

## **GAD Process Audit Summary:**

**11/10/15 Press Brake Job# 49325**

**Performed by: B. Smith**

Press brake Job for Heil; part number 311-2198-001 from WIP tag 119598.

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

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

All post-forming dimensional checks were completed using height gauge (serial #16001038) for linear dimensions and protractor (#P001) for angular dimensions called out on customer supplied print (311-2198-001). All measurements fell within customer tolerances for first piece and secondary inspections.

### Corrective Action Audit

Press Brake form (GAD 059) was implemented as corrective action to case #9579. This done to ensure parts were being checked.

The form was attached to the work order and properly updated at the frequency required, 20 piece intervals.

### Training Audit

Reviewed Press Brake Operator Training Matrix (JDM-F-021). All items were documented as competent.

No follow up required.

### Measuring tools:

Height gauge (serial #16001038)

Last Calibration: 11.12.15      Due: 11.12.16

Protractor (serial #P001)

Last Calibration: 11.19.15      Due: 11.19.16

Controlled documents:

GAD020 REV 1

GAD 059 Press Brake From REV 0

Print: 311-2198-001 REV A

JDM-F-021 REV 0

GAD014 REV 1

# Part Spec/PO Audit Form

Cust #	10	Customer	KC15	Grp/Sz/Grd/Width	K45/.25/5550/10.0720
Equip/Plant	16 1	Work Order #	49525	Part No.	311-2198-001
Date	11.10.15				
Work Order Information		Material to be Used		Actual	
	Tag #1	119548	Tag #2	Gauge #1	.245
	PO #	56220-157-PO# 61046-001		% Gauge In Spec	100
Gauge Range	.735 - .245			Low/High Gauge	.243 - .245
Width Range	1.56 - 1.44			Average	.244
Length Range	10.15 - 10.01			Width	1.44
Rockwell	X	Rockwell	X	Length	10.04
Tensile	45,000	Rockwell		Rockwell	
Yield	56,000				
% Elongation	17.00				
Chem Rqmts	K45				
Other Rqmts	K45				
	K45 .507			Other	
	K45 (K45 + 507)				
Summary	FOLLOWED PROCEDURE - CHECKED PART				
Actions	NONE				
Final Status	NO FOLLOW UP NEEDED				

~~LINK TO CEA.~~

~~LINK TO FOLLOW UP NEEDED~~

Y85203K  
 42045524 N047229  
 L74 # 033887-001  
 A10 - 1.5 - 1.445

~~REWORK TO FOLLOW UP NEEDED~~  
~~REWORK TO FOLLOW UP NEEDED~~  
~~REWORK TO FOLLOW UP NEEDED~~



## Corrective Action Report

<b>Case#</b>	9579	<b>Date Created</b>	7/2/2015
<b>Branch</b>	GAD	<b>Created By</b>	Rachel White
<b>Assigned Responsibility</b>	Operations	<b>Customer</b>	HEIL -FT. PAYNE
<b>Internal/External</b>	External		

**Has finished goods inventory been checked for the same issue?** Yes

**Problem Description:**  
(Who, What, Where, When)

Ten pcs of 137-0480 that were formed incorrectly made it into Heil's inventory.

**Root Cause Of Issue:**  
(Why)

The parts were not correctly positioned against the backstop when bent.

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<b>Interim Responsible</b>	John Foster/Bradley Write	<b>Implementation Date:</b>	6/30/2015
<b>Plan:</b>	Checked all finished goods in inventory and brought issue to the attention of team manager and operators.		

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<b>Permanent Responsible</b>	Bradley Wright	<b>Implementation Date:</b>	7/2/2015
<b>Plan:</b>	Operators were retrained on the correct way to form these parts. Added a Press Brake check sheet to ensure that parts are being checked.		

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<b>Material Disposition</b>	----		
<b>Audit Date 1</b>	10/16/2015	<b>Outcome 1</b>	Pass
<b>Audit Date 2</b>	----	<b>Outcome 1</b>	----
<b>Audit Date 3</b>	----	<b>Outcome 1</b>	----
<b>Follow Up:</b>	10.16.15-verified PB check sheet is used correctly(bps). Part spec audit will be performed again on this part by EOM Nov 2015		

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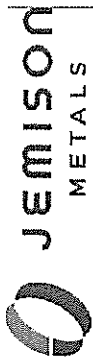
<b>Complete</b>	Yes	<b>Closed</b>	No
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## PRESS BRAKE FORM

Job Number:	Operator Name:
Part number:	Date:

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	
80th	
100th	
120th	
140th	
160th	
180th	
200th	
220th	
240th	
260th	
280th	
300th	
320th	
340th	
360th	
380th	
400th	
420th	
440th	
460th	
480th	
500th	



