

Process/Product Audit Checklist

Cust #: <u>2806</u> Customer: <u>NATIONAL BEVERAGE</u> GRP/Size/GRD/Width: <u>PGVSI.0266/BLACK/32.205</u>				
PWC: <u>SRB</u> W/O#: <u>74546</u> Date: <u>6/25/2019</u> Part #(s): <u>770331B</u> Auditor: <u>B. Clem</u>				
Gauge Range: <u>.0226 - .0306</u> Actual Gauge: <u>.023</u> Width Range: <u>32.205-32.215</u> Width Actual: <u>32.207</u>				
Length Range: <u>78.705-78.735</u> Length Actual: <u>78.719</u> W-B-F Other: <u>0-.12</u> Other Actual: <u>LESS .125</u>				
SQ Other: <u>0-.030</u> Other Actual: <u>.002</u> Other: <u>N/A</u> Other Actual: <u>N/A</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?		X		Chris M. - End of run check was noted on FOP081 but was not done. Job had 3 skids at 3 different pc. counts. Two of the skids listed on the FOP081 had incorrect pc. count listed.
Correct raw material type and size?	X			Tag(s) to use: <u>3518008</u> Tag(s) used: <u>3518008</u>
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 - Chris M. & Marion
Forms are the latest revision per Quality Intranet?	X			List Forms (Observed Rev vs Intranet Rev) FOP081 2/16/01 1
Hardcopy Controlled Documents are listed on Quality Intranet by location?	X			List Documents and their Location: SMT-SRB-001 11/8/16 5 JM-OP-001 4/21/15 0



Material Inspection Report

LOCATION

Sumter

DATE

6/25/2019

CUSTOMER

NATIONAL

JOB # SMT

74546

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	Order Dim		Tolerances		Tolerances		Low Limit		High Limit
Gauge	0.022	-	0.000	+	0.008		0.022		0.030
Width	32.205	-	0.000	+	0.010		32.205		32.215
Length	78.705	-	0.000	+	0.030		78.705		78.735

	Set up Target		Side Type	Skid Type Error		Skid Code	0 1 3
Gauge	0.026			SOP'S			
Width	32.210		JDOP008	JDOP016	JDOP046		
Length	78.720		JDOP014	JDOP034	JDOP032		

Finished Goods Tag	82693	82694					
Master Coil Number	3518008						
Heat							
Enhanced Weight							
Gross Weight	1930	3375	920				
Tare	100	100	100				
Net Weight	1830	3275	820	0	0		
Bundle Status							
Good Pcs.	110	110	110				
Scraped Pcs.							
Rockwell							
Gauge Head	E 0.023	0.023	0.023				
	C 0.023	0.023	0.023				
	E 0.023	0.023	0.023				
Body	E						
	C						
	E						
Tail	E						
	C						
	E						
Surface	0						
Width Head	32.207	32.207	32.207				
Body	32.207	32.207	32.207				
Tail	32.207	32.207	32.207				
Shape	0.000						
Residual Check							
Length Head	78.719	78.708	78.708				
Body	78.719	78.705	78.708				
Tail	78.719	78.708	78.708				
Squareness	.002						
Camber							
Operator	CM						
Setup Approval							
Run Time	S	F		Down Time	S	F	
Total Run Time	0:00	Cost	\$0.00	Cst/Hour		\$400.00	
Comments							

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| By:   beverlyc   At: SMT      Date: 25Jun19   Time: 19:13   |
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Tag Yld Cons      6,660      eSTELpro Production      Brh: SMT      PN- 74546
Prod      5,915      88.81 % Scr      % UScr      745 Pkg
                                     Tot Scr 11.19 %
--- Production Entry ---
Group Size      Grade Dimension      Tag      Whs      Pcs      Qty Cut
- Consumption - Ga .0220 M Usb Wdth 32.2050"
PGVC 25B        BLACK 32.2050      3518008 SPW      1      6,660
- Production -   * Costs not Finalized *      PIW
PGVS 25B        BLACK
          FA      32.2050 78.7050 82693 SFG      110      1,830      Y
          FA      32.2050 78.7050 82694 SFG      200      3,265      Y
          FA      32.2050 78.7050 82695 SFG      52       820      Y

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Brh/Ord No      -
Grp             Size      Grd      Dim
Tag             Whs

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1-Allocate 2-Cost Item 3-Inv 4-Scrap 5-Prt Tag 6-Prt Rng 7-Set Prtr 8-Cpy 9-Cut