

**Subject:** Cleveland Process Audit

**Date:** February 20, 2015

**Completed By:** Steve Busicnki

On February 19, 2015, work order CLV 54928 was ran on the CLO for Arrow Tru-Line. The master coil was slit to the appropriate width for the customer. Tag 65036 was verified prior to loading and use of the coil. When production began, a micrometer was used to verify that the material was within tolerance at both edges and at the crown of the master coil. A caliper was used to check the width of each cut and verify that the width was within tolerance. The material was run until the OD measurements at the re-coiler reached the customer requirement. Once the material was split, a micrometer was used to take the gauge measurements prior to beginning the second set of finished coils. The gauge measurements were taken again at the end of the master coil and all measurements were recorded. Thickness readings for the material were also taken from the gauger. Based on the gauge report, 100.0% of the material was within specification with an average thickness of 0.1009". There is a flatness requirement of 0.00-.37 listed on the part. Due to this being finished in coil form, we communicated with sales about the flatness requirement and it is to be removed from the part spec. There is also a camber requirement of 0.00-.25 listed. It was noticed that there is no section listed on the Slit Size Inspection Sheet for camber recordings. We will determine if it would be best to reformat the form to add a camber section or if it can be recorded elsewhere. This determination will be made the week of 02/22/2015.

# Part Spec/PO Audit Form

Cust #	9509	Customer	Arrow Tru-Line	Grp/Sz/Grd/Width	
Equip/Plant	CLO	Work Order #	CLV 54928	Part No.	42.0970 X 2.375 HDG
		Date	2/19/2015		
Work Order Information		Material to be Used		Actual	
		Tag #1	65036	Gauge #1	Gauge #2
		PO#		% Gauge In Spec	% Gauge In Spec
Gauge Range	0.0970-0.1030	Gauge Min	.0970 Min	Low/High Gauge	Low/High Gauge
Width Range	2.370-2.380	Width	46.1870	Average	Average
Length Range	N/A			Width	Width
Rockwell		Rockwell	Rockwell	Length	Length
Tensile				Rockwell	Rockwell
Yield		Toll Processed			
% Elongation		GVC SS GR33			
Chem Rqmts		G40			
Other Rqmts					
Camber	0.00-.25			Other	
Flatness	0.00-.37			Hand Mic	.100/.102
				Beginning	.098/.100
				Split	.099/.101
				End	
Summary					
Actions					
Final Status					