

Part Spec Audit 06/15/15 BB1

TBEI

W1448593

FINDINGS:

Run of material was without incidence.

Spec called out JD3 packaging which are skids but the notes said width runners. Width runners are correct as this material is going to laser and they cannot easily unload from skids. Skid packaging spec likely pulled from FG part number when it was copied to create WIP.

Spec also had no flatness spec on it. As this material will be run on the Plasma/Laser the line should be given something from which to gauge a go or no go.

For each of the above issues I emailed Mark Clough (Material Manager) as he creates WIP part specs. He has added a flatness specification of .250" MAX and corrected the packing spec to JD8.

Part Spec/PO Audit Form

Cust #	474	Customer	TRF-E	Grp/Sz/Gnd/Width	HRS 10 73 2 224
Equip/Plant	4181	Work Order #	46512	Part No.	W14218593
		Date	6/15/15		
Work Order Information		Material to be Used		Actual	
		Tag #1	47467	Tag #2	
		PO#	640-10291	PO#	
Gauge Range	.1245 - .1445	Gauge Min	.1235	Gauge Min	
Width Range	73 - 74.25	Width	73.00	Width	
Length Range	214 - 224.5			Average	
Rockwell		Rockwell		Length	
Tensile	58-80	Yield	51.3	Rockwell	
Yield	36.00	Tensile	64.8		
% Elongation	23	Elongation	31		
Chem Rqmts					
Other Rqmts				Other	
Summary	100 was fine				
Actions	email to mark to update part spec packaging and to advise to addition of flatness spec				
Final Status					

+ Spec calls out "width runners" but has SD 3 (skid) in packaging
 - called Mark Clough to change

+ this goes to plasma but there is no flatness spec
 (note the bushing on this order also has no flatness spec)
 - will email Clough, Phil, & Foster and is going to Kase

+ width gauge is NOT working again - Jason out