

Process/Product Audit Checklist

Cust #: <u>2719</u> Customer: <u>ALTEC</u> GRP/Size/GRD/Width: <u>GNS/.0635/CB40NO/60</u>				
PWC: <u>SRB</u> W/O#: <u>74971</u> Date: <u>8/16/2019</u> Part #(s): <u>970083436</u> Auditor: <u>B. CLEM</u>				
Gauge Range: <u>.0555-.0695</u> Actual Gauge: <u>.057</u> Width Range: <u>60-60.9999</u> Width Actual: <u>60.206</u>				
Length Range: <u>124-124.125</u> Length Actual: <u>124.060</u> Other: <u>FLATN 0-.12</u> Other Actual: <u>Less .125</u>				
Other: <u>N/A</u> Other Actual: <u>N/A</u> Other: <u>N/A</u> Other Actual: <u>N/A</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		Sam Jackson - Flatness and residual checks were done but not noted on the Inspection Report. Job number was listed incorrectly on the Inspection Report.
Correct raw material type and size?	X			Tag(s) to use: <u>ND62566</u> Tag(s) used: <u>ND62566</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			First skid (86645) had several long sheets throughout. Skid was placed in reject to be sorted.
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 7/30/2019 7/30/2020 M50 1" MIC 8/13/2019 8/13/2020 ST-5 STEP GAUGE 7/1/2019 7/1/2020 63294 MEASURING TABLE 4/24/2019 4/24/2020
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	X			
Required PPE being worn?		X		No Safety Glasses - Sam Jackson
Forms are the latest revision per Quality Intranet?	X			List Forms (Observed Rev vs Intranet Rev) FOP081 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

8/16/2019

CUSTOMER

ALTEC

JOB # SMT

759741

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	Order Dim		Tolerances		Tolerances		Low Limit		High Limit
Gauge	0.055	-	-0.001	+	0.015		0.056		0.070
Width	60.000	-	0.000	+	1.000		60.000		61.000
Length	124.000	-	0.000	+	0.125		124.000		124.125

	Set up Target		Side Type		Skid Type Error		Skid Code	
Gauge	0.063				SOP'S			0 3 5
Width	60.500							
Length	124.063							
			JDOP008		JDOP016		JDOP046	
			JDOP014		JDOP034		JDOP032	

Finished Goods Tag	86638		86641		538402				
Master Coil Number	ND62566								
Heat									
Enhanced Weight									
Gross Weight	5115		5115		3700				
Tare	190		190		190				
Net Weight	4925		4925		3510		0		0
Bundle Status									
Good Pcs.	41		41		29				
Scraped Pcs.									
Rockwell									
Gauge Head	E 0.057								
	C 0.057								
	E 0.057								
Body	E 0.057		0.057		0.056				
	C 0.057		0.057		0.057				
	E 0.057		0.057		0.056				
Tail	E 0.057								
	C 0.057								
	E 0.057								
Surface									
Width Head	60.206								
Body	60.206		60.195		60.212				
Tail	60.206								
Shape									
Residual Check									
Length Head	124.060								
Body	124.060		124.060		124.060				
Tail	124.060								
Squareness									
Camber									
Operator									
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: 74971 Coil Number: ND62566

Customer Number: ALTEC Coil Information: NUDSJ3687 Supplier: NUCORDECATUR

Product: Steel Aug-16-19 7:58 to 10:13 (clock 134.9 min/ run 41.5 min) Shift: 1

Average Thickness and Tolerance Data

Target	62.0 mil	Average^	57.7 mil	Average - Target	-4.3100 mil (-6.95%)
				Standard Deviation^	0.2400 mil (0.39%)
Length	4118 ft	Above High Limit	69.0 mil	0 ft (0.0%)	
Width	60.000 in	In Tolerance		4118 ft (100.0%)	
Weight	48576 lbs	Below Low Limit	55.0 mil	0 ft (0.0%)	
Max Thickness	59.0 mil at	3863 ft	Min Thickness	56.4 mil at	4026 ft

Statistical Process Control Data

Upper Control Limit	58.4 mil	Upper Tolerance Limit	69.0 mil
X Double Bar	57.7 mil	R Bar	0.7 mil
Lower Control Limit	57.0 mil	Lower Tolerance Limit	55.0 mil
CR	10.3% (Capability Ratio %, 100/CP)		
CP	9.722 (Process Capability, HiLim-LoLim/6*Sigma)		
CPK	3.736 (Capability vs Limits)	TMW Ratio	0.953 (Low Limit/Avg)

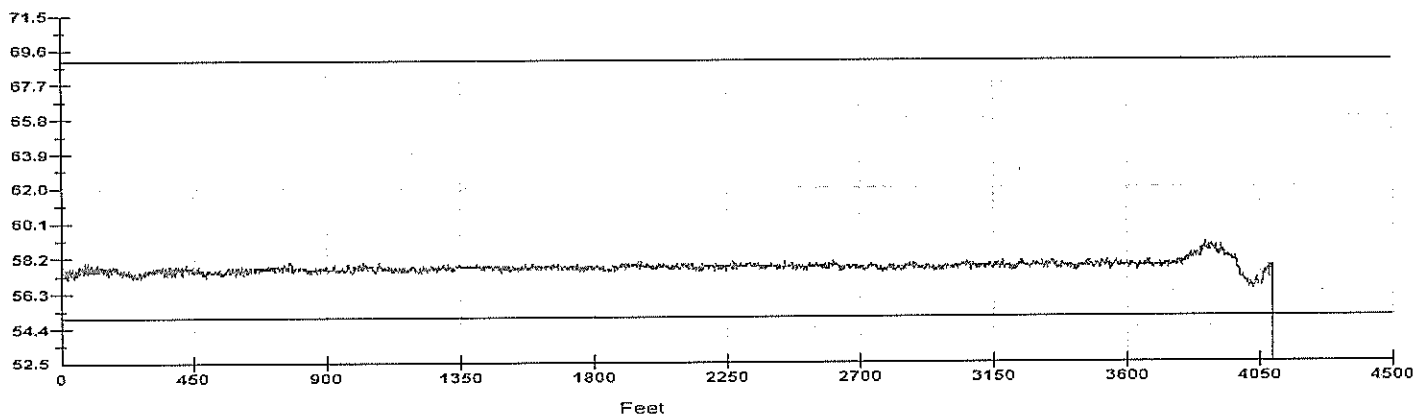
Thickness Distribution Relative to the Target

+++	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%
+ 3.0	0.0%
+ 2.0	0.0%
+ 1.0	0.0%
+ 0.0	0.0%
--1.0	0.0%
--2.0	0.0%
--3.0	0.0%
--4.0	5.4% *****
--5.0	93.1% *****>
--6.0	1.5% ***
--7.0	0.0%
--8.0	0.0%
--9.0	0.0%
-10.0	0.0%
----	0.0%

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

0.0% is within ± 2.0000 mil of the target 98.5% 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 ND62566)



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