

Process/Product Audit Checklist

Cust #: <u>3428</u> Customer: <u>PSG Custom Fab</u> GRP/Size/GRD/Width: <u>GNS. 0516C840CD50</u>				
PWC: <u>SRB</u> W/O#: <u>71476</u> Date: <u>9-25-18</u> Part #(s): <u>188A X 50 X 106.125</u> Auditor: <u>B. Clem</u>				
Gauge Range: <u>.0436 - .0596</u>		Actual Gauge: <u>50 - 50.2500</u>		Width Actual: <u>106.125</u>
Length Range: <u>106 - 106.25</u>		Length Actual: <u>106.125</u>		Other Actual: <u>108.375</u>
Other: <u>108.875 - 89.125</u>		Other Actual: <u>W.O.F. 8-25/50-12</u>		Other Actual: <u>50.2500</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>Chris m. (Details on Back)</u>
Correct raw material type and size?	☒	☐	☐	Tag(s) to use: <u>AB59828</u> Tag(s) used: <u>AB59828</u>
Setup performed according to W/O?	☒	☐	☐	
Product is acceptable according to customer-specific requirements? (<u>Fab</u> : Is the Part Print Present & the correct Revision? Are required measurements documented?)	☒	☐	☐	(<u>Fab</u> : 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>9-3 25' Tape 3-30-18 3-30-19</u> <u>m-501" mic 8-31-18 8-31-19</u> <u>5T-5 Step Gauge 7-5-18 7-5-19</u> <u>63294 meas-Table 4-20-18 4-20-19</u>
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	☒	☐	☐	
Required PPE being worn?	☐	☒	☐	<u>Packer - No Safety Glasses</u>
Forms are the latest revision per Quality Intranet?	☒	☐	☐	List Forms (Observed Rev vs Intranet Rev) <u>FOP081 2-16-01 1</u>
Hardcopy Controlled Documents are listed on Quality Intranet by location?	☐	☐	☐	List Documents and their Location: <u>SMT-SRB-001</u> <u>JM-OP-001</u>

There was no length check done until 14 sheets into the first skid. A square check was not done until the end of the first skid. There was only a flatness check done on the last skid of the job. Last skid Tag # 527810, 50 x 89, was not noted on the FOP081.

527810 - Last Skid
Only Flat Check done



Material Inspection Report

LOCATION

Sumter

DATE

9/25/2018

CUSTOMER

PSG CUSTOM

JOB # SMT

71476

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	Order Dim	Tolerances	Tolerances	Low Limit	High Limit
Gauge	0.043	- 0.000	+ 0.016	0.043	0.059
Width	50.000	- 0.000	+ 0.250	50.000	50.250
Length	106.125	- 0.125	+ 0.125	106.000	106.250

	Set up Target	Side Type	Skid Type Error	Skid Code
Gauge	0.051		SOPS	0 3 4
Width	50.125	JJOP008	JJOP016	JJOP046
Length	106.125	JJOP014	JJOP034	JJOP032

Finished Goods Tag	51333						
Master Coil Number	NB59829						
Heat							
Enhanced Weight							
Gross Weight	4280						
Tare	140						
Net Weight	4140	0	0	0	0		
Bundle Status							
Good Pcs.							
Scraped Pcs.							
Rockwell							
Gauge Head	E 0.045						
	C 0.045						
	E 0.045						
Body	E						
	C						
	E						
Tail	E						
	C						
	E						
Surface	0						
Width Head	50.129						
Body	50.129						
Tail	50.129						
Shape	0.000						
Residual Check							
Length Head	106.125						
Body	10.000	I					
Tail							
Squareness							
Camber							
Operator							
Setup Approval							
Run Time	S	F		Down Time	S	F	
Total Run Time	0:00		Cost	\$0.00	Cst/Hour	\$400.00	
Comments							



Material Inspection Report

LOCATION

Sumter

DATE

9/25/2018

CUSTOMER 0

PSG CUSTOM

JOB # SMT

71476

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	Order Dim	Tolerances	Tolerances	Low Limit	High Limit
Gauge	0.043	0.000	0.016	0.043	0.059
Width	50.000	0.000	0.250	50.000	50.250
Length	102.250	0.125	0.125	102.125	102.375

	Set up Target	Side Type	Skid Type Error	Skid Code
Gauge	0.051			0 3 4
Width	50.125			
Length	102.250			

Finished Goods Tag	51332						
Master Coil Number	NB59828					0	
Heat							
Enhanced Weight							
Gross Weight	4320						
Tare	160						
Net Weight	4160	0	0	0	0		
Bundle Status							
Good Pcs.	65						
Scraped Pcs.							
Rockwell							
Gauge Head	E	0.045					
	C	0.046					
	E	0.045					
Body	E						
	C						
	E						
Tail	E						
	C						
	E						
Surface	0						
Width Head	50.105						
Body	50.105						
Tail	50.105						
Shape	0.000						
Residual Check							
Length Head	102.250						
Body	102.250						
Tail	102.250						
Squareness	.00						
Camber							
Operator	CM						
Setup Approval							
Run Time	S 12:00 AM	F 12:00 AM	Down Time	S 12:00 AM	F 12:00 AM		
Total Run Time	0:00						
Comments							

JEMISON METALS --

Customer Number: USCHEMICAL Coil Information: NUB2811789 Supplier: NUCOR BERKL