

Process/Product Audit Checklist

Cust #: <u>3023</u> Customer: <u>Custom Metal</u> GRP/Size/GRD/Width: <u>GNS.0635C860CD60</u>				
PWC: <u>SBB</u> W/O#: <u>761088</u> Date: <u>7-19-18</u> Part #(s): <u>16 GA GNS 60x96</u> Auditor: <u>B. Clem</u>				
Gauge Range: <u>.0575 - .0635</u> Actual Gauge: <u>.0575</u> Width Range: <u>60-60.2500</u> Width Actual: <u>59.990</u> OK				
Length Range: <u>96-96.1250</u> Length Actual: <u>96.060</u> W-F: <u>0-12</u> Other Actual: <u>.000</u>				
Other: <u>Wt./Skid 5000 lbs.</u> Other Actual: <u>4670 lbs.</u> Other: <u>Pcs/Tag 48 pcs</u> Other Actual: <u>48 pcs/Tag</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?	✓			Insp. Sheet filled out but no length check done at end of run. Length check on Chris m. 1st skid not done till 10 sheets in.
Correct raw material type and size?	✓			Tag(s) to use: <u>524431</u> Tag(s) used: <u>524431</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?	✓			Width .010 under OK'd by B. Clem
Non-conforming material put into reject warehouse and physically put into non-conforming area?		✓		OK'd By B. Clem
Required gages available & functional?	✓			
All Gages Calibrated (List in Comments)	✓			Gages Observed (list last calibration and when due) 8-3 25' Tape 3-30-19 3-30-19 M50 1" mic 5-29-18 5-29-19 ST-5 Step Gauge 7-5-18 7-5-19 63294 M405 Table 4-20-18 4-20-19
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	✓			
Required PPE being worn?		✓		No Safety Glasses
Forms are the latest revision per Quality Intranet?	✓			List Forms (Observed Rev vs Intranet Rev) FOP 081 2-16-01 1
Hardcopy Controlled Documents are listed on Quality Intranet by location?	✓			List Documents and their Location: SMT-SRB-P01 Jm-0P-001

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 70688 Coil Number: 524431

Customer Number: CUSTOM Coil Information: NUB1718312 Supplier: ZZ

Product: Steel Jul-19-18 16:39 to 17:36 (clock 56.8 min/ run 9.0 min) Shift: 2

Average Thickness and Tolerance Data

Target: 0.0600 in Average: 0.0583 in Average - Target -0.0017 in (-2.8%)
 Standard Deviation: 0.0004 in (0.7%)
 Above Tolerance Limit 0.0630 in 0 ft (0%)
 In Tolerance 0.0570 in 1168 ft (99%)
 Below Tolerance Limit 0.0570 in 1 ft (0%)
 Min Thickness 0.0565 in at 872 ft

Statistical Process Control Data

Upper Control Limit 0.0630 in Upper Tolerance Limit 0.0630 in
 Lower Control Limit 0.0537 in Lower Tolerance Limit 0.0570 in
 Process Capability Ratio (Cp) 1.0000 (Process Capability, 100% Sigma)
 Process Capability Ratio (Cpk) 0.978 (Low Limit/Avg)

