

Process/Product Audit Checklist

Cust #: 1697		Customer: ABB-MEBANE		GRP/Size/GRD/Width: GVS/.0666/FB40NO/33.1670	
PWC: SRB		W/O#: 74222		Date: 6/21/2019	
		Part #(s): CDB0374		Auditor: B. CLEM	
Gauge Range: .0606-.0726		Actual Gauge: .061		Width Range: 33.137-33.197 Width Actual: 33.167	
Length Range: 49.47-49.53		Length Actual: 49.504		B-F-W Other: 0-.12 Other Actual: .125	
SQ Other: 0-.06		Other Actual: .045		RESIDUAL CHECK Other: NOT DONE	
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		JAMES & LAQUWON - There was no square check done on the 3rd, 4th & 5th check. A square check was done at the end of the run but was not noted. A Residual Stress Check was not done. FMA045 GE Sheet Checklist not filled out.	
Correct raw material type and size?	X			Tag(s) to use: 535451 Tag(s) used: 535451	
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) 8-3 25' TAPE 4/19/2019 4/19/2020 M50 1" MIC 8/31/2018 8/31/2019 ST-5 STEP GAUGE 7/5/2018 7/5/2019 63294 MEASURING TABLE 4/24/2019 4/24/2020	
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	X				
Required PPE being worn?		X		No safety glasses-James, Sam and Roland	
Forms are the latest revision per Quality Intranet?	X			List Forms (Observed Rev vs Intranet Rev) FMA045 GE Sheet Checklist 5/23/14 0 FOP081 2/16/01 1	
Hardcopy Controlled Documents are listed on Quality Intranet by location?	X			List Documents and their Location: SMT-SRB-001 Redbud Procedure SMT-SH-001 Residual Stress Check Procedure - NOT DONE JM-OP-001 Tagging Procedure	

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 74222 Coil Number: 535451

Customer Number: ABB MEBANE Coil Information: 478727 Supplier: METALONE CALX

Product: Steel Jan-21-19 8:51 to 10:54 (clock 122.3 min/ run 44.3 min) Shift: 1

Average Thickness and Tolerance Data

Target 61.6 mil Tolerance ±2.2 mil Average 61.2 mil Standard Deviation 1.306 mil
 Length 1941 ft Actual Weight Limit 5.3 mil 0.00
 Width 66.834 in In Tolerance 2.62 ft 100%
 Weight 41679 lb Below Weight Limit 0.1211 0.00
 Max Thickness 62.1 mil at 2983 ft Min Thickness 61.0 mil at 2983 ft

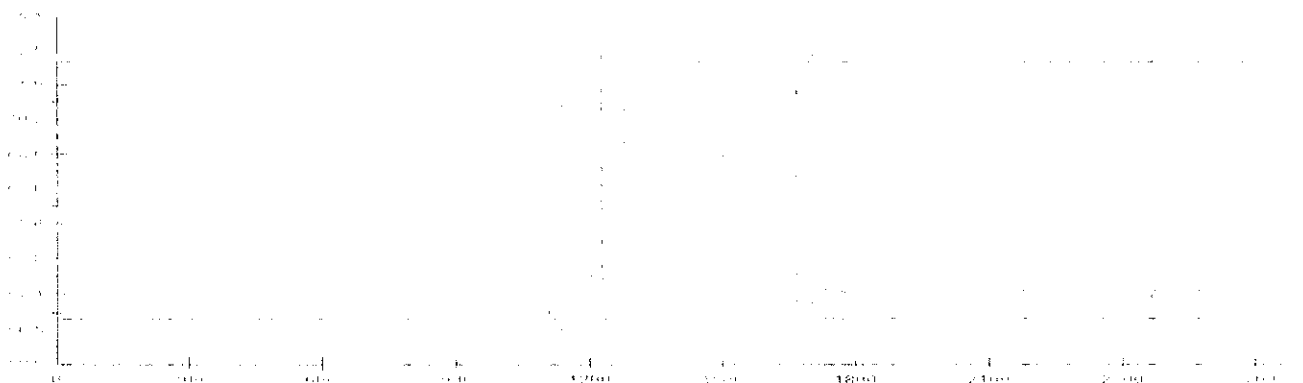
Statistical Process Control Data

Upper Control Limit 63.8 mil Lower Control Limit 59.4 mil
 Center Line 61.2 mil Process Standard Deviation 1.306 mil
 Process Capability Index 1.33 Process Capability Ratio 1.33
 CP 1.33 (Process Capability Ratio) 1.33
 Cpk 1.00 (Process Capability Index) 1.00

