

GAD Process Audit Summary:

1/22/16 Press Brake Job# 50697

Performed by: B. Smith

Summary:

Press brake Job for Heil; part number 272-9110-001

Procedural first piece inspection and secondary sign off was followed properly.

48 parts produced packaged and tagged correctly in reference to work order.

All post-forming dimensional checks were completed using height gauge (serial #16001038) for two linear dimensions, protractor (#P001) for angular dimensions, and calipers #1202 for one inside channel dimension that was called out on customer supplied print (272-9110-001). All measurements fell within customer tolerances for first piece and secondary inspections.

Part spec Revision level was stated as Original while the Part print was Revision B. Notified inside sales to change to Rev B.

Corrective Action Audit

This part pertains to open/external/customer complaint Case# 10364. The dimension of 3.062" +/- .03 was verified using calipers #1202 and fall within the customer's tolerance per the 272-9110-001 print.

Follow up required: Verify part spec has been changed to correct Rev Level B. –Verified in Stelplan 1.22.16 11:00am (bps).

Measuring tools:

Height gauge (serial #16001038)

Last Calibration: 11.12.15	Due: 11.12.16
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Protractor (serial #P001)

Last Calibration: 11.19.15	Due: 11.19.16
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Caliper (#1202)

Last Calibration: 8.13.15	Due: 8.13.16
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Controlled documents:

GAD020 REV 1

GAD 059 Press Brake From REV 0

Print: 272-9110-001 REV B

Part Spec/PO Audit Form

Cust #	10	Customer	HKLL	Grp/Sz/Grd/Width	HMS / 250 / H580 /
Equip/Plant	P.B. #1 / #1	Work Order #	50697	Part No.	272-910-001
Work Order Information		Material to be Used		Actual	
	Tag #1	Tag #2		Gauge #1	Gauge #2
	PO#	PO#		% Gauge In Spec	% Gauge In Spec
Gauge Range	.235 - .265	Gauge Min	.235	Low/High Gauge	Low/High Gauge
Width Range	32.81 +/- .06	Width	32.79	Average	Average
Length Range	11.34 +/- .06	Rockwell	N/A	Width	Width
Rockwell				Length	Length
Tensile	90000			Rockwell	Rockwell
Yield	80000				
% Elongation	18				
Chem Rqmts					
Other Rqmts				Other	
WAVE	0-.5				
BOW	0-.5				
FLATN	0-.05				
Summary	PART SPEC REV: ORIGINAL / PRINT: 5				
Actions	INITIALS REQUIRED TO FIX TO REV 6.				
Final Status	FIXED @ 11:00AM 1.22.16				

123555-6415
122249-7215

FABRICATION PRODUCTION REPORT

Jemison Metals

[illegible]

TIME: 7:32

STOP TIME: 9:00

DOWNTIME:

8100

9.05

9115

9:25

9:45

1087

9/3/2015

Rev. Level 1

Job Number: 50697

Part number: 272-9110-031

PRESS BRAKE FORM

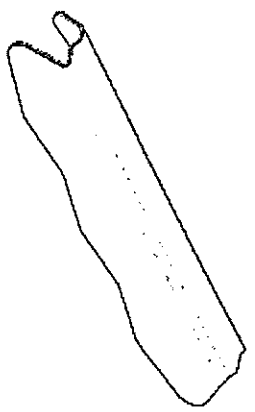
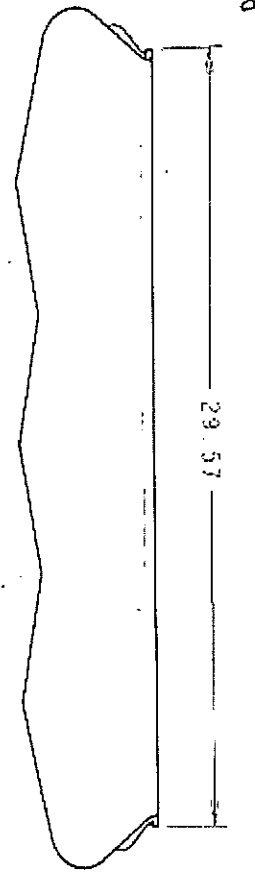
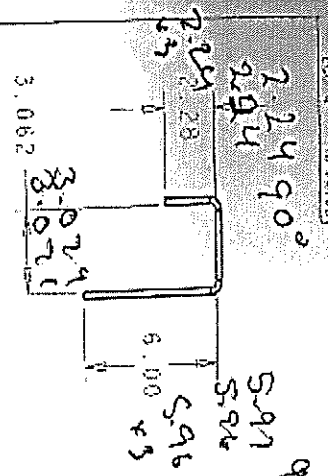
Operator Name: D. Steward

