

Process/Product Audit Checklist

Cust #: <u>3357</u> Customer: <u>Eaton-Fay</u> GRP/Size/GRD/Width: <u>CR3.0570CSB 27.8900</u>				
PWC: <u>SRB</u> W/O#: <u>66748</u> Date: <u>8-22-17</u> Part #(s): <u>6271A08H52</u> Auditor: <u>B. Clem</u>				
Gauge Range: <u>.0530 - .0610</u> Actual Gauge: <u>.055</u> Width Range: <u>27.875 - 27.905</u> Width Actual: <u>27.894</u>				
Length Range: <u>26.755 - 26.785</u> Length Actual: <u>26.764</u> W-B-F Other: <u>0-.12</u> Other Actual: <u>.030</u>				
Other: <u>SO 0-.06</u> Other Actual: <u>-.019</u> Other: <u>970 lbs.</u> Other Actual: <u>970 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?		✓		<u>Quan - Details on back</u>
Correct raw material type and size?	✓			Tag(s) to use: <u>NB55758</u> Tag(s) used: <u>NB55758</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: _____] (Leave blank if non-Fab audit)
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) <u>8-3 25' Tape 7-31-17 7-31-18</u> <u>m-44 1" Mic 6-27-17 6-27-18</u> <u>5T-5 Step Gauge 7-5-17 7-5-18</u> <u>63294 meas. Table 4-19-17 4-19-18</u>
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	✓			
Required PPE being worn?		✓		<u>Safety Glasses - Details on back</u>
Forms are the latest revision per Quality Intranet?	✓			List Forms (Observed Rev vs Intranet Rev) <u>SMT-SRB-001 11-8-16 5</u> <u>Jm-op-001 4-21-15 0</u> <u>F08081 2-16-01 1</u>
Hardcopy Controlled Documents are listed on Quality Intranet by location?			✓	List Documents and their Location:

Chris m. wearing safety glasses on top of his head.

Job required 3 checks on skid. (Beginning, middle and end). Middle check was not done. The missed check was brought to the operators attention.

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 66748 Coil Number: NB55758

Parent Number: EATON FAY Coil Information: NUB2710761 Supplier: NUCOR BERKLEY

Product: Steel Aug-22-17 14:58 to 15:44 (clock 45.4 min/ run 8.3 min) Shift: 2

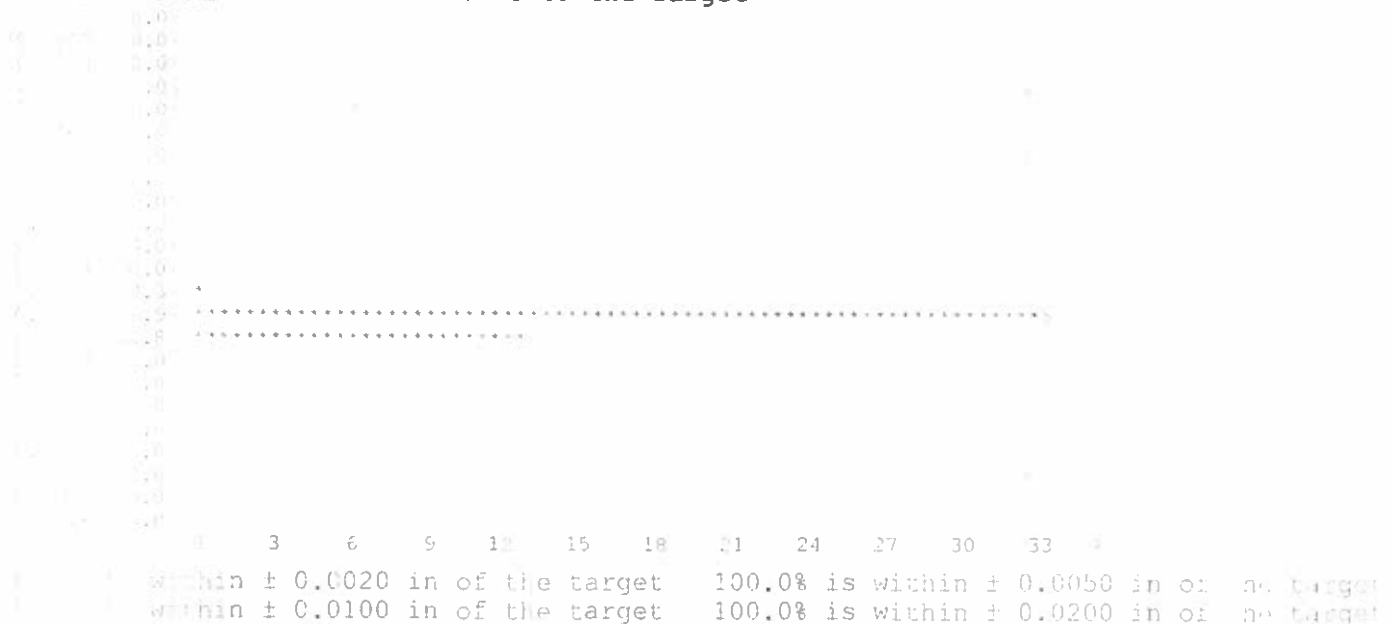
Average Thickness and Tolerance Data

at 0.0570 in	Average^ 0.0553 in	Average - Target	-0.0017 in	(-1.04%)
		Standard Deviation^	0.0003 in	(0.49%)
286 ft		Above High Limit	0.0610 in	0 ft (0.0%)
5.760 in		In Tolerance		286 ft (100.0%)
3002 lbs		Below Low Limit	0.0530 in	0 ft (0.0%)
Thickness 0.0560 in at	29 ft	Min Thickness	0.0543 in at	18 ft

Statistical Process Control Data

Upper Control Limit	0.0561 in	Upper Tolerance Limit	0.0610 in
R Bar	0.0553 in	R Bar	0.0008 in
Lower Control Limit	0.0544 in	Lower Tolerance Limit	0.0530 in
(Capability Ratio = 100/CP)			
(Process Capability, HiLim-LoLim/6*Sigma)			
1.302	(Capability vs Limits)	TMW Ratio	0.959 (Low Limit Avg)

Thickness Distribution Relative to the Target



Thickness vs Length (Coil Number NB55758)

