

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 61876 Coil Number: NB50510

Customer Number: CUSTOM Coil Information: NUB2605280 Supplier: NUCOR BERKELY

Product: Steel Jul-7-16 21:48 to 23:06 (clock 78.4 min/ run 31.6 min) Shift: 2

Average Thickness and Tolerance Data

Target 0.0605 in Average^ 0.0582 in Average - Target -0.0023 in (-0.37%)
Standard Deviation^ 0.0003 in (0.46%)
Length 5147 ft Above High Limit 0.0635 in 0 ft (0.0%)
Width 48.000 in In Tolerance
Weight 48967 lbs Below Low Limit 0.0575 in 67 ft (1.3%)
Max Thickness 0.0588 in at 43 ft Min Thickness 0.0572 in at 6 ft

Statistical Process Control Data

Upper Control Limit 0.0590 in Upper Tolerance Limit 0.0635 in
X Double Bar 0.0582 in R Bar 0.0008 in
Lower Control Limit 0.0573 in Lower Tolerance Limit 0.0575 in
CR 28.0% (Capability Ratio %, 100/CP)
CP 3.571 (Process Capability, HiLim-LoLim/6*Sigma)
CPK 0.786 (Capability vs Limits) TMW Ratio 0.989 (Low Limit/Avg)

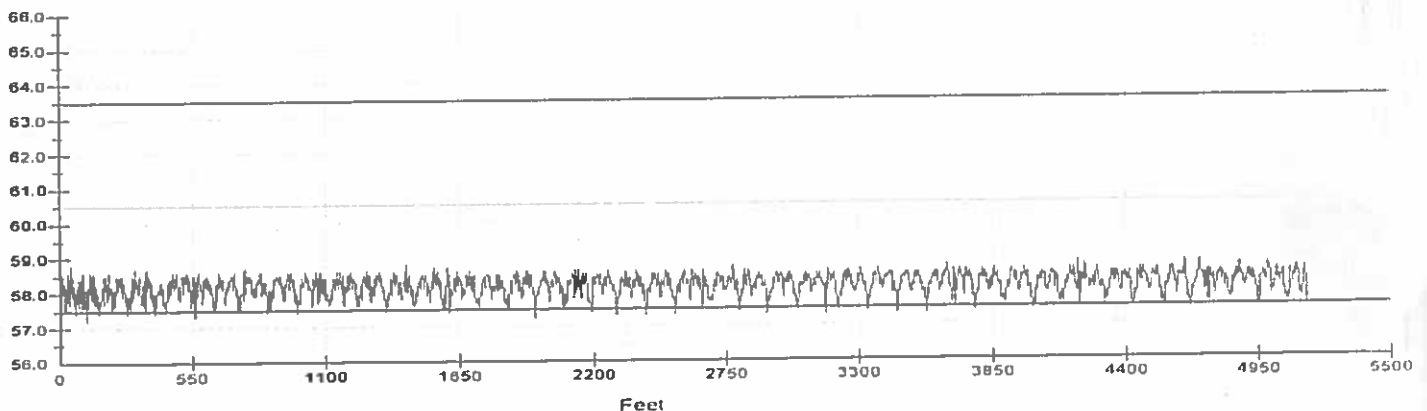
Thickness Distribution Relative to the Target

Thickness	Percentage
+++	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	0.0%
+0.0010	0.0%
-0.0000	0.0%
-0.0010	0.0%
-0.0020	0.0%
-0.0030	0.0%
-0.0040	1.3%
-0.0050	0.0%
-0.0060	0.0%
-0.0070	0.0%
-0.0080	0.0%
-0.0090	0.0%
-0.0100	0.0%
---	0.0%

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

12.5% is within ± 0.0020 in of the target 100.0% is within ± 0.0050 in of the target
100.0% is within ± 0.0100 in of the target 100.0% is within ± 0.0200 in of the target

Thickness vs Length (Coil Number NB50510)



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

Process/Product Audit Checklist

Cust #: <u>3023</u> Customer: <u>Custom Metal</u> GRP/Size/GRD/Width: <u>GNS .0635 CB60 CD 48</u>				
PWC: <u>SRB</u> W/O#: <u>61876</u> Date: <u>7-7-16</u> Part #(s): <u>16 GA GNS 48 X 110</u>				
Gauge Range: <u>.0575-.0635</u> Actual Gauge: <u>.058</u> Width Range: <u>48-48.1875</u> Width Actual: <u>48.162</u>				
Length Range: <u>110-110.1250</u> Length Actual: <u>110.050</u> Other: <u>W-F 0-.12</u> Other Actual: <u>0</u>				
Wght Other: <u>4.944 lbs</u> Other Actual: <u>4.670 lbs</u> Other: <u>52 pcs/Tag</u> Other Actual: <u>52 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?	✓			<u>Leguon & Chris</u>
Correct raw material type and size?	✓			Tag(s) to use: <u>NB50510</u> Tag(s) used: <u>NB50510</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: _____]
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)	✓			Gages Observed (list last calibration and when due) 8-3 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 Meas. Table 4-26-16 4-26-17
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) SMT-SRB-001 3-7-13 4 JM-OP-001 4-21-15 0 FOP081 2-16-01 1
Hardcopy Controlled Documents are listed on Quality Intranet by location?			✓	List Documents and their Location: