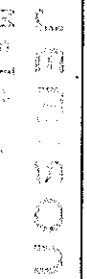


Process/Product Audit Checklist

Cust #: 2720 Customer: S.I.P. INC GRP/Size/GRD/Width: GVS/1.1382/S4235C/48				
PWC: BB1 W/O#: 95199 Date: 6/17/2019 Part #(s): 35-10-144-48-G40 Auditor: B. CLEM				
Gauge Range: .1292-.1472 Actual Gauge: .130 Width Range: 48-48.187 Width Actual: 48.562				
Length Range: 144-144.5000 Length Actual: 144.187 BOW/FLATN Other: 0-.50 Other Actual: OK (NEED ACTUAL MEASUREMENT)				
Other: 25 PCS/TAG Other Actual: 25 PCS/TAG 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 <u>frequency</u> and <u>sampling</u> required?	X			Steven White - Inspection Sheet was filled out but the midpoint and last piece of run check was not done.
Correct raw material type and size?	X			Tag(s) to use: 59816 Tag(s) used: 59816
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		Width was out of tolerance but was OK'd by Joe Ross. Unable to find documentation. [Fab: Print Rev: _____, W/O Rev: _____, Part Spec Rev: _____] (Leave blank if non-Fab audit)
Packaging is acceptable according to customer-specific requirements?			X	Quality was not present for packaging
Visual Inspection performed and product meets requirements?	X			
Out of spec noted, with actions taken?	X			Width out of tolerance - OK'd to ship per Joe Ross. Unable to find documentation.
Non-conforming material put into reject warehouse and physically put into non-conforming area?		X		Width out of tolerance - OK'd to ship per Joe Ross. Unable to find documentation.
Required gages available & functional?	X			
All Gages Calibrated (List in Comments)	X			Gages Observed (list last calibration and when due) 012 1" Mic 2/2019 2/2020 ST8 Step Gauge 7/2018 7/2019 T1029 30' Tape 8/2018 8/2019 T1026 30' Tape 8/2018 8/2019 T1032 35' Tape 8/2018 8/2019
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	X			
Required PPE being worn?		X		No safety glasses - Bronnie Grissom, Whitney Windsor
Forms are the latest revision per Quality Intranet?				List Forms (Observed Rev vs Intranet Rev) DEC-BB1-CTL 6/26/17 4
Hardcopy Controlled Documents are listed on Quality Intranet by location?				List Documents and their Location: DEC-CTL-001A DEC-CTL-001B DEC-CTL-004



PAGE 1 OF 1

JOB WORK ORDER NO.	DATE	MACHINE	SHIFT	MASTER COIL NO.	Yield Strength				
95199	6-17-44	BB1	1st	59816					
OPERATOR	RUN HOURS	Burr Msmnt(s)	Head Scrap	Tail Scrap	GA MIN	MAX WAVE	MAX SQUARE	KEYED BY	CKD. BY
3 hours	1:10 2:10		12'	2	.124	.50			

PAGE 1 OF 1

Minimum Inspection Frequency:
(Unless otherwise specified on the Work Order/Part Spec)
CHECK PIECE ONCE LINE RUN IS ESTABLISHED + PIECE AT MIDPOINT
OF RUN + LAST PIECE OF RUN

[illegible]

DEC-CTL-001A

CTL Operator Procedure

1. Fill out Production Report (DEC-BB1-CTL), Enter Work Order information into computer, Enter Stelplan job.
2. Set stacker gates and end stop.
3. In manual mode, go to preclamp, go to auto, adjust clamp pressure (if stretching).
4. Press cycle start, if stretching. Stretch in manual mode to desired affect or by length or % elongation.
5. Run coil to shear.
6. Brushes in auto (HR Black Only), confirm laser setting, center coil in feed roll.
7. Close feed roll, lower tach wheel, run steel past shear blade.
8. Go to line auto, make registration cut, enter footage for stretcher (if stretching)
9. Measure width and gauge at stretch bed, record onto the production report. Also, record helper measurements onto the production report.
10. If needed, adjust shear for squareness.
11. Run one bundle then lower stacker.
12. If stretching, bring in side guides after the last stretch, before material begins moving, in order to hold tighter squareness.

