

Subject: Cleveland Process Audit

Date: May 07, 2015

Completed By: Steve Busicnki

On May 07, 2015, work order CLV 55871 was ran on the CLO for American Roll Form. Tag 20124 was verified prior to loading and use of the coil. The operator measured the master coil width with a tape measure and measured the gauge with a micrometer on both edges and the crown prior to being slit. Once fed through the slitter, the width of each cut was measured with calipers. The material thickness was measured again at the end of the coil using a micrometer at both edges and the crown. I did not witness camber being checked or the widths being measured at the end of the job. Based on the gauge report, 100.0% of the material was within specification with an average thickness of 0.0614".

Part Spec/PO Audit Form

Cust #	1514	Customer		American Roll Form		Grp/Sz/Grd/Width	EGC / 0.0590 / CS801Z / 4.673
Equip/Plant	PWC CLO	Work Order #	CLV 55871	Date	5/7/2015	Part No.	EGC - CQ - .058 - 4.673
Work Order Information		Material to be Used		Actual			
		Tag #1	20124	Tag #2		Gauge #1	Gauge #2
		PO#	21725-001	PO#		% Gauge In Spec	% Gauge In Spec
Gauge Range	0.0580 - 0.0630	Gauge Min	.0590 Min	Gauge Min		Low/High Gauge	Low/High Gauge
Width Range	4.668 - 4.678	Width	40.3750"	Width		Average	Average
Length Range	N/A					Width	Width
Rockwell		Rockwell		Rockwell		Length	Length
Tensile						Rockwell	Rockwell
Yield		A879 Electro				Gauge (End)	.059 / .060
% Elongation		Galv Coil				Width (End)	4.677,4.676,4.676,4.677,4.676
Chem Rqmts		CSB Flash					
Other Rqmts		Coat 01Z					
Camb 0 - .25		.0590 Min X				Other	
		40.3750"					
Summary							
Actions							
Final Status							

Slit Size Inspection

Date: May 7, 2015

Work Order: 01455871

Size of Cuts	Beginning Width	Mics	(Paxson Only) Middle Mics	End Width	Mics
4.673	4.677		L.25	4.677	
	4.674			4.674	
	4.674			4.674	
	4.677		L.25	4.677	
	4.674	.000		4.674	.059
3.170	3.174	.000		3.174	.000
	3.174		L.25	3.174	
	3.173			3.173	
	3.174			3.174	
	3.174		L.25	3.174	

DO ANY CUTS HAVE:

Rust/Stain

Burrs

Knife Marks

OK

Initials

J.P.

Jemison Metals -- 60 Inch Loopco Slitter

Customer Name: AM ROLL Heat Number: DUFNLK1469902

Average Thickness and Tolerance Data

Length	2214 ft	Above High Limit	0.0630 in	0 ft (0.0%)
Width	40.500 in	In Tolerance		2214 in (100.0%)
Weight	18768 lbs	Below Low Limit	0.0590 in	0 ft (0.0%)

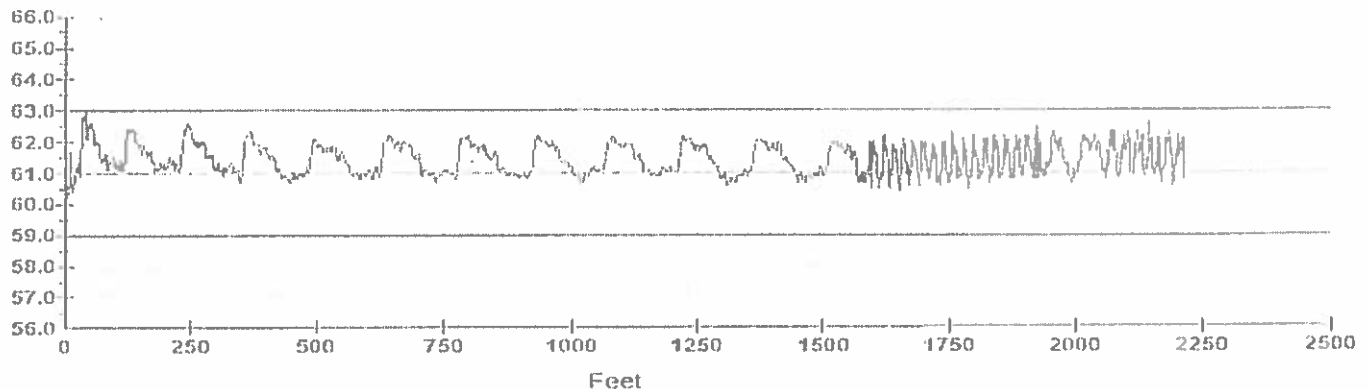
Statistical Process Control Data

Lower Control Limit	0.0600 in	Lower Tolerance Limit	0.0590 in
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CPK	1.114	(Capability vs Limits)	TMW Ratio	0.960 (Low Limit/Avg)
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+0.0000	0.0%
+0.0100	0.0%
+0.0090	0.0%
+0.0080	0.0%
+0.0070	0.0%
+0.0060	0.0%
+0.0050	0.0%
+0.0040	0.0%
+0.0030	0.0%
+0.0020	0.0%
+0.0010	10.1%
-0.0060	65.0%
-0.0010	18.0%
-0.0020	0.0%
-0.0030	0.0%
-0.0040	0.0%
-0.0050	0.0%
-0.0060	0.0%
-0.0070	0.0%
-0.0080	0.0%
-0.0090	0.0%
-0.0100	0.0%
---	0.0%

100.0% is within ± 0.0100 in of the target 100.0% is within ± 0.0200 in of the target



Slitting Order

Date: 5-7-15	Customer: Am Roll
Work Order #: CL/55871	Date Run: May 7, 2015

Incoming Inspection Checklist

Tag #	Gauge & Width	Type	Tag Wgt.	RB	Olsen	Actual Wgt.	Width	Mic
20124	.059 x 40.315	EGE	18,840	NA		18,840	40 9/16	CLC
								Del

Cutting Instructions: 5 cuts 4.613 5 cuts 3.170

Slit Tolerance: $\pm .005$	Max O.D:	Max Skid Wgt: 5,000	I.D: 20"
Gauge Range: .059 / .063	Salesman:		

Special Instructions:

1 Cuts with some defect but okay to ship

_____ Cut Size
 _____ Cut Weight
 _____ Defect
 _____ Approved By

2 Cuts Rejected

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

3 Ok to move material for shipment or to Stock

_____ Name
 _____ Date