

Process/Product Audit Checklist

Cust #: <u>2719</u> Customer: <u>Altec</u>		GRP/Size/GRD/Width: <u>GNS.0785 CB40NO 72</u>		
PWC: <u>SRB</u> W/OH: <u>65369</u> Date: <u>4-18-17</u> Part #(s): <u>970132967</u>		Auditor: <u>B. Clem</u>		
Gauge Range: <u>.0685-.0865</u> Actual Gauge: <u>.069</u>		Width Range: <u>72-72.3125</u> Width Actual: <u>72.126</u>		
Length Range: <u>132-132.1250</u> Length Actual: <u>132.060</u>		Other: <u>158-158.1250</u> Other Actual: <u>158.030</u>		
Flatn Other: <u>0-.12</u> Other Actual: <u>.030</u>		SQ Other: <u>0-.31</u> Other Actual: <u>.060</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?	✓			<u>Lagunson & Chris M.</u>
Correct raw material type and size?	✓			Tag(s) to use: <u>654643</u> Tag(s) used: <u>654643</u>
Setup performed according to W/O?	✓			
Product is acceptable according to customer-specific requirements? [Fab: Is the Part Print Present & the correct Revision? Are required measurements documented?]	✓			[Fab: Print Rev: <u>N/A</u> , W/O Rev: <u>N/A</u> , Part Spec Rev: <u>N/A</u>] (Leave blank if non-Fab audit)
Packaging 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) <u>8-3 25' Tape 3-14-17 3-14-18</u> <u>m-44 1" mic 6-28-16 6-28-17</u> <u>ST-5 step Gauge 7-5-16 7-5-17</u> <u>63294 Meas. Table 4-26-16 4-26-17</u>
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) <u>SMT-SRB-001 11-8-16 5</u> <u>SMT-SH-001 10-26-11 0</u> <u>SM-OP-001 4-21-15 0</u> <u>FOP081 2-16-01 1</u>
Hardcopy Controlled Documents are listed on Quality Intranet by location?			✓	List Documents and their Location:

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 65369 Coil Number: 654643

Customer Number: ALTEC Coil Information: ME42149 Supplier: AMNS CALVERT

Product: Steel Apr-18-17 22:24 to 23:12 (clock 48.5 min/ run 11.6 min) Shift: 2

Average Thickness and Tolerance Data

Target	0.0775 in	Average	0.0697 in	Average - Target	-0.0078 in (10.04)
				Standard Deviation	0.0003 in (0.43)
Length	1326 ft	Above High Limit	0.0865 in		0 ft. (0.0)
Width	72.000 in	In Tolerance			1323 ft (99.6)
Weight	22690 lbs	Below Low Limit	0.0685 in		3 ft (0.2)
Max Thickness	0.0708 in at	5 ft	Min Thickness	0.0684 in at	3 ft

Statistical Process Control Data

Upper Control Limit	0.0707 in	Upper Tolerance Limit	0.0865 in
X Double Bar	0.0697 in	R Bar	0.0010 in
Lower Control Limit	0.0687 in	Lower Tolerance Limit	0.0685 in

CR 11.0% (Capability Ratio %, 100/CP)

CP 9.091 (Process Capability, HiLim-LoLim/6*Sigma)

CPK 1.232 (Capability vs Limits) TMW Ratio 0.983 (Low Limit/Avg)

Thickness Distribution Relative to the Target

+++	0.0%
+0.0100	0.0%
+0.0090	0.0%
+0.0080	0.0%
+0.0070	0.0%
+0.0060	0.0%
+0.0050	0.0%
+0.0040	0.0%
+0.0030	0.0%
+0.0020	0.0%
+0.0010	0.0%
+0.0000	0.0%
-0.0010	0.0%
-0.0020	0.0%
-0.0030	0.0%
-0.0040	0.0%
-0.0050	0.0%
-0.0060	0.0%
-0.0070	0.7%
-0.0080	79.8%
-0.0090	19.2%
-0.0100	0.2%
---	0.0%

0.0% is within ± 0.0020 in of the target 0.0% is within ± 0.0050 in of the target
 100.0% is within ± 0.0100 in of the target 100.0% is within ± 0.0200 in of the target

Thickness vs Length (Coil Number 654643)

