

Process/Product Audit Checklist

Cust #: 3376		Customer: Eaton-TN		GRP/Size/GRD/Width: CRS/.0730/CSB/23.26	
PWC: SRB		W/O#: 94197		Date: 6/7/2024	
		Part #(s):		Auditor: B. Clem	
Gauge Range: .067-.0790		Actual Gauge: .069		Width Range: 23.236-23.265	
		Width Actual: 23.241			
Length Range: 31.236-31.265		Length Actual: 31.251		W-B-F Other: 0-.12	
		Other Actual: Less .12			
SQ Other: 0-.04		Other Actual: Less .040		Pc/Tag Other: 150	
		Other Actual: 150			

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 Jackson - Shape check not noted on FOP081. Square check not noted on FOP081.
Correct raw material type and size?	x			Tag(s) to use: 585544 Tag(s) used: 585544
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 6/29/2024 6/29/2025 M50 1" Mic 1/19/2024 1/19/2025 ST-4 Step Gauge 6/28/2023 6/28/2024 63294 Measuring Table 4/26/2022 4/26/2025
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

7/16/2024

CUSTOMER

EATON TN

JOB # SMT

94197

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	Order Dim	Tolerances	Tolerances	Low Limit	High Limit
Gauge	0.067	0.000	0.012	0.067	0.079
Width	23.250	0.015	0.015	23.235	23.265
Length	31.250	0.015	0.015	31.235	31.265

	Set up Target	Side Type	Skid Type Error	Skid Code
Gauge	0.073			0 1 1
Width	23.250			
Length	31.250			

JDOP008	JDOP016	JDOP046
JDOP014	JDOP034	JDOP032

Finished Goods Tag	270591	270593			
Master Coil Number	585544				
Heat					
Enhanced Weight					
Gross Weight	2180	2180			
Tare	50	50			
Net Weight	2130	2130	0	0	0
Bundle Status					
Good Pcs.	150	150			
Scraped Pcs.					
Rockwell					
Gauge Head	E 0.069	0.069			
	C 0.069	0.069			
	E 0.069	0.069			
Body	E 0.069				
	C				
	E				
Tail	E				
	C				
	E				
Surface					
Width Head	23.241	23.255			
Body	23.241	23.248			
Tail					
Shape					
Residual Check					
Length Head	31.251	31.245			
Body	31.249	31.248			
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: 94197 Coil Number: 585544

Customer Number: EATON TN Coil Information: 483572 Supplier: CLEVELAND CLIF

Product: Steel Jun-7-24 10:08 to 10:58 (clock 49.4 min/ run 22.7 min) Shift: 1

Average Thickness and Tolerance Data

Target	69.0 mil	Average^	69.6 mil	Average - Target	-3.4100 mil (-4.67%)
				Standard Deviation^	0.1100 mil (0.15%)
Length	994 ft	Above High Limit	79.0 mil	0 ft (0.0%)	
Width	48.000 in	In Tolerance			
Weight	11312 lbs	Below Low Limit	67.0 mil	0 ft (0.0%)	
Max Thickness	69.9 mil at 6 ft	Min Thickness	69.3 mil at 16 ft		

Statistical Process Control Data

Upper Control Limit	69.9 mil	Upper Tolerance Limit	79.0 mil
X Double Bar	69.6 mil	R Bar	0.3 mil
Lower Control Limit	69.3 mil	Lower Tolerance Limit	67.0 mil

CR 5.5% (Capability Ratio %, 100/CP)

CP 18.182 (Process Capability, HiLim-LoLim/6*Sigma)

CPK 7.849 (Capability vs Limits) TMW Ratio 0.963 (Low Limit/Avg)

Thickness Distribution Relative to the Target

+++	0.0%
+10.0	0.0%
+ 9.0	0.0%
+ 8.0	0.0%
+ 7.0	0.0%

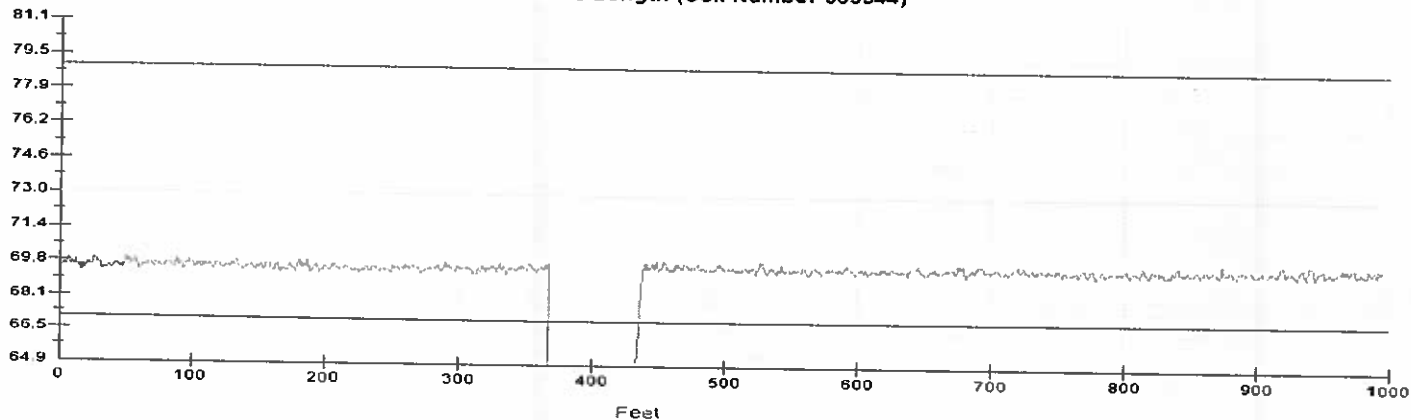
-	0.0%
-10.0	0.0%
- 9.0	0.0%
- 8.0	0.0%
- 7.0	0.0%

---	0.0%
--10.0	0.0%
-- 9.0	0.0%
-- 8.0	0.0%
-- 7.0	0.0%

0 3 6 9 12 15 18 21 24 27 30 33

0.0% is within ± 2.0000 mil of the target 100.0% is within ± 5.0000 mil of the target
100.0% is within ± 10.0000 mil of the target 100.0% is within ± 20.0000 mil of the target

Thickness vs Length (Coil Number 585544)



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