Process/Product Audit Checklist

Cust #: 2073 Customer: Specialty Manuf. GRP/Size/GRD/Width: GVS .0296 CBGACD 48

PWC: SRB W/O#: 61646 Date: 6-15-16 Part #(s): 0104462

Gauge Range: .0296-.0376 Actual Gauge: .031 Width Range: 48-48.1875 Width Actual: 48.234

Length Range: 96-96.2500 Length Actual: 96.130 Other: W-B-F 0-.12 Other Actual: 0

Other: SQ 0-.25 Other Actual: .095 Other: Wgt 2635 lbs Other Actual: 2550 lbs.

Item	YES	NO	N/A	Comments/Action Taken (Required for NO)
Process Inspection Sheets filled out according to frequency and sampling required?	✓	✓		Checks filled out but not completed James Sam Roland
Correct raw material type and size?	✓			Tag(s) to use: NB50869 Tag(s) used: NB50869
Setup performed according to W/O?	✓			
Product is acceptable according to customer-specific requirements? [Fab: Is the Part Print Present & the correct Revision? Are required measurements documented?]	✓			[Fab: Print Rev:____, W/O Rev:____, Part Spec Rev:____]
Packaging is acceptable according to customer-specific requirements?	✓			
Visual Inspection performed and product meets requirements?	✓			
Out of spec noted, with actions taken?	✓			Width 48.234 OK per Patrick
Non-conforming material put into reject warehouse and physically put into non-conforming area?			✓	
Required gages available & functional?	✓			
All Gages Calibrated (List in Comments)	✓			Gages Observed (list last calibration and when due) 8-3 25' Tape 3-8-16 3-8-17 M44 1" mic 10-1-15 10-1-16 ST-5 step Gauge 7-7-15 7-7-16 63294 Meas. Table 4-26-16 4-26-17
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	✓			
Required PPE being worn?		✓		No Safety Glasses
Forms are the latest revision per Quality Intranet?	✓			List Forms (Observed Rev vs Intranet Rev) SmT-SRB-001 3-9-13 4 JMA-OP-001 4-21-15 0 FOP081 2-16-01 1 SmT-SH-001 10-26-11 0
Hardcopy Controlled Documents are listed on Quality Intranet by location?			✓	List Documents and their Location:

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 61646 Coil Number: NB50869+

Customer Number: SPECILTY Coil Information: NUB2607608 Supplier: NUCORBERKELY

Product: Steel Jun-15-16 12:20 to 13:28 (clock 68.5 min/ run 23.6 min) Shift: 1

Average Thickness and Tolerance Data

Target	0.0340 in	Average^	0.0308 in	Average - Target	-0.0033 in (-9.58
				Standard Deviation^	0.0002 in (0.47
Length	3461 ft	Above High Limit	0.0380 in	0 ft (	0.0%)
Width	48.000 in	In Tolerance			
Weight	17411 lbs	Below Low Limit	0.0300 in	0 ft (	0.0%)

