,515.33	150					

**PLANNED CONSUMPTION**

**PLANNED PRODUCTION**

Dimension	Pcs	LBS	SFT Assign To	Customer/Next Prs	Due
HR Sheet, A36 SS, - Part No W10053481	429	1,008.15	SO-61141-1-1	BLUE BIRD BODY(3364)	4/6
5.4558" x 8.59" Irregular					
Gauge		Width	Length	Diag	Fitns
SO-61141-1-1	0.24 [0.225 - 0.255"]	[-0.06 +0.06"]	[-0.06 +0.06"]		

SO-61141-1-1 **Cond Incl Mill Edge**  
 Flat: 0  
 Wave: 0  
 Bow: 0  
 Square: 0  
 Camber: 0

**PACKAGING**

Customer	Dimension	PCS	LBS Pcs/Pkg	LBS	Hgt	# Skid/Pkg
SO-61141-1-1	BLUE BIRD BODY(3364)	5,4558" x 8.59" Irregular	429	1,008.15	350	<= 823
						2 F2 -FAB - Pallet
						-Sheet Lifter / FB -
						Shrink Wrap



Copy Number 1

Job Set 89743

3/30/2026 10:57 AM

Legend: ✓ QDS approved

Warehouse (GAD) Gadsden

Whs Zone

PWC (GL7) Laser 7

Process (AS-) As-Is

Operator

Job Work Order

Job 89012

Date 3/31 06:00 AM

ORDER INFORMATION

SO-61141 BLUE BIRD BODY(3364)/0

Due 4/6 1 HR ASTM A36 - A36 SS

0.255 N x 5.4558 x 8.59

W10053481

Charles Love

Process Route {AS-}

Customer PO STOCK Sls Cat Sale

PCS 429

SFT 102.87

LBS 1,008.15

+/- Shp % Cert

2.35/PC

CAA



Legend: ✓ QDS approved

Copy Number

Job Set: 89743

3/30/2026

10:57 AM





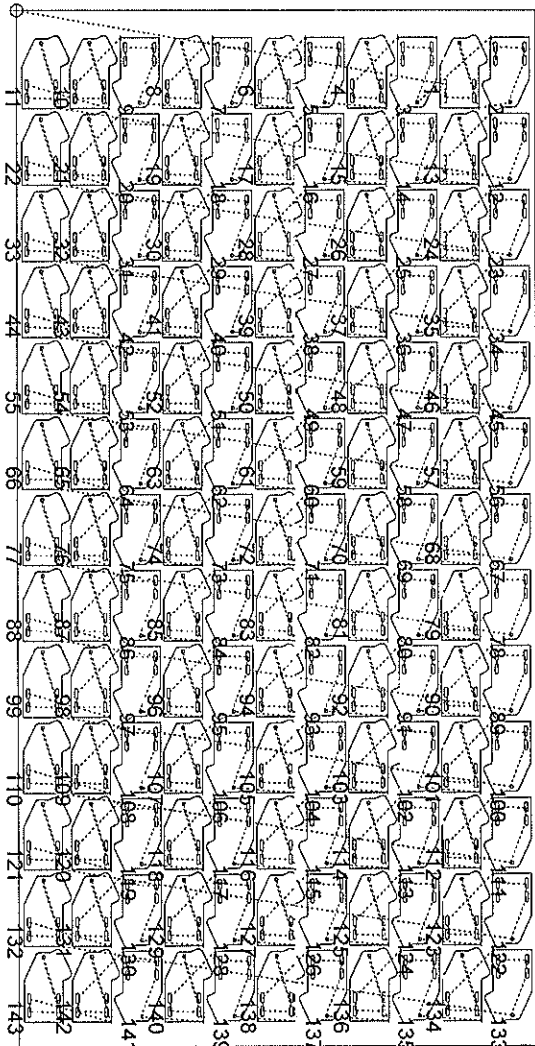
# Layout Detail

Machine TRUMPF TruLaser\_5040\_S

3/30/2026 10:52:02 AM

Task Name : T45643 Program Name : 41280

Number of Sheets with Same Layout	3	True Scrap	31.123	Qty Required	31	Layout 1 of 1
Stack Quantity	1	Rect Scrap	6.882	Qty Nested	143	



