

**Subject:** Cleveland Process Audit

**Date:** February 27, 2015

**Completed By:** Steve Busicnki

On February 27, 2015, work order CLV 55005 was ran on the CLO Paxson for Arrow Tru-Line. The master coil was slit to the appropriate width for the customer. Tag 65068 was verified, by the operator, 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, which was 15" of material for this product. Once the material was split, a micrometer was used to take the gauge measurements at the end of the first set of finished coils. The gauge measurements were taken again at the end of the master coil and measurements were recorded. There is no gauger on this machine. Based on the readings from the micrometer, 100% of the material was within specification with an average thickness of 0.0995". There is a flatness requirement of 0.00 - .37 listed in this part. It is recommended that this requirement be removed from this part as this is finished in coil form. Camber was not checked on this order. This check for camber will be reviewed with operations and sales to determine if this can be done efficiently for the volume that is produced or if it should be removed from the part.

# Part Spec/PO Audit Form

Cust #	9509	Customer	Arrow Tru-Line	Grp/Sz/Grd/Width	
Equip/Plant	CLO Paxson	Work Order #	CLV 55005	Part No.	Z1 .0970 X 3.940 HDG
			Date		2/27/2015
Work Order Information		Material to be Used		Actual	
		Tag #1	65068	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	3.935 - 3.945	Width	46.1870"	Average	Average
Length Range	0.0000 - 0.0000			Width	Width
Rockwell		Rockwell	Rockwell	Length	Length
Tensile				Rockwell	Rockwell
Yield		Toll Processed			
% Elongation		GVC SS GR33			
Chem Rqmts		G40			
Other Rqmts					
Flatness	0.00 - 0.37	1 pc. 43,980 lbs		Other	
Camber	0.00 - 0.25				
Summary					
Actions					
Final Status					