

Subject: Cleveland Process Audit

Date: March 20, 2015

Completed By: Steve Busicnki

On March 20, 2015, work order CLV 55263 was ran on the CLO Paxson for Arrow Tru-Line. The master coil was slit to the appropriate width for the customer. Tag 65042 was the first of two master coils that was to be used for this job and was verified prior to loading and use of the coil. The material width was checked with calipers once fed into the machine. The material thickness was also checked at this point with a micrometer. Material width and thickness was checked again when coil 65056 was fed through the machine. At the end of the workday on March 20, 2015, there were no final width measurements recorded on the Slit Size Inspection sheet for the second master coil. These measurements may have been recorded elsewhere and not yet placed on this official sheet. There is a flatness requirement on this part for Arrow Tru-Line. This flatness requirement will be removed from this part as it was removed from another coil part number for this customer. The camber requirement will be discussed with operations and sales to see if it should be removed from all slit parts for this customer. An e-mail to the sales person and operations was sent on 03/20/15 for reconsideration of this requirement.

Part Spec/PO Audit Form

Cust #	9509	Customer	Arrow Tru-Line		Grp/Sz/Grd/Width	TGVC / .086 / S33G40 / 2.825	
Equip/Plant	CLO Paxson	Work Order #	CLV 55263	Date	3/20/2015	07 .0860 X 2.825 HDG	
Work Order Information		Material to be Used			Actual		
		Tag #1	65042	Tag #2	65059	Gauge #1	Gauge #2
		PO#		PO#		% Gauge In Spec	% Gauge In Spec
Gauge Range	0.0860 - 0.0920	Gauge Min	0.0860	Gauge Min	0.0860	Low/High Gauge	Low/High Gauge
Width Range	2.820 - 2.830	Width	48.3120"	Width	48.3120"	Average	Average
Length Range	0.0000 - 0.0000					Width	Width
Rockwell		Rockwell		Rockwell		Length	Length
Tensile						Rockwell	Rockwell
Yield		Toll Processed		Toll Processed			
% Elongation		GVC SS GR33		GVC SS GR33		Gauge Middle	.087 / .089 / .089
Chem Rqmts		G40		G40		Gauge End	.087 / .088 / .087
Other Rqmts							
Flatness	0.00 - .37					Other	
Camber	0.00 - .25						
Summary							
Actions							
Final Status							

Jemison Metals On-The-Job (OJT) Group Training Form

EMAIL completed form to HR for filing. Maintain original on location.

Continual Learning is key to Continual Improvement in the JM QMS. This Form recognizes that:

(Attendees):

Print Name	Initial	Print Name	Initial
ROBERT S. JONES	RS		
EDWARD NEIGHBORS	EN		

have successfully completed OJT for:

Department: Shifters

Subject: 03/20/15 Process Audit, width measurements not recorded for 2nd coll.

Training Start Date: 03/26/15

Training Completion Date: 03/26/15

Signature of Trainer: John Chandler

According to this document, the OJT for these individuals have been trained and have demonstrated sufficient competence to conduct the documented function/task without further instructions. Continued performance evaluation and observation could result in additional training being specified.