Process/Product Audit Checklist

Cust #: 3023 Customer: Custom Metel GRP/Size/GRD/Width: CRS .1046 CSB 48

PWC: SRB W/O#: 65659 Date: 5-11-17 Part #(s): 12 GA CRS 48x96 Auditor: B. Clem

Gauge Range: .0950 – .1046 Actual Gauge: .096 Width Range: 48 – 48.1875 Width Actual: 48.105

Length Range: 95.875 – 96.1250 Length Actual: 96.000 Other: W-F 0 – .12 Other Actual: 0

Other: 36 pcs./Tag Other Actual: 36 pcs/Tag Other: Wt. 4921 lbs. Other Actual: 4550 lbs

Item	YES	NO	N/A	Comments/Action Taken (Required for NO)
Process Inspection Sheets filled out according to frequency and sampling required?	✓			Lequwon + Chris D.
Correct raw material type and size?	✓			Tag(s) to use: 509158 Tag(s) used: 509158
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: N/A, W/O Rev: N/A Part Spec Rev: N/A] (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) 8-3 25' Tape 3-14-17 3-14-18 M-44 1" Mic 6-28-16 6-28-17 ST-5 Step Gauge 7-5-16 7-5-17 63294 Meas. Table 4-19-17 4-19-18
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) SMT-SRB-001 11-8-16 5 JM-OP-001 4-21-15 0 FOP081 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: 65659 Coil Number: 509158

Customer Number: CUSTOM METAL Coil Information: NUB1701183 Supplier: NUCOR BERKELY

Product: Steel May-11-17 18:32 to 19:04 (clock 32.0 min/ run 10.6 min) Shift: 2

Average Thickness and Tolerance Data

Target 0.0998 in Average^ 0.0968 in Average - Target -0.0030 in (-3.01%)
Standard Deviation^ 0.0004 in (0.43%)

Length	954 ft	Above High Limit	0.1046 in	0 ft (0.0%)
Width	48.000 in	In Tolerance		954 ft (100.0%)
Weight	15112 lbs	Below Low Limit	0.0950 in	2 ft (0.0%)

Max Thickness 0.0979 in at 927 ft Min Thickness 0.0950 in at 890 ft

Statistical Process Control Data

Upper Control Limit	0.0981 in	Upper Tolerance Limit	0.1046 in
X Double Bar	0.0968 in	R Bar	0.0013 in
Lower Control Limit	0.0955 in	Lower Tolerance Limit	0.0950 in

CR 26.9% (Capability Ratio %, 100/CP)
CP 3.721 (Process Capability, HiLim-LoLim/6*Sigma)
CPK 1.395 (Capability vs Limits) TMW Ratio 0.981(Low Limit/Avg)

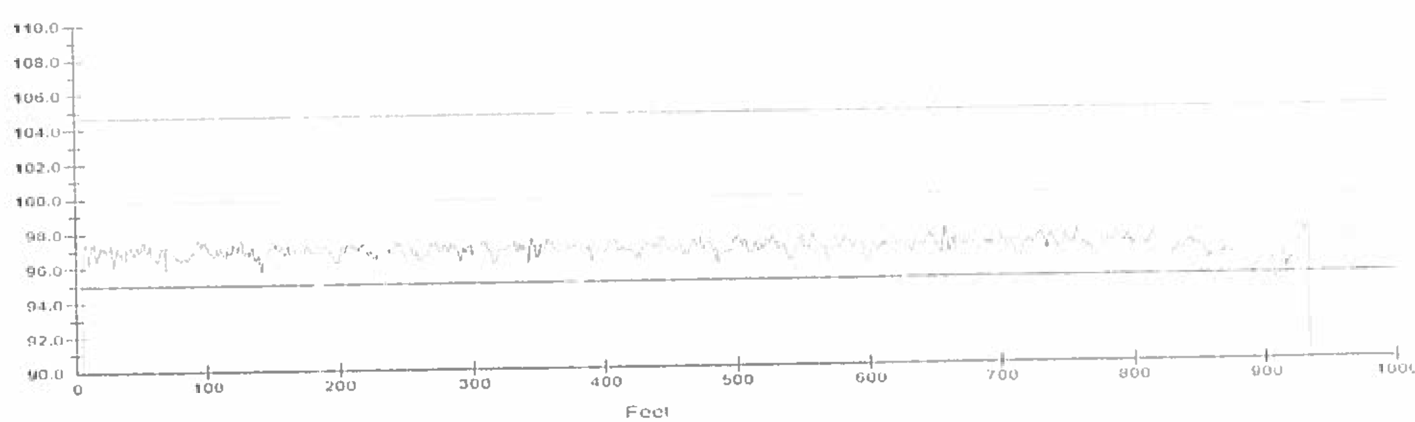
Thickness Distribution Relative to the Target

+++	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	0.2%
-0.0030	63.6%
-0.0040	33.4%
-0.0050	2.8%
-0.0060	0.0%
-0.0070	0.0%
-0.0080	0.0%
-0.0090	0.0%
-0.0100	0.0%
---	0.0%

0 3 6 9 12 15 18 21 24 27 30 33

0.2% is within ± 0.0020 in of the target 100.0% 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 509158)



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