

Process/Product Audit Checklist

Cust #: 1795 Customer: BSH-NEW BERN GRP/Size/GRD/Width: CRS/.0330/DSENT1/25.2500				
PWC: SRB W/O#: 73804 Date: 4-23-2019 Part #(s): 8001120734 Auditor: B. CLEM				
Gauge Range: .0300-.0330 Actual Gauge: .031 Width Range: 25.235-25.265 Width Actual: 25.262				
Length Range: 41.278-41.342 Length Actual: 41.340 W-B-F Other: 0-.12 Other Actual: .125				
SQ Other: 0-.12 Other Actual: .004/.038 WT/SKD Other: 2000 lbs Other Actual: 1715 lbs				
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 M. - Op noted an end of the run check on the FOP081 but the check was never done. He laid the pieces on the table but never checked them.
Correct raw material type and size?	X			Tag(s) to use: 661764 Tag(s) used: 661764
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 4-19-2019 4-19-2020 M50 1" MIC 8-31-2018 8-31-2019 ST-5 STEP GAUGE 7-5-2018 7-5-2019 63294 MEASURING TABLE 4-2018 4-2019
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	X			
Required PPE being worn?		X		NO SAFETY GLASSES - Chris M. and Marion
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

4/23/2019

CUSTOMER

BSH

JOB # SMT

73804

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	Order Dim		Tolerances		Tolerances		Low Limit		High Limit
Gauge	0.029	-	-0.001	+	0.004		0.030		0.033
Width	25.250	-	0.015	+	0.015		25.235		25.265
Length	41.310	-	0.032	+	0.032		41.278		41.342

	Set up Target		Side Type	Skid Type Error		Skid Code	
Gauge	0.032			SOPS			0.12
Width	25.250		JDOP008	JDOP016	JDOP046		
Length	41.310		JDOP014	JDOP034	JDOP032		

Finished Goods Tag	BH75910	BH75911	BH75912	BH75913	
Master Coil Number	661764				
Heat					
Enhanced Weight					
Gross Weight	1715	1715	1715	1715	
Tare	60	60	60	60	
Net Weight	1655	1655	1655	1655	0
Bundle Status					
Good Pcs.	180	180	180	180	
Scraped Pcs.					
Rockwell					
Gauge Head	E 0.031	0.031	0.031	0.031	
	C 0.031	0.032	0.032	0.032	
	E 0.031	0.031	0.031	0.031	
Body	E				
	C				
	E				
Tail	E				
	C				
	E				
Surface	0				
Width Head	25.262	25.261	25.255	25.255	
Body	25.262	25.261	25.250	25.255	
Tail	25.262	25.261	25.255	25.255	
Shape	0.125	0.125	0.125	0.125	
Residual Check					
Length Head	41.340	41.333	41.300	41.300	
Body	41.340	41.333	41.300	41.300	
Tail	41.340	41.330	41.300	41.300	
Squareness	.004	.038	.004	.038	
Camber					
Operator	CM	CM	CM	CM	CM
Setup Approval					
Run Time	S	F	Down Time	S	F
Total Run Time	0:00	Cost	\$0.00	Cst/Hour	\$400.00
Comments					