

Part Spec Audit 05/21/15 PB2

JOST

SK77056

FINDINGS:

No findings. Work order, correct tags, and correct forms being used. Using pallets instead of baskets for FG, this was due to Jost having not sent back baskets

Things of note:

One person running both press brakes as well as packaging parts. Took over an hour for him to move from one master tag to another on this job, meaning he finished forming one master tag but had to do so much before being able to start the next.

Cust #	2919	Customer	Soit	Part No.	SK-77056	GP/52/Gnd/Width	PO 2/312/H380/1000 x 20
Equip/Plant	TR2 / CROPP/STU	Work Order #	416064	Date	9/21/15		
Work Order Information		Material to be Used		Actual			
		Tag #1	113444	Tag #2		Gauge #1	Gauge #2
		PO#	C40-1013	PO#		% Gauge In Spec	% Gauge In Spec
Gauge Range	.3025 - .3225	Gauge Min	.3025	Gauge Min		Low/High Gauge	Low/High Gauge
Width Range	6.433 - 6.443	Width	6.443 x 20	Width		Average	Average
Length Range	19.97 - 20.03			Length		Width	Width
Rockwell		Rockwell		Rockwell		Length	Length
Tensile						Rockwell	Rockwell
Yield							
% Elongation							
Chem Rmmts							
Other Rmmts							
	Use the form						
	C40 D58						
Summary							
Actions							
Final Status							

Other
Cut out
Height
Lip Height
Chamfer

1.01"
6.00"
1.01"
5.53"

dimensions

top 113433 / 113444 - same order - parts moved
on pallet of FC double check on pallet - ~~check sheet FG~~
Philip running both press brakes and packaging parts
using pallets because no baskets available from Soit

Started at 1pm brake hasn't run yet - 1:30

Cut out 6.01
H - 6.00
Lip H 1.01
chamfer - 5.53