

Process/Product Audit Checklist

Cust #: <u>20173</u> Customer: <u>SPC/14 MON</u> GRP/Size/GRD/Width: <u>GVC/22/1036001/1062</u>				
PWC <u>SLT</u> W/O#: <u>67012</u> Date: <u>8-31-17</u> Part #(s): <u>010472</u> Auditor: <u>Petrick Macis</u>				
Gauge Range: <u>0.0296 - 0.0376</u> Actual Gauge: _____		Width Range: <u>9.057 - 9.067</u> Width Actual: _____		
Length Range: <u>NA</u> Length Actual: <u>NA</u>		Other: <u>201-12</u> Other Actual: _____		
Other: <u>NA</u> Other Actual: <u>NA</u>		Other: <u>NA</u> Other Actual: <u>NA</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			<u>FOR 015</u>
Correct raw material type and size?	X			Tag(s) to use: <u>NB54929</u> Tag(s) used: <u>NB54929</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			
All Gages Calibrated (List in Comments)				Gages Observed (list last calibration and when due) <u>M55-C91 Due 12-1-2018</u> <u>D5-C91 Due 6-6-2018</u> <u>Gamma 921003 - Cal Due 10-31-17</u>
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) <u>FOR 015 Rev 12-16-01</u>
Hardcopy Controlled Documents are listed on Quality Intranet by location?				List Documents and their Location: <u>SMT-SL-001 Rev-1</u> <u>server</u> <u>FOR 015 Rev-1</u> <u>server</u>

AGT400 Coil Summary Report

Jemison Metals -- 60 Inch Pro-Eco Slitter

Work Order: 67012 Coil Number: NB54929

Customer Name: SPCLTY Heat Number: NUB1706360 Vendor: ZZZZZZZZ

Product: G60 Galvanized Aug-31-17 13:51 to 14:19 (clock 28.2 min/ run 14.8 min) Shift: 1

Average Thickness and Tolerance Data

Target 0.0336 in Average^ 0.0308 in Average - Target -0.0028 in (-8.33%)
Standard Deviation^ 0.0003 in (0.80%)

Length 2296 ft Above High Limit 0.0376 in 0 ft (0.0%)
Width 48.500 in In Tolerance 2296 ft (100.0%)
Weight 11688 lbs Below Low Limit 0.0296 in 0 ft (0.0%)

Max Thickness 0.0321 in at 7 ft Min Thickness 0.0300 in at 212 ft
Head Scrap 0 ft Tail Scrap 0 ft

Statistical Process Control Data

Upper Control Limit 0.0316 in Upper Tolerance Limit 0.0376 in
X Double Bar 0.0308 in R Bar 0.0008 in
Lower Control Limit 0.0300 in Lower Tolerance Limit 0.0296 in

CR 20.3% (Capability Ratio %, 100/CP)

CP 4.938 (Process Capability, HiLim-LoLim/6*Sigma)

CPK 1.482 (Capability vs Limits) TMW Ratio 0.961 (Low Limit/Avg)

Thickness Distribution Relative to the Target

+++ 0.0%
+0.0050 0.0%
+0.0045 0.0%
+0.0040 0.0%
+0.0035 0.0%
+0.0030 0.0%
+0.0025 0.0%
+0.0020 0.0%
+0.0015 0.0%
+0.0010 0.0%
+0.0005 0.0%
+0.0000 0.0%
-0.0005 0.0%
-0.0010 0.0%
-0.0015 0.2%
-0.0020 1.6% ***
-0.0025 12.9% *****
-0.0030 69.9% *****>
-0.0035 15.1% *****
-0.0040 0.3% *
-0.0045 0.0%
-0.0050 0.0%
--- 0.0%

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

0.0% is within ± 0.0010 in of the target 14.6% is within ± 0.0025 in of the target
100.0% is within ± 0.0050 in of the target 100.0% is within ± 0.0100 in of the target

Thickness vs Length (Coil Number NB54929)

