

Subject: Cleveland Process Audit

Date: January 29, 2016

Completed By: Steve Busicnki

On January 29, 2016, work order CLV 58966 was ran on the PWC CLO (Paxson) for Arrow Tru-Line. Tags 68829, 68830 and 68833 were verified prior to loading and use of each coil. The width of each cut was measured when first fed through the arbors with calipers SP1 on coil 68829. The full width of the material was measured with tape measure 8 and the gauge was measured at the crown and both edges with micrometer ASP015. The gauge was measured again at the end of the master coil before the arbors at both edges and the crown using the same micrometer.

For tag 68830, the gauge was measured at the crown and both edges. The width of the full coil was measured before the arbors. The gauge was measured halfway through the coil and again at the end of the coil before the arbors at both edges and the crown.

For tag 68833, the width of each cut was measured at the beginning of the coil. The full width of the master was measured with a tape measure and the gauge was measured at both edges and the crown. The gauge was measured again at the end of the coil before the arbors at both edges and the crown.

The procedural checks were completed per CLV-SL-001 procedure and recorded on forms JDM3 and JDM4. Based on the micrometer readings from the Slit Size Inspection form, 100.0% of the gauge was within the customer range.

Measuring Tools:

Calipers – SP1 last calibration 12/15 calibration due 03/16

Tape – 8 last calibration 09/15 calibration due 09/16

Micrometer – ASP015 last calibration 12/15 calibration due 01/16

Controlled Documents:

CLV-SL-001 rev date 03/07/13

JDM3 rev date 11/30/15

JDM4 rev date 07/21/11

Part Spec/PO Audit Form

Cust #	9509	Customer	Arrow Tru-Line		
Equip/Plant	PWC CLO (Paxson)	Work Order #	CLV 58966	Date	1/29/2016
Work Order Information		Material to be Used			
		Tag #1	68829	Tag #2	68830
		PO#		PO#	
Gauge Range	0.0690 - 0.0750	Gauge Min	.0690 Min	Gauge Min	.0690 Min
Width Range	5.770 - 5.780	Width	48.0000"	Width	48.0000"
Length Range	Coil				
Rockwell		Rockwell		Rockwell	
Tensile					
Yield		Toll Processed		Toll Processed	
% Elongation		GVCSS GR33		GVCSS GR33	
Chem Rqmts		G40		G40	
Other Rqmts		.0690Min X		.0690 Min X	
		48.0000"		48.0000"	
		1pcs 20,520lbs		1pcs 19,910lbs	
Summary					
Actions					
Final Status					

Part Spec/PO Audit Form

Grp/Sz/Grd/Wdth	TGVC / 0.0690 / S33G40 / 5.775		
Part No.	9509 / GV .0690 X 5.775 HDG		
Actual			
Gauge #1	.071 , .073	Gauge #2	
% Gauge In Spec	100%	% Gauge In Spec	
Low/High Gauge	.071 / .073	Low/High Gauge	
Average	0.072	Average	
Width	5.7760	Width	
Length	Coil	Length	
Rockwell		Rockwell	
Other			

Slitting Order

Date:	Customer: ARROW
Work Order #: CLV 58966	Date Run: 1-29-16

Incoming Inspection Checklist

Tag #	Gauge & Width	Type	Tag Wgt.	RB	Olsen	Actual Wgt.	Width	Mic
68829	069 x 48"	G VL	20,520	NA	NA	20,520	48 1/8	.071
68830			19,910	NA	NA	19,910	48 1/8	.071
68833			21,490	NA	NA	21,490	48 1/8	.071

Cutting Instructions: 1cut 6.450 1cut 2.825
 1cut 5.775 1cut 1.180
 3cuts 5.290
 3cuts 5.190

Slit Tolerance: $\pm .005$	Max O.D: STR THRU	Max Skid Wgt: 5000	I.D: 20
Gauge Range: 069-075	Salesman:		

Special Instructions:

1 Cuts with some defect but okay to ship

_____	Cut Size
_____	Cut Weight
_____	Defect
_____	Approved By

NA

2 Cuts Rejected

_____	Cut Size
_____	Cut Weight
_____	Tag No. or No.'s
_____	Reason for Reject

NA

3 Ok to move material for shipment or to Stock

_____	Name
_____	Date

Ant
2/11/16

10F3

Slit Size Inspection

Date: 1-29-16Work Order: CLV 58966

Size of Cuts	Beginning		(Paxson Only)	End	
	Width	Mics	Middle Mics	Width	Mics
6.450	6.448	.071	.071	6.448	.071
5.290	5.288			5.288	
1	5.290			5.290	
1	5.288			5.288	
1.180	1.183			1.183	
2.825	2.827	.073	.073	2.827	.073
5.190	5.188			5.188	
1	5.187			5.187	
1	5.189			5.189	
5.775	5.776	.071	.071	5.776	.071

Yes*/No** (If Yes, Description)

Non-Conformance

Surface
DefectsNO

Burrs

NO

Shape

Defects

NO

Initials

*Need Resolution, OK'd or Segregated

**No Non-Conformance Present

RS

Slit Size Inspection

Date: 1-29-12 Work Order: CLV 58966

Size of Cuts	Beginning Width	Mics	(Paxson Only) Middle Mics	End Width	Mics
6.450	6.448	.071	.071	6.448	.072
5.290	5.288			5.288	
1	5.290			5.290	
1	5.288			5.288	
1.180	1.183	.072	.072	1.183	.074
2.825	2.827			2.827	
5.190	5.188			5.188	
1	5.187			5.187	
1	5.189			5.189	
5.775	5.776	.070	.070	5.776	.073

Yes*/No** (If Yes, Description)

Non-Conformance

Surface
Defects

Burr

Shape

Defects

Initials

*Need Resolution, OK'd or Segregated

**No Non-Conformance Present

Slit Size Inspection

Date: 1-29-16 Work Order: CLV 58966

Size of Cuts	Beginning Width	Beginning Mics	(Paxson Only) Middle Mics	End Width	End Mics
6.450	6.448	071	071	6.448	071
5.290	5.288			5.288	
1	5.290			5.290	
1	5.288			5.288	
1.180	1.183			1.183	
2.825	2.827	073	072	2.827	072
5.190	5.188			5.188	
1	5.187			5.187	
1	5.189			5.189	
5.775	5.776	072	071	5.776	071

Yes*/No** (If Yes, Description)

Non-Conformance

Surface Defects

NO

Burrs

NO

Shape

Defects

NO

Initials

*Need Resolution, OK'd or Segregated

**No Non-Conformance Present

RCS