

Process/Product Audit Checklist

Cust #: <u>2719</u> Customer: <u>ALTEC</u> GRP/Size/GRD/Width: <u>GNS/.0396/CB40NO/60</u>				
PWC: <u>SRB</u> W/O#: <u>75334</u> Date: <u>9/16/2019</u> Part #(s): <u>970082657</u> Auditor: <u>B. CLEM</u>				
Gauge Range: <u>.0336-.0436</u> Actual Gauge: <u>.035</u> Width Range: <u>60-60.9999</u> Width Actual: <u>60.001</u>				
Length Range: <u>105-105.125</u> Length Actual: <u>105.060</u> FLATN Other: <u>0-.12</u> Other Actual: <u>LESS .12</u>				
PC/TAG Other: <u>77 PCS</u> Other Actual: <u>77 PCS</u> Other: <u>N/A</u> Other Actual: <u>N/A</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			Chris D.
Correct raw material type and size?	X			Tag(s) to use: <u>NB62843</u> Tag(s) used: <u>NB62843</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)	X			Gages Observed (list last calibration and when due) 8-3 25' TAPE 7/30/2019 7/30/2020 M50 1" MIC 8/13/2019 8/13/2020 ST-5 STEP GAUGE 7/1/2019 7/1/2020 63294 MEASURING TABLE 4/24/2019 4/24/2020
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	X			
Required PPE being worn?		X		NO SAFETY GLASSES - Marion
Forms are the latest revision per Quality Intranet?	X			List Forms (Observed Rev vs Intranet Rev) FOP081 2/16/01 1
Hardcopy Controlled Documents are listed on Quality Intranet by location?	X			List Documents and their Location: SMT-SRB-001 11/8/16 5 SMT-SH-001 10/26/11 0 JM-OP-001 4/21/15 0

AGT400 Coil Summary Report

JEMISON METALS ---

Job Number: 75334 Coil Number: NB62843

Customer Number: ALTEC Coil Information: NUB1909772 Supplier: NUCOR BERKLEY

Product: Steel Sep-16-19 16:38 to 18:13 (clock 94.8 min/ run 35.6 min) Shift: 2

Average Thickness and Tolerance Data

Target	38.6 mil	Average^	35.0 mil	Average - Target	-3.6200 mil (-9.38%)
				Standard Deviation^	0.1300 mil (0.34%)
Length	3412 ft	Above High Limit	43.6 mil	0 ft (0.0%)	
Width	60.000 in	In Tolerance		3412 ft (100.0%)	
Weight	24402 lbs	Below Low Limit	33.6 mil	0 ft (0.0%)	
Max Thickness	35.5 mil at 3015 ft	Min Thickness	34.5 mil at 107 ft		

Statistical Process Control Data

Upper Control Limit	35.4 mil	Upper Tolerance Limit	43.6 mil
X Double Bar	35.0 mil	R Bar	0.4 mil
Lower Control Limit	34.6 mil	Lower Tolerance Limit	33.6 mil

CR 7.8% (Capability Ratio %, 100/CP)

CP 12.821 (Process Capability, HiLim-LoLim/6*Sigma)

CPK 3.539 (Capability vs Limits) TMW Ratio 0.961 (Low Limit/Avg)

Thickness Distribution Relative to the Target

+++	0.0%
+ 5.0	0.0%
+ 4.5	0.0%
+ 4.0	0.0%
+ 3.5	0.0%
+ 3.0	0.0%
+ 2.5	0.0%
+ 2.0	0.0%
+ 1.5	0.0%
+ 1.0	0.0%
+ 0.5	0.0%
+ 0.0	0.0%
--0.5	0.0%
--1.0	0.0%
--1.5	0.0%
--2.0	0.0%
--2.5	0.0%
--3.0	0.0%
--3.5	26.5% *****
--4.0	73.4% *****>
--4.5	0.1%
--5.0	0.0%
---	0.0%

0.0% is within ± 1.0000 mil of the target 0.0% is within ± 2.5000 mil of the target
100.0% is within ± 5.0000 mil of the target 100.0% is within ± 10.0000 mil of the target

Thickness vs Length (Coil Number NB62843)

