

Subject: Cleveland Process Audit

Date: May 22, 2015

Completed By: Steve Busicnki

On May 22, 2015, work order CLV 56008 was ran on the CPA Paxson for Arrow Tru-Line. The master coil was slit to the appropriate widths for the customer. Tag 66033 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. A piece was cut and the width was measured with a measuring tape. Gauge was also checked on this piece with a hand micrometer. Once fed through, the slit materials widths were measured with calipers. Tag 66046 was also verified prior to loading and use of the coil. A piece was cut and the gauge was checked with a hand micrometer. Each cut was measured with calipers once fed through. Gauge was checked again at the end of the coil and the width of each cut was measured with calipers.

Part Spec/PO Audit Form

Cust #	9509	Customer	Arrow Tru-Line	Grp/Sz/Grd/Width	TGVC/0.0800/533G40/8.560
Equip/Plant	PWC CPA	Work Order #	CLV 56008	Part No.	DH .0800 X 8.560 HDG
Work Order Information		Material to be Used		Actual	
		Tag #1	66033	Gauge #1	Gauge #2
		PO#		% Gauge In Spec	% Gauge In Spec
Gauge Range	0.0800 - 0.0860	Gauge Min	0.0800 Min	Low/High Gauge	Low/High Gauge
Width Range	8.555 - 8.565	Width	48.0000	Average	Average
Length Range	N/A			Width	Width
Rockwell		Rockwell		Length	Length
Tensile				Rockwell	Rockwell
Yield		Toll Processed			
% Elongation		GVC SS			
Chem Rqmts		GR33 G40			
Other Rqmts		.0800 Min X			
20.00 ID		48.0000"		Other	
49.97 MxOD					
4000 Mx Wgt		1pc 20900lbs	1pc 22010lbs		
Summary					
Actions					
Final Status					

Slit Size Inspection

Date: 5-22-15

Work Order: CLV 5008

Size of Cuts	Beginning		(Paxson Only)	End	
	Width	Mics	Middle Mics	Width	Mics
8.560	8.558	.081	.081	8.558	.081
8.125	8.123			8.123	
"	8.127			8.127	
7.875	7.876	.082	.082	7.876	.082
"	7.873			7.873	
7.125	7.126	.080	.080	7.126	.081
8.560	8.568	.082	.082	8.568	.082
8.125	8.123			8.123	
"	8.127			8.127	
7.875	7.876	.082	.083	7.876	.083
"	7.873			7.873	
7.125	7.126	.081	.081	7.126	.081

DO ANY CUTS HAVE:

Rust/Stain NO

Burrs OK

Knife Marks OK

Initials

ROS

Slitting Order

Date:	Customer: <u>ARROW</u>
Work Order #: <u>CLV 86006</u>	Date Run: <u>5-22-15</u>

Incoming Inspection Checklist

Tag #	Gauge & Width	Type	Tag Wgt.	RB	Olsen	Actual Wgt.	Width	Mic
66033	080 x 48"	G-12	22,900	NA	NA	22,900	48 1/16	082
66046	"	"	22,010	NA	NA	22,010	48 1/16	082

Cutting Instructions: 1 cut 3.580
2 cuts 3.105
3 cuts 2.875
1 cut 2.125

Slit Tolerance: <u>± .005</u>	Max O.D.: <u>STR T42U</u>	Max Skid Wgt: <u>5000</u>	I.D.: <u>20</u>
Gauge Range: <u>080-086</u>	Salesman:		

Special Instructions:

1 Cuts with some defect but okay to ship

NA Cut Size
NA Cut Weight
NA Defect
NA Approved By

2 Cuts Rejected

NA Cut Size
NA Cut Weight
NA Tag No. or No.'s
NA Reason for Reject

3 Ok to move material for shipment or to Stock

(Y) Name
5/27/15 Date