

Process/Product Audit Checklist

Cust #: 2719 Customer: Altec GRP/Size/GRD/Width: GNS/.0785/CB40NO/72				
PWC: SRB W/O#: 73778 Date: 4/16/2019 Part #(s): 970132967 Auditor: DM				
Gauge Range: .0685-.0865 Actual Gauge: .069-.070 Width Range: 72-72.3125 Width Actual: 72.26				
Length Range: 132-132.125 Length Actual: 132.060 Other: <u>Residual Stress</u> Other Actual: OK				
SQ Other: 0-.31 Other Actual: LESS .31 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 D. - Operator did not list the FG tag numbers checked on the Inspection Report.
Correct raw material type and size?	X			Tag(s) to use: <u>533113</u> Tag(s) used: <u>533113</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			
Visual Inspection performed and product meets requirements?	X			Rust on surface. Ok per quality. (Stephen F.)
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 3-7-19 3-7-20 M-50 1" MIC 8-31-18 8-31-19 ST-5 STEP GAUGE 7-5-18 7-5-19 63294 MEASURING TABLE 4-20-18 4-20-19
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 SMT-SH-001



Material Inspection Report

LOCATION

Sumter

DATE

4/17/2019

CUSTOMER

ALTEC

JOB # SMT

73778

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	Order Dim		Tolerances		Tolerances		Low Limit		High Limit
Gauge	0.067	-	-0.002	+	0.019		0.069		0.086
Width	72.000	-	0.000	+	0.312		72.000		72.312
Length	132.000	-	0.000	+	0.125		132.000		132.125

	Set up Target		Side Type		Skid Type Error		Skid Code	
Gauge	0.077				SOP'S			0 3 5
Width	72.156		JDOP008		JDOP016		JDOP046	
Length	132.063		JDOP014		JDOP034		JDOP032	

Finished Goods Tag								
Master Coil Number	533113							
Heat								
Enhanced Weight								
Gross Weight	4965	4965						
Tare	270	270						
Net Weight	4695	4695	0	0	0			
Bundle Status								
Good Pcs.	25	25						
Scraped Pcs.								
Rockwell								
Gauge Head	E	0.069	0.069					
	C	0.069	0.070					
	E	0.069	0.069					
Body	E							
	C							
	E							
Tail	E							
	C							
	E							
Surface	RUST							
Width Head	72.185	72.260						
Body	72.185	72.260						
Tail	72.185	72.260						
Shape	LESS.12							
Residual Check	GOOD							
Length Head	132.060	132.060						
Body	132.060	132.060						
Tail	132.060	132.060						
Squareness	LESS.31							
Camber								
Operator	CD							
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: 73778 Coil Number: 533113

Customer Number: ALTEC Coil Information: 1298174 Supplier: XXXXXXXXXXXXXXX

Product: Steel Apr-16-19 16:17 to 16:55 (clock 38.6 min/ run 9.1 min) Shift: 2

Average Thickness and Tolerance Data

Target	77.5 mil	Average^	70.4 mil	Average - Target	-7.0700 mil (-
				Standard Deviation^	0.1900 mil (-
Length	603 ft	Above High Limit	86.5 mil	0 ft (	
Width	72.000 in	In Tolerance		603 ft (100	
Weight	10424 lbs	Below Low Limit	68.5 mil	0 ft (	
Max Thickness	71.3 mil at	578 ft	Min Thickness	70.1 mil at	2

Statistical Process Control Data

Upper Control Limit	71.0 mil	Upper Tolerance Limit	86.5 mil
X Double Bar	70.4 mil	R Bar	0.6 mil
Lower Control Limit	69.9 mil	Lower Tolerance Limit	68.5 mil

CR 6.3% (Capability Ratio %, 100/CP)

CP 15.790 (Process Capability, HiLim-LoLim/6*Sigma)

CPK 3.386 (Capability vs Limits) TMW Ratio 0.973 (Low Limit/Ave

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	0.0%
-6.0	0.0%
-7.0	26.9% *****
-8.0	73.1% *****>
-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 0.0% is within ± 5.0000 mil of the target
10.0% is within ± 10.0000 mil of the target 100.0% is within ± 20.0000 mil of the target

Thickness vs Length (Coil Number 533113)