# TRAINING MATRIX

EMPLOYEE NAME Damirque Steward  
SUPERVISOR NAME Bradley Wright

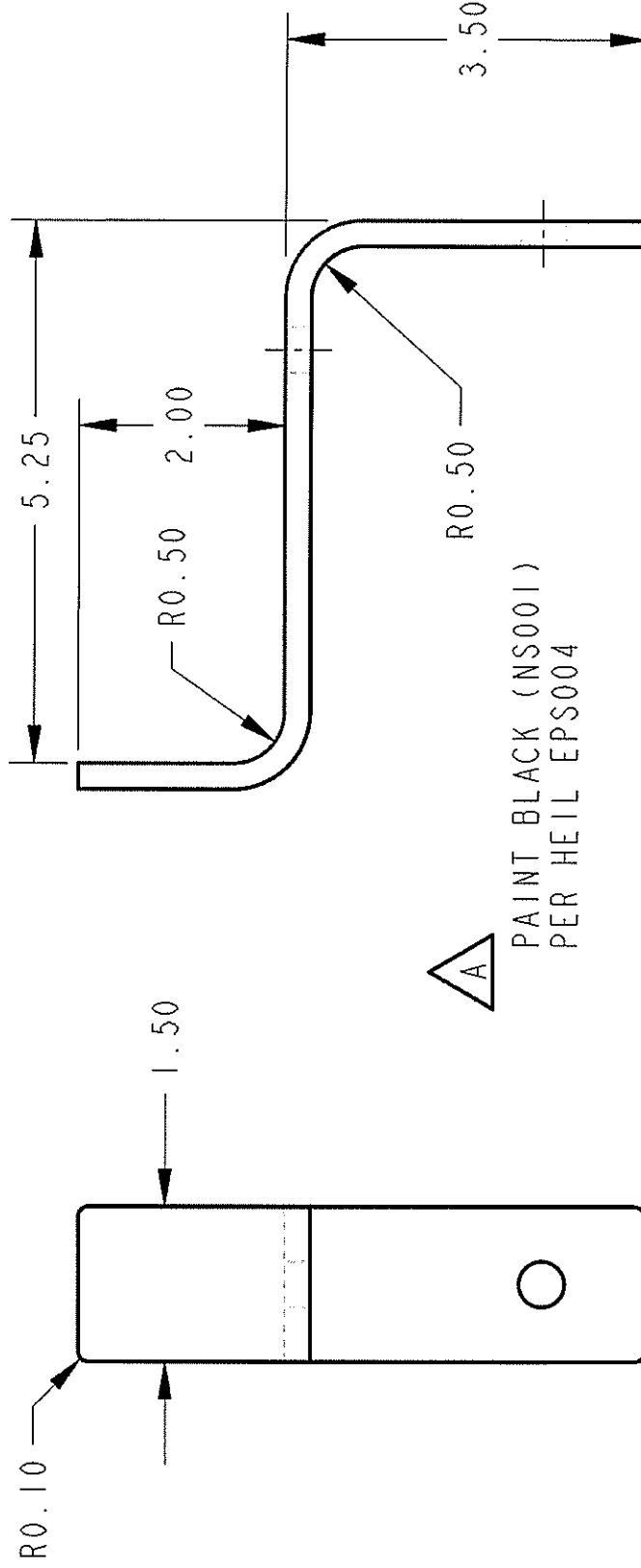
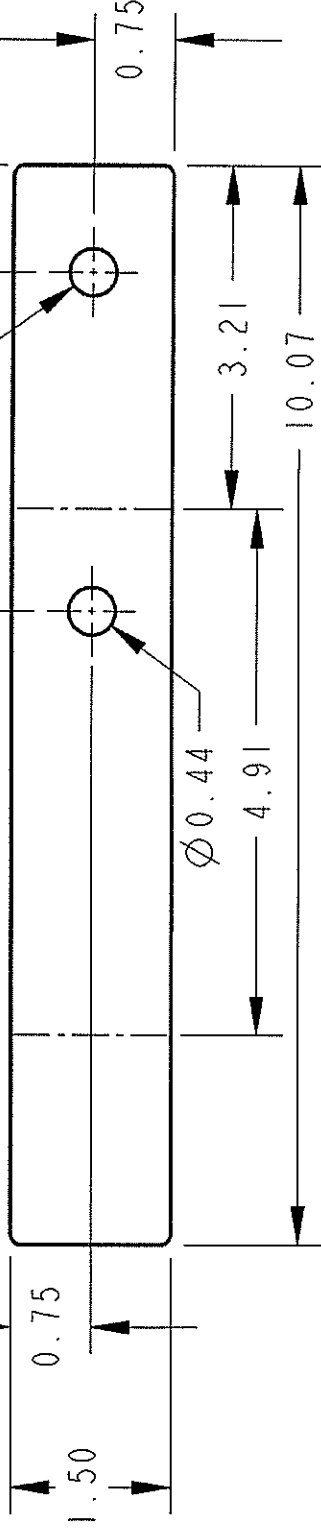
HIRE DATE	JOB TITLE: Press Brake Operator	Training Goals - Tracking				
		Description	Trainer Initials	Employee Initials	Competent (Y or N)*	Notes/Comments
		Cincinnati Press Brake Safe operation and JSA (this must be completed before operator is cleared to run any press brake). Trainee must be 100% supervised by trainer for the first 2 shifts on a press brake	BW	DS	BW	
		Packaging, Material to be Produced. Connection to Part Specifications (detail on W/O comes from Part Spec).	BW	DS	BW	
		Forklift training	BW	DS	BW	
		Crate Training	BW	DS	BW	
		SS. What it is, employee responsibilities, training on SS schedule (if applicable)	BW	DS	BW	
		Stock Plan	BW	DS	BW	
		Material movement to finished goods or secondary processes. How is stock organized and stacked?	BW	DS	BW	
		Material tracking, identification, and log hanging	BW	DS	BW	
		Machine Operation	BW	DS	BW	
		Basic training on machine controls and tooling set-up procedures	BW	DS	BW	
		Quality Intranet	BW	DS	BW	
		How to pull up on computer to view procedures, forms, skid types etc.	BW	DS	BW	
		Who can reject material? Segregation and identification of reject material	BW	DS	BW	
		Non-Conforming Material (Reject)	BW	DS	BW	
		Stepplan/FIT Operations and	BW	DS	BW	
		Production tracking	BW	DS	BW	
		Measuring Instruments	BW	DS	BW	
		Visual Inspection	BW	DS	BW	
Additional Notes/Comments:						

