

Subject: Cleveland Process Audit

Date: June 26, 2015

Completed By: Steve Busicnki

On June 26, 2015, work order CLV 56440 was ran on the CPA Paxson for Arrow Tru-Line. Tag 66445 was verified prior to loading and use of the coil. The operator recorded the measurements taken during the production process on the Slit Size Inspection sheet. Towards the end of the coil, it was noticed that three of the finished coils displayed defects along the edges. The 5.735" cut had what appeared to be indentations along the edge. Two of the 4.562" cuts had a burred edge. Sales was contacted about the three cuts and they approved the three cuts for shipment to the customer.

Part Spec/PO Audit Form

Cust #	9509	Customer	Arrow Tru-Line	Grp/Sz/Grd/Width	TGVC / 0.0970 / S33G40 / 5.735
Equip/Plant	PWC CLO	Work Order #	CLV 56440	Part No.	22 .0970 X 5.735 HDG
			Date	6/26/2015	
Work Order Information		Material to be Used		Actual	
		Tag #1	66445	Gauge #1	Gauge #2
		PO#		% Gauge In Spec	% Gauge In Spec
Gauge Range	0.0970 - 0.1030	Gauge Min	.0970 Min	Low/High Gauge	Low/High Gauge
Width Range	5.7300 - 5.7400	Width	46.1870"	Average	Average
Length Range	Coil			Width	Width
Rockwell		Rockwell	Rockwell	Length	Length
Tensile				Coil	Rockwell
Yield		Toll Processed		Middle Mic	
% Elongation		GVC SS GR33		End Mic	
Chem Rqmts		G40 .0970 Min			
Other Rqmts		X 46.1870"			
				Other	
Summary					
Actions					
Final Status					

Slitting Order

Date: 06/26/15	Customer: ARROW
Work Order #: 01156440	Date Run: 06/26/15

Incoming Inspection Checklist

Tag #	Gauge & Width	Type	Tag Wgt.	RB	Olsen	Actual Wgt.	Width	Mic
06445	.097m x 46/87	SL	44870	N/A	N/A	44870	46 1/4	0.001/0.001

Cutting Instructions:

1 cut 5.735
3 cuts 4.562
5 cuts 4.156
3 cuts 3.834

Slit Tolerance: + .005	Max O.D: Split Half	Max Skid Wgt: 5.0m L max	I.D: 2
Gauge Range: 017/103	Salesman: Matthew S 39.70		

Special Instructions:

1 Cuts with some defect but okay to ship

5.735 - 4.562 - 4.156 - 2.834 Cut Size

44120 Cut Weight

Edge damage Defect

Q.M. STEVE + SALES Bill H. 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

(4) Ant Name
6/29/15 Date

Slit Size Inspection

Date: 06/26/15 Work Order: CLV 56440

Size of Cuts	Beginning Width	Beginning Mics	(Paxson Only) Middle Mics	End Width	End Mics
5735	5.731	099	100	5734	099
4562	4.564			4.565	
	4.568			4.562	
	4.565			4.563	
2834	2.837	099	100	2835	098
	2.833			2834	
4156	4.159			4.158	
	4.156			4.157	
	4.159			4.155	
	4.156			4.158	
	4.158	100	100	4.157	099

15 1/4

DO ANY CUTS HAVE:

Rust/Stain NO
 Burrs OK
 Knife Marks OK

Initials

E.N.