

Process/Product Audit Checklist

Cust #: <u>2888</u> Customer: <u>CUPPLES</u> GRP/Size/GRD/Width: <u>POS/0.1703/A57250/60</u>				
PWC: <u>BB1</u> W/O#: <u>45819</u> Date: <u>9/30/2025</u> CS HRSLPO CT 7GAX60 A57250 SBD Part #(s): _____ Auditor: <u>B. CLEM</u>				
Gauge Range: <u>0.171 - 0.187</u> Actual Gauge: <u>0.180</u> Width Range: <u>60 - 60.9999</u> Width Actual: <u>60.625</u>				
Length Range: <u>120 - 120.5</u> Length Actual: <u>120.125</u> FLAT/BOW Other: <u>0 - 0.19</u> Other Actual: <u>LESS 0.187</u>				
PCS/TAG Other: <u>12 PCS</u> Other Actual: <u>12 PCS</u> WT/SKID Other: <u>< 5000 LBS</u> Other Actual: <u>4512 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?	X			NATE
Correct raw material type and size?	X			Tag(s) to use: <u>31897</u> Tag(s) used: <u>31897</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) 017 - 1" MIC 5/13/2025 5/13/2026 63332 - FLATNESS TABLE 2/16/2024 2/15/2026 ST 10 - STEP GAGE 0.75 9/30/2025 9/30/2026
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) DEC-CTL-001A CTL 4/1/2024 4 DEC-CTL-001B CTL 6/23/2022 2
Hardcopy Controlled Documents are listed on Quality Intranet by location?	X			List Documents and their Location: DEC-BB1-CTL DCT

PRODUCTION REPORT

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 PAGE OF

JOB WORK ORDER NO.	DATE	MACHINE	SHIFT	MASTER COIL NO.	Yield Strength
45819	9/30	BB1	1st	31897	
OPERATOR	RUN HOURS	Burr Msmt(s)	Head Scrap	Tail Scrap	
MAH	8:30-9:35		20	18	
GA MIN 179 MAX WAVE 187 GA MAX 171 MAX BOW 187 MAX SQUARE KEYED BY CKD. BY					

Minimum Inspection Frequency:
 (Unless otherwise specified on the Work Order/Part Spec)
 CHECK PIECE ONCE LINE RUN IS ESTABLISHED + PIECE AT MIDPOINT
 OF RUN + LAST PIECE OF RUN

FINISHED GOODS TAG NO.	PCS Required	PCS Actual	Width Actual	Length Entered	Length Actual	Gauge Actual	Wave/Bow Actual	Square Actual	Weight	Comments
3897-A	12	12	60.625	120.562	120.125	.180	ALL	.187	4572	
B	12	12					ALL			
C	12	12					ALL			
D	12	12					ALL			
E	12	12					ALL			
F	12	12	60.625		120.125	.181	ALL	.125		
G	12	12					ALL			
H	12	12					ALL			
I	12	12					ALL			
J	12	12					ALL			
K	6	2	60.625		120.125	.182	ALL	.250	740	Scrap top 250005

Warehouse	(DCT) Decatur	Operator		Job Work Order		
W/hs Zone						
PWC	(BB1) Butech Stretch			Job 45819		
Process	(CTL) Cut to Length			Date 9/29 03:30 AM		

Gauge 0.171" - 0.187" (dimensions in inches, if not specified) **JOB RESERVATIONS**

Dimension	Pcs	LBS	PIW	ID	OD	CLgth	Tag/Lot	Ven	Tag	Heat	Zn	Loc	Date Planned
HRPO Coil, A572 50, -	1	45,620	760			1,266'	31897	5361353.000		✓NUD/NQ4983	-	E24	

Consumption 1 Coils Theo Scrap -3.35% (-1,529.97 LBS) **CUTTING INSTRUCTIONS**

Width	Cons LBS	PIW	Produced Sheets (Pcs-Length)
60"	45,620	760	129-120"

Dimension **Pcs** **LBS** **FT Assign To** **Customer/Next Prs** **Due** **PLANNED PRODUCTION**

HRPO Sheet, A572 50, - Part No CS HRSLPO CT 7GAX60 A57250 SBD

60" x 120" 0.179" -N	115	42,032.92	SO-30792-5-1	CUPPLES' J & J(2888)	9/25
60" x 120" 0.179" -N	14	5,117.05	SO-30792-5-1	CUPPLES' J & J(2888)	9/25
Carbon Scrap, , , -	761.67		Scrap		

SO-30792-5-1	Gauge	Width	Length	Diag	Fits
	0.179 [0.171 - 0.187"]	60 [60 - 60.9999"]	120 [120 - 120.5"]		

SO-30792-5-1 Cond Incl Mill Edge

Flat: 0.19
Wave: 0
Bow: 0.19
Square: 0
Camber: 0

PACKAGING

SO-30792-5-1	Customer	Dimension	PCS	LBS	Pc/Pkg	LBS	Hgt	#	Skid/Pkg
	CUPPLES' J & J(2888)	60" x 120"	129	47,149.97	12	<= 5,000	11	R2 - Sheet - 2" x 2"	Runner / RD - Paper Runners

T 240
D 17

Warehouse	(DCT) Decatur	Operator		Job Work Order		
W/hs Zone				Job 45819 Date 9/29 03:30 AM		
PWC	(BB1) Butech Stretch					
Process	(CTL) Cut to Length					

ORDER INFORMATION				
SO-30792	CUPPLES' J & J(2888)/0	 Parker Sigmom/Denise Clayton	Customer PO P26484	Sls Cat Sale
Due 9/25	Item Product/Part/End User Label1	Process Route	PCS	SFT LBS +/- Shp % Cert
	5 A1011 HRP&O SHEET A-572 GRADE 50	{CTL}	115	5,75044,331.98 +10-10 CAA+
	0.179 N x 60 x 120 .1790 Nom X 60.0000" X 120.0000"			
	CS HRSLPO CT 7GAX60 A57250 SBD			

SO-30792	Name	Route/Color	Transp Zn	Divy Mthd	Carrier	DESTINATION
	CUPPLES' J & J CO INC	(RT1) Default Route	A	CC Truck	BEST WAY	