

Process/Product Audit Checklist

| Cust #: <u>3497</u> Customer: <u>ABB</u> GRP/Size/GRD/Width: <u>POC/11L/CBTPLE</u> | | | | |
|--|-----|----|-----|---|
| PWC: <u>L2B</u> W/O#: <u>20014</u> Date: <u>04/23/21</u> Part #(s): <u>3497/10454T</u> Auditor: <u>N. RAGLAND</u> | | | | |
| Gauge Range: <u>0.1116 - 0.1276</u> Actual Gauge: <u>0.112</u> Width Range: <u>60.0 - 60.99</u> Width Actual: <u>60.125</u> | | | | |
| Length Range: <u>120 - 120.25</u> Length Actual: <u>120.125</u> Other: <u>80</u> <u>170 M4</u> Other Actual: <u>134.375</u> <u>134.375"</u> | | | | |
| Other: <u>FLAT</u> <u>.250</u> Other Actual: <u>< .250</u> Other: <u>N/A</u> Other Actual: <u>N/A</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? | ✓ | | | OPERATOR: <u>LACEY RUSH</u> |
| Correct raw material type and size? | ✓ | | | Tag(s) to use: <u>NB12709</u> Tag(s) used: <u>NB12709</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: _____, W/O Rev: _____, Part Spec Rev: _____] (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) TPO4 11/21 01/21 - 01/22 MIC02 - 11/21 01/21 - 01/22 AGT - 11/21 4/21 - 01/22 |
| 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>LYN-F-001 REV 1</u> |
| Hardcopy Controlled Documents are listed on Quality Intranet by location? | | | ✓ | List Documents and their Location: |

AGT400 Coil Summary Report

Jemison Metals -- 72 Red Bud Multi-Blanking

Work Order: 20014 Coil Number: NB12709

Customer Name: ABB Heat Number: 2016718 Vendor: NUCOR

Product: H.R.P.O. Steel Apr-23-21 10:38 AM to 10:54 AM (clock 16.0 min/ run 16.0 min) Shift: 1

Average Thickness and Tolerance Data

Target 0.1196 in Average* 0.1135 in Average ~ Target -0.0062 in (-5.14%)
Standard Deviation* 0.0006 in (0.50%)

Length* 734 ft Above High Limit 0.1276 in 0 ft (0.0%)
Width 60.000 in In Tolerance 734 ft (100.0%)
Weight 17037 lbs Below Low Limit 0.1116 in 0 ft (0.0%)

Max Thickness 0.1151 in at 696 ft Min Thickness 0.1119 in at 435 ft
Head Scrap 0 ft Tail Scrap 0 ft

Statistical Process Control Data

Upper Control Limit 0.1153 in Upper Tolerance Limit 0.1276 in
X Double Bar 0.1135 in R Bar 0.0018 in
Lower Control Limit 0.1117 in Lower Tolerance Limit 0.1116 in

CR 22.5% (Capability Ratio %, 100/CP)

CP 4.444 (Process Capability, HiLim-LoLim/6*Sigma)

CPK 1.028 (Capability vs Limits) TMW Ratio 0.984 (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 | 1.9% **** |
| -0.0060 | 49.7% *****> |
| -0.0070 | 39.7% *****> |
| -0.0080 | 8.6% ***** |
| -0.0090 | 0.0% |
| -0.0100 | 0.0% |
| --- | 0.0% |

0 3 6 9 12 15 18 21 24 27 30 33 %

0.0% is within ± 0.0020 in of the target 1.9% 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 NB12709)