Thickness Distribution Relative to the Target

100% 100% 100% 100% 100% 100% 100% 100% 100% 100%
 90% 90% 90% 90% 90% 90% 90% 90% 90% 90%
 80% 80% 80% 80% 80% 80% 80% 80% 80% 80%
 70% 70% 70% 70% 70% 70% 70% 70% 70% 70%
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 60.0 60.5 61.0 61.5 62.0 62.5 63.0 63.5 64.0 64.5

Thickness vs Length (Coil Number 535451)





Material Inspection Report

LOCATION

Sumter

DATE

6/21/2019

CUSTOMER

ABB MEBANE

JOB # SMT

74222

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	Order Dim		Tolerances		Tolerances		Low Limit		High Limit
Gauge	0.060	-	-0.001	+	0.013		0.061		0.073
Width	33.167	-	0.030	+	0.030		33.137		33.197
Length	49.500	-	0.030	+	0.030		49.470		49.530

	Set up Target
Gauge	0.067
Width	33.167
Length	49.500

Side Type

Skid Type Error

Skid Code 0 1 3

Finished Goods Tag	79800								
Master Coil Number									
Heat									
Enhanced Weight									
Gross Weight									
Tare	100								
Net Weight	(100)	0	0	0	0				
Bundle Status									
Good Pcs.	100								
Scraped Pcs.									
Rockwell									
Gauge Head	E 0.061								
	C 0.061								
	E 0.061								
Body	E								
	C								
	E								
Tail	E								
	C								
	E								
Surface									
Width Head	33.174								
Body	33.174								
Tail	33.174								
Shape	0.125								
Residual Check									
Length Head	49.508								
Body	49.508								
Tail	49.508								
Squareness									
Camber									
Operator									
Setup Approval									
Run Time	S 12:00 AM	F 12:00 AM	Down Time	S 12:00 AM	F 12:00 AM				
Total Run Time	0:00								
Comments									



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Gauge	0.060	-	-0.001	+	0.013		0.061		0.073
Width	33.167	-	0.030	+	0.030		33.137		33.197
Length	49.500	-	0.030	+	0.030		49.470		49.530

	Set up Target		Side Type	Skid Type Error		Skid Code	0 1 3
Gauge	0.067			SOP'S			
Width	33.167		JDOP008	JDOP016	JDOP046		
Length	49.500		JDOP014	JDOP034	JDOP032		

Finished Goods Tag	79795	79796	79797	79798	79799
Master Coil Number					
Heat					
Enhanced Weight					
Gross Weight	2900	2900	2900	2900	2900
Tare	100	100	100	100	100
Net Weight	2800	2800	2800	2800	2800
Bundle Status					
Good Pcs.	100	100	100	100	100
Scraped Pcs.					
Rockwell					
Gauge Head	E 0.061	0.061	0.061	0.061	0.061
	C 0.061	0.061	0.061	0.061	0.061
	E 0.061	0.061	0.061	0.061	0.061
Body	E				
	C				
	E				
Tail	E				
	C				
	E				
Surface					
Width Head	33.167	33.175	33.164	33.174	33.164
Body	33.167	33.175	33.164	33.174	33.164
Tail	33.167	33.175	33.164	33.174	33.164
Shape	0.125		0.125		0.125
Residual Check					
Length Head	49.504	49.508	49.501	49.508	49.501
Body	49.514	49.518	49.501	49.508	49.501
Tail	49.514	49.518	49.501	49.508	49.501
Squareness	.045	.023			
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					