

Part Spec Audit 03/18/15 Laser

Hokes Bluff

77003643-F

A few points of interest-

The operator is using a caliper to mic material instead of a micrometer. After discussing with John Foster, it was determined that this will be okay. The sheets will have already been mic'd by the time it gets to the laser. A caliper should be sufficient.

A 1st inspection was no done. Operator had no drawing with the work order with which to compare the part. Most drawings are still not on our SNData. I have requested that these all be sent to me immediately so that I can get them in the system.

Part went to press brake where the 2" lip and 7" side were measured to insure the correct dimensions.

Part Spec/PO Audit Form

Cust #	2521	Customer	Hoke's Bldg	Grp/Sz/Grd/Width	.250 / 5.58 / 9.51	#572.50
Equip/Plant	Layer 1	Work Order #	44922	Date	3/18/15	
Work Order Information		Material to be Used		Actual		
	Tag #1	Tag #2		Gauge #1	Gauge #2	
	PO#	PO#		% Gauge In Spec	% Gauge In Spec	
Gauge Range	.240 - .260	Gauge Min	640-9432	Low/High Gauge	Low/High Gauge	
Width Range	5.58 - 5.61	Width	2.35	Average	Average	
Length Range	9.78 - 9.84	Rockwell	84"	Width	Width	
Tensile	65000			Length	Length	
Yield	50000			Rockwell	Rockwell	
% Elongation	22					
Chem Rmpts	N/A					
Other Rmpts	.580" thickness			Other		
Summary						
Actions						
Final Status						

1st pc. inspection - not done - currently no standard form to do so.
 Uses caliper to mic material instead of micrometer. Caliper is calibrated. Take micrometer away??
 goes to press brake and dimension checked after the bend
 2" lip and 7" side are measured to insure correct dimensions