

Process Audit Summary:

4/3/15 Sumter Red Bud PN 55743

Performed by: Patrick Macias

Level job of white painted for FHP.

All procedural coil identification checks followed.

Fourteen skids of 48" x 96" produced for FHP from coil. All skids produced to piece counts ordered by customer except for last skid which was 5 pieces over max piece count. Overage okayed by quality and sales notified. 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. 48.210" width measurement okayed by quality based on knowledge of customer's requirements. All measurements fell within customer tolerances.

Surface check showed no irregularities. Quality personnel stationed on observation stand throughout run.

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

No follow up required.

Part Spec/PO Audit Form

Cust #	2671	Customer	Florida Heat Pump	Grp/Sz/Grd/Width	PGVS/.0406"/WHITE/48"
Equip/Plant		Work Order #	Date	Part No.	
Work Order Information		Material to be Used		Actual	
		Tag #1	7551301	Tag #2	
		PO#	SMT-16023-1	PO#	
Gauge Range	.0360"-.0410"	Gauge Min	.0356"	Gauge Min	
Width Range	48"-48.1875"	Width	48"	Width	
Length Range	96"-96.25"				
Rockwell	NA	Rockwell	NA	Rockwell	
Tensile	NA				
Yield	NA				
% Elongation	NA				
Chem Rqmts	NA				
Other Rqmts	Wave/Bow/Flatness 0"-.12"				
	Square 0"-.03"				
Summary					
Actions					
Final Status					

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 55743 Coil Number: 7551301

Customer Number: FHP Coil Information: 2445652000 Supplier: PRECOAT METALS

Product: Steel Apr-3-15 14:22 to 16:25 (clock 122.4 min/ run 51.2 min) Shift: 2

Average Thickness and Tolerance Data

Target	0.0380 in	Average	0.0380 in	Average - Target	-0.0005 in (-1.33%)
				Standard Deviation	0.0002 in (0.55%)
Length	7499 ft	Above High Limit	0.0410 in	0 ft (0.0%)	
Width	48.000 in	In Tolerance		7499 ft (100.0%)	
Weight	46601 lbs	Below Low Limit	0.0360 in	0 ft (0.0%)	
Max Thickness	0.0390 in at 7476 ft	Min Thickness	0.0374 in at 630 ft		

Statistical Process Control Data

Upper Control Limit	0.0386 in	Upper Tolerance Limit	0.0410 in
X Double Bar	0.0380 in	R Bar	0.0006 in
Lower Control Limit	0.0374 in	Lower Tolerance Limit	0.0360 in
CR	25.2% (Capability Ratio %, 100/CP)		
CP	3.968 (Process Capability, HiLim-LoLim/6*Sigma)		
CPK	3.159 (Capability vs Limits)	TMW Ratio	0.948 (Low Limit/Avg)

Thickness Distribution Relative to the Target

+++	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%

100.0% is within ± 0.0010 in of the target	100.0% 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 7551301)

