

Process/Product Audit Checklist

Cust #: 3023 Customer: Custom Metal GRP/Size/GRD/Width: GNS .0635 CB60CD 60
16 GA GNS 60X120.375
PWC: SRB W/O#: 61401 Date: 5-25-16 Part #(s): 16 GA GNS 60X144 / 16 GA GNS 60X96
.0575 - .0635
Gauge Range: .059 Actual Gauge: .059 Width Range: 60-60.1875 Width Actual: 60.134
144 - 144.1250
Length Range: 144.030 Length Actual: 144.030 120.3750 Other: 120.5000 Other Actual: 120.400
96 - 96.1250
Length 96-96.1250 Other: 96.030 W-F Other: 0-.12 Other Actual: 0

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?		✓		<u>Leguon & Chris</u> <u>only one check done on 1st skid</u>
Correct raw material type and size?	✓			Tag(s) to use: <u>NB50383</u> Tag(s) used: <u>NB50383</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: _____]
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) <u>25' Tape 8-3 3-8-16 3-8-17</u> <u>1" mic m-44 10-1-15 10-1-16</u> <u>57.5 Step Gauge 7-7-15 7-7-16</u> <u>63294 Meas. Table 4-26-16 4-26-17</u>
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	✓			
Required PPE being worn?		✓		<u>No Safety Glasses - Chris</u>
Forms are the latest revision per Quality Intranet?	✓			List Forms (Observed Rev vs Intranet Rev) <u>Smt-SRB-001 3-7-13 4</u> <u>Jm-OP-001 4-21-15 0</u> <u>FOP081 2-16-01 1</u>
Hardcopy Controlled Documents are listed on Quality Intranet by location?			✓	List Documents and their Location:

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 61400 Coil Number: NB50383

Customer Number: CUSTOM Coil Information: NUB2605641 Supplier: NUCOR BERKELY

Product: Steel May-25-16 18:25 to 19:20 (clock 55.1 min/ run 13.7 min) Shift: 2

Average Thickness and Tolerance Data

Target 0.0605 in Average^ 0.0583 in Average - Target -0.0022 in (-3.70%)
Standard Deviation^ 0.0003 in (0.53%)

Length 1943 ft Above High Limit 0.0635 in 0 ft (0.0%)
Width 60.000 in In Tolerance
Weight 23146 lbs Below Low Limit 0.0575 in 6 ft (0.3%)

Max Thickness 0.0592 in at 1868 ft Min Thickness 0.0573 in at 1365 ft

Statistical Process Control Data

Upper Control Limit 0.0592 in Upper Tolerance Limit 0.0635 in
X Double Bar 0.0583 in R Bar 0.0010 in
Lower Control Limit 0.0573 in Lower Tolerance Limit 0.0575 in

CR 32.0% (Capability Ratio %, 100/CP)

CP 3.125 (Process Capability, HiLim-LoLim/6*Sigma)

CPK 0.792 (Capability vs Limits) TMW Ratio 0.987 (Low Limit/Avg)

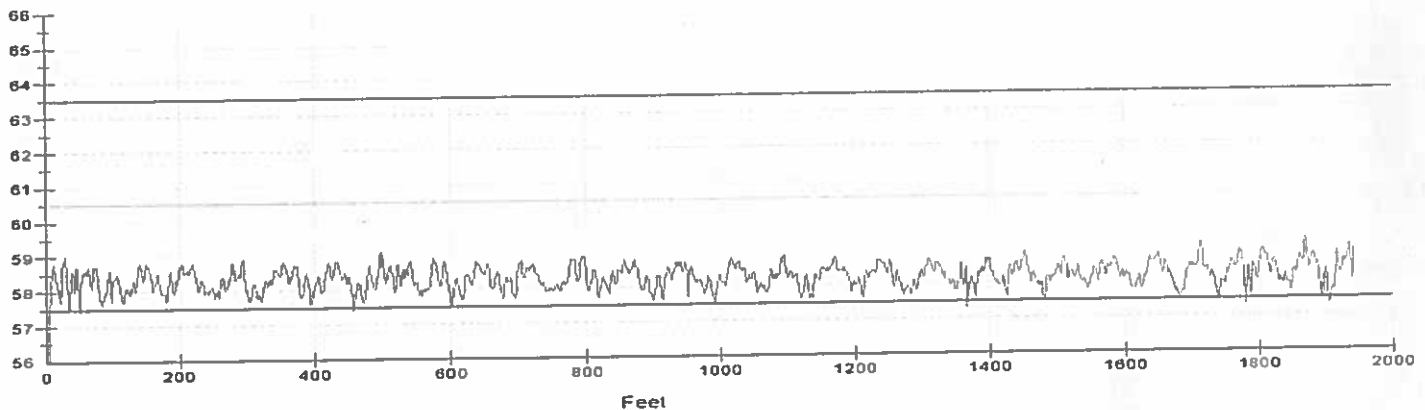
Thickness Distribution Relative to the Target

+++	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	29.9%
-0.0030	29.9%
-0.0040	0.3%
-0.0050	0.0%
-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

29.9% 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 NB50383)



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