Minimum Inspection Frequency:

(Unless otherwise specified on the Work Order/Part Spec)

**CHECK PIECE ONCE LINE RUN IS ESTABLISHED + PIECE AT MIDPOINT
OF RUN + LAST PIECE OF RUN**

Revision History

<u>Revision Date</u>	<u>Revision Level</u>	<u>Changes Made</u>
06/14/2018	1	Added Step #12
04/13/2017	0	Original Version

14Jun19 12:25

J O B W O R K O R D E R

GAD 95199

Jemison Metals - Gadsden
3001 Hickory Street
Gadsden, AL 35902
Tel: 800-235-1086 Fax: 205-986-6604

Job Type LEV Process PWC BB1
Metric N Cust
Desc 86452 S.I.P.
Due Date 17Jun19 Whs DFG
Setup 00:00 Run 01:15 Prtd By decops

<<< JOB SPECIFICATIONS >>>

Group GVS Grade S4235C Gauge 0.1382 (0.1382 to 0.1382) ID 0.0000

<<< ORDER SPECIFICATIONS >>>

F 01 GVS/10/S4235C/48.0000"X144.00/.1382N SS-40 G235 CT DRY
Ord GAD 86452- 1 Cust S.I.P.INC OF DE Ga 0.1382 Wth 48.0000 Lth 144.0000
Part 2720/35-10-144-48-G40 Ga 0.1382 Wth 48.0000 Lth144.0000
Ga Rng 0.1292to 0.1472 Pc/Tag
WthTol + 0.1870 - 0.0000 Wt/Skd 7000
LthTol + 0.5000 - 0.0000 Ty JD3 Pk .
YLD:40000.00 TENS:55000.00 ELONG:16.00
BOW:0.00-.50 FLATN:0.00-.50

CERTIFICATION REQUIRED

WITH COATING WEIGHT & SOURCE CERTS
INACCORDANCE WITH ASTM A-924, X-RAY OR TRIPLE
SPOT METHOD REQUIRED

***** ALL METAL TO BE CERTIFIED IN THE USA *****

ASTM A-653, G165 GALV "SS40" COATING PER ASTM
A-924 SURFACE TO BE CHEMICALLY TREATED & NO OIL
PAPER WRAP BUNDLE WITH CROSS BRACING
FORKLIFT SIDE UNLOAD

USE 4 CROSS BLOCK ON SKIDS

<<< PROCESSING INSTRUCTIONS >>>

<Step 1>
Level To: 48.0000 X 144.0000 175 Pcs 47340 LBS 999 Pcs/Tag

<<< MATERIAL TO BE USED >>>

Tag No	Whs	Gauge	Width	Length	PCS	Weight	Heat Number	Locn
<GVC/10L/S4235C>								
59816	DPW	0.1277M	48.0000		1	47040	SDIB813626	C26R6
Rmks: S.I.P.INC OF DE								
Spec: YLD=45.2/TENS=<58.7>/ELONG=33								
Total:					1	47040		

<<< MATERIAL TO BE SHIPPED >>>

01 Ord GAD 86452- 1 Cust S.I.P.INC OF DE Part 35-10-144-48-G40
A 653 GALVANIZED SHEET SS-40 G235 CT DRY Pcs/Tg 0 Bal Pcs
.1382 Nom X 48.0000" X 144.0000" DueDt 19Jun19 45,000 LBS
Itm Rmks: S ***** RECEIVING HRS: 7AM-3PM *****
MON - THURS, CALL TO SCHEDULE
256-546-5858

BUNDLE WITH CROSS BRACING

BAND WITH AT LEAST 3 BANDS ACROSS WIDTH

Con	Tag	Whs	Tag No	Whs T	Gauge	Width	Length	OD	Pcs	Weight
-----	-----	-----	--------	-------	-------	-------	--------	----	-----	--------

DEC-CTL-001B

CTL Helper Procedure

1. Compare coil number, from tag, to tag on work order.
2. Load and center coil. Input coil diameter on tension setting.
3. Close leveler. Turn on autotension.
4. Adjust leveler settings for bow (back in and out of leveler).
5. Crop head of coil at entry crop shear (as needed)
6. Run halfway down table, begin adjusting for shape (as needed). Continue feeding into fixed stretch head.
7. Set steering feed roll laser.
8. Inspect/change gripper cardboard.
9. Lower steering roll. Lower tables if looping coil.
10. Run coil to moveable stretch head. Set centering guides.
11. Move dunnage for next job to stacker.
12. Run 1-3 sheets then check specs as compared to work order requirements. Length must be written down and initialed, by someone other than the operator, on the work order.
13. Place appropriate dunnage between bundles.
14. Communicate measurements, to the operator at required frequency, for recording onto production report.

Minimum Inspection Frequency:**(Unless otherwise specified on the Work Order/Part Spec)****CHECK PIECE ONCE LINE RUN IS ESTABLISHED + PIECE AT MIDPOINT
OF RUN + LAST PIECE OF RUN**

Revision Historyss="style1">

Revision Date

04/13/2017

<u>Revision</u>	<u>Changes</u>
<u>Level</u>	<u>Made</u>
0	Original Version

DEC-CTL-004

Burr Procedure

1. Burr must be checked, at minimum, once per coil by helper.
2. Burr cannot be more than 10% of material thickness.
3. If burr is greater than 10% of material thickness, Operator must close gap on the shear blade.
4. If Operator sets gap at 10% and the burr is still greater than 10%, Operator must flip/change shear blades.

Revision History

<u>Revision Date</u>	<u>Revision Level</u>	<u>Changes Made</u>
04/13/2017	0	Original Version