PART SPEC AUDIT 03-11-15 S22

BROWN-FORMAN

PART .058 X 2.00"

A few important notes during this audit

- Extreme oscillation at beginning of coil. Set up took over 30 mins due to this. Operators had to crawl up on the table and saw through the steel a few times before getting coil correct.

  Per conversation with operator this is not unusual. Coils are loosely banded and come to our plant via rail car
- High scrap due to oscillation mentioned above. This coil had a scrap rate of 3.9%. The job as a whole (six coils total) had a scrap rate of 3.66%. The part number is set up in FIT at 3.1%

Other than those two issues the run was good and had no findings

Part Spec/PO Audit Form

Cust #	1997		Customer	Brown-Forman			Grp/Sz/Grd/Wdth	HRC 5555 .058 x 2.00		
Equip/Plant	~~5822~~ S22 / GAD		Work Order #	447662	Date	3/11/15	Part No.	.058 x 2.00"		
Work Order Information			Material to be Used				Actual			
			Tag #1	GA 416154	Tag #2		Gauge #1	.060	Gauge #2	
			PO#	GAD-9913	PO#		% Gauge In Spec	100%	% Gauge In Spec	
Gauge Range	.056 - .060		Gauge Min	.056	Gauge Min		Low/High Gauge	.056 / .060	Low/High Gauge	
Width Range	1.94 - 2.06		Width	48.5	Width		Average	~~.0595~~ .0595	Average	
Length Range	N/A						Width	2.001 / 1.751	Width	
Rockwell	70-90		Rockwell	89 7	Rockwell		Length	N/A	Length	
Tensile	70,000 M						Rockwell		Rockwell	
Yield	55,000 M									
% Elongation	17 - 30									
Chem Rqmts										
Other Rqmts	no oil/check pads before run surface CLEAN						Other			
Summary	sticker on coil when run through									
Actions	Pad removed prior to run coil oscillated from mill. ~~Stayed~~									
Final Status										

Add to width range 1.75"
1.69" - 1.81"

Oscillation typical
loose banding / rail car per Roger
having to scrap through oscillation? how much weight will that be? typical scrap for this ???

scrap for this coil 3.9%

for full six coil run 3.66%

Had to physically cut through scrap - time suck

Set up over 30 mins, Oscillation issue at least 20 mins

Fit ~~(illegible)~~ scrap at 3.10%