

Process/Product Audit Checklist

Cust #: <u>3364</u> Customer: <u>BLUE BIRD</u> GRP/Size/GRD/Width: <u>HRS SHEET, CSB, 56X99 .0747</u>				
PWC: <u>GL9</u> W/O#: <u>20536</u> Date: <u>5/30/2025</u> Part #(s): <u>W10078982</u> Auditor: <u>PHILLIP MATHIS</u>				
Gauge Range: <u>..0667-.0827</u> Actual Gauge: <u>.0747</u> Width Range: <u>6.57-6.63</u> Width Actual: <u>6.61</u>				
Length Range: <u>92.47-92.53</u> Length Actual: <u>92.49</u> Other: _____ Other Actual: _____				
Other: _____ Other Actual: _____ Other: _____ Other Actual: _____				
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: <u>379329</u> Tag(s) used: <u>379329</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: <u>0</u> , W/O Rev: <u>0</u> , Part Spec Rev: <u>NA</u>] (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) TM049- Tape Measure last calibrated 3.28.2025, due 3.28.2026 MC27-Micrometer, last calibrated 3.28.2025, due 3.28.2026 C027- Caliper 12", last calibrated 3.28.2025, due 3.28.2026
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) JDM -F 014 - JDM -F-014
Hardcopy Controlled Documents are listed on Quality Intranet by location?	X			List Documents and their Location: GAD-LA-001 LOC ON OP. DESK

FABRICATION PRODUCTION REPORT

Laser / Plasma

[illegible]

# of Parts Scraped (Tally)		DOWNTIME TYPE	DOWNTIME ESTIMATED IN (MINUTES)	OPERATOR COMMENTS / REASON FOR DOWNTIME
Were there issues?	YES ☐ NO ☐	BREAK		
Was shift lead notified of Issues?	YES ☐ NO ☐	LUNCH		
Were Issues resolved?	YES ☐ NO ☐	MAINTENANCE		
START TIME	STOP TIME	QUALITY - PART CHECKS		
		PROCESS - MATL HANDLING & MACHINE SETUP		
		ORDER - ALL MACHINE ISSUES & ERRORS		
		ORDER - ALL MACHINE ISSUES & ERRORS		
		ORDER - ALL MACHINE ISSUES & ERRORS		

Warehouse (GAD) Gadsden Whs Zone PWC (GL9) Laser 9 Process (AS) As-Is		Operator		Job Work Order Job 20536 Date 5/29 04:00 AM			
PROGRAM 38205- HOT JOB NEED DONE ASAP							
Dimension HR Sheet, CSB, - 56" x 99" 0.0747-N		D	Pcs	LBS	SFT Tag/Lot	Ven Tag	Heat
			22	2,496.35	379329		? NUD/SP7041
Theo Scrap 100.00% (2,496.34 LBS)							
Dimension 56" x 99" 0.0747" -N		Pcs	LBS	SFT			
		22	2,496.35				
Dimension Part No W10078982 6.6" x 92.5" Irregular		Pcs	LBS	SFT Assign To	Customer/Next Prs	Due	
		176	0.01	SO-14531-1-1	BLUE BIRD BODY(3364)	6/6	
SO-14531-1-1		Cond	Incl	Mill Edge			
SO-14531-1-1		Customer	Dimension 6.6" x 92.5" Irregular		LBS Pc/Pkg	LBS	Hgt
		BLUE BIRD BODY(3364)			0.01	90	2
SO-14531		BLUE BIRD BODY(3364)/0	Charles Love				
Due 6/6		Item Product/Part/End User Label1 1 HR ASTM A1011 - CSB null N x 6.6 x 92.5 W10078982	Process Route {AS}		PCS 176	SFT	LBS +/- Shp % Cert 0.01 +20-20 CAA 0/Pc
ORDER INFORMATION							
JOB INSTRUCTIONS							
JOB RESERVATIONS (dimensions in inches, if not specified)							
Zn Loc Date Planned							
PLANNED CONSUMPTION							
PLANNED PRODUCTION							
PACKAGING							
ORDER INFORMATION							
Legend: ? QDS review 5 Scaling required							
Job Set 20860 5/29/2025 10:31 AM 1							

