

Process/Product Audit Checklist

Cust #: 1545 Customer: The Austin Comp GRP/Size/GRD/Width: GVS .0710 CB90CD 60

PWC: SRB W/O#: 60635 Date: 4-26-16 Part #(s): STL1560120GAL

.0630 - .0770 Actual Gauge: .0635 Width Range: 60-60.1875 Width Actual: 60.0306

120.2500 - 120.4375 Length Range: 120.2800 Length Actual: W-B-F Other: 0-.12 Other Actual: 0

SS Other: 0-.18 Other Actual: .060 ^{Wght} Other: 7990 lbs Other Actual: 7370 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?				James, Sam, Samuel Samuel
Correct raw material type and size?	✓			Tag(s) to use: <u>NB49937</u> Tag(s) used: <u>NB49937</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: _____]
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) <u>Calib. Sched. 4-26-16</u>	✓			Gages Observed (list last calibration and when due) 8-3 25' Tape 3-8-16 3-8-17 m44 1" mic 10-1-15 10-1-16 ST-5 stop Gauge 7-7-15 7-7-16 63294 Meas. Table 4-20-15 4-20-16
Housekeeping: Machine/Floor clean?	✓			
Loose tags & paperwork cleaned up?	✓			
Required PPE being worn?		✓		No Safety Glasses
Forms are the latest revision per Quality Intranet?	✓			List Forms (Observed Rev vs Intranet Rev) SMT-SRB-001 3-7-13 4 JM-OP-001 4-21-15 0 - Not Followed FMA 030 9-16-09 0 EOP 081 2-16-01 1
Hardcopy Controlled Documents are listed on Quality Intranet by location?			✓	List Documents and their Location:

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 60635 Coil Number: NB49937

Customer Number: AUSTIN Coil Information: NUB2603834 Supplier: NUCORBERKELY

Product: Galvanize G60 Apr-26-16 11:58 to 12:32 (clock 34.3 min/ run 12.2 min) Shift: 1

Average Thickness and Tolerance Data

Target	0.0092 in	Average	0.0634 in	Average - Target	-0.0046 in	
				Standard Deviation	0.0022 in	
Length	1883 ft	Above High Limit	0.0770 in	0 ft (0.0%)		
Width	59.938 in	In Tolerance				
Weight	24395 lbs	Below Low Limit	0.0630 in	17 ft (0.9%)		
Max Thickness	0.0641 in at 1547 ft	Min Thickness	0.0628 in at 105 ft			

Statistical Process Control Data

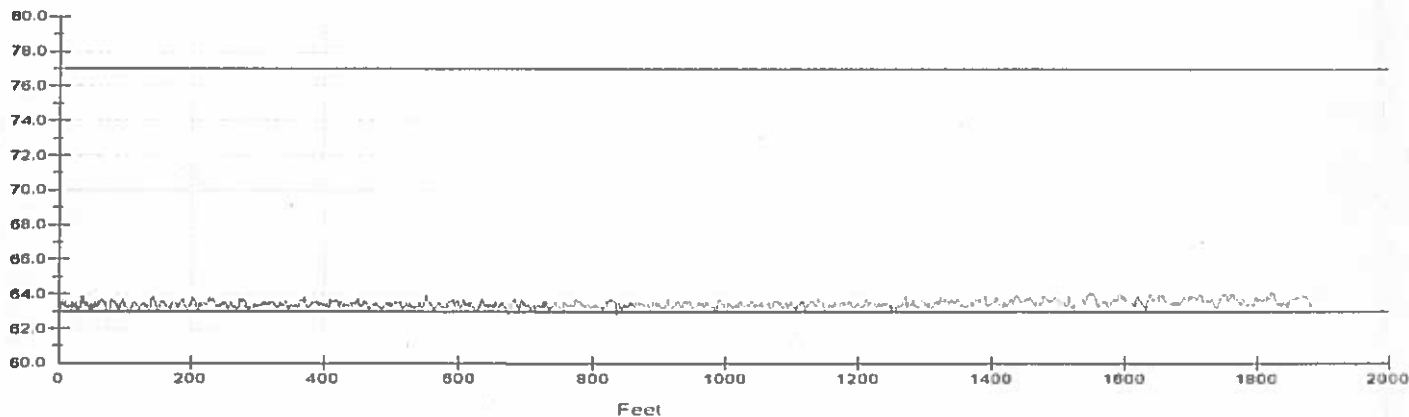
Upper Control Limit	0.0641 in	Upper Tolerance Limit	0.0770 in
X Double Bar	0.0634 in	R Bar	0.0022 in
Lower Control Limit	0.0628 in	Lower Tolerance Limit	0.0630 in
CR	9.0% (Capability Ratio %, 100/CP)		
CP	11.111 (Process Capability, HiLim-LoLim/6*Sigma)		
CPK	0.683 (Capability vs Limits)	TMW Ratio	0.993 (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	0.0%
-0.0080	0.9% --
-0.0090	0.0%
-0.0100	0.0%
---	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 NB49937)



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