

# Process/Product Audit Checklist

| Cust #: <u>1795</u> Customer: <u>BSH Home</u> GRP/Size/GRD/Width: <u>CRS, 0302 DSENT 125.0500</u>                                                                    |                                     |                                     |                                     |                                                                                                                                                                                          |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------|-------------------------------------|-------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| PWC: <u>SRB</u> W/O#: <u>66120</u> Date: <u>6-14-17</u> Part #(s): <u>9000299326</u> Auditor: <u>B. Clem</u>                                                         |                                     |                                     |                                     |                                                                                                                                                                                          |
| Gauge Range: <u>.0300 - .0330</u> Actual Gauge: <u>.031</u> Width Range: <u>25.235 - 25.265</u> Width Actual: <u>25.250</u>                                          |                                     |                                     |                                     |                                                                                                                                                                                          |
| Length Range: <u>35.218 - 35.282</u> Length Actual: <u>35.251</u> Other: <u>41.278 - 41.342</u> Other Actual: <u></u>                                                |                                     |                                     |                                     |                                                                                                                                                                                          |
| W-B-F Other: <u>0 - .12</u> Other Actual: <u>.030</u> Other: <u>0 - .12</u> Other Actual: <u>.0093</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?                                                                     |                                     | <input checked="" type="checkbox"/> |                                     | NO Shape Check<br>Sam J. - noted on FOP081.                                                                                                                                              |
| Correct raw material type and size?                                                                                                                                  | <input checked="" type="checkbox"/> |                                     |                                     | Tag(s) to use: <u>655218</u><br>Tag(s) used: <u>65218</u>                                                                                                                                |
| Setup performed according to W/O?                                                                                                                                    | <input checked="" type="checkbox"/> |                                     |                                     |                                                                                                                                                                                          |
| Product is acceptable according to customer-specific requirements?<br>[Fab: Is the Part Print Present & the correct Revision? Are required measurements documented?] | <input checked="" type="checkbox"/> |                                     |                                     | [Fab: Print Rev: <u>N/A</u> , W/O Rev: <u>N/A</u> , Part Spec Rev: <u>N/A</u> ] (Leave blank if non-Fab audit)                                                                           |
| Packaging is acceptable according to customer-specific requirements?                                                                                                 | <input checked="" type="checkbox"/> |                                     |                                     |                                                                                                                                                                                          |
| Visual Inspection performed and product meets requirements?                                                                                                          | <input checked="" type="checkbox"/> |                                     |                                     |                                                                                                                                                                                          |
| Out of spec noted, with actions taken?                                                                                                                               |                                     |                                     | <input checked="" type="checkbox"/> |                                                                                                                                                                                          |
| Non-conforming material put into reject warehouse and physically put into non-conforming area?                                                                       |                                     |                                     | <input checked="" type="checkbox"/> |                                                                                                                                                                                          |
| Required gages available & functional?                                                                                                                               | <input checked="" type="checkbox"/> |                                     |                                     |                                                                                                                                                                                          |
| All Gages Calibrated (List in Comments)                                                                                                                              | <input checked="" type="checkbox"/> |                                     |                                     | 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 m285, Table 4-19-17 4-19-18 |
| Housekeeping: Machine/Floor clean?<br>Loose tags & paperwork cleaned up?                                                                                             | <input checked="" type="checkbox"/> |                                     |                                     |                                                                                                                                                                                          |
| Required PPE being worn?                                                                                                                                             | <input checked="" type="checkbox"/> |                                     |                                     |                                                                                                                                                                                          |
| Forms are the latest revision per Quality Intranet?<br><u>Details on Back</u>                                                                                        | <input checked="" type="checkbox"/> |                                     |                                     | List Forms (Observed Rev vs Intranet Rev)<br>SMT-SRB-001 11-8-16 5 - Not Followed<br>Jm-op-001 4-21-15 0<br>FOP081 2-16-01 1                                                             |
| Hardcopy Controlled Documents are listed on Quality Intranet by location?                                                                                            |                                     |                                     | <input checked="" type="checkbox"/> | List Documents and their Location:                                                                                                                                                       |

Last piece of first skid not checked until pointed out by QA.

Square check not done until pointed out by QA.

# AGT400 Coil Summary Report

## JEMISON METALS --

Job Number: 66120 Coil Number: 655218

Customer Number: BSHTRIAL Coil Information: AKS572373 Supplier: AKSTEELCORP

Product: Steel Jun-14-17 14:53 to 15:41 (clock 48.3 min/ run 4.1 min) Shift: 2

### Average Thickness and Tolerance Data

Target 0.0315 in Average 0.0309 in Average - Target -0.0006 in (-0.0019%)  
Standard Deviation 0.0002 in (0.0006%)  
Length 145 ft Above High Limit 0.0330 in 14 ft (9.6%)  
Width 57.050 in In Tolerance 14 ft (9.6%)  
Weight 871 lbs Below Low Limit 0.0307 in 14 ft (9.6%)  
Max Thickness 0.0313 in at 11 ft Min Thickness 0.0302 in at 11 ft

### Statistical Process Control Data

Upper Control Limit 0.0315 in Upper Tolerance Limit 0.0330 in  
X Double Bar 0.0309 in R Bar 0.0001 in  
Lower Control Limit 0.0303 in Lower Tolerance Limit 0.0300 in  
CP 42.0 (Capability Ratio, 100/CP)  
CPK 2.381 (Process Capability, (High-LowLim)/6\*Sigma)  
CPK 1.413 (Capability vs Limits) TMW Rat. 0.971400 391.78%

### Thickness Distribution Relative to the Target

|         |       |
|---------|-------|
| ---     | 0.04  |
| +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 | 47.1% |
| -0.0010 | 49.8% |
| -0.0015 | 3.1%  |
| -0.0020 | 0.0%  |
| -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

96.9% is within  $\pm 0.0010$  in of the target 100.0% is within  $\pm 0.002$  in of the target  
100.0% is within  $\pm 0.0050$  in of the target 100.0% is within  $\pm 0.0100$  in of the target

Thickness vs Length (Coil Number 655218)

