

**Subject:** Cleveland Process Audit

**Date:** March 6, 2015

**Completed By:** Steve Busicnki

On March 6, 2015, work order CLV 54882 was ran on the CR2 for Akro. A total of two bundles of 25.8 X 38.2 were produced. Tag 212978 was verified prior to loading and use of the coil. The material width was measured when the material was initially fed through and trimmed. When production began, one of the first finished sheets produced was measured for square, length, flatness, and gauge. All measurements were relayed to another operator who recorded them on the Quality Checklist. The last piece of the first bundle was also measured for length, width, gauge, square, and flatness. The last piece of the second, and last, bundle was also measured for length, width, gauge, square, and flatness. Thickness readings for the material were taken from the gauger as well. Based on the gauge report, 80.6% of the material was within specification with an average thickness of 0.0846". This average of 0.0846" is within the customer's specification of 0.0840" – 0.0940". The 19.4% of material was seen in the gauger report after the job was complete. The floor supervisor approved of the final hand mic edge measurement of 0.083". The salesman was notified of the under gauge material and stated that it will be acceptable.

# Part Spec/PO Audit Form

Cust #	4295	Customer	Akro	Grp/Sz/Grd/Width	
Equip/Plant	CR2	Work Order #	CLV 54882	Part No.	R13GA25.8X38.2
		Date	3/6/2015		
Work Order Information		Material to be Used		Actual	
		Tag #1	212978	Gauge #1	Gauge #2
		PO#		% Gauge In Spec	% Gauge In Spec
Gauge Range	0.0840 - 0.0940	Gauge Min	.0830 Min	Low/High Gauge	Low/High Gauge
Width Range	38.157 - 38.217	Width	38.6870"	Average	Average
Length Range	25.782 - 25.842			Width	Width
Rockwell		Rockwell	Rockwell	Length	Length
Tensile				Rockwell	Rockwell
Yield		A1008 Cold		Square	.031,.031,.031
% Elongation		Rolled Coil		Flatness	<.120,<.120,<.120
Chem Rqmts		CS-Type B			
Other Rqmts					
Bow	0.00 - .12	1 pc 5840 lbs		Other	
Flatness	0.00 - .12			Mic	
Square	0.00 - .04			Edge	.084,.084,.083
Summary				Crown	.085,.085,.084
				Edge	.084,.084,.083
Actions					
Final Status					