Process/Product Audit Checklist

Cust #: 2443 Customer: GENERAL MTLS-NC GRP/Size/GRD/Width: POS/.1183/CSB/48

PWC: SCT W/O#: 89610 Date: 5/8/2023 Part #(s): HRS120048120 Auditor: B. CLEM

Gauge Range: .1156-.1315 Actual Gauge: .119 Width Range: 48-48.9990 Width Actual: 48.645

Length Range: 119.875-120.125 Length Actual: 120.125 Other: WAVE/FLTN 0-.12 Other Actual: LESS .12

Other: LGTH 95.875-96.125 Other Actual: 96.125 Other: N/A Other Actual: N/A

Item	YES	NO	N/A	Comments/Action Taken (Required for NO)
Process Inspection Sheets filled out according to frequency and sampling required?	X			Robert and Marquiez
Correct raw material type and size?	X			Tag(s) to use: NB75691 Tag(s) used: NB75691
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 5/4/2023 5/4/2024 CL-2 25' TAPE 1/10/2023 1/10/2024 M50 1" MIC 6/14/2022 6/14/2023 ST-4 STEP GAUGE 6/21/2022 6/21/2023 63294 MEASURING TABLE 7/8/2020 7/8/2023
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 JM-OP-001

Material Inspection Report

LOCATION	Sumter		DATE	5/8/2023
CUSTOMER	GENERAL	JOB # SMT	89610	Page 1

	Order Dim		Tolerances		Tolerances	Low Limit	High Limit
Gauge	0.114	-	-0.002	+	0.018	0.116	0.132
Width	48.000	-	0.000	+	0.999	48.000	48.999
Length	120.000	-	0.125	+	0.125	119.875	120.125

	Set up Target
Gauge	0.124
Width	48.500
Length	120.000

Side Type | Skid Type Error

SOP'S

JDOP008	JDOP016	JDOP046
JDOP014	JDOP034	JDOP032

Skid Code 0 2 4

Finished Goods Tag		227456		227459		227455					
Master Coil Number		NB75691		NB75691		NB75691					
Heat											
Enhanced Weight											
Gross Weight		4010		4010		2475					
Tare		165		165		135					
Net Weight		3845		3845		2340		0		0	
Bundle Status		OK		OK		OK					
Good Pcs.		20		20		15					
Scraped Pcs.											
Rockwell											
Gauge Head	E	0.120		0.116		0.119					
	C	0.120		0.119		0.121					
	E	0.117		0.118		0.119					
Body	E										
	C										
	E										
Tail	E										
	C										
	E										
Surface											
Width Head		48.645		48.601		49.095	H				
Body		48.645		48.601		49.095	H				
Tail		48.645		48.601		49.095	H				
Shape											
Residual Check											
Length Head		120.125		120.125		96.125	L				
Body		120.125		120.125		96.125	L				
Tail		120.125		120.125		96.125	L				
Squareness											
Camber											
Operator											
Setup Approval											
Run Time	S		F		Down Time	S		F			
Total Run Time		**0:00**		Cost	$0.00		Cst/Hour		$400.00		
Comments											