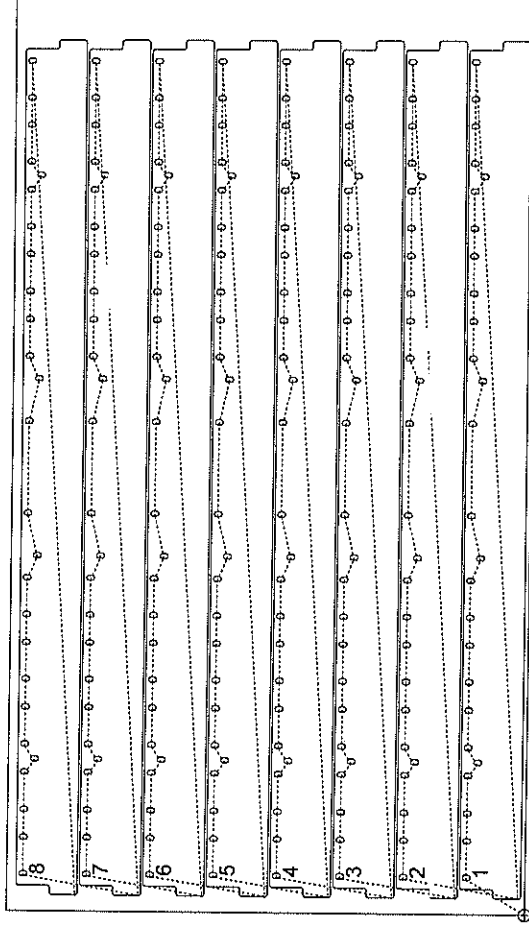


Layout Detail

Machine TRUMPF TruLaser 5040 S

Task Name : T42577 Program Name : 38205

Number of Sheets with Same Layout		22	24	10.409	Qty Required	2
Stack Quantity		1	1	7.792	Qty Nested	8
				Layout 1 of 1		



Material	MS	Sheet Length	99.000"	Sheet X Used	94.271"	Heat Number	Mill
Thickness	0.075	Sheet Width	56.000"	Sheet Y Used	54.969"	Sheet Location	Prime Code
Sheet Name		Cutting Time	00:05:02	Cutting Length	2071.572"	Bin Number	Parameters NITROGEN
Part ID	Part Name	Qty Req	Qty Nested	Net Weight	Drawing Number	Revision Number	Work Order Number

1 W10078982- 2 246- 12.56lb 10078982-HB BLUE BIRD 00:05:02

379329 20536-

145 31-1-1



Layout Report

Task Name : T42577

Program Name :38205

Layout 1 of 1

Number of Sheets with Same Layout : 31

Sheet Parameters

Material : MS

Thickness : 0.075"

Sheet Length : 99.000"

Sheet Width : 56.000"

Sheet Name :

Bin Number :

Heat Number :

Location :

Mill :

Prime Code :

Sheet X Used : 94.271

Sheet Y Used : 54.969

Plate Used : 95.48%

Plate Recovered : 4.52%

Nesting Task Results

Qty Required : 2

Qty Nested : 8

Total Cutting Time : 00:05:02

Total Net Weight : 100.463lb

True Scrap : 10.41%

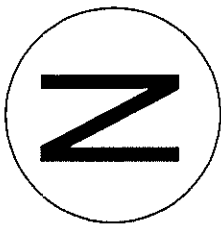
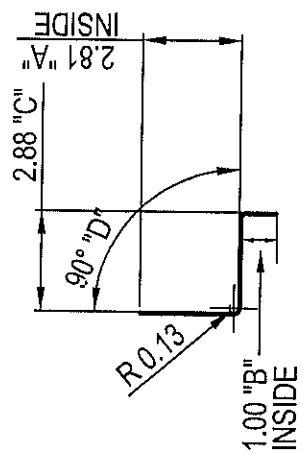
Rectangular Scrap : 7.79%

Total Cutting Length : 2071.572"

