

Process/Product Audit Checklist

Cust #: 2719 Customer: Altec - NC GRP/Size/GRD/Width: GNS.0785CB40N072

PWC: SRB W/O#: 73658 Date: 4-5-19 Part #(s): 970132967 Auditor: B. Clem

Gauge Range: .0685-.0865 Actual Gauge: .069 Width Range: 72-72.3125 Width Actual: 72.120

Length Range: 132-132.125 Length Actual: 132.050 Flatn Other: 0-.12 Other Actual: .050

Other: SQ 0-.31 Other Actual: Not Done Other: 25 pc/Tag Other Actual: 25 pc/Tag

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?		✓		Residual Stress Check Not done. No Square check Leguon - Done.
Correct raw material type and size?	✓			Tag(s) to use: <u>532995</u> Tag(s) used: <u>532995</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?		✓		Light black rust. OK'd per Stephen to run 2 bundles to see if customer can use
Out of spec noted, with actions taken?			✓	
Non-conforming material put into reject warehouse and physically put into non-conforming area?		✓		Run 2 Bundles per Stephen for Customer approval.
Required gages available & functional?	✓			
All Gages Calibrated (List in Comments)	✓			Gages Observed (list last calibration and when due) 8-3 25' Tape 3-7-19 3-7-20 m-sd 1" mic 8-31-18 8-31-19 ST-5 Step Gauge 7-5-18 7-5-19 63294 meas. Table 4-20-18 4-20-19
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	✓			
Required PPE being worn?		✓		No Safety Glasses - Leguon, James, Roland
Forms are the latest revision per Quality Intranet?	✓			List Forms (Observed Rev vs Intranet Rev) FOP081 2-16-01 1
Hardcopy Controlled Documents are listed on Quality Intranet by location?	✓			List Documents and their Location: SMT-SRB-001 JM-OP-001 SMT-SH-001

Residual Stress check was noted on inspection Sheet (FOP 081) but was not done. There was no square check done.



Material Inspection Report

LOCATION

Sumter

DATE

4/5/2019

CUSTOMER

ALTEC

JOB # SMT

73658

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	Order Dim		Tolerances		Tolerances		Low Limit		High Limit
Gauge	0.067	-	-0.002	+	0.020		0.069		0.087
Width	72.000	-	0.000	+	0.313		72.000		72.313
Length	132.000	-	0.000	+	0.125		132.000		132.125

	Set up Target		Side Type	Skid Type Error		Skid Code
Gauge	0.078			SOP'S		035
Width	72.156					
Length	132.063					

Finished Goods Tag	74482	74484					
Master Coil Number	532995						
Heat							
Enhanced Weight							
Gross Weight	4940	4940					
Tare	275	275					
Net Weight	4665	4665	0	0	0		
Bundle Status							
Good Pcs.	25	25					
Scraped Pcs.							
Rockwell							
Gauge Head	E 0.069						
	C 0.070						
	E 0.069						
Body	E 0.069						
	C 0.070						
	E 0.069						
Tail	E 0.069	0.069					
	C 0.070	0.070					
	E 0.069	0.069					
Surface							
Width Head	72.120						
Body	72.120						
Tail	72.121	72.132					
Shape	.050/.050/.050	0.050					
Residual Check	.050/.050/.050	0.050					
Length Head	132.050						
Body	132.050						
Tail	132.050	132.050					
Squareness							
Camber							
Operator	LM	LM					
Setup Approval							
Run Time	S	F		Down Time	S	F	
Total Run Time	0:00	Cost	\$0.00	Cst/Hour		\$400.00	
Comments							