# Process/Product Audit Checklist

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|---|---|---|---|
| Cust #: 3023 | Customer: Custom metal | GRP/Size/GRD/Width: GNS.0635CB60CD 60 | |
| PWC: SRB | W/O#: 65842 | Date: 5-25-17 | Part #(s): 16 GA GNS 60x96 / Auditor: B. Clem |
| Gauge Range: .0575-.0635 | Actual Gauge: .057 | Width Range: 60-60.2500 | Width Actual: 60.121 |
| Length Range: 96-96.1250 | Length Actual: 96.050 | Other: W-F 0-.12 | Other Actual: .050 |
| Other: wt 6016 lbs | Other Actual: 5495 lbs | Other: 58pcs/Tag | Other Actual: 58pcs./Tag |

| Item | YES | NO | N/A | Comments/Action Taken (Required for NO) |
|---|---|---|---|---|
| Process Inspection Sheets filled out according to frequency and sampling required? | ✓ | | | Laquwon & Chris |
| Correct raw material type and size? | ✓ | | | Tag(s) to use: NB2082<br>Tag(s) used: NB2082 |
| 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 was .057 - OK per Patrick<br>[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? | ✓ | | | Gauge .057 OK per Patrick |
| Non-conforming material put into reject warehouse and physically put into non-conforming area? | | ✓ | | Gage .057 OK per Patrick |
| Required gages available & functional? | ✓ | | | |
| All Gages Calibrated (List in Comments) | ✓ | | | Gages Observed (list last calibration and when due)<br>8-3 25' Tape 5-25-17 5-25-18<br>M-44 1" mic 6-28-16 6-28-17<br>ST-5 Step Gauge 7-5-16 7-5-17<br>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)<br>SMT-SRB-001 11-8-16 5<br>JM-OP-001 4-21-15 0<br>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: 65842 Coil Number: NB2082

Customer Number: CUSTOM Coil Information: NUB2615131 Supplier: NUCOR BERKLEY

Product: Steel May-25-17 21:40 to 22:13 (clock 33.0 min/ run 10.7 min) Shift: 2

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Average Thickness and Tolerance Data
Target  0.0605 in    Average^ 0.0589 in       Average - Target     -0.0016 in (-2.65%)
                                              Standard Deviation^  0.0003 in ( 0.50%)

Length      1317 ft             Above High Limit    0.0635 in       0 ft (  0.0%)
Width     60.000 in             In Tolerance                     1317 ft (100.0%)
Weight    15852 lbs             Below Low Limit     0.0575 in       0 ft (  0.0%)

Max Thickness  0.0597 in at    915 ft      Min Thickness  0.0575 in at      0 ft

Statistical Process Control Data
Upper Control Limit    0.0598 in    Upper Tolerance Limit      0.0635 in
X Double Bar           0.0589 in    R Bar                      0.0009 in
Lower Control Limit    0.0580 in    Lower Tolerance Limit      0.0575 in

CR    30.0% (Capability Ratio %, 100/CP)
CP    3.333  (Process Capability, HiLim-LoLim/6*Sigma)
CPK   1.522  (Capability vs Limits)          TMW Ratio        0.977(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    1.6% ***
 -0.0020   89.9% ****************************************************************************
 -0.0030    8.5% ****************
 -0.0040    0.0%
 -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

 91.5% 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
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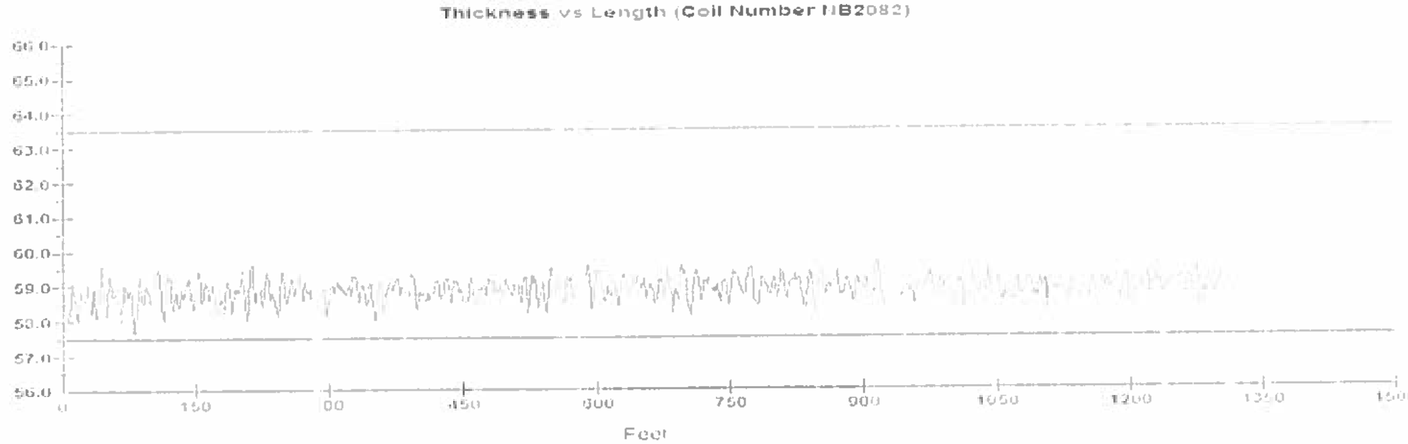
Thickness vs Length (Coil Number NB2082)




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