

Process Audit Summary:

4/24/15 Sumter Red Bud PN 56099

Performed by: Patrick Macias

Edge trim and level job of black painted for National Beverage.

All procedural coil identification checks followed.

Four skids of 22.995" x 80.121" produced for National Beverage from coil of 24.965" width. All skids produced to piece counts ordered by customer except for second to last skid which was 7 pieces under ordered piece count due to surface imperfections. Surface inspected by quality from viewing stand. Total of 15 pieces scrapped due to surface imperfections. All packaged and identified correctly per W/O instructions.

All procedural dimensional checks (Gauge-width-length) were done at required intervals and recorded on FOP081. All measurements fell within customer tolerances.

Shape checks done at required interval based on tight tolerance per procedure and recorded.

No follow up required.

Part Spec/PO Audit Form

Cust #	2806	Customer	NATIONAL BEVERAGE	Grp/Sz/Grd/Width	PGV5/.026/BLACK/22.995
Equip/Plant	SRB	Work Order #	56099	Part No.	7703308
			Date		4/24/2015
Work Order Information		Tag #1	Material to be Used		Actual
		PO#	6051002	Gauge #1	Gauge #2
			SMT-16774-1	% Gauge In Spec	% Gauge In Spec
Gauge Range	.022"-.030"	Gauge Min	.022"	Low/High Gauge	Low/High Gauge
Width Range	22.995"-23.005"	Width	24.965"	Average	Average
Length Range	80.121"-80.151"			Width	Width
Rockwell	NA	Rockwell	NA	Length	Length
Tensile	NA			Rockwell	Rockwell
Yield	NA				
% Elongation	NA				
Chem Rqmts	NA				
Other Rqmts	WAVE/BOW/FLAT<.12"				
	SQUARE <.030"			Other	WAVE/BOW/FLAT<.12"
					5Q<.030"
Summary					
Actions					
Final Status					

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 56099 Coil Number: 6051002

Customer Number: NATIONAL BEVERAGE Coil Information: NUDNC3148 Supplier: PRECOAT METALS

Product: Steel Apr-24-15 9:11 to 11:28 (clock 137.0 min/ run 54.5 min) Shift: 1

Average Thickness and Tolerance Data

Target . Average^ 0.0235 in Average - Target -0.0025 in (-9.65%)
Standard Deviation^ 0.0002 in (0.62%)

Length 5323 ft Above High Limit 0.0300 in 0 ft (0.0%)
Width 24.965 in In Tolerance 5323 ft 24.965 in
Weight 10638 lbs Below Low Limit 0.0220 in 0 ft (0.0%)

Max Thickness 0.0238 in at 23 ft Min Thickness 0.0230 in at 1196 ft

Statistical Process Control Data

Upper Control Limit 0.0240 in Upper Tolerance Limit 0.0300 in
X Double Bar 0.0235 in R Bar 0.0005 in
Lower Control Limit 0.0230 in Lower Tolerance Limit 0.0220 in

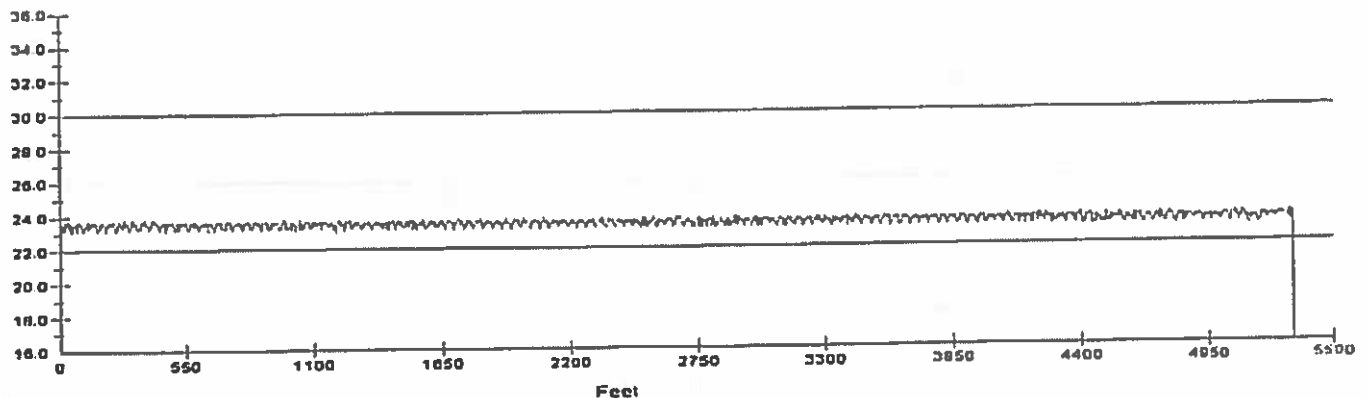
CR 12.0% (Capability Ratio %, 100/CP)
CP 8.333 (Process Capability, HiLim-LoLim/6*Sigma)
CPK 3.104 (Capability vs Limits) TMW Ratio 0.937 (Low Limit/Avg)

Thickness Distribution Relative to the Target

Thickness	Percentage
+++	0.0%
+0.0050	0.0%
+0.0045	0.0%
0.0040	0.0%
0.0035	0.0%
0.0030	0.0%
0.0025	0.0%
0.0020	0.0%
0.0015	0.0%
0.0010	0.0%
0.0005	0.0%
0.0000	0.0%
-0.0005	0.0%
-0.0010	0.0%
-0.0015	0.0%
-0.0020	0.0%
-0.0025	0.0%
-0.0030	0.0%
-0.0035	0.0%
-0.0040	0.0%
-0.0045	0.0%
-0.0050	0.0%
---	0.0%

0.0% is within ± 0.0010 in of the target 63.1% is within ± 0.0025 in of the target
100.0% is within ± 0.0050 in of the target 100.0% is within ± 0.0100 in of the target

Thickness vs Length (Coil Number 6051002)



Gauge readings provided by Advanced Gauging Technologies, L.L.C. Plain City, OH 43064 USA Tel:(614) 873-6691