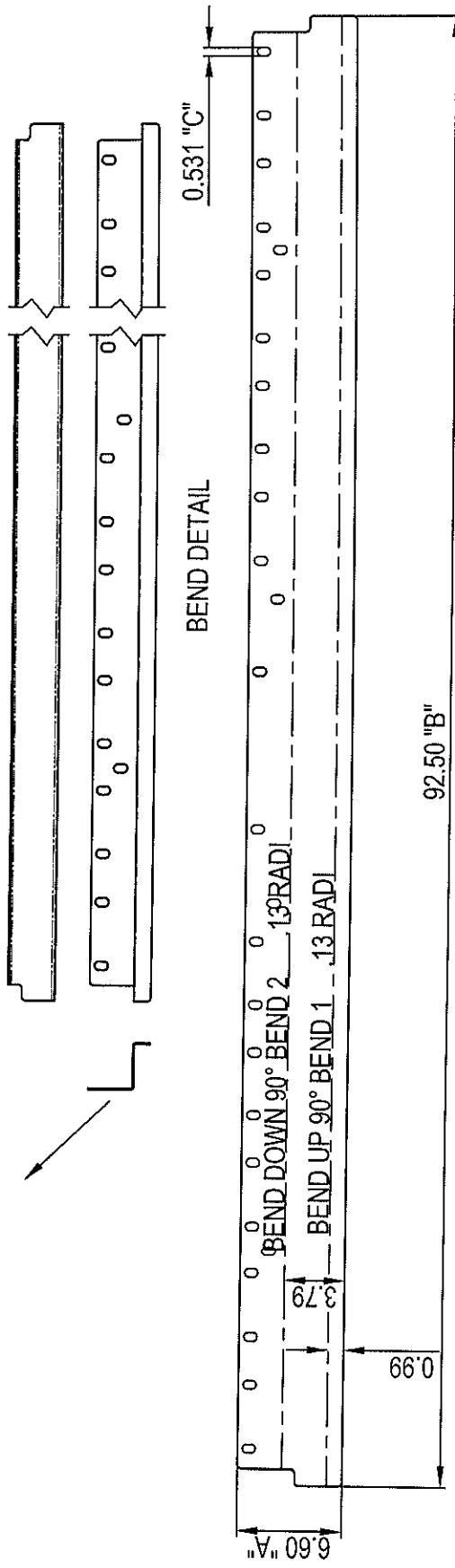
Number of Pierces : 216

Part ID	Part Name	Qty Req	Qty Nested	Net Weight	Drawing Number	Revision Number	Work Order	Customer	Cutting Time
1	W10078982-HB	2	8	12.56	1007898			BLUE BIRD	00:05:02

JEMISON REVISION		CUSTOMER REVISION	
REV.	DESCRIPTION	REV.	DESCRIPTION



0 BENT DOWN 90° BENT 2ND
0 BENT UP 90° BENT 1ST



JEMISON METALS									
CUSTOMER		BLUE BIRD CORPORATION							
TITLE		SHIELD, FUEL TANK, GAS, BBCV, 100 GAL, 2023							
MATERIAL		14GA HRS							
BY CC	DATE	2/16/23		SHT.	1 OF 1		JEMISON REV.		
PART NO.		10078982		0					

BENT/FORMED FIRST ARTICLES				CUT/BURNT FIRST ARTICLES				TOLERANCES UNLESS OTHERWISE SPECIFIED	
	NOMINAL	TOLERANCE	ACTUAL		NOMINAL	TOLERANCE	ACTUAL		
TOL "A"	2.81	2.78-2.84		MTL THICKNESS	.0747	.0687-.0827		LINEAR DECIMAL = ± .03	
TOL "B"	1.00	.97-1.03		TOL "A"	6.60	6.57-6.63	6.61	EDGE TO CL = ± .06	
TOL "C"	2.88	2.85-2.91		TOL "B"	92.50	92.47-92.53	92.49	HOLE TO HOLE = ± .03	
TOL "D"	90°	88°-92°		TOL "C"	.531	.516-.546	.531	BREAK LOCATIONS: ± .03	
								BREAK ANGLES = ± 2°	
								HOLE DIA = ± .015	

