Process/Product Audit Checklist

Cust #: 1795 Customer: BSH Home GRP/Size/GRD/Width: CRS.0307DSENT114.6970

PWC: SRB W/O#: 65722 Date: 5-16-17 Part #(s): 9000544794 Auditor: B.Clem

Gauge Range: .0307—.0335 Actual Gauge: .0298 Width Range: 14.682—14.712 Width Actual: 14.707

Length Range: 36.57—36.634 Length Actual: 36.603 Other: W-B-F 0-.12 Other Actual: .030

Other: SQ 0-.12 Other Actual: .015 Other: WH 2342 lbs Other Actual: 1995 lbs.

Item	YES	NO	N/A	Comments/Action Taken (Required for NO)
Process Inspection Sheets filled out according to frequency and sampling required?	✓			Leguwon & Chris M.
Correct raw material type and size?	✓			Tag(s) to use: 508570 Tag(s) used: 508570
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?]		✓		Gauge .0298 - OK per Patrick [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?		✓		Gauge .0298 - OK per Patrick
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: 65722   Coil Number: 508570

Customer Number: BSH   Coil Information: M R25170   Supplier: ARCELOR USA

Product: Steel   May-16-17 20:09 to 21:40 (clock 91.3 min/ run 49.6 min)   Shift: 2

Average Thickness and Tolerance Data

```
Target  0.0320 in    Average^ 0.0292 in     Average - Target     -0.0028 in (-8.72%)
                                            Standard Deviation^  0.0002 in ( 0.53%)

Length      4520 ft              Above High Limit    0.0335 in       0 ft (   0.0%)
Width     14.697 in              In Tolerance                        0 ft (   0.0%)
Weight      6613 lbs             Below Low Limit     0.0305 in    4520 ft (100.0%)

Max Thickness  0.0297 in at   4255 ft        Min Thickness  0.0285 in at   1380 ft
```

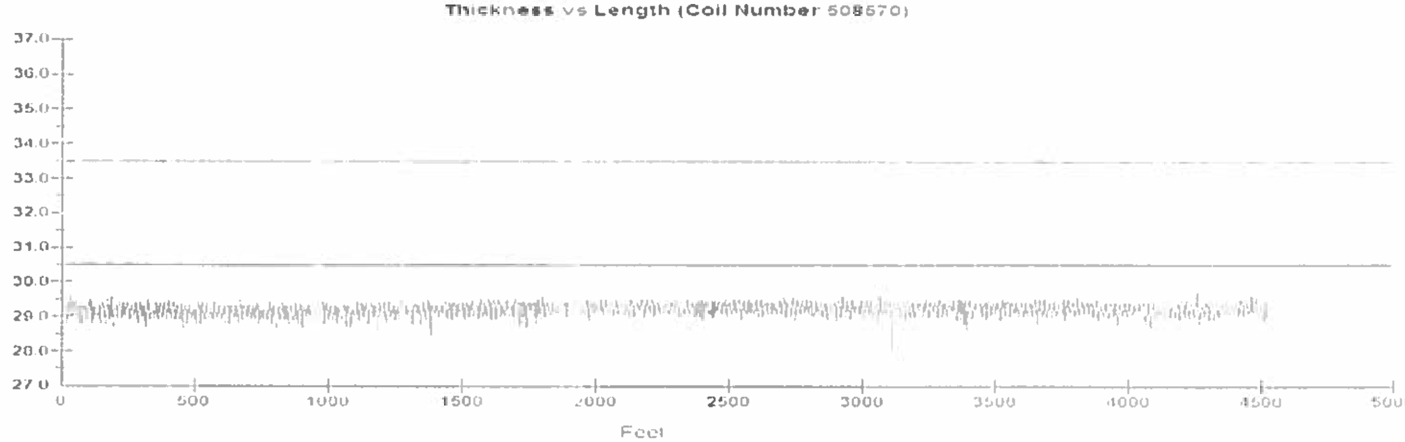
Statistical Process Control Data

```
Upper Control Limit     0.0297 in    Upper Tolerance Limit      0.0335 in
X Double Bar            0.0292 in    R Bar                      0.0005 in
Lower Control Limit     0.0287 in    Lower Tolerance Limit      0.0305 in

CR     34.0% (Capability Ratio %, 100/CP)
CP     2.941  (Process Capability, HiLim-LoLim/6*Sigma)
CPK  -2.529  (Capability vs Limits)         TMW Ratio      1.044(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    5.6% -----------
 -0.0030   86.8% ------------------------------------------------------------------->
 -0.0035    7.6% ---------------
 -0.0040    0.0%
 -0.0045    0.0%
 -0.0050    0.0%
     ---    0.0%
                 0     3     6     9     12    15    18    21    24    27    30    33

  0.0% is within ± 0.0010 in of the target      5.6% 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 508570)



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