

Process/Product Audit Checklist

Cust #: 1795 Customer: BSH HOME GRP/Size/GRD/Width: A25 .0276 CSB125 24.9800

PWC: SRB W/O#: 62645 Date: 9-14-16 Part #(s): 9000883708

.0236 - .0276 Gauge Range: .025 Actual Gauge: 24.949 - 25.011 Width Range: 24.981 Width Actual: 24.981

20.319 - 20.381 Length Range: 20.343 Length Actual: FLAT Other: 0 - .12 Other Actual: .060

Other: 735 pcs./T⁹⁵ Other Actual: 660 pcs/T⁹⁵ Other: 2925 lbs Other Actual: 2235 lbs

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>Taguion + Chris</u>
Correct raw material type and size?	✓			Tag(s) to use: <u>NI51203</u> Tag(s) used: <u>NI51203</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: _____]
Packaging is acceptable according to customer-specific requirements?	✓			<u>All machine would allow</u> <u>SLid would only hold 660 pcs.</u>
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) 8-3 25' Tape 7-21-16 7-21-17 m-44 1" mic 6-28-16 6-28-17 ST-5 Step Gauge 7-5-16 7-5-17 63294 Meas. Table 4-26-16 4-26-17
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) SMT-SRB-001 3-7-13 4 JM-OP-001 4-21-15 0 FOP081 2-16-01 1
Hardcopy Controlled Documents are listed on Quality Intranet by location?			✓	List Documents and their Location:

AGT400 Coil Summary Report

JEMISON METALS --

Job Number: 62645 Coil Number: NI51203

Customer Number: BSH Coil Information: M F22554 Supplier: METAL ONE WN

Product: Steel Sep-14-16 18:01 to 21:13 (clock 191.9 min/ run 109.4 min) Shift: 2

Average Thickness and Tolerance Data

Target	0.0236 in	Average^	0.0230 in	Average - Target	-0.0007 in
				Standard Deviation^	0.0002 in
Length	6275 ft	Above High Limit	0.0276 in	0 ft (0.0%)	
Width	50.460 in	In Tolerance			
Weight	24764 lbs	Below Low Limit	0.0236 in	6275 ft (99.8%)	
Max Thickness	0.0235 in at 1031 ft	Min Thickness	0.0222 in at 6 ft		

Statistical Process Control Data

Upper Control Limit	0.0236 in	Upper Tolerance Limit	0.0276 in
X Double Bar	0.0230 in	R Bar	0.0007 in
Lower Control Limit	0.0223 in	Lower Tolerance Limit	0.0236 in
CR	34.5% (Capability Ratio %, 100/CP)		
CP	2.899 (Process Capability, HiLim-LoLim/6*Sigma)		
CPK	-0.942 (Capability vs Limits)	TMW Ratio	1.028 (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	0.0%
-0.0020	0.0%
-0.0025	37.9%
-0.0030	56.2%
-0.0035	5.7%
-0.0040	0.0%
-0.0045	0.0%
-0.0050	0.0%
---	0.0%

0.0% is within ± 0.0010 in of the target 38.1% 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 NI51203)