JEMISON METALS

CUSTOMER: BLUE BIRD CORPORATION

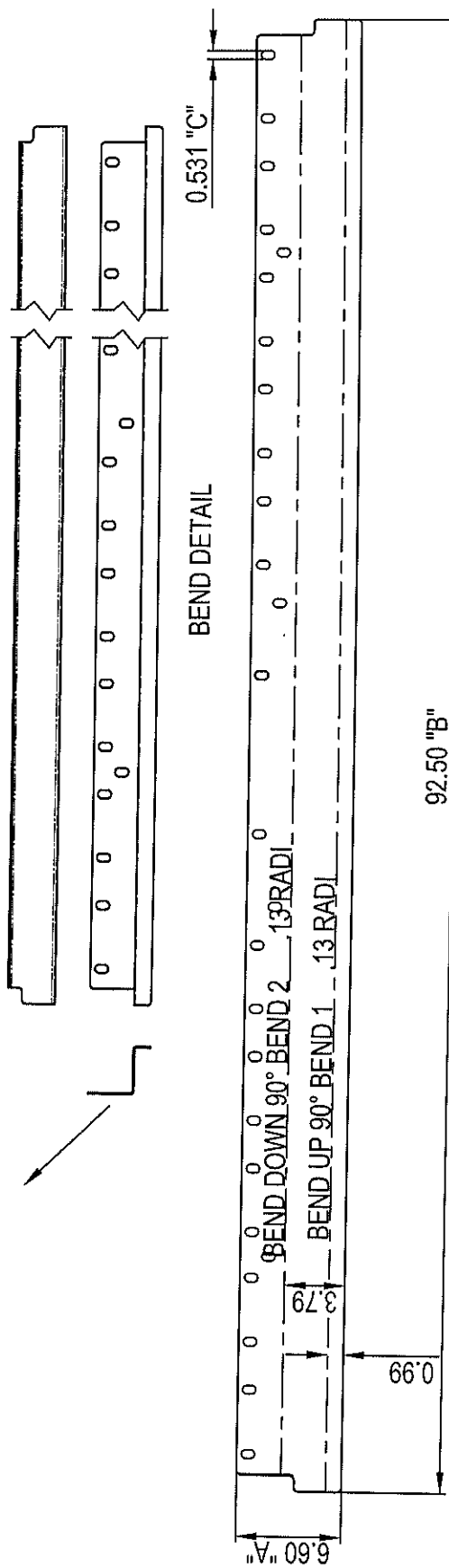
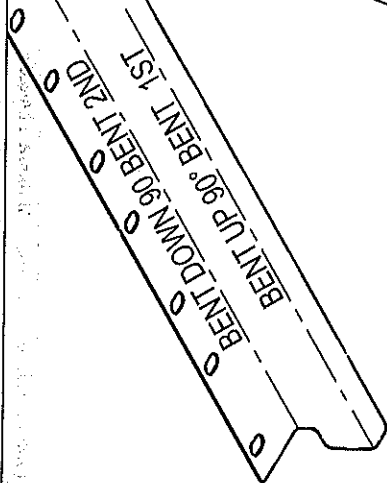
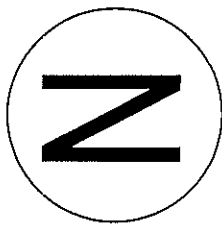
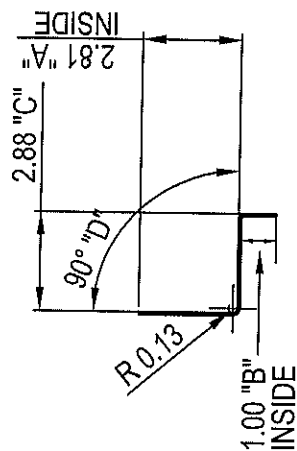
TITLE: SHIELD, FUEL TANK, GAS, BBCV, 100 GAL, 2023

