

Process/Product Audit Checklist

Cust #: <u>1744</u> Customer: <u>Eaton-Greenwood</u> GRP/Size/GRD/Width: <u>POS/.0748/CSB/60</u>				
PWC: <u>SCT</u> W/O#: <u>93686</u> Date: <u>5/21/2024</u> Part #(s): <u>HRPO-080-5X10</u> Auditor: <u>B. Clem</u>				
Gauge Range: <u>.0677-.0817</u> Actual Gauge: <u>.074</u> Width Range: <u>60-60.9999</u> Width Actual: <u>60.112</u>				
Length Range: <u>120-120.260</u> Length Actual: <u>120.126</u> W-B Other: <u>0-.18</u> Other Actual: <u>Less .18</u>				
SQ Other: <u>0-.31</u> Other Actual: <u>.126</u> W/Skd Other: <u>4000</u> Other Actual: <u>3971</u>				
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		Marquez - Shape check not noted on inspection report. No guage width or length check noted on 3rd or last check.
Correct raw material type and size?	x			Tag(s) to use: <u>NB79045</u> Tag(s) used: <u>NB79045</u>
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:____] (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) 03-03 25' Tape 3/13/2024 3/13/2025 CL-2 25' Tape 3/26/2024 3/26/2025 M50 1" Mic 1/19/2024 1/19/2025 ST-4 Step Gauge 6/28/2023 6/28/2024 63294 Measuring Table 4/26/2022 4/26/2025
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) FOP081 2/16/01 1
Hardcopy Controlled Documents are listed on Quality Intranet by location?	x			List Documents and their Location: SMT-CTL-001 SMT-SH-001 JM-OP-001



Material Inspection Report

LOCATION

Sumter

DATE

7/12/2024

CUSTOMER

LASER

JOB # SMT

93686

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	Order Dim	Tolerances	Tolerances	Low Limit	High Limit
Gauge	0.069	0.002	0.012	0.067	0.081
Width	60.000	0.000	0.999	60.000	60.999
Length	120.000	0.000	0.250	120.000	120.250

	Set up Target	Side Type	Skid Type Error	Skid Code	0	3	4
Gauge	0.074						
Width	60.500						
Length	120.125						

SOP'S		
JDOP008	JDOP016	JDOP046
JDOP014	JDOP034	JDOP032

Finished Goods Tag	265083	265053	265089	265092		
Master Coil Number	NB79045	NB79045	NB79045	NB79045		
Heat	NUB1403222	NUB1403222	NUB1403222	3971		
Enhanced Weight	3971	3971	3971			
Gross Weight	3971	3971	3971	3971		
Tare						
Net Weight	3971	3971	3971	3971	0	
Bundle Status						
Good Pcs.	26	26	26	26		
Scraped Pcs.						
Rockwell						
Gauge Head	E 0.074	0.075				
	C 0.073	0.074				
	E 0.073	0.073				
Body	E					
	C					
	E					
Tail	E					
	C					
	E					
Surface						
Width Head	60.112	60.114				
Body						
Tail						
Shape						
Residual Check	0.060	0.060	0.060	0.060		
Length Head	120.125					
Body						
Tail						
Squareness	.125	.125	.125	.125		
Camber						
Operator	MR	MR	MR	MR		
Setup Approval						
Run Time	S	F	Down Time	S	F	
Total Run Time	0:00	Cost	\$0.00	Cst/Hour	\$400.00	
Comments						

AGT400 Coil Summary Report

Jemison Metals -- 72 Inch Pro-Eco C-T-L

Work Order: 93686 Coil Number: NB79045

Customer Name: LASER Heat Number: NUB1403222 Vendor: XYZ Co

Product: Cold-Rolled Steel May-21-24 8:17 AM to 9:59 AM (clock 101.5 min/ run 28.8 min) Shift: 1

Average Thickness and Tolerance Data

Target 74.0 mil Average^ 73.6 mil Average - Target -0.4300 mil (-0.58%)
Standard Deviation^ 0.6100 mil (0.82%)

Length 2500 ft Above High Limit 81.0 mil 0 ft (0.0%)
Width 60.000 in In Tolerance 2500 ft (100.0%)
Weight 37758 lbs Below Low Limit 67.0 mil 0 ft (0.0%)

Max Thickness 76.5 mil at 2495 ft Min Thickness 71.8 mil at 2260 ft
Head Scrap 0 ft Tail Scrap 0 ft