Date: 1-22-15

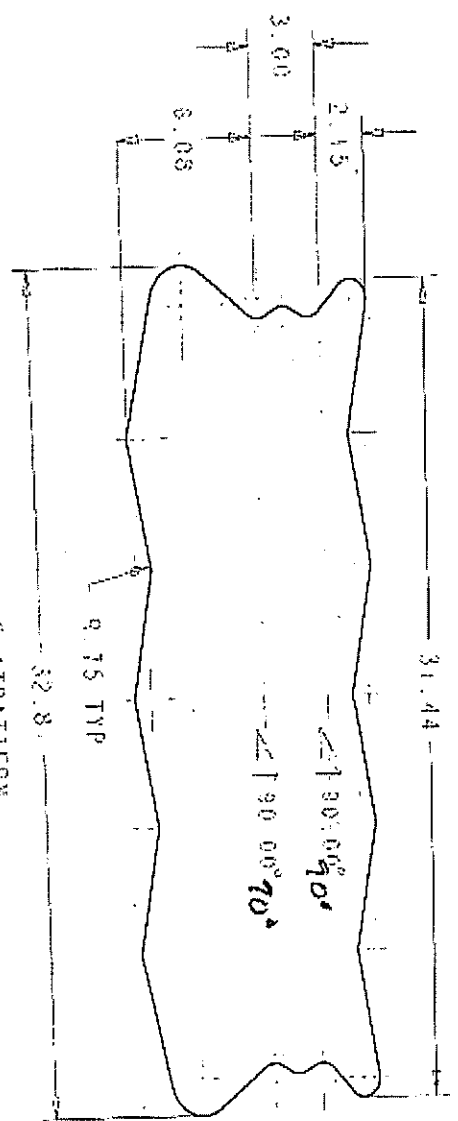
Check all formed deminsions on 1st pc, at 20 pc intervals and on last pc of the job.

Frequency	Pass/Fail
1st pc	/
20th	/
40th	/
60th 4S	-
80th	
100th	
120th	
140th	
160th	
180th	
200th	
220th	
240th	
260th	
280th	
300th	
320th	
340th	
360th	
380th	
400th	
420th	
440th	
460th	
480th	
500th	

DRAWING SIZE	B
REVISION	1
DATE	10/10/03



SCALE 0.125



FLAT PATTERN

ITEM	DESCRIPTION	QUANTITY	UNIT
1	FLAT PATTERN	1	PC
2	FLAT PATTERN	1	PC
3	FLAT PATTERN	1	PC
4	FLAT PATTERN	1	PC
5	FLAT PATTERN	1	PC
6	FLAT PATTERN	1	PC
7	FLAT PATTERN	1	PC
8	FLAT PATTERN	1	PC
9	FLAT PATTERN	1	PC
10	FLAT PATTERN	1	PC

272-9110-001

REXEL
INDUSTRIES, LTD.
A CANADIAN COMPANY

1/2" DIA. H9S
H9S - STSHE - 10

1/2" DIA. H9S
H9S - STSHE - 10

1/2" DIA. H9S
H9S - STSHE - 10