

Process/Product Audit Checklist

Cust #: <u>2678</u> Customer: <u>Advanced metal</u>		GRP/Size/GRD/Width: <u>GVS.1040CB60N048</u>		
PWC: <u>SRB</u> W/O#: <u>67015</u> Date: <u>8-30-17</u>		Part #(s): <u>370010848074</u> Auditor: <u>B. Clem</u>		
Gauge Range: <u>.0960 - .1120</u>	Actual Gauge: <u>.099</u>	Width Range: <u>48-48.1875</u>	Width Actual: <u>48.078</u>	
Length Range: <u>74-74.2500</u>	Length Actual: <u>74.125</u>	Other: <u>Flatn</u>	Other Actual: <u>.050</u>	
Other: <u>37 pcs / Tag</u>		Other Actual: <u>37 pcs / Tag</u> Other: <u>3876 lbs.</u> Other Actual: <u>37.70 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>Leguwon</u>
Correct raw material type and size?	✓			Tag(s) to use: <u>NB55825</u> Tag(s) used: <u>NB55825</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>ST-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?	✓			
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>FOP081 2-16-01 1</u>
Hardcopy Controlled Documents are listed on Quality Intranet by location?			✓	List Documents and their Location:

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 67015 Coil Number: NB55825

Customer Number: ADVANCED METAL Coil Information: NUB2710983 Supplier: NUCOR BERKELEY

Product: Steel Aug-30-17 19:28 to 19:50 (clock 21.7 min/ run 8.6 min) Shift: 2

Average Thickness and Tolerance Data

Thickness 0.1040 in Average 0.0978 in Average - Target -0.0062 in (-6.93%)
Standard Deviation 0.0005 in (0.52%)
Length 447 ft Above High Limit 0.1120 in 0 ft (0.0%)
Weight 48,000 in In Tolerance 446 ft (99.8%)
Weight 7147 lbs Below Low Limit 0.0960 in 3 ft (0.2%)
Min Thickness 0.0992 in at 19 ft Min Thickness 0.0959 in at 60 ft

Statistical Process Control Data

Control Limit 0.0995 in Upper Tolerance Limit 0.1120 in
R Bar 0.0978 in R Bar 0.0016 in
Control Limit 0.0962 in Lower Tolerance Limit 0.0960 in
1.33 (Capability Ratio, 100/CP)
0.936 (Process Capability, HiLim-LoLim/6*Sigma)
1.10 (Capability vs Limits) TMW Ratio 0.981 (Low Limit/Avg)

Thickness Distribution Relative to the Target



within ± 0.0020 in of the target 0.7% is within ± 0.0050 in of the target
within ± 0.0100 in of the target 100.0% is within ± 0.0200 in of the target

Thickness vs Length (Coil Number NB55825)

