

Process/Product Audit Checklist

Cust #: 9509 Customer: Arrow Tru-Line GRP/Size/GRD/Width: TGV/C/0.0380/S33G40/7.9690				
PWC: CLO W/O#: CLV 60477 Date: 05/25/16 Part #(s): 9509/02 .0380 X 7.969 HDG				
Gauge Range: 0.0380-0.0420 Actual Gauge: .040/.0405 Width Range: 7.964-7.974 Width Actual: 7.970/7.971				
Length Range: Coil Length Actual: Coil Other: ID: 20" Other Actual: ID: 20"				
Other: Wt/Skd: 5000 Other Actual: Wt/Skd: <5000 Other: MxWgt: 3750 Other Actual: MxWgt: <3750				
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			
Correct raw material type and size?	X			Tag(s) to use: 69767 Tag(s) used: 69767
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			[Fab: Print Rev: _____, W/O Rev: _____, Part Spec Rev: _____]
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) Mic: Pasxon 12 Last Cal: 05/16 Due: 06/16 Caliper: SH1 Last Cal: 03/16 Due: 06/16 Tape: 7 Last Cal: 09/15 Due: 09/16
Housekeeping: Machine/Floor clean?	X			
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) Slit Size Inspection Rev. Level 3 Int: Level 3 JDM3 11/30/2015 11/30/15 Slitting Order Rev. Level 7 Int: Level 7 JDM4 7/21/2011 07/21/11
Hardcopy Controlled Documents are listed on Quality Intranet by location?	X			List Documents and their Location: Quality Policy Rev. 0 JDM200 05/15/2010

Slit Size Inspection

Date: 5.25.16 Work Order: CLV 60477

Size of Cuts	Beginning Width	Mics	(Paxson Only) Middle Mics	End Width	Mics
7.969	7.970			7.970	
	7.970	.040		7.970	
	7.971			7.971	.040.5
	7.970	.040.5		7.970	
	7.970			7.970	
	7.970			7.970	
	7.971			7.971	

Non-Conformance

Surface
Defects

Yes*/No** (If Yes, Description)

NO

Burrs

NO

Shape

Defects

NO

Initials

*Need Resolution, OK'd or Segregated

**No Non-Conformance Present

T.R.

Slitting Order

Date: 5.26.16	Customer: Arrow
Work Order #: CLV 60477	Date Run: 5.25.16

Incoming Inspection Checklist

Tag #	Gauge & Width	Type	Tag Wgt.	RB	Olsen	Actual Wgt.	Width	Mic
69767	.038 / 56.125	TGVC	21,960	11		21,900	56 3/16	.040 / .0405

Cutting Instructions:

7. CUTS @ 7.969

Slit Tolerance: + - .005	Max O.D: STR THRU	Max Skid Wgt: 5000	I.D: 20"
Gauge Range: .038 / .042	Salesman:		

Special Instructions:

1 Cuts with some defect but okay to ship

_____ Cut Size
 _____ Cut Weight
 N/A _____ Defect
 _____ Approved By

2 Cuts Rejected

_____ Cut Size
 _____ Cut Weight
 N/A _____ Tag No. or No.'s
 _____ Reason for Reject

3 Ok to move material for shipment or to Stock

E.T _____ Name
 5-26-16 _____ Date

AGT400 Coil Summary Report

Jemison Metals -- 60 Inch Loopco Slitter

Work Order: CLV 60477 Coil Number: 69767

Customer Name: ARROW Heat Number: META603593

Product: G30 Galvanized May-25-16 2:21 PM to 2:28 PM (clock 8.0 min/ run 7.9 min) Shift: 1

Average Thickness and Tolerance Data

Target 0.0400 in Average^ 0.0400 in Average - Target 0.0000 in (-0.08%)
Standard Deviation^ 0.0003 in (0.70%)

Length 2896 ft Above High Limit 0.0420 in 0 ft (0.0%)
Width 56.125 in In Tolerance 2896 ft (100.0%)
Weight 22137 lbs Below Low Limit 0.0380 in 0 ft (0.0%)

Max Thickness 0.0409 in at 7 ft Min Thickness 0.0392 in at 580 ft
Head Scrap 0 ft Tail Scrap 0 ft

Statistical Process Control Data

Upper Control Limit 0.0408 in Upper Tolerance Limit 0.0420 in
X Double Bar 0.0400 in R Bar 0.0008 in
Lower Control Limit 0.0391 in Lower Tolerance Limit 0.0380 in

CR 42.0% (Capability Ratio %, 100/CP)

CP 2.381 (Process Capability, HiLim-LoLim/6*Sigma)

CPK 2.345 (Capability vs Limits) TMW Ratio 0.951(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	3.1% *****
+0.0000	50.3% >*****>
-0.0005	44.6% >*****>
-0.0010	1.9% *****
-0.0015	0.0%
-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%

100.0% 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 69767)