3.55  
6141-1  
8/12

Material	MS	Sheet Length	120.000"	Sheet X Used	117.281"	Heat Number	Mill		
Thickness	0.250	Sheet Width	60.000"	Sheet Y Used	59.426"	Sheet Location	Prime Code		
Sheet Name		Cutting Time	01:18:20	Cutting Length	5457.551"	Bin Number	Parameters NITROGEN		
Part ID	Part Name	Qty Req	Qty Nested	Net Weight	Drawing Number	Revision Number	Work Order Number	Customer	Cutting Time

1 W/10053481 31 429 2.41lb BLUE BIRD 01:18:20

# Layout Report



Task Name : T45643  
 Program Name : 41280  
 Layout 1 of 1  
 Number of Sheets with Same Layout : 3

## Sheet Parameters

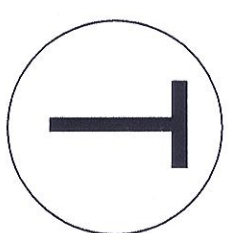
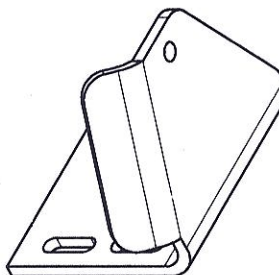
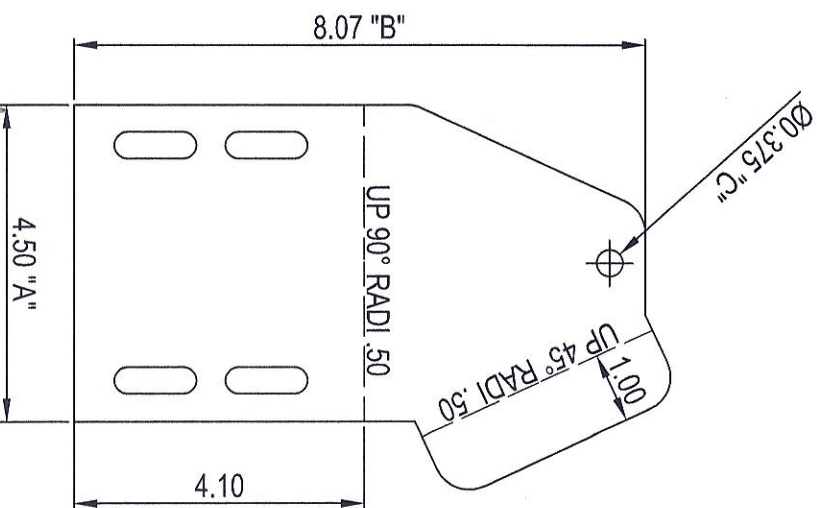
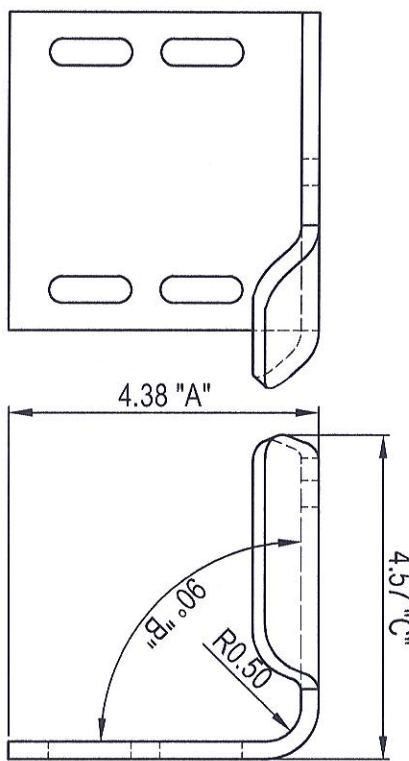
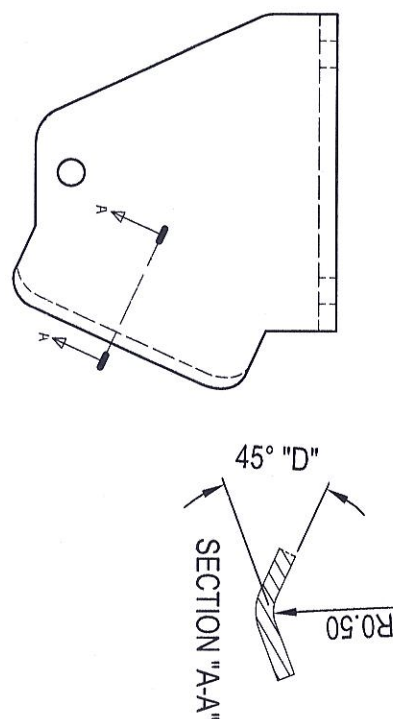
Material : MS  
 Thickness : 0.250"  
 Sheet Length : 120.000"  
 Sheet Width : 60.000"  
 Sheet Name :  
 Bin Number :  
 Heat Number :  
 Location :  
 Mill :  
 Prime Code :  
 Sheet X Used : 117.281  
 Sheet Y Used : 59.426  
 Plate Used : 98.05%  
 Plate Recovered : 1.95%