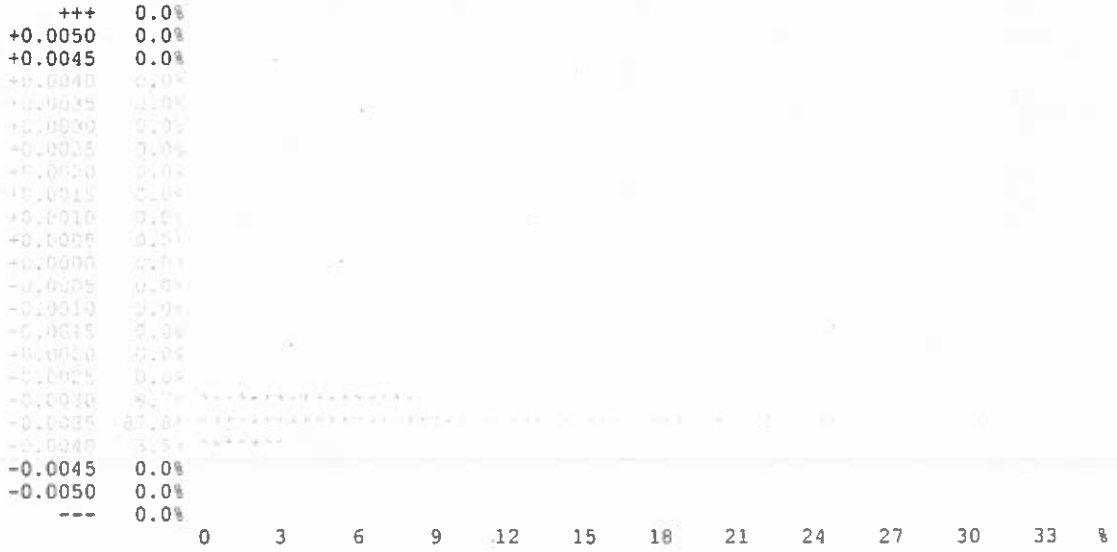
Max Thickness 0.0313 in at 3353 ft Min Thickness 0.0302 in at 38 ft

Statistical Process Control Data

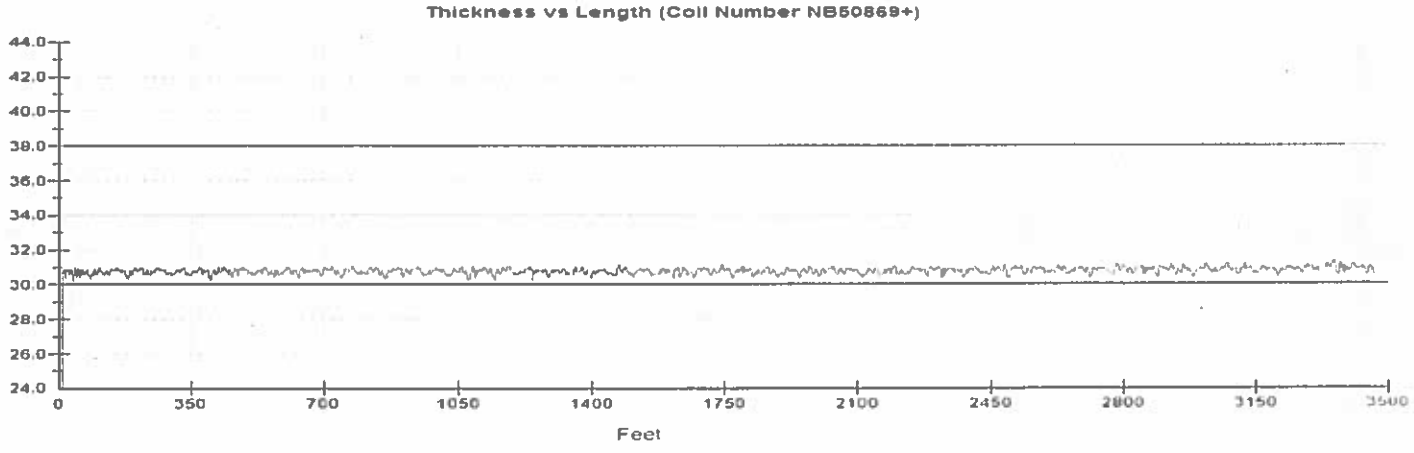
Upper Control Limit	0.0312 in	Upper Tolerance Limit	0.0380 in
X Double Bar	0.0308 in	R Bar	0.0005 in
Lower Control Limit	0.0303 in	Lower Tolerance Limit	0.0300 in

CR 12.0% (Capability Ratio %, 100/CP)
CP 8.333 (Process Capability, HiLim-LoLim/6*Sigma)
CPK 1.563 (Capability vs Limits) TMW Ratio 0.976(Low Limit/Avg)

Thickness Distribution Relative to the Target



0.0% is within ± 0.0010 in of the target 0.0% 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



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