

Process/Product Audit Checklist

Cust #: <u>1697</u> Customer: <u>GE Mebane</u> GRP/Size/GRD/Width: <u>POC.0830C5B16.5</u>				
PWC: <u>SSL</u> W/O#: <u>66467</u> Date: <u>7-18-17</u> Part #(s): <u>B8A3AP314</u> Auditor: <u>B. Clem</u>				
Gauge Range: <u>.0830 - .0900</u> Actual Gauge: <u>.096</u> Width Range: <u>16.495 - 16.5005</u> Width Actual: <u>16.499</u>				
Length Range: <u>N/A</u> Length Actual: <u>N/A</u> Other: <u>Camb. 0-.12</u> Other Actual: _____				
Other: <u>14.358 - 14.368</u> Other Actual: <u>14.362</u> Other: _____ Other Actual: _____				
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?	☒	☒	☐	<u>Camber Check not done</u> <u>Farron</u>
Correct raw material type and size?	☒	☐	☐	Tag(s) to use: <u>NB55458</u> Tag(s) used: <u>NB55458</u>
Setup performed according to W/O?	☒	☐	☐	
Product is acceptable according to customer-specific requirements? [Fab: Is the Part Print Present & the correct Revision? Are required measurements documented?]	☒	☐	☐	[Fab: Print Rev: _____, W/O Rev: _____, Part Spec Rev: _____] (Leave blank if non-Fab audit)
Packaging is acceptable according to customer-specific requirements?	☐	☐	☐	
Visual Inspection performed and product meets requirements?	☒	☐	☐	
Out of spec noted, with actions taken?	☐	☐	☒	
Non-conforming material put into reject warehouse and physically put into non-conforming area?	☐	☐	☒	
Required gages available & functional?	☒	☐	☐	
All Gages Calibrated (List in Comments)	☒	☐	☐	<u>D-2 40" Caliper 9-7-16 9-7-17</u> <u>Gages Observed (list last calibration and when due)</u> <u>13-01 25' Tape 8-16-16 8-16-17</u> <u>11-03 12' Tape 5-16-17 5-16-18</u> <u>M-55 1" mic 12-1-16 12-1-17</u> <u>D-5 24" Caliper 6-6-17 6-6-18</u>
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	☒	☐	☐	
Required PPE being worn?	☒	☐	☐	
Forms are the latest revision per Quality Intranet?	☒	☐	☐	List Forms (Observed Rev vs Intranet Rev) <u>SMT-SL-001 3-7-13 1</u> <u>FOP015 3-16-01 1</u>
Hardcopy Controlled Documents are listed on Quality Intranet by location?	☒	☐	☐	List Documents and their Location: <u>FMA044 - Sumter - Quality</u> <u>Intranet</u>



Manual Inspection Report

FOAD01 Inspection Codes

JPD01993 JPD01996

JPD01997 JPD01939

Date 7/19/2017

Job # SMT- 66467

Location: Sumter

Gauge Spec 0.08300

Page #

Operator: FMI

Liabilities 0.08300

Machines: Target

Slitter 0.08650

CQ 0.01245

Horizontal Clearance HS 10b38

0.01660 0.02075

Cut	Set Up	Actual	Cut	Set Up	Actual	Cut	Set Up	Actual	Cut	Set Up	Actual
1	16.504	16.499	6			11			16		21
2	16.504	16.498	7			12			17		22
3	14.367	14.362	8			13			18		23
4			9			14			19		24
5			10			15			20		25

Set Up Comments:

	Coil #	Olen	Rb	Gauge						Camber	Linear Ft	Burr Hgt	Good PC	Bad PC	Comment
				Head	1/4	Center	3/4	Tail							
1	NB55458			E 0.08600	0.09000	0.09000	0.09000	0.09000							
				C 0.08700	0.08800	0.08800	0.08800	0.08800							
				E 0.08600	0.08600	0.08600	0.08600	0.08600							
2				E											
				C											
				E											
3				E											
				C											
				E											
4				E											
				C											
				E											
5				E											
				C											
				E											
Start Time		Stop Time		Start Derna Time		Stop Derna Time		Total Derna Time		0:00	Total Run Time		0:00	Cut/Hour Cost	\$550.00 50.00
Comments															

17Jul17 13:29

J O B W O R K O R D E R

SMT 66467

Jemison Metals - Sumter
 1255 North Gate Drive
 Sumter, SC 29154
 Tel: 803-481-0707 Fax: 803-481-0713

Job Type SLT Process PWC SSL
 Metric N Cust
 Desc 130380 GE MEBANE
 Due Date 17Jul17 Whs SFG
 Setup 00:00 Run 01:30 Prtd By rclar

=====
 <<< JOB SPECIFICATIONS >>>
 Group POC Grade CSB Gauge 0.0830 (0.0830 to 0.0900) ID 20.0000
 =====

=====
 <<< ORDER SPECIFICATIONS >>>
 01 POC/13/CSB/16.5000"/.0830M CS-TYPE B
 Ord SMT 130380- 1 Cust GE MEBANE Ga 0.0830 Wth 16.5000 Lth
 Part 1697/B8A3AP314 Ga 0.0830 Wth 16.5000 Lth
 Ga Rng 0.0830to 0.0900 Pc/Tag 1 ID MnOD MxOD MnWgt MxWgt
 WthTol + 0.0050 - 0.0050 Wt/Skd 10000 20.00 36.00 55.50 3293 9850
 LthTol + 0.0000 - 0.0000 Ty J11 Pk .
 CAMB:0.00-.12

 SHIP ONLY TWO COILS PER ORDER-IF SALES ORDER
 AMOUNT EXCEEDS THE WEIGHT OF TWO COILS, SEE SANDI
 FOR CLARIFICATION

 PLACE PROTECTIVE BAG OVER ALL STANDUP COILS ONCE
 PACKAGED

=====
 02 POC/13/CSB/14.3630"/.0830M CS-TYPE B
 Part 1697/B8A3AP311 Ga 0.0830 Wth 14.3630 Lth
 Ga Rng 0.0830to 0.0900 Pc/Tag 1 ID MnOD MxOD MnWgt MxWgt
 WthTol + 0.0050 - 0.0050 Wt/Skd 10000 20.00 36.00 59.00 2866 9857
 LthTol + 0.0000 - 0.0000 Ty J11 Pk .
 CAMB:0.00-.12

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<<< ARBOR SET UP >>>

1 2 3
 16.5000 16.5000 14.3630

Arbor Recap: 2 X 16.5000 1 X 14.3630
 Total Width: 47.3630

<<< PROCESSING INSTRUCTIONS >>>

Set 1, Step 1> Cut as follows:
 1Pcs, 1Pass, Cut Partial, Run @ Pos 1- 3, To 38.72 OD, 867 Lgth, 245 PIW

Use Tags:
 NB55458 SPW 0.0830M 48.0000

ID Wdth OD Wdth
 0.0000 48.2500

<<< MATERIAL TO BE USED >>>