

Process/Product Audit Checklist

Cust #: <u>1795</u> Customer: <u>BSH</u> GRP/Size/GRD/Width: <u>CRS.0307 DSENT 14.6970</u>				
PWC: <u>SRB</u> W/O#: <u>65061</u> Date: <u>4-4-17</u> Part #(s): <u>9000544794</u> Auditor: <u>B. Clem</u>				
Gauge Range: <u>.0305 - .0335</u> Actual Gauge: <u>.031</u> Width Range: <u>14.682 - 14.712</u> Width Actual: <u>14.702</u> Length Range: <u>36.5700 - 36.634</u> Length Actual: <u>36.595</u> Other: <u>W-B-F</u> Other Actual: <u>.060</u> Other: <u>0 - .120</u> Other Actual: <u>.024</u> Other: <u>2342 lbs</u> Other Actual: <u>2375 lbs</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?	✓			<u>Quwan & Chris M.</u>
Correct raw material type and size?	✓			Tag(s) to use: <u>AR54234</u> Tag(s) used: <u>AR54234</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: <u>N/A</u> W/O Rev: <u>N/A</u> Part Spec Rev: <u>N/A</u>] (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) <u>8-3 25' Tape 3-14-17 3-14-18</u> <u>m-44 1" mic 6-28-16 6-28-17</u> <u>ST-5 Step Gauge 7-5-16 7-5-17</u> <u>63294 Meas. Table 4-26-16 4-26-17</u>
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>SMT-SRB-001 11-8-16 5</u> <u>Jm-OP-001 4-21-15 0</u> <u>FOP081 2-16-01 1</u>
Hardcopy Controlled Documents are listed on Quality Intranet by location?			✓	List Documents and their Location:

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 65061 Coil Number: AR54234

Customer Number: BSH Coil Information: M S85739 Supplier: ARCELOR USA

Product: Steel Apr-4-17 20:14 to 21:23 (clock 68.8 min/ run 27.0 min) Shift: 2

Average Thickness and Tolerance Data

Target	0.0320 in	Average	0.0314 in	Average - Target	-0.0006 in (-1.75%)
				Standard Deviation	0.0003 in (0.84%)
Length	1838 ft	Above High Limit	0.0335 in	0 ft (0.0%)	
Width	59.400 in	In Tolerance		1838 ft (100.0%)	
Weight	11700 lbs	Below Low Limit	0.0305 in	0 ft (0.0%)	
Max Thickness	0.0325 in at	77 ft	Min Thickness	0.0306 in at	255 ft

Statistical Process Control Data

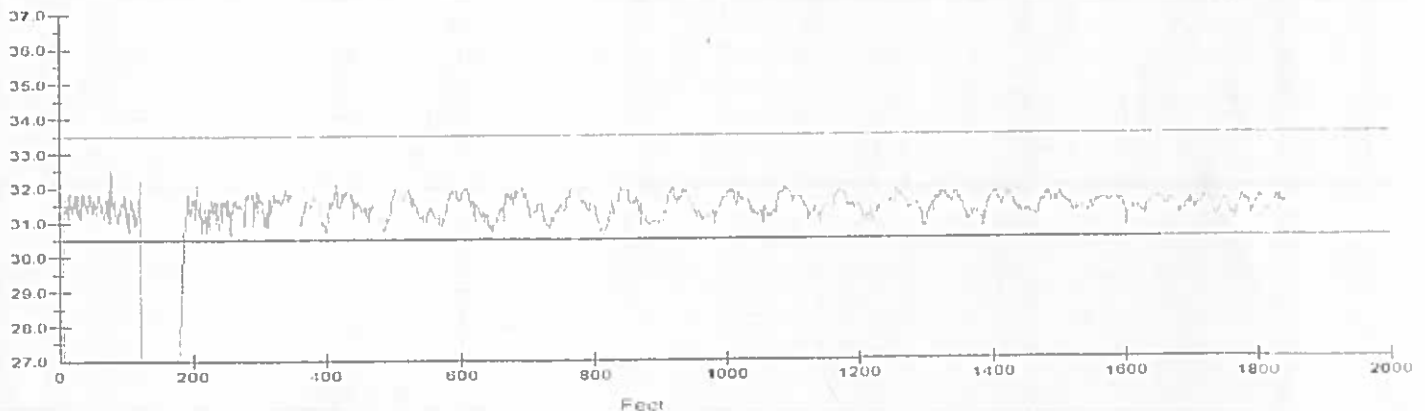
Upper Control Limit	0.0323 in	Upper Tolerance Limit	0.0335 in
X Double Bar	0.0314 in	R Bar	0.0008 in
Lower Control Limit	0.0306 in	Lower Tolerance Limit	0.0305 in
CR	54.0% (Capability Ratio %, 100/CP)		
CP	1.852 (Process Capability, HiLim-LoLim/6*Sigma)		
CPK	1.161 (Capability vs Limits)	TMW Ratio	0.970 (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	1.6% ***
-0.0005	48.5%
-0.0010	45.8%
-0.0015	4.1%
-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%

95.9% 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 AR54234)



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