

Process/Product Audit Checklist

Cust #: <u>3554</u> Customer: <u>Blue Bird SM2</u> GRP/Size/GRD/Width: <u>PGVS/.0360,BB2Y/52</u>				
PWC: <u>SRB</u> W/O#: <u>20057</u> Date: <u>6/29/2023</u> Part #(s): <u>WPGV20GA52.00X114.00-BB FAB</u> Auditor: <u>B. Clem</u>				
Gauge Range: <u>.0360-.0400</u> Actual Gauge: <u>.0375</u> Width Range: <u>52-52.250</u> Width Actual: <u>52.213</u>				
Length Range: <u>114-114.250</u> Length Actual: <u>114.125</u> Pcs/Tag Other: <u>50</u> Other Actual: <u>50 Pcs</u>				
Other: <u>N/A</u> Other Actual: <u>N/A</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			Sam
Correct raw material type and size?	X			Tag(s) to use: <u>9814101</u> Tag(s) used: <u>9814101</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 5/4/2023 5/24/2024 M50 1" Mic 5/24/2023 5/24/2024 ST-4 6/28/2023 6/28/2024 63294 Measuring Table 7/8/2020 7/8/2023
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	X			
Required PPE being worn?	X			
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 JM-OP-001



Material Inspection Report

LOCATION

Sumter

DATE

7/3/2023

CUSTOMER

FAB

JOB # SMT

SM2 20057

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	Order Dim		Tolerances		Tolerances		Low Limit		High Limit
Gauge	0.036	-	0.000	+	0.004		0.036		0.040
Width	52.000	-	0.000	+	0.250		52.000		52.250
Length	114.000	-	0.000	+	0.250		114.000		114.250

	Set up Target		Side Type	Skid Type Error		Skid Code	0 3 4
Gauge	0.038						
Width	52.125						
Length	114.125						
			JDOP008	JDOP016	JDOP046		
			JDOP014	JDOP034	JDOP032		

Finished Goods Tag	43275	43278	432281			
Master Coil Number	9814101					
Heat						
Enhanced Weight						
Gross Weight	3240	3240	3240	960		
Tare	120	120	120	120		
Net Weight	3120	3120	3120	840	0	
Bundle Status						
Good Pcs.	50	50	50			
Scraped Pcs.						
Rockwell						
Gauge Head	E 0.037	0.038	0.038			
	C 0.037	0.038	0.038			
	E 0.037	0.038	0.038			
Body	E					
	C					
	E					
Tail	E					
	C					
	E					
Surface						
Width Head	52.213	52.216	52.211			
Body						
Tail						
Shape						
Residual Check						
Length Head	114.125	114.125	114.125			
Body						
Tail						
Squareness						
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						

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: SM2 20057 Coil Number: 9814101

Customer Number: FAB Coil Information: NUDSN2406 Supplier: PRECOAT METL

Product: Steel Jun-29-23 6:18 to 7:11 (clock 53.0 min/ run 33.1 min) Shift: 1

Average Thickness and Tolerance Data

Target 38.0 mil Average^ 38.0 mil Average - Target 0.0400 mil (0.11%)
Standard Deviation^ 0.1400 mil (0.37%)

Length 3411 ft Above High Limit 40.0 mil 0 ft (0.0%)
Width 52.000 in In Tolerance 3411 ft (100.0%)
Weight 22998 lbs Below Low Limit 36.0 mil 0 ft (0.0%)

Max Thickness 38.4 mil at 342 ft Min Thickness 37.3 mil at 3257 ft

Statistical Process Control Data

Upper Control Limit 38.5 mil Upper Tolerance Limit 40.0 mil
X Double Bar 38.0 mil R Bar 0.4 mil
Lower Control Limit 37.6 mil Lower Tolerance Limit 36.0 mil

CR 21.0% (Capability Ratio %, 100/CP)

CP 4.762 (Process Capability, HiLim-LoLim/6*Sigma)

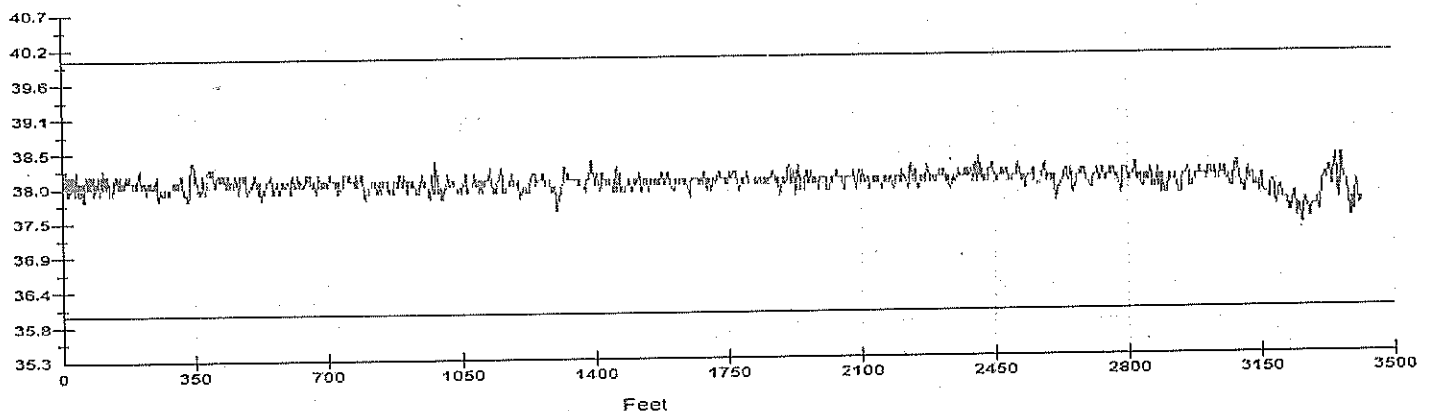
CPK 4.667 (Capability vs Limits) TMW Ratio 0.946 (Low Limit/Avg)

Thickness Distribution Relative to the Target

+++	0.0%
+ 5.0	0.0%
+ 4.5	0.0%
+ 4.0	0.0%
+ 3.5	0.0%
+ 3.0	0.0%
+ 2.5	0.0%
+ 2.0	0.0%
+ 1.5	0.0%
+ 1.0	0.0%
+ 0.5	0.0%
+ 0.0	100.0%
- 0.5	0.0%
- 1.0	0.0%
- 1.5	0.0%
- 2.0	0.0%
- 2.5	0.0%
- 3.0	0.0%
- 3.5	0.0%
- 4.0	0.0%
- 4.5	0.0%
- 5.0	0.0%
---	0.0%

100.0% is within ± 1.0000 mil of the target 100.0% is within ± 2.5000 mil of the target
100.0% is within ± 5.0000 mil of the target 100.0% is within ± 10.0000 mil of the target

Thickness vs Length (Coil Number 9814101)



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