Statistical Process Control Data

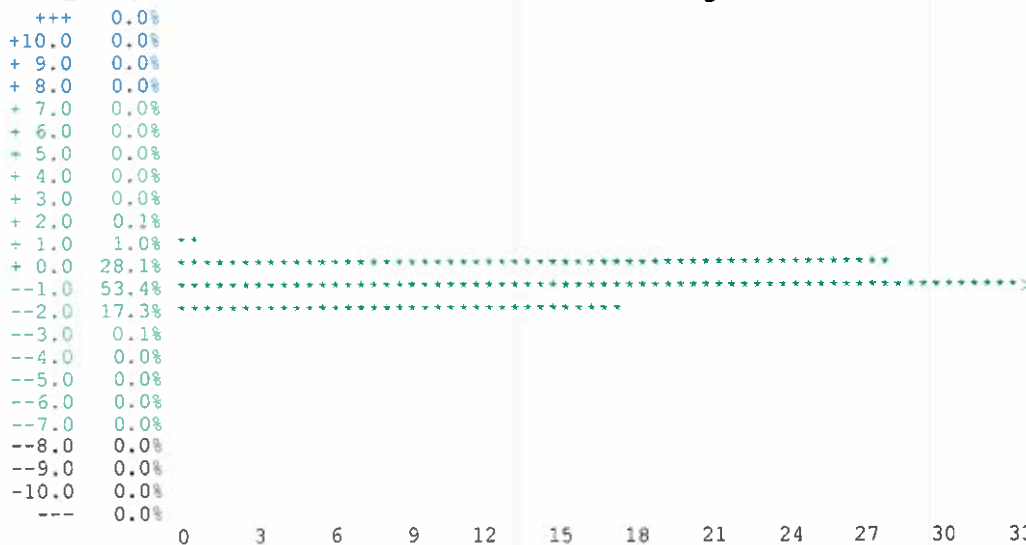
Upper Control Limit 75.4 mil Upper Tolerance Limit 81.0 mil
X Double Bar 73.6 mil R Bar 1.8 mil
Lower Control Limit 71.7 mil Lower Tolerance Limit 67.0 mil

CR 26.1% (Capability Ratio %, 100/CP)

CP 3.825 (Process Capability, HiLim-LoLim/6*Sigma)

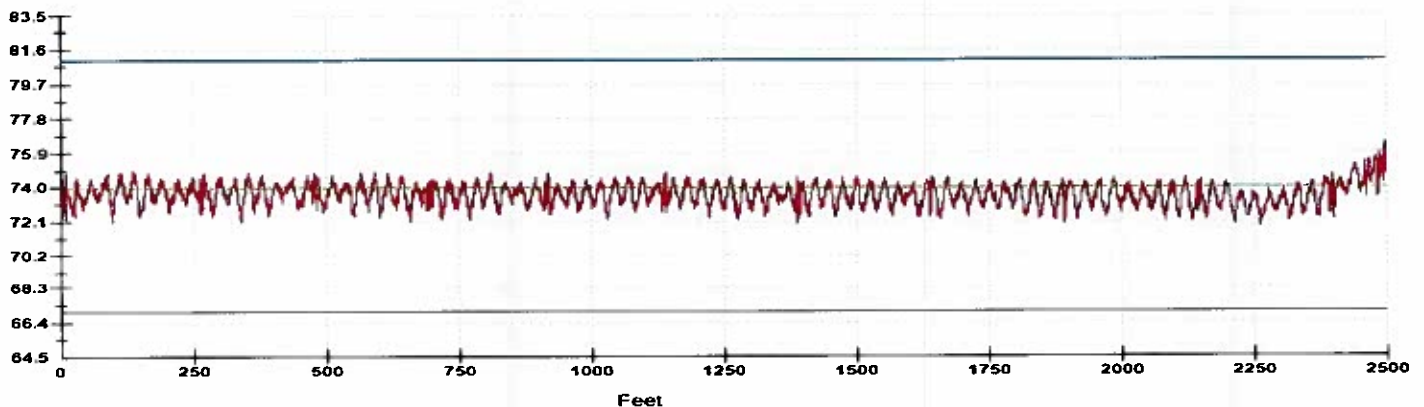
CPK 3.590 (Capability vs Limits) TMW Ratio 0.911 (Low Limit/Avg)

Thickness Distribution Relative to the Target



99.9% is within ± 2.0000 mil of the target 100.0% is within ± 5.0000 mil of the target
100.0% is within ± 10.0000 mil of the target 100.0% is within ± 20.0000 mil of the target

Thickness vs Length (Coil Number NB79045)



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