

Process/Product Audit Checklist

Cust #: 2990 Customer: Ohio Stamping GRP/Size/GRD/Width: GVC/0.0296/DD30CD/33.4450				
PWC: CLO W/O#: CLV 60400 Date: 05/27/16 Part #(s): 2990/900022067				
Gauge Range: 0.0296-0.0336 Actual Gauge: .0305/.0310 Width Range: 33.445-33.465 Width Actual: 33.446				
Length Range: Coil Length Actual: Coil Other: ID: 24 Other Actual: ID: 24				
Other: MnWgt: 7628 Other Actual: Wgt OK per Sales/Customer Other: MxWgt: 34327 Other Actual: MxWgt: <34327				
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: 69835 Tag(s) used: 69835
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			Laminations removed when spotted during production.
Non-conforming material put into reject warehouse and physically put into non-conforming area?				Job was costed prior to reject tags being entered. Still working on job to created rejects as of 06/02/16.
Required gages available & functional?	X			
All Gages Calibrated (List in Comments)	X			Gages Observed (list last calibration and when due) Mic: Paxson 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 JDM 200 05/15/2010

Slitting Order

Date: 5.27.16	Customer: OHIO STAMPING
Work Order #: CLV 60400	Date Run: 5.31.16

Incoming Inspection Checklist

Tag #	Gauge & Width	Type	Tag Wgt.	RB	Olsen	Actual Wgt.	Width	Mic
69835	.029.6 / 33.945	GVC	31,130	11		31,130	34 1/8	.0305 / .031

Cutting Instructions:

1 cut @ 33.445

Slit Tolerance: + - .020	Max O.D: 43.85	Max Skid Wgt: 36,000	I.D: 24"
Gauge Range: .029.6 / .033.6		Salesman:	

Special Instructions:

1 Cuts with some defect but okay to ship

_____ Cut Size
 _____ Cut Weight
 _____ NA Defect
 _____ Approved By

2 Cuts Rejected

_____ Cut Size
 _____ Cut Weight
 _____ NA Tag No. or No.'s
 _____ Reason for Reject

3 Ok to move material for shipment or to Stock

_____ Name
 _____ Date
 (Signature) 6/1/16

AGT400 Coil Summary Report

Jemison Metals -- 60 Inch Loopco Slitter

Work Order: CLV 60400 Coil Number: 69835

Customer Name: OHIO STAMPING Heat Number: DUFUSSR22882

Product: G30 Galvanized May-31-16 5:30 AM to 7:04 AM (clock 93.8 min/ run 22.7 min) Shift: 1

Average Thickness and Tolerance Data

Target 0.0316 in Average^ 0.0304 in Average - Target -0.0012 in (-3.92%)
Standard Deviation^ 0.0003 in (0.82%)

Length 8882 ft Above High Limit 0.0336 in 0 ft (0.0%)
Width 33.945 in In Tolerance 8882 ft (100.0%)
Weight 31195 lbs Below Low Limit 0.0296 in 0 ft (0.0%)

Max Thickness 0.0314 in at 26 ft Min Thickness 0.0296 in at 221 ft
Head Scrap 0 ft Tail Scrap 0 ft

Statistical Process Control Data

Upper Control Limit 0.0311 in Upper Tolerance Limit 0.0336 in
X Double Bar 0.0304 in R Bar 0.0008 in
Lower Control Limit 0.0296 in Lower Tolerance Limit 0.0296 in

CR 39.0% (Capability Ratio %, 100/CP)

CP 2.564 (Process Capability, HiLim-LoLim/6*Sigma)

CPK 0.974 (Capability vs Limits) TMW Ratio 0.975 (Low Limit/Avg)

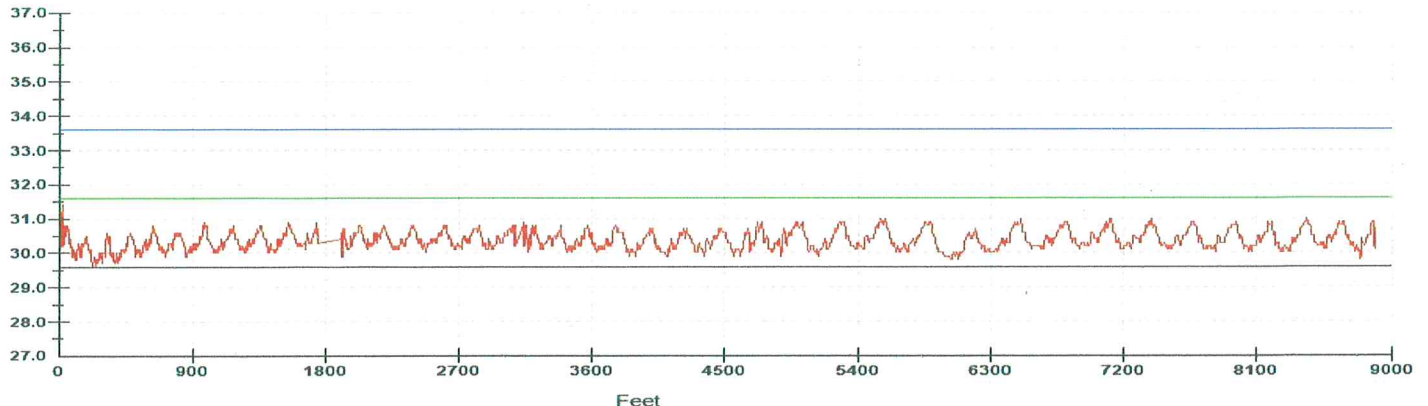
Thickness Distribution Relative to the Target

+++ 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 25.3% *****
-0.0015 63.8% *****>
-0.0020 10.9% *****
-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%

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

25.3% 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 69835)



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

Slit Size Inspection

Date: 5.27.16

Work Order: CLV 60400

Size of Cuts	Beginning Width	Mics	(Paxson Only) Middle Mics	End Width	Mics
33.445	33.446	.030.5		33.446	.030.5
		.031			.031.5

Non-Conformance

Surface
Defects
Burrs
Shape
Defects

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

NO
NO
NO

Initials

T.R.

*Need Resolution, OK'd or Segragated

**No Non-Conformance Present