\* If employee is not yet deemed competent, list actions and timing for more training and/or review for competency.



DRAWING SIZE	A
REVISION	A
ECO #	DPF08073

311-2198-001



HEIL ENVIRONMENTAL INDUSTRIES, LTD. A <b>DOVER</b> INDUSTRIES COMPANY		TITLE: BRACKET, HOSE HANGER HEIL UNITS		DRAWN BY: J. HURLEY		PART No. 311-2198-001	
HEIL		WEIGHT 1.06		TYPE PART		SCALE: 1:2	
TOLERANCES UNLESS OTHERWISE SPECIFIED:  LINEAR XX = ± .06 XXX = ± .030 ANGULAR = ± 1°		NOTICE: This print is the property of HEIL Environmental Industries, Ltd. and is recyclable at any time. It must not be copied or used detrimentally to the interest of HEIL Environmental Industries, Ltd.		DATE: 18-Jan-02		MATERIAL: 1/4" HI-TEN	
ADD PAINT SPEC		11/11/08		DPF08073		ECO NO.	
RELEASED		01/18/02		7F01068		DATE	
REV. WAS							

# Calibration Worksheet

## Calibration Record

Identification Number: <u>16001038</u>		
Location: <u>Gadsden</u>		
Responsible Individual, Q.A.	Assigned To: <u>LUSS BLAKE</u>	
Description: <u>18" MITUTOYO HEIGHT GAUGE</u>		
Range/Capabilities/Accuracy/Precision: <u>0" - 18"</u>		
Calibration Procedure: <u>ENV STANDARDS</u>		
Received Date:	Calibration Date: <u>11.12.15</u>	Due Date: <u>11.12.16</u>
Environmental Conditions:		

Equipment settings increment, or mark being checked	Standard used to check, & ID number	Acceptance Criteria	As received readings	Adj, Readings
<u>11.999</u>	<u>8118</u>	<u>+/- .001</u>	<u>12.000</u>	
<u>8.999</u>	<u>8115</u>	<u>+/- .001</u>	<u>8.999</u>	
<u>6.000</u>	<u>8112</u>	<u>+/- .001</u>	<u>6.000</u>	

Were the standards used traceable to NIST? ☒ yes ☐ no

When were standards calibrated? 10.14.14

What is the calibration due date of the standards? 10.14.17

Calibration/Verification performed by, S. SMITH Date, 11.12.15

Comments about condition of equipment:

NONE

Were adjustments made? ☐ yes ☒ no

If adjustments were made, who in Quality Assurance verified that the evaluation was made on the impact on product already accepted by the equipment and took the appropriate action, re-measure the material or other response, name of QA personel who performed evaluation:



# Calibration Worksheet

## Calibration Record

Identification Number: <u>P001</u>		
Location: <u>Gadsden</u>		
Responsible Individual, Q.A.		Assigned To: <u>PRESS BRACK</u>
Description: <u>PROTRACTOR</u>		
Range/Capabilities/Accuracy/Precision: <u>0° - 180°</u>		
Calibration Procedure: <u>Round Arm</u>		
Received Date: <u>11.19.15</u>	Calibration Date: <u>11.19.15</u>	Due Date: <u>11.17.16</u>
Environmental Conditions: <u>MANUFACTURING</u>		

Equipment settings increment, or mark being checked	Standard used to check, & ID number	Acceptance Criteria	As received readings	Adj, Readings
90°	Round Arm	+/- .5°	90.23	
	7530-3327-DC			
135°		+/- .5°	134.99	
45°		+/- .5°	45.14	

Were the standards used traceable to NIST? Yyes \_\_\_no

When were standards calibrated? 10.22.15

What is the calibration due date of the standards? 10.22.16

Calibration/Verification performed by, B. Smith Date, 11.19.15

Comments about condition of equipment:

none

Were adjustments made? \_\_\_yes Xno

If adjustments were made, who in Quality Assurance verified that the evaluation was made on the impact on product already accepted by the equipment and took the appropriate action, re-measure the material or other response, name of QA personel who performed evaluation: