

Subject: Cleveland Process Audit

Date: February 26, 2016

Completed By: Steve Busicnki

On February 26, 2016, work order number CLV 59350 was ran on the CR2 for The Sheet. Tag 217925 was verified prior to loading and use of the coil. One of the first pieces was measured for length, width and square using tape measure 1. Flatness and wave were checked against the flatness table 092726 and the step gauge ST2 was available. The materials thickness was measured at both edges and the crown using micrometer ASP016. The last piece of the third bundle was checked and the length and width was measured along with a visual inspection for wave and flatness. The gauger was used to verify thickness of the material. Based on the gauge report, 97.2% of the gauge was within the customer range, with 2.8% representing the edge drop off associated with the edge of the steel. Micrometer readings verified material to be within specification.

Measuring Tools:

Tape – 1 last calibration 09/15 calibration due 09/16

Micrometer – ASP016 last calibration 01/16 calibration due 02/16

Flatness Table – 092726 last calibration 11/25/14 calibration due 11/25/19

Step Gauge – ST2 last calibration 03/11/15 calibration due 03/11/17

Controlled Documents:

CLV-RB-002 rev date 03/07/13

JDM13 rev date 11/30/12

Part Spec/PO Audit Form

Cust #	5922	Customer	The Sheet		
Equip/Plant	PWC CR2	Work Order #	CLV 59350	Date	2/26/2016
Work Order Information		Material to be Used			
		Tag #1	217925	Tag #2	
		PO#	21882-001	PO#	
Gauge Range	0.0986 - 0.1106	Gauge Min	.0976 Min	Gauge Min	
Width Range	44.0000 - 44.5000	Width	44.0000"	Width	
Length Range	75.0000 - 75.1870				
Rockwell		Rockwell		Rockwell	
Tensile					
Yield		A1008 Cold Rolled			
% Elongation		Coil CS-Type B			
Chem Rqmts		.0976 Min X			
Other Rqmts		44.0000"			
		1 pcs 6,660 lbs			
Summary					
Actions					
Final Status					

Part Spec/PO Audit Form

Grp/Sz/Grd/Wdth	CRS / 0.0986 / CSB / 44.0000		
Part No.	5922/CRS 12GA 44X75		
Actual			
Gauge #1	.0987, .0998, .0987	Gauge #2	
% Gauge In Spec	97.20%	% Gauge In Spec	
Low/High Gauge	0.0955 / 0.1007	Low/High Gauge	
Average	0.0996	Average	
Width	44.1870	Width	
Length	75.0620	Length	
Rockwell		Rockwell	
Other			

Date: 2-26-16	Customer: THE SHEET	Work Order # 59350	Machine # 2
Master Tag # 217925	Tag Weight: 6660	Type: CRC	Ordered RB: NA

Gauge Tolerance			Width Tol:	Length Tol:	Square Tol:	Flatness Tol:	Inspected By	Date
			±.50 6	±.187 8	1/16	-.12		
Skid Tag#	Edge	Crown	Width	Length	Square	Flatness	Inspected By	Date
16956	0987	0998	44.187	75.062	-.12	< .125	Jm	2-26
Last piece of 1st bundle	6987	0998	44.187	75.062	-.12	< .125	Jm	2-26

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