

# Historical Audit

	Date	Shift	BU / Dept	Cell/Operation/Program	P/N Runnings	Audit Standard
Scheduled	09/25/06	1	KJ Shock	Pressing	P52128532AA/533AA	ISO/TS16949
Actual	09/26/06	1	KJ Shock	Pressing	P52128532AA/533AA	

Original Audit (Assigned to) **BRIGITTE WIEHLE**

Date Completed	Auditor	Email Notification	Date Printed	Shift	Conforming	FollowUp Requested
09/26/06	WIEHLE, BRIGITTE	09/22/06 11:10:07 AM	09/26/06 12:44:16 PM	1	YES	NO

Comments

Follow-Up Audit

Date Completed	Auditor	Email Notification	Email Address

FollowUp Comments & Corrective Action

A	Pressing - General Injection Parts	If NonConforming, check "NO" and explain.			
	QUESTION	EVIDENCE REQUIRED	LOOK FOR	NO	COMMENTS & Corrective Action
1	Raw material expiry date.	Per SCHD-023 & SCHD-026 prepped inserts and raw rubber must be used before expiry.	Check that expiry date on all insert and rubber labels is not past due.	<input type="checkbox"/>	
2	Traceability Tag content for bushing container.	Per IDEN-011 - Tag IDEN-003 present on bushing container with required information recorded on top part of tag.	Trace tag Insert Lot# & Rubber Batch-Compound#'s match raw material tag/label. All current shift info. recorded on Trace Tag.	<input type="checkbox"/>	
3	Traceability Tag copies for bushing container.	Per IDEN-011 - Only one full set of 3 copies of Tag IDEN-003 is required for subsequent operations. Exceptions are Customer bins or small totes e.g. Clevis.	Check that there are not 2 sets of tags on bin (unless 1 set has 2 previous shifts recorded). All 3 copies of one set of tags must be on in-house bins in plastic sleeve. Only 1 copy per container needed for exceptions listed in Evidence Required column.	<input type="checkbox"/>	
4	Non-conforming material.	Per INSP-049 - Defects to be placed in red tub.	Pressing DOR for correct part # is present at work station.	<input type="checkbox"/>	
5	Stray parts or components.	Per IDEN-010 - All material to be identified.	Loose parts or components with no tag on floor, machine or non-red tubs.	<input type="checkbox"/>	
6	Correct program loaded in press.	Rep - First 3 digits of Program # in press matches the first 3 digits stamped into the mold. Desma - Program # list is posted at press.	Facilitator (maybe operator) can display the Program # in the press. Check it against mold stamp (Rep) or list (Desma).	<input type="checkbox"/>	
7	Order of tasks.	Per Molding WI's - oper. to be present when press opens and load and close mold before colour coding & deflashing parts.	Observe at least one cycle of the press.	<input type="checkbox"/>	
8	Inspection of parts.	Per Oper. Inspection Instruction - 100% visual inspection is required.	Is each part handled and inspected individually?	<input type="checkbox"/>	

9	Operator Sampling Plan for QA Test Samples.	Per TEST-033 - 15-30 minutes after shift start, operator to retain 3 samples. Then 1 sample needs to be retained every hour after the start of the shift.	<p>Ask operator</p> <p>a) how soon after shift start do the first samples need to be taken?</p> <p>b) how many samples are to be taken initially?</p> <p>c) how often are the rest of the samples to be retained?</p> <p>Answers are in Evidence Required column (to the left).</p>	<input type="checkbox"/>	
10	Traceability tag and samples.	Per TEST-033 - Initial samples to be placed in yellow tub attached to press with short copy of Trace tag IDEN-003 if available. Rate Tech's remove tag with samples first half of shift.	<p>Check yellow tub.</p> <p>If 1st half of shift:</p> <ul style="list-style-type: none"> <li>- no more than 1 tag in tub</li> <li>- if tag is present, there must be at least 3 samples with it</li> <li>- all info. is recorded on short copy of tag</li> </ul> <p>If 2nd half of shift:</p> <ul style="list-style-type: none"> <li>- tag removed by QA (unless part started recently).</li> </ul>	<input type="checkbox"/>	