

Process/Product Audit Checklist

Cust #: <u>3023</u> Customer: <u>Custom Metal PR</u> GRP/Size/GRD/Width: <u>GNS/.0635/CB60CD/48</u>				
PWC: <u>SRB</u> W/O#: <u>94891</u> Date: <u>7/30/2024</u> Part #(s): <u>16 GA GNS 48 X 86.5</u> Auditor: <u>B. Clem</u>				
Gauge Range: <u>.0575-.0635</u> Actual Gauge: <u>.0575</u> Width Range: <u>48-48.1875</u> Width Actual: <u>48.109</u>				
Length Range: <u>86.5-86.625</u> Length Actual: <u>86.560</u> W-F Other: <u>0-.12</u> Other Actual: <u>Less .12</u>				
Other: <u>Residual Stress Test</u> Other Actual: <u>Good</u> Wt/Skid Other: <u>5000 lbs</u> Other Actual: <u>4515 lbs</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?	x			Chris D.
Correct raw material type and size?	x			Tag(s) to use: <u>NB80235</u> Tag(s) used: <u>NB80235</u>
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 Last Calibration: 6/27/2024 Due: 6/27/2025 M60 1" Mic Last Calibration: 1/19/2024 Due: 1/19/2025 ST-4 Step Gauge Last Calibration: 6/24/2024 Due: 6/24/2025 63294 Measuring Table Last Calibration: 4/26/2022 Due: 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) FOP061 2/16/01 1
Hardcopy Controlled Documents are listed on Quality Intranet by location?	x			List Documents and their Location: SMT-SRB-001 SMT-SH-001 JM-OP-001



Material Inspection Report

LOCATION

Sumter

DATE

7/30/2024

CUSTOMER

SPECIALTY

JOB # SMT

94891

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	Order Dim	Tolerances	Tolerances	Low Limit	High Limit
Gauge	0.056	-0.001	0.007	0.057	0.063
Width	48.000	0.000	0.187	48.000	48.187
Length	86.500	0.000	0.125	86.500	86.625

	Set up Target	Side Type	Skid Type Error	Skid Code
Gauge	0.060			0 2 3
Width	48.094			
Length	86.563			

JDOP008	JDOP016	JDOP046
JDOP014	JDOP034	JDOP032

Finished Goods Tag	275913	275916	275919	587648	
Master Coil Number	NB80235				
Heat					
Enhanced Weight					
Gross Weight	4625	4625	4625		
Tare	110	110	110	110	
Net Weight	4515	4515	4515	(110)	0
Bundle Status					
Good Pcs.	66	66	66	48	
Scraped Pcs.					
Rockwell					
Gauge Head	E 0.057	0.058	0.057	0.058	
	C 0.058	0.058	0.058	0.058	
	E 0.057	0.057	0.057	0.048	L
Body	E				
	C				
	E				
Tail	E				
	C				
	E				
Surface	OK				
Width Head	48.109	48.082	48.074	48.110	
Body			48.079		
Tail					
Shape	0.000				
Residual Check	GOOD				
Length Head	86.560	86.560	86.560	86.560	
Body					
Tail					
Squareness					
Camber					
Operator	CD				
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: 94851 Coil Number: NB80235

Customer Number: SPECIALTY Coil Information: NUB1409057 Supplier: NUCOR BERKELEY

Product: Steel Jul-30-24 14:16 to 15:26 (clock 70.7 min/ run 42.6 min) Shift: 2

Average Thickness and Tolerance Data

Target	58.4 mil	Average	58.4 mil	Average - Target	-2.1100 mil (-3.49%)
				Standard Deviation	0.2400 mil (0.40%)
Length	4585 ft	Above High Limit	63.5 mil	0 ft (0.0%)	
Width	48.000 in	In Tolerance			
Weight	43798 lbs	Below Low Limit	57.5 mil	1 ft (0.0%)	
Max Thickness	59.2 mil at 169 ft	Min Thickness	57.5 mil at 36 ft		

Statistical Process Control Data

Upper Control Limit	59.1 mil	Upper Tolerance Limit	63.5 mil
X Double Bar	58.4 mil	R Bar	0.7 mil
Lower Control Limit	57.7 mil	Lower Tolerance Limit	57.5 mil

CR 24.0% (Capability Ratio %, 100/CP)

CP 4.167 (Process Capability, HiLim-LoLim/6*Sigma)

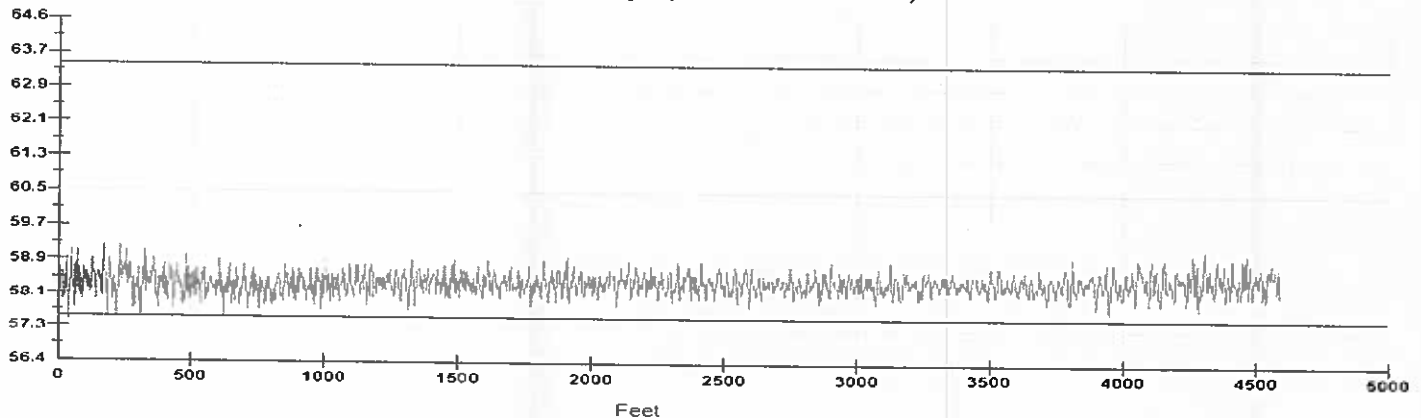
CPK 1.236 (Capability vs Limits) TMW Ratio 0.985 (Low Limit/Avg)

Thickness Distribution Relative to the Target

+++	0.0%
+10.0	0.0%
+ 9.0	0.0%
+ 8.0	0.0%
+ 7.0	0.0%
+ 6.0	0.0%
+ 5.0	0.0%
+ 4.0	0.0%
---	0.0%
--4.0	0.0%
--5.0	0.0%
--6.0	0.0%
--7.0	0.0%
--8.0	0.0%
--9.0	0.0%
-10.0	0.0%

40.8% 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 NB80235)



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