

Process Audit Summary:

6/22/15 Sumter Red Bud Job# 57060

Performed by: Beverly Clem

Leveling job to produce 60" x various length sheets for Accu Fab Inc. from master tag NB46791.

All procedural coil identification checks followed.

Two skids produced at 60 x 96 and 14 skids at 60 x 120. All skids produced within max lifts and packaged and identified correctly per W/O instructions.

All procedural dimensional checks (Gauge-width-length-square) were done in excess of required intervals. All measurements fell within customer tolerances. Gamma report showed 34' under min gauge but it was determined that was on very edge of sheet. Shape checks done in excess of required interval based on flatness requirements, all checks within tolerance.

No follow up required.

Part Spec/PO Audit Form

Cust #	2965	Customer	ACCU FAB INC	Grp/Sz/Grd/Width	GNS/0.0635/CB40NO/60
Equip/Plant	SRB	Work Order #	57060	Part No.	SHGNA653A60.060
		Date	6/22/2015		
Work Order Information		Material to be Used		Actual	
		Tag #1	NB46791	Gauge #1	Gauge #2
		PO#	16773	% Gauge In Spec	% Gauge In Spec
Gauge Range	0.0575-0.0695	Gauge Min	0.0575	Low/High Gauge	Low/High Gauge
Width Range	60-60.25	Width	60.0000	Average	Average
Length Range	96-96025/120-120-120.25			Width	Width
Rockwell	N/A	Rockwell	N/A	Length	Length
Tensile	N/A			Rockwell	Rockwell
Yield	N/A			W-F-B	< 0.180
% Elongation	N/A			SQ	< .250
Chem Rqmts	N/A				
Other Rqmts	N/A			Other	
W-F-B	0-180				
SQ	0-25				
Summary					
Actions					
Final Status					

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 57060 Coil Number: NB46791

Customer Number: ACCFAB Coil Information: NUB2505868 Supplier: NUCOR BERKELEY

Product: Steel Jun-22-15 17:45 to 20:14 (clock 148.5 min/ run 28.3 min) Shift: 2

Average Thickness and Tolerance Data

Target	Average^	Average - Target	-0.0052 in (-8.22%)
		Standard Deviation^	0.0004 in (0.58%)
Length	3834 ft	Above High Limit	0.0695 in 0 ft (0.0%)
Width	60.000 in	In Tolerance	
Weight	45693 lbs	Below Low Limit	0.0575 in 34 ft (0.9%)
Max Thickness	0.0592 in at 27 ft	Min Thickness	0.0572 in at 721 ft

Statistical Process Control Data

Upper Control Limit	0.0594 in	Upper Tolerance Limit	0.0695 in
X Double Bar	0.0583 in	R Bar	0.0011 in
Lower Control Limit	0.0572 in	Lower Tolerance Limit	0.0575 in
CR	18.5% (Capability Ratio 1, 100/CP)		
CP	5.405 (Process Capability, HiLim-LoLim/6*Sigma)		
CPK	0.703 (Capability vs Limits)	TMW Ratio	0.987 (Low Limit/Avg)

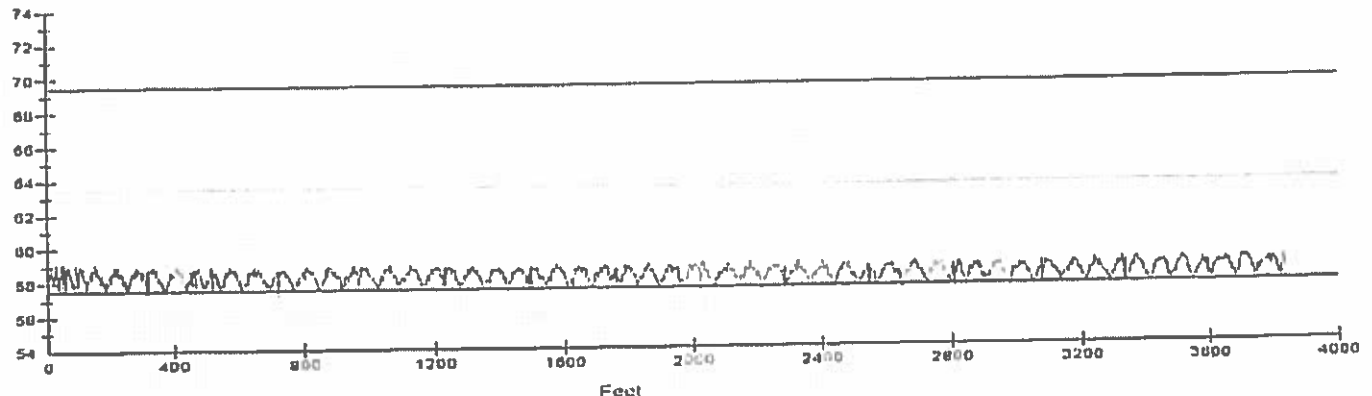
Thickness Distribution Relative to the Target

---	0.0%
---	0.0%
-0.0100	0.0%
-0.0090	0.0%
-0.0080	0.0%
-0.0070	0.0%

-0.0070	0.9%
-0.0080	0.0%
-0.0090	0.0%
-0.0100	0.0%
---	0.0%

0.0%	is within ± 0.0020 in of the target	39.5%	is within ± 0.0050 in of the target
100.0%	is within ± 0.0100 in of the target	100.0%	is within ± 0.0200 in of the target

Thickness vs Length (Coil Number NB46791)



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