

Subject: Cleveland Process Audit

Date: February 13, 2015

Completed By: Steve Busicnki

On February 13, 2015, work order CLV 54796 was ran on the CR2 for Capital. A total of six bundles of 18.5240 X 18.8120 were produced. Tag 212738 was verified prior to loading and use of the coil. When production began, one of the first finished sheets produced was checked for length, width, and square. A micrometer was also used on this sheet to check the thickness of the material at both edges and the crown. All measurements were relayed to another operator who recorded them on the Quality Checklist. All bundles had a minimum of one sheet checked for length, width and square. Thickness readings for the material were also taken from the gauger. Based on the gauge report, 98.6% of the material was within specification with an average thickness of 0.1249". The 1.4% of material that was outside of specification limits is assumed to be along the edge of the material. This represents approximately .259" of coil width and is within ASTM A568 for thickness from the edge.

Part Spec/PO Audit Form

Cust #	4885	Customer	Capital		Grp/Sz/Grd/Width	
Equip/Plant	CR2	Work Order #	CLV 54796	Date	2/13/2015	Part No.
						VB-CDE6516
Work Order Information		Material to be Used		Actual		
		Tag #1	212738	Tag #2		
		PO#		PO#		
Gauge Range	0.1220-0.1280	Gauge Min	0.1210	Gauge Min		
Width Range	18.5040-18.5440	Width	18.5240	Width		
Length Range	18.7920-18.8320					
Rockwell		Rockwell		Rockwell		
Tensile						
Yield		HRPO DS				
% Elongation		Type B				
Chem Rqmts						
Other Rqmts						
Summary						
Actions						
Final Status						