

# Process/Product Audit Checklist

Cust #: 6941		Customer: Lozier		GRP/Size/GRD/Width: CRC/0.080/CSB/3.3438"	
PWC: CLO		W/O#: 81073		Date: 5/2/2022	
				8097313-009, 8097313-005	
				Auditor: Patrick Macias	
Gauge Range: .080"-.086"		Actual Gauge: .086/.087" GAUGE OK BY SV		Width Range: 3.3388"-3.3488"	
				Width Actual: 3.345"	
Length Range: NA		Length Actual: NA		Other: Camber .25"	
				NO CAMBER CHECK Other Actual: RECORDED	
Other: NA		Other Actual: NA		Other: NA	
				Other Actual: NA	
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?	X			JERALD PRINCE	
Correct raw material type and size?	X			Tag(s) to use: 258150 Tag(s) used: 258150	
Setup performed according to W/O?	X				
Product is acceptable according to customer-specific requirements? [Fab: Is the Part Print Present & the correct Revision? Are required measurements documented?]		X		.087" GAUGE ONE POINT HIGH, APPROVED BY SUPERVISOR Camber check performed but not recorded. [Fab: Print Rev: _____, W/O Rev: _____, Part Spec Rev: _____] (Leave blank if non-Fab audit)	
Packaging is acceptable according to customer-specific requirements?	X				
Visual Inspection performed and product meets requirements?	X				
Out of spec noted, with actions taken?			X		
Non-conforming material put into reject warehouse and physically put into non-conforming area?			X		
Required gages available & functional?	X				
All Gages Calibrated (List in Comments)	X			Gages Observed (list last calibration and when due) Micrometer #RB121 last 5/0/2022 due 6/0/2022* Caliper #SH1 last 5/0/2022 due 6/0/2022	
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	X				
Required PPE being worn?	X				
Forms are the latest revision per Quality Intranet?	X			List Forms (Observed Rev vs Intranet Rev) Slitting order JDM 4, 7/21/2017, rev 7 (current) Slit Size Inspection JDM 3, 3/1/17, Rev 4 (current)	
Hardcopy Controlled Documents are listed on Quality Intranet by location?	X			List Documents and their Location: CLV-SL-001 LOOPCO Procedure (electronic copy) REV 1, 3/7/13	



# AGT400 Coil Summary Report

## Jemison Metals -- 60 Inch Loopco Slitter

Work Order: CLV 81073 Coil Number: 258150

Customer Name: LOZIER Heat Number: MNL80:0

Product: H.R.P.O. Steel May-2-22 5:28 AM to 5:32 AM (clock 4.2 min/ run 3.8 min) Shift: 3

### Average Thickness and Tolerance Data

Target	86.3 mil	Average^	86.3 mil	Average - Target	3.3200 mil ( 4.00%)
				Standard Deviation^	0.6300 mil ( 0.76%)
Length	1313 ft	Above High Limit	86.0 mil		792 ft ( 60.3%)
Width	19.250 in	In Tolerance			792 ft ( 60.3%)
Weight	7434 lbs	Below Low Limit	80.0 mil		0 ft ( 0.0%)

Max Thickness	87.8 mil at	1301 ft	Min Thickness	85.0 mil at	4 ft
Head Scrap	0 ft		Tail Scrap	0 ft	

### Statistical Process Control Data

Upper Control Limit	88.2 mil	Upper Tolerance Limit	86.0 mil
X Double Bar	86.3 mil	R Bar	1.9 mil
Lower Control Limit	84.4 mil	Lower Tolerance Limit	80.0 mil

CR 63.0% (Capability Ratio %, 100/CP)

CP 1.587 (Process Capability, HiLim-LoLim/6\*Sigma)

CPK -0.169 (Capability vs Limits)

TMW Ratio

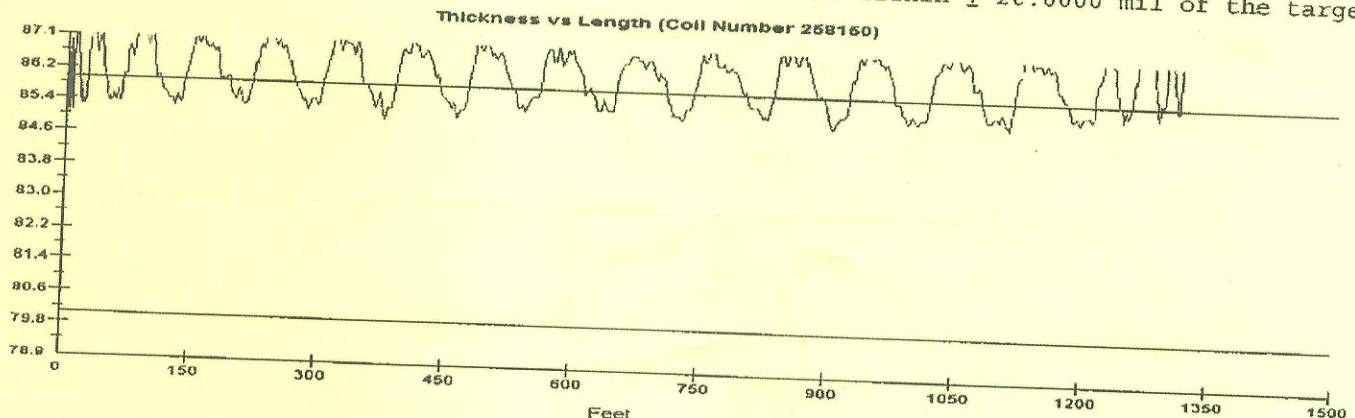
0.927 (Low Limit/Avg)

### Thickness Distribution Relative to the Target

+++ 0.0%	
+10.0 0.0%	
+ 9.0 0.0%	
+ 8.0 0.0%	
+ 7.0 0.0%	
+ 6.0 0.0%	
+ 5.0 0.0%	
+ 4.0 20.3%	
+ 3.0 35.3%	
+ 2.0 14.4%	
+ 1.0 0.0%	
+ 0.0 0.0%	
- 0.0 0.0%	
- 1.0 0.0%	
- 2.0 0.0%	
- 3.0 0.0%	
- 4.0 0.0%	
- 5.0 0.0%	
- 6.0 0.0%	
- 7.0 0.0%	
- 8.0 0.0%	
- 9.0 0.0%	
- 10.0 0.0%	
--- 0.0%	

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

34.4% is within  $\pm 2.0000$  mil of the target 100.0% is within  $\pm 5.0000$  mil of the target  
 100.0% is within  $\pm 10.0000$  mil of the target 100.0% is within  $\pm 20.0000$  mil of the target



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