

Process Audit Summary:

8/18/15 Sumter RedBud Job# 57801

Performed by: Beverly Clem

Leveling job to produce 26.8750" X 112.0000" length sheets for Specialty Manufacturing from master tag NB47616.

All procedural coil identification checks followed.

Nine skids produced at 26.8750"x 112.0000" sheets. All skids produced within max lifts and packaged and identified correctly per W/O instructions.

All procedural dimensional checks (Gauge-width-length-square) were done in excess of required intervals. All measurements fell within customer tolerances. Shape checks done in excess of required interval based on flatness requirements, all checks within tolerance.

No follow up required.

Part Spec/PO Audit Form

Cust #	2073	Customer	SPECIALTY MANUF	Grp/Sz/Grd/Width	GNS/0.0635/CB60ND/26.8750
Equip/Plant	SRB	Work Order #	57801	Part No.	10017
Work Order Information					
		Tag #1	Material to be Used	Gauge #1	Actual
		PO#	NB47616 017089-001	% Gauge In Spec	.059/.059/.059
Gauge Range	0.0575 - 0.0695	Gauge Min	0.0575	Low/High Gauge	100%
Width Range	26.845 - 26.905	Width	54.5000	Average	0.0579/0.0606
Length Range	112 - 112.1250			Width	0.0599
Rockwell	N/A	Rockwell	N/A	Length	26.3750
Tensile	N/A			Rockwell	112.0600
Yield	N/A			W-B-F	N/A
% Elongation	N/A			SQ	< .12
Chem Rqmts	N/A				< .12
Other Rqmts	N/A			Other	
W-B-F	0.00 - .12				
SQ	0.00 - .12				
Summary					
Actions					
Final Status					

AGT400 Coil Summary Report

JEMISON METALS -

Job Number: 57801 Coil Number: NB47616

Customer Number: SPECIALTY Coil Information: NUB1508909 Supplier: NUCOR BEREKLEY

Product: Galvanize G60 Aug-18-15 21:36 to 22:56 (clock 80.2 min/ run 18.4 min) Shift: 2

Average Thickness and Tolerance Data

Target	Average^	Average - Target	-0.0036 in (-5.6%)
		Standard Deviation^	0.0005 in (0.49%)
Length	2074 ft	Above High Limit	0.0695 in 0 ft (0.0%)
Width	54.500 in	In Tolerance	
Weight	23081 lbs	Below Low Limit	0.0575 in 0 ft (0.0%)
Max Thickness	0.0606 in at 59 ft	Min Thickness	0.0579 in at 2 ft

Statistical Process Control Data

Upper Control Limit	0.0608 in	Upper Tolerance Limit	0.0695 in
X Double Bar	0.0594 in	R Bar	0.0009 in
Lower Control Limit	0.0590 in	Lower Tolerance Limit	0.0575 in
CR	15.5% (Capability Ratio %, 100/CP)		
CP	6.452 (Process Capability, HiLim-LowLim/6*Sigma)		
CPK	2.591 (Capability vs Limits)	TMW Ratio	0.960 (Low Limit/Avg)

Thickness Distribution Relative to the Target

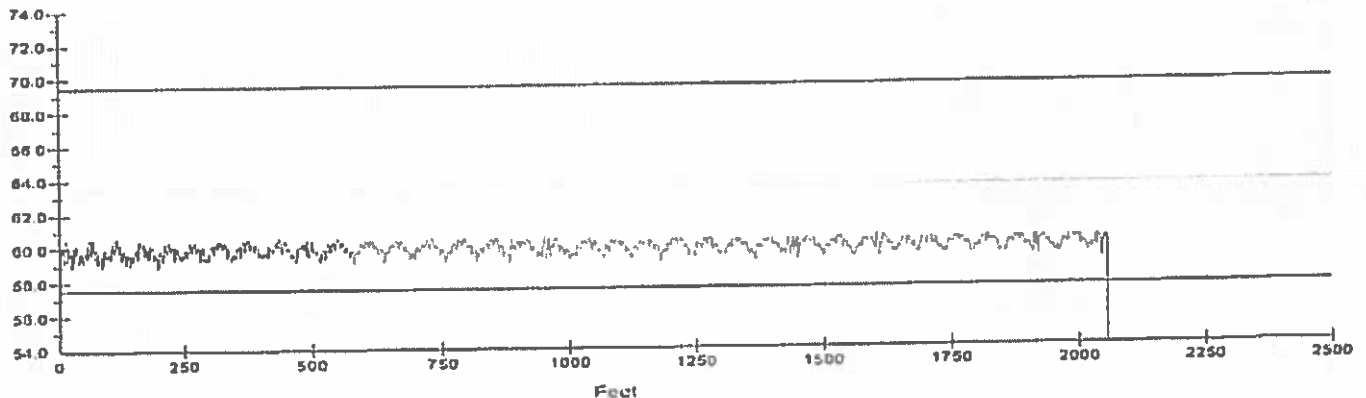
+++	0.0%
+0.0100	0.0%
+0.0090	0.0%
+0.0080	0.0%
+0.0070	0.0%

-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	%
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0.0% 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 NB47616)



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



Material Inspection Report

LOCATION

Sumter

DATE

8/19/2015

CUSTOMER

SPECIALTY

JOB # SMT

57801

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	Order Dim	Tolerances	Tolerances	Low Limit	High Limit
Gauge	0.058	0.000	0.012	0.058	0.070
Width	26.875	0.030	0.031	26.845	26.905
Length	112.000	0.000	0.125	112.000	112.125

	Set up Target	Side Type	Skid Type	Slid Code
Gauge	0.064			
Width	26.875			
Length	112.063			

Finished Goods Tag	924591	924592	924593	924594	924595
Master Coil Number	NB47616				
Heat					
Enhanced Weight					
Gross Weight	2630	2630	2630	2630	2630
Tare	105	105	105	105	105
Net Weight	2525	2525	2525	2525	2525
Bundle Status					
Good Pcs.	50	50	50	50	50
Scraped Pcs.					
Rockwell					
Gauge Head	E 0.059	0.060	0.060	0.059	0.060
	C 0.059	0.059	0.060	0.060	0.060
	E 0.059	0.059	0.060	0.060	0.060
Body	E				
	C				
	E				
Tail	E				
	C				
	E				
Surface					
Width Head	26.875	26.879	26.874	26.874	26.880
Body	26.875	26.879	26.874	26.874	26.880
Tail	26.875	26.879	26.874	26.874	26.880
Shape	0.060	0.090			
Residual Check					
Length Head	112.060	112.060	112.060	112.060	112.060
Body	112.060	112.060	112.060	112.060	112.060
Tail	112.060	112.060	112.060	112.060	112.060
Squareness	.070	.089			
Camber					
Operator	LM	LM	LM	LM	LM
Setup Approval					
Run Time	S	F	Down Time	S	F
Total Run Time	0:00	Gost	\$0.00	Cst/Hour	\$400.00
Comments					