## Nesting Task Results

Qty Required : 31  
 Qty Nested : 143  
 Total Cutting Time : 01:18:20  
 Total Net Weight : 344.734lb  
 True Scrap : 31.12%  
 Rectangular Scrap : 6.88%  
 Total Cutting Length : 5457.551"  
 Number of Pierces : 1001

Part ID	Part Name	Qty Req	Qty Nested	Net Weight	Drawing Number	Revision Number	Work Order	Customer	Cutting Time
1	W10053481 Rev	31	143	2.41				BLUE BIRD	01:18:20

JEMISON REVISION		CUSTOMER REVISION	
REV.	DESCRIPTION	DATE	REV.
1	CHANGED FROM NORTH PLANT TO THOMAS		A



BENT/FORMED FIRST ARTICLES			CUT/BURNT FIRST ARTICLES		
NOMINAL	TOLERANCE	ACTUAL	NOMINAL	TOLERANCE	ACTUAL
TOL. "A"	4.38	4.32-4.44	MTL THICKNESS	.25	.24-.26
TOL. "B"	90°	88-92°	TOL. "A"	4.50	4.44-4.56
TOL. "C"	4.57	4.51-4.63	TOL. "B"	8.07	8.01-8.13
TOL. "D"	45°	43-47°	TOL. "C"	.375	.360-.390

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TOL. "D"	45°	43-47°	TOL. "C"	.375	.360-.390

**TOLERANCES UNLESS OTHERWISE SPECIFIED**

A. SERR                      FLAT SIZE ALLOWANCE: ±.06  
   SQUARENESS: ±.5°

B. SQUARE OR 'V' NOTCHES      EDGE OF METAL TO BACK OF  
ON OUTSIDE EDGE OF PART      NOTCH: ±.06

C. HOLE LOCATIONS:              EDGE TO CENTERLINE HOLE: ±.06  
   HOLE TO HOLE: ±.03

D. BREAK LOCATIONS:              EDGE TO BREAK: ±.06  
   BREAK TO BREAK: ±.06

E. BREAK ANGLES                      ±.2°

F. HOLE DIAMETERS                      ±.015

CUSTOMER: BLUE BRD CORPORATION

TITLE: BRACKET, GUIDE, HOOD, REAR, RH  
BCV

MATERIAL: 1/4" HRS

BY CC      DATE 6/19/18      SHT. 1 OF 1

PART NO. 10053481      JEMISON REV. 1      DIST. REV. A



CAW