

Subject: Cleveland Process Audit

Date: November 12, 2015

Completed By: Steve Busicnki

On November 12, 2015, work order CLV 58109 was ran on the PWC CLO (Paxson) for Arrow Tru-Line. Tags 68174 and 68175 were verified prior to loading and use of each coil. The width of each cut was measured with calipers SP1 when first fed through the arbors. The full width of the material was measured with tape measure 8. The coils thickness was measured at both edges and the crown with micrometer ASP015. The gauge was measured again at the middle of the coil and the end of the coil at both edges and the crown using the same micrometer. This process was repeated using the same measuring devices, for the second coil. These 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 09/15 calibration due 12/15

Tape – 8 last calibration 09/15 calibration due 12/15

Micrometer – ASP015 last calibration 11/15 calibration due 12/15

Controlled Documents:

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

JDM3 rev date 07/21/11

JDM4 rev date 07/21/11

Part Spec/PO Audit Form

Cust #	9509	Customer	Arrow Tru-Line			Grp/Sz/Grd/Wdth	TGVC / .0800 / S33G40 / 8.125		
Equip/Plant	PWC CLO	Work Order #	CLV 58109	Date	11/12/2015	Part No.	64 .0800 X 8.125 HDG		
Work Order Information		Material to be Used				Actual			
		Tag #1	68174	Tag #2	68175	Gauge #1	.081, .083, .082	Gauge #2	.083, .084, .082
		PO#		PO#		% Gauge In Spec	100%	% Gauge In Spec	100%
Gauge Range	0.0800 - 0.0920	Gauge Min	.0800 Min	Gauge Min	.0800 Min	Low/High Gauge	.081/.083	Low/High Gauge	.082/.084
Width Range	8.1200 - 8.1300	Width	48.0000"	Width	48.0000"	Average	0.082	Average	0.083
Length Range	Coil					Width	8.1260	Width	8.1260
Rockwell		Rockwell		Rockwell		Length	Coil	Length	Coil
Tensile						Rockwell		Rockwell	
Yield		Toll Processed		Toll Processed					
% Elongation		GVC SS GR33		GVC SS GR33					
Chem Rqmts		G40		G40					
Other Rqmts		.0800 Min X		.0800 Min X					
		48.0000"		48.0000"		Other			
		1pcs 21,750lbs		1pcs 21,850lbs					
Summary									
Actions									
Final Status									

Slit Size Inspection

Date: 11-12-15 Work Order: CLV 58109

Size of Cuts	Beginning		(Paxson Only)	End	
	Width	Mics	Middle Mics	Width	Mics
9.000	9.001	.081	.081	9.001	.082
8.125	8.126			8.126	
7.625	7.627			7.627	
3.665	3.668	.083	.083	3.668	.083
2.250	^{2.251} 2.250			^{2.251} 2.250	
7.300	7.302			7.302	
7.375	7.374	.082	.081	7.374	.082
9.000	9.001	.083	.083	9.001	.083
8.125	8.126			8.126	
7.625	7.627			7.627	
3.665	3.668	.084	.084	3.668	.084
2.250	^{2.251} 2.250			^{2.251} 2.250	
7.300	7.302			7.302	
7.375	7.374	.082	.082	7.374	.082

DO ANY CUTS HAVE:

Rust/Stain

NO

Burrs

OK

Knife Marks

OK

Initials

RES

Slitting Order

Date:	Customer: ARROW
Work Order #: CLV 58109	Date Run: 11-12-15

Incoming Inspection Checklist

Tag #	Gauge & Width	Type	Tag Wgt.	RB	Olsen	Actual Wgt.	Width	Mic
68174	080 x 48"	G-1/2	21,750	NA	NA	21,750	48 1/8	082
68175	"	"	21,850	NA	NA	21,850	48 1/8	083

Cutting Instructions: 1 CUT 4.000 1 CUT 7.300
 1 CUT 8.125 1 CUT 3.605
 1 CUT 2.625 2 CUT 2.250
 1 CUT 7.375

Slit Tolerance: + .005	Max O.D: STR THRU	Max Skid Wgt: 5000	I.D: 20
Gauge Range: 080-092	Salesman:		

Special Instructions:

1 Cuts with some defect but okay to ship

 Cut Size

 Cut Weight

 Defect

 Approved By

2 Cuts Rejected

 Cut Size

 Cut Weight

 Tag No. or No.'s

 Reason for Reject

3 Ok to move material for shipment or to Stock

D. Ramsey

 Name
11-17-15

 Date