MATERIAL: 14GA HRS

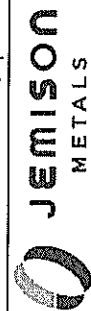
BY CC DATE 2/16/23 SHT. 1 OF 1

PART NO. 10078982 JEMISON REV. 0

JEMISON REVISION		CUSTOMER REVISION	
REV.	DESCRIPTION	REV.	DESCRIPTION



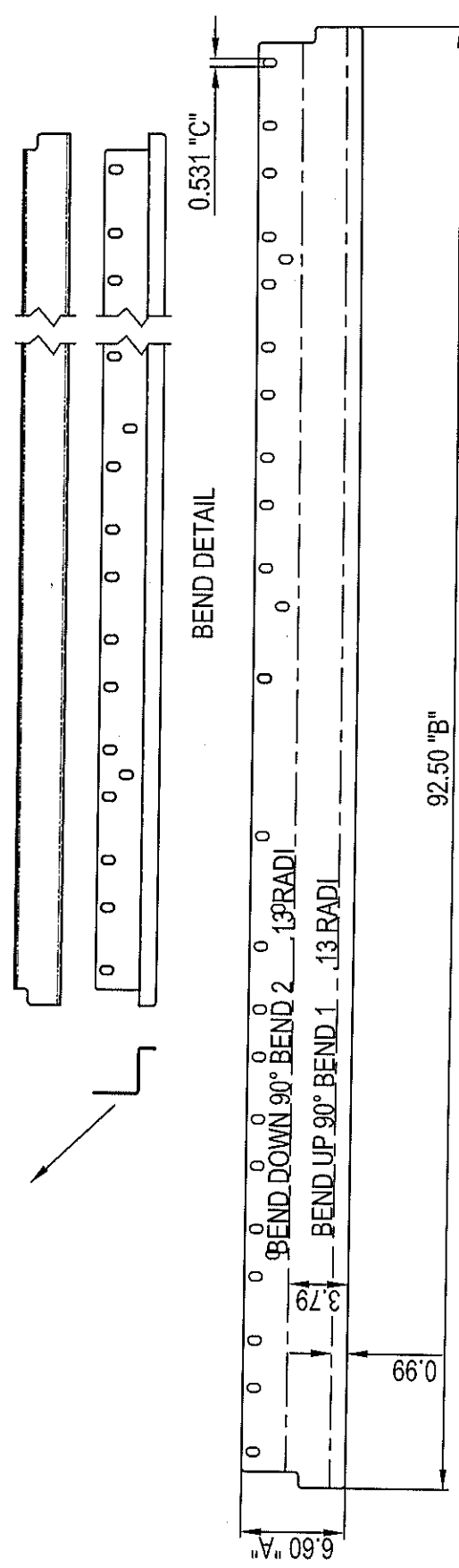
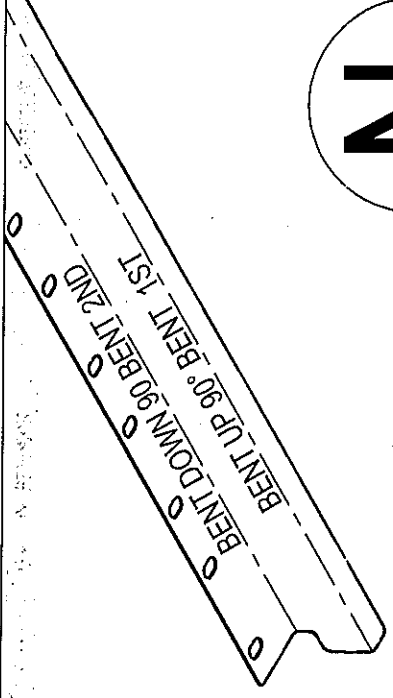
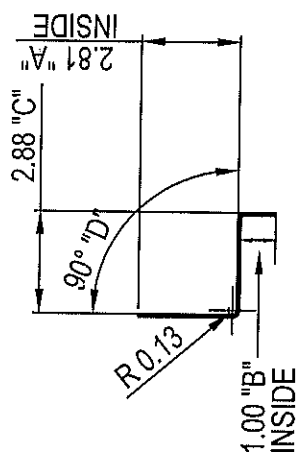
FLAT PATTERN



BENT/FORMED FIRST ARTICLES				CUT/BURNT FIRST ARTICLES				TOLERANCES UNLESS OTHERWISE SPECIFIED	
NOMINAL	TOLERANCE	ACTUAL		NOMINAL	TOLERANCE	ACTUAL		LINEAR DECIMAL = ± .03	
TOL "A"	2.81	2.78-2.84		.0747	.0687-.0827			HOLE LOCATIONS:	
TOL "B"	1.00	.97-1.03		8.60	8.57-8.63			EDGE TO CL = ± .06	
TOL "C"	2.88	2.85-2.91		92.50	92.47-92.53			HOLE TO HOLE = ± .03	
TOL "D"	90°	88°-92°		.531	.518-.546			BREAK LOCATIONS: ± .03	
								BREAK ANGLES: ± 2°	
								HOLE DIA = ± .015	

CUSTOMER: BLUE BIRD CORPORATION		TITLE: SHIELD FUEL TANK, GAS, BBCV, 100 GAL, 2023	
DATE: 2/16/23		MATERIAL: 14GA HRS	
BY CC		SHEET 1 OF 1	
PART NO. 10078982		JEMISON REV. 0	

JEMISON REVISION		CUSTOMER REVISION	
REV.	DESCRIPTION	REV.	DESCRIPTION



BENT/FORMED FIRST ARTICLES				CUT/BURNT FIRST ARTICLES				TOLERANCES UNLESS OTHERWISE SPECIFIED	
NOMINAL	TOLERANCE	ACTUAL		NOMINAL	TOLERANCE	ACTUAL		LINEAR DECIMAL = ± .03	
TOL "A"	2.81	2.78-2.84			.0747	.0667-.0827		HOLE LOCATIONS:	
TOL "B"	1.00	.97-1.03			6.60	6.57-6.63		EDGE TO CL = ± .06	
TOL "C"	2.88	2.85-2.91			92.50	92.47-92.53		HOLE TO HOLE = ± .03	
TOL "D"	90°	88°-92°			.531	.516-.546		BREAK LOCATIONS: ± .03	
								BREAK ANGLES: ± 2°	
								HOLE DIA = ± .015	

JEMISON METALS

CUSTOMER: BLUE BIRD CORPORATION

TITLE: SHIELD FUEL TANK, GAS, BECV, 100 GAL, 2023

MATERIAL: 14GA HRS

BY CC: DATE 2/16/23 SMT. 1 OF 1

PART NO. 10078982 JEMISON REV. 0