

# Process/Product Audit Checklist

Cust #: <u>2719</u> Customer: <u>Alter</u> GRP/Size/GRD/Width: <u>GNS .1084 CB40NO 60</u>				
PWC: <u>SRB</u> W/O#: <u>61956</u> Date: <u>7-18-16</u> Part #(s): <u>970380126/970061512/970510050</u>				
Gauge Range: <u>.0974 - .1174</u> Actual Gauge: <u>.099</u> Width Range: <u>60 - 60.9999</u> Width Actual: <u>60.233</u>				
Length Range: <u>159 - 159.1250</u> Length Actual: <u>159.030</u> Other: <u>Length 120 - 120.1250</u> Other Actual: <u>120.030</u>				
Length 109 - 109.1250 Other: <u>109.030</u> FLATN Other: <u>0 - .12</u> Other Actual: <u>0</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?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<u>Leguon &amp; Chris</u>
Correct raw material type and size?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Tag(s) to use: <u>NB 51060</u> Tag(s) used: <u>NB 51060</u>
Setup performed according to W/O?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Product is acceptable according to customer-specific requirements? [Fab: Is the Part Print Present & the correct Revision? Are required measurements documented?]	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	[Fab: Print Rev: _____, W/O Rev: _____, Part Spec Rev: _____]
Packaging is acceptable according to customer-specific requirements?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Visual Inspection performed and product meets requirements?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Out of spec noted, with actions taken?	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
Non-conforming material put into reject warehouse and physically put into non-conforming area?	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
Required gages available & functional?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
All Gages Calibrated (List in Comments)	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Gages Observed (list last calibration and when due) P-3 25' Tape 3-8-16 3-8-17 M-44 1" mic 6-28-16 6-28-17 ST-5 Step Gauge 7-5-16 7-5-17 63294 Mers. Table 4-26-16 4-26-17
Housekeeping: Machine/Floor clean?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Loose tags & paperwork cleaned up?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Required PPE being worn?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
Forms are the latest revision per Quality Intranet?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	List Forms (Observed Rev vs Intranet Rev) SMT-SRB-001 3-7-13 4 SMT-SH-001 10-26-11 0 Jim-OP-001 4-21-15 0 FOP081 2-16-01 1
Hardcopy Controlled Documents are listed on Quality Intranet by location?	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	List Documents and their Location:

# AGT400 Coil Summary Report

## JEMISON METALS --

Job Number: 61956 Coil Number: NB51060

Customer Number: ALTEC Coil Information: NUB2608582 Supplier: NUCOR BERKLEY

Product: Steel Jul-18-16 20:14 to 21:54 (clock 100.9 min/ run 29.9 min) Shift: 2

### Average Thickness and Tolerance Data

Target	0.1074 in	Average^	0.0984 in	Average - Target	-0.0090 in (-0.36%)
				Standard Deviation^	0.0004 in (0.36%)
Length	2478 ft	Above High Limit	0.1174 in	0 ft (0.0%)	
Width	60.000 in	In Tolerance			
Weight	49876 lbs	Below Low Limit	0.0974 in	10 ft (0.4%)	
Max Thickness	0.0997 in at 1858 ft	Min Thickness	0.0971 in at 2281 ft		

### Statistical Process Control Data

Upper Control Limit	0.0997 in	Upper Tolerance Limit	0.1174 in
X Double Bar	0.0984 in	R Bar	0.0017 in
Lower Control Limit	0.0972 in	Lower Tolerance Limit	0.0974 in
CR	12.6% (Capability Ratio %, 100/CP)		
CP	7.937 (Process Capability, HiLim-LoLim/6*Sigma)		
CPK	0.810 (Capability vs Limits)	TMW Ratio	0.990 (Low Limit/Avg)

### Thickness Distribution Relative to the Target

+++	0.0%
+0.0100	0.0%
+0.0090	0.0%
+0.0080	0.0%
+0.0070	0.0%
+0.0060	0.0%
+0.0050	0.0%
+0.0040	0.0%
+0.0030	0.0%
+0.0020	0.1%
+0.0010	0.2%
+0.0000	0.3%
-0.0010	0.1%
-0.0020	0.0%
-0.0030	0.0%
-0.0040	0.0%
-0.0050	0.0%
-0.0060	0.0%
-0.0070	0.0%
-0.0080	0.0%
-0.0090	0.0%
-0.0100	0.0%
---	0.4%

0.0% is within  $\pm 0.0020$  in of the target      0.0% is within  $\pm 0.0050$  in of the target  
99.6% is within  $\pm 0.0100$  in of the target      100.0% is within  $\pm 0.0200$  in of the target

Thickness vs Length (Coil Number NB51060)

