Subject: Cleveland Process Audit

Date: October 30, 2015

Completed By: Steve Busicnki

On October 30, 2015, work order CLV 57826 was ran on the CR2 for Akro. Tag 216859 was verified prior to loading and use of the coil. The width of the material was measured when initially fed into the machine. The length of the sheet was measured when cut, before the bundle was started. One of the first pieces was measured for length, width, square, flatness and wave. The gauge of the material was measured with a micrometer at both edges and the crown. Based on the gauge report, 100.0% of the gauge was within the customer range.

Part Spec/PO Audit Form

Cust #	4295	Customer	Akro		Grp/Sz/Grd/Wdth	CRS / 0.0470 / CSB / 35.4370			
Equip/Plant	PWC CR2	Work Order #	CLV 57826	Date	10/30/2015	Part No.	R18GA35.4X24.0		
Work (Work Order Information Material to be Used			Actual					
		Tag #1	216859	Tag #2		Gauge #1	.0435 , .0440	Gauge #2	
		PO#	21978-001	PO#		% Gauge In Spec	100.00%	% Gauge In Spec	
Gauge Range	0.0430 - 0.0510	Gauge Min	.0422 Min	Gauge Min		Low/High Gauge	0.0434 / 0.0442	Low/High Gauge	
Width Range	35.432 - 35.442	Width	36.0000"	Width		Average	0.0438	Average	
Length Range	23.970 - 24.030					Width	35.4370	Width	
Rockwell		Rockwell		Rockwell		Length	24.0000	Length	
Tensile						Rockwell		Rockwell	
Yield		A1008 Cold							
% Elongation		Rolled Coil							
Chem Rqmts		CS-Type B							
Other Rqmts		.0422 Min							
		X 36.0000"				Other			
		1pcs 14,360lbs							
Summary									
Summary									
Actions									
Actions									
Final Status									
i iliai Status									

Master Tag # コル 859 Date: 10 - 30 - 15 Tag Weight: Customer: AKRO 14,360 Type: CACK Work Order # 57826 Machine # 🔭 Ordered RB:

			.7		
	Last piece of 1st bundle		Skid Tag#		
	6435 044	64×	Edge	. 643	Ga
	044	044	Crown	4	Gauge Tolerance
	0435	6435	Edge	051	Се
	35.437	6435 35 437	35 Width ??	±050	Width Tol:
	24.00	34.00	Length	<u> </u>	Length Tol:
	03)	03/	Square	ma	Square Tol:
	2-120	< 7200	Flatness	n	Flatness Tol:
0	Br be	In de	Inspected By	3	
-	10-30	10-30	Date		

						_
						Skid Tag#
						Edge
						Crown
						Edge
				,		Width
		a ,			-3	Length
	/					Square
						Flatness
						Inspected By
						Date

Last piece of last bundle		Skid Tag#
		Edge
	-	Crown
		Edge
*	že.	Width
		Length
		Square
		Flatness
	¥	Inspected By
		Date

AGT400 Coil Summary Report

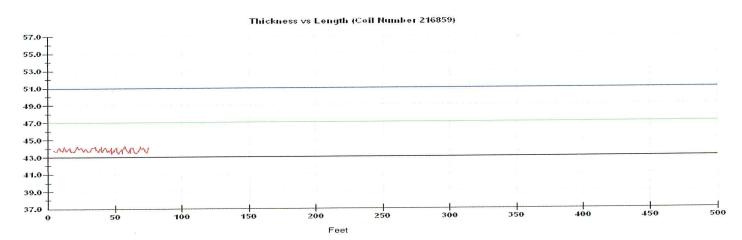
Jemison Metals -- 75 Inch Red Bud CTL Line

Work Order: 57826 Coil Number: 216859

Customer Name: AKRO Heat Number: DUFNLK1558189 Vendor: DUFERCO

Product: Cold-Rolled Steel Oct-30-15 10:20 AM to 10:34 AM (clock 14.1 min/ run 2.1 min) Shift: 1

Average Thickness and Tolerance Data -0.0032 in (-6.72%)Average - Target Target 0.0470 in Average* 0.0438 in 0.0002 in (0.43%) Standard Deviation* 0.0510 in 0 ft (Above High Limit 83 ft Length In Tolerance 83 ft (100.0%) Width 36.156 in Below Low Limit 0.0430 in 0 ft (0.0%) Weight 450 lbs 47 ft Max Thickness 0.0442 in at 35 ft Min Thickness 0.0434 in at Tail Scrap Head Scrap Statistical Process Control Data 15.0% (Capability Ratio %, 100/CP) (Process Capability, HiLim-LoLim/6*Sigma) CP 6.667 TMW Ratio 0.981 (Low Limit/Avg) 1.400 (Capability vs Limits) CPK Thickness Distribution Relative to the Target 0.0% +0.0050 0.0% +0.0045 0.0% +0.0040 0.0% +0.0035 0.0% +0.0030 +0.0025 0.0% +0.0020 0.0% 0.0% +0.0015 +0.0010 +0.0005 0.0% +0.0000 0.0% -0.0005 0.0% -0.00100.0% -0.00150.0% 0.0% -0.0025 0.08 33.8% 63.9% *********************************** 2.3% ***** -0.0040 -0.0045 0.0% -0.0050 0.0% 0.0% 24 27 30 33 6 12 15 0.0% is within \pm 0.0025 in of the target 0.0% is within \pm 0.0010 in of the target 100.0% is within \pm 0.0100 in of the target 100.0% is within \pm 0.0050 in of the target



Gauge readings provided by Advanced Gauging Technologies, L.L.C. Plain City, OH 43064 USA Tel:(614) 873-6691