

Subject: Cleveland Process Audit

Date: October 23, 2015

Completed By: Steve Busicnki

On October 23, 2015, work order CLV 57854 was ran on the PWC CLO (Paxson) for Arrow Tru-Line. Tag 67804 was verified prior to loading and use of the coil. The operator stated that he measured each cut with calipers prior to running. The full width of the master coil was measured and the gauge was measured at both edges and the crown with a micrometer. The materials gauge was measured again in the middle of the run and at the end of the run with a micrometer. The width of one cut was measured again at the end of the job. Based on the micrometer readings from the Slit Size Inspection form, 100.0% of the gauge was within the customer range.

Part Spec/PO Audit Form

Cust #	9509	Customer	Arrow Tru-Line			Grp/Sz/Grd/Wdth	TGVC / 0.1090 / S33G40 / 12.750	
Equip/Plant	PWC CLO (Paxson)	Work Order #	CLV 57854	Date	10/23/2015	Part No.	AM .1090 X 12.750 HDG	
Work Order Information		Material to be Used				Actual		
		Tag #1	67804	Tag #2		Gauge #1	.111 , .112 , .113	Gauge #2
		PO#		PO#		% Gauge In Spec	100.00%	% Gauge In Spec
Gauge Range	0.1090 - 0.1230	Gauge Min	.1090 Min	Gauge Min		Low/High Gauge	.111 / .113	Low/High Gauge
Width Range	12.745 - 12.755	Width	49.0620"	Width		Average	0.112	Average
Length Range	Coil					Width	12.7490	Width
Rockwell		Rockwell		Rockwell		Length	Coil	Length
Tensile						Rockwell		Rockwell
Yield		Toll Processed						
% Elongation		GVC SS GR33						
Chem Rqmts		G40						
Other Rqmts		.1090 Min X						
		49.0620"				Other		
		1pcs 22,780lbs						
Summary								
Actions								
Final Status								

Slitting Order

Date:	Customer: <u>ARROW</u>
Work Order #: <u>CLV 57854</u>	Date Run: <u>10-23-15</u>

Incoming Inspection Checklist

Tag #	Gauge & Width	Type	Tag Wgt.	RB	Olsen	Actual Wgt.	Width	Mic
67804	109 x 49.062	GVL	22,780	NA	NA	22,780	49 1/16	.112

Cutting Instructions: 1cut 12.750 1cut 5.000
 1cut 9.750 1cut 4.150
 1cut 6.240 1cut 2.865
 1cut 5.500 2cuts 1.180

Slit Tolerance: <u>± .005</u>	Max O.D: <u>STR THRU</u>	Max Skid Wgt: <u>5000</u>	I.D: <u>20</u>
Gauge Range: <u>109-123</u>	Salesman:		

Special Instructions:

1 Cuts with some defect but okay to ship

NA Cut Size
NA Cut Weight
NA Defect
NA Approved By

2 Cuts Rejected

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

3 Ok to move material for shipment or to Stock

D. Ramsey Name
10-23-15 Date

Slit Size Inspection

Date: 10-23-15 Work Order: CLV 57854

Size of Cuts	Beginning		(Paxson Only) Middle Mics	End	
	Width	Mics		Width	Mics
12.750	12.749	-111	-111	12.749	-111
6.240	6.238			6.238	
5.500	5.498			5.498	
1.180	1.183			1.183	
"	1.184	-113	-112	1.184	-113
2.865	2.864			2.864	
4.156	4.157			4.157	
5.000	5.001			5.001	
9.750	9.748	-112	-111	9.748	-112

DO ANY CUTS HAVE:

Rust/Stain NO
 Burrs OK
 Knife Marks OK

Initials

ROS