

Process/Product Audit Checklist

Cust #: <u>2793</u> Customer: <u>Daimler-SMT</u> GRP/Size/GRD/Width: <u>POC/1775/HS50-1/18.75</u>				
PWC: <u>SSL</u> W/O#: <u>90269</u> Date: <u>7/5/2023</u> Part #(s): <u>48-00731-519-18.75</u> Auditor: <u>B. Clem</u>				
Gauge Range: <u>.1775-.1955</u> Actual Gauge: <u>.183</u> Width Range: <u>18.745-18.755</u> Width Actual: <u>18.748</u>				
Length Range: <u>N/A</u> Length Actual: <u>N/A</u> With Other: <u>16.245-16.255</u> Other Actual: <u>16.246</u>				
With Other: <u>5.745-5.755</u> Other Actual: <u>5.749</u> With 2nd Cut Other: <u>16.245-16.255</u> Other Actual: <u>16.247</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			Farron
Correct raw material type and size?	X			Tag(s) to use: <u>ND76021</u> Tag(s) used: <u>ND76021</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		Gamma not working. Part ordered.
All Gages Calibrated (List in Comments)	X			Gages Observed (list last calibration and when due) 13-01 25' Tape 4/17/2023 4/17/2024 11-03 12' Tape 6/7/2023 6/7/2024 M55 1" Mic 6/5/2023 6/5/2024 D-5 24" Caliper 7/3/2023 7/3/2024
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) FOP015 2/16/01 1
Hardcopy Controlled Documents are listed on Quality Intranet by location?	X			List Documents and their Location: SMT-SL-001 JM-OP-001



Manual Inspection Report

EQ4013 Rejection Codes

JDOPE005 JDOPE006

JDOPE007 JDOPE049

Date 7/5/2023

Job # SMT-	90269	Page #	1	Machine:	Sitter	Horizontal Clearance	CQ	HS	10b38
Location:	Summer	Operator:	RM	Target	0.18600	0.02665	0.03340	0.04425	
Gauge Spec	0.17700	Limit	0.17700						

Cut	Set Up	Actual	Cut	Set Up	Actual	Cut	Set Up	Actual	Cut	Set Up	Actual
1	18.754	18.748	6			11			16		21
2	16.254	16.247	7			12			17		22
3	16.254	16.246	8			13			18		23
4	5.754	5.749	9			14			19		24
5			10			15			20		25

Set Up Comments:

Gauge											
Coil #	Olen	Rb	Head	1/4	Center	3/4	Tail	Camber	Linear Ft	Burr Hgt	Good PC
1	ND76021		E 0.18100	0.18400	0.18400	0.18400	0.18400				
			C 0.18300	0.18300	0.18300	0.18300	0.18300				
			E 0.18400	0.18100	0.18100	0.18100	0.18100				
2			E								
			C								
			E								
3			E								
			C								
			E								
4			E								
			C								
			E								
5			E								
			C								
			E								
Start Time	Stop Time	Start Time	Stop Time	Total Down Time	0:00	Total Run Time	0:00	Cut/Hour	\$550.00	Cost	\$0.00
Comment											