Thickness Distribution Relative to the Target

Thickness Distribution Relative to the Target

Thickness (in)	Count	Percentage (%)
0.0565	1	0.08
0.0570	1	0.08
0.0575	1	0.08
0.0580	1	0.08
0.0585	1	0.08
0.0590	1	0.08
0.0595	1	0.08
0.0600	1	0.08
0.0605	1	0.08
0.0610	1	0.08
0.0615	1	0.08
0.0620	1	0.08
0.0625	1	0.08
0.0630	1	0.08
0.0635	1	0.08
0.0640	1	0.08
0.0645	1	0.08
0.0650	1	0.08
0.0655	1	0.08
0.0660	1	0.08
0.0665	1	0.08
0.0670	1	0.08
0.0675	1	0.08
0.0680	1	0.08
0.0685	1	0.08
0.0690	1	0.08
0.0695	1	0.08
0.0700	1	0.08
0.0705	1	0.08
0.0710	1	0.08
0.0715	1	0.08
0.0720	1	0.08
0.0725	1	0.08
0.0730	1	0.08
0.0735	1	0.08
0.0740	1	0.08
0.0745	1	0.08
0.0750	1	0.08
0.0755	1	0.08
0.0760	1	0.08
0.0765	1	0.08
0.0770	1	0.08
0.0775	1	0.08
0.0780	1	0.08
0.0785	1	0.08
0.0790	1	0.08
0.0795	1	0.08
0.0800	1	0.08
0.0805	1	0.08
0.0810	1	0.08
0.0815	1	0.08
0.0820	1	0.08
0.0825	1	0.08
0.0830	1	0.08
0.0835	1	0.08
0.0840	1	0.08
0.0845	1	0.08
0.0850	1	0.08
0.0855	1	0.08
0.0860	1	0.08
0.0865	1	0.08
0.0870	1	0.08
0.0875	1	0.08
0.0880	1	0.08
0.0885	1	0.08
0.0890	1	0.08
0.0895	1	0.08
0.0900	1	0.08
0.0905	1	0.08
0.0910	1	0.08
0.0915	1	0.08
0.0920	1	0.08
0.0925	1	0.08
0.0930	1	0.08
0.0935	1	0.08
0.0940	1	0.08
0.0945	1	0.08
0.0950	1	0.08
0.0955	1	0.08
0.0960	1	0.08
0.0965	1	0.08
0.0970	1	0.08
0.0975	1	0.08
0.0980	1	0.08
0.0985	1	0.08
0.0990	1	0.08
0.0995	1	0.08
0.1000	1	0.08
0.1005	1	0.08
0.1010	1	0.08
0.1015	1	0.08
0.1020	1	0.08
0.1025	1	0.08
0.1030	1	0.08
0.1035	1	0.08
0.1040	1	0.08
0.1045	1	0.08
0.1050	1	0.08
0.1055	1	0.08
0.1060	1	0.08
0.1065	1	0.08
0.1070	1	0.08
0.1075	1	0.08
0.1080	1	0.08
0.1085	1	0.08
0.1090	1	0.08
0.1095	1	0.08
0.1100	1	0.08
0.1105	1	0.08
0.1110	1	0.08
0.1115	1	0.08
0.1120	1	0.08
0.1125	1	0.08
0.1130	1	0.08
0.1135	1	0.08
0.1140	1	0.08
0.1145	1	0.08
0.1150	1	0.08
0.1155	1	0.08
0.1160	1	0.08
0.1165	1	0.08
0.1170	1	0.08
0.1175	1	0.08
0.1180	1	0.08
0.1185	1	0.08
0.1190	1	0.08
0.1195	1	0.08
0.1200	1	0.08
0.1205	1	0.08
0.1210	1	0.08
0.1215	1	0.08
0.1220	1	0.08
0.1225	1	0.08
0.1230	1	0.08
0.1235	1	0.08
0.1240	1	0.08
0.1245	1	0.08
0.1250	1	0.08
0.1255	1	0.08
0.1260	1	0.08
0.1265	1	0.08
0.1270	1	0.08
0.1275	1	0.08
0.1280	1	0.08
0.1285	1	0.08
0.1290	1	0.08
0.1295	1	0.08
0.1300	1	0.08
0.1305	1	0.08
0.1310	1	0.08
0.1315	1	0.08
0.1320	1	0.08
0.1325	1	0.08
0.1330	1	0.08
0.1335	1	0.08
0.1340	1	0.08
0.1345	1	0.08
0.1350	1	0.08
0.1355	1	0.08
0.1360	1	0.08
0.1365	1	0.08
0.1370	1	0.08
0.1375	1	0.08
0.1380	1	0.08
0.1385	1	0.08
0.1390	1	0.08
0.1395	1	0.08
0.1400	1	0.08
0.1405	1	0.08
0.1410	1	0.08
0.1415	1	0.08
0.1420	1	0.08
0.1425	1	0.08
0.1430	1	0.08
0.1435	1	0.08
0.1440	1	0.08
0.1445	1	0.08
0.1450	1	0.08
0.1455	1	0.08
0.1460	1	0.08
0.1465	1	0.08
0.1470	1	0.08
0.1475	1	0.08
0.1480	1	0.08
0.1485	1	0.08
0.1490	1	0.08
0.1495	1	0.08
0.1500	1	0.08

Thickness ± 0.0020 in of the target is within ± 0.0050 in of the target
 Thickness ± 0.0040 in of the target is within ± 0.0200 in of the target

Thickness vs Length (Coil Number 524431)

