Subject: Cleveland Process Audit

Date: June 05, 2015

Completed By: Steve Busicnki

On June 05, 2015, work order CLV 56199 was ran on the CPA Paxson for Arrow Tru-Line. The master coil was slit to the appropriate widths for the customer. Tag 66126 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 at the beginning and checked for overall width and gauge at both edges and the crown. The width of each cut was measured with calipers when the job began. Tag 66127 was also verified prior to loading and use of the coil. A piece was cut at the beginning of the second coil and checked for overall width and gauge at both edges and the crown. Gauge was checked again at the end of the second coil.

Upon review of the completed order, it was noticed that three of the gauge readings were higher than the specified gauge range of 0.0690 - 0.0720. The inside sales rep was made aware of the higher gauge readings. As this is the customer's material, we would not make a claim to the mill for material that is out of gauge.

Part Spec/PO Audit Form

Cust #	6056	Customer	Arrow Tru-Line			Grp/Sz/Grd/Wdth	Grp/Sz/Grd/Wdth TGVC / .0690 / S33G40 / 2.825	7 2.825	
Equip/Plant	PWC CLO	Work Order #	CLV 56199	Date	6/5/2015	Part No.	H3.0690 X 2.825 HDG		
Work	Work Order Information	The second second	Material to	o be Used	Section and the second section is a second section of the sectio		Actual	nal	
		Tag #1	66126	Tag #2	66127	Gauge #1	1,070/.071/.071	Gauge #2	.071/.073/.072
		PO#		PO#		% Gauge In Spec		% Gauge In Spec	
Gauge Range	0.0690 - 0.0720	Gauge Min	.0690 Min	Gauge Min	0690 Min	Low/High Gauge	.070/.073	Low/High Gauge	.071/.074
Width Range	2.820 - 2.830	Width	48.0000"	Width	48.0000"	Average	0.071	Average	0.072
Length Range	Length Range 0.0000 - 0.0000					Width	2.827/2.826	Width	2.827/2.826
Rockwell		Rockwell		Rockwell		Length		Length	
Tensile						Rockwell		Rockwell	
Yield		Toll Processed		Toll Processed	_		.072/.073/.072		.071/.074/.072
% Elongation		GVC SS GR33		GVC SS GR33			2.827/2.826		2.827/2.826
Chem Ramts		G40		G40					
Other Ramts		.0690 Min		.0690 Min					
20.0" ID		X 48.0000"		X 48.0000"		Other			
79.75" MaxOD		1pcs 20760lbs		1pcs 20780lbs					
3750 MxWgt									
Summary					•				
Artions									
Final Status									

20F2 Slit Size Inspection

Date:	6-8-15		Work Order:	CLV 56199	
Size of Cuts		nning Mics	(Paxson Only Middle Mics	•	End Mics
5,290	5.093 6.392	-07	മാ	5.243 5.040	- 57 i
	5,713			5.243	,
	5-295			5-સ્ક	
	6,295 2,827	- 973	୍ଟମର	5,295	. 074
2.825	2827 2886			2-527 2-526	
5 149	5.191 5.192			5.191	
Vl.	6/42 6/42	. 072	872	2-135 6143	07,3
5,040	8293 5292	. (37)	070	6-293 6-293	. 970
	5,293			5.293	
	5,293			5.293	
	6,296	. 072	_ 071	5295	_ 07
2.825	2877 8.826			2,8.27 3,8,36	
5,190				5,190	
VI	5,191 5,192 5,192	150	071	ର । ଏମ ଜିମ୍ବର	.070

DO ANY CUTS HAVE:	Rust/Stain	NO	
	Burrs	Ou	
	Knife Marks	OVL	

Initials

າວະ ງ Slit Size Inspection

Date:	6-5-15		Work Order: CLV	56199	
Size of Cuts	Begi Width	nning Mics	(Paxson Only) Middle Mics		End Mics
5,240	5,293	979	<i>,</i> 5 70	5-243	× 072
1	5,29,2			5,242	=
	5,243			5.293	
	୍ଟେମ୍ବର			5,293	
	<i>ର</i> ଥିକ୍ତ	.07/	- 072	S.সুণ্	.073
2.825	2527			2827	
M	2826			2.826	
6.K10	5,191			6.191	
i	5,192			6,192	
	6.192	.071	.071	6.40	072
	1			· · · · · · · · · · · · · · · · · · ·	
DO ANY CUTS H	AVE:	Rust/Stain	NO		
		Burrs	Oic		
		Valle Marke	Ola		

Initials

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SI	itt.	ing	O r	der

	<u></u>		Simile	3 Oruci					
Date:				Customer	ARRI	DIW	entre :		
Work Order #: CLV SG 194				Date Run: 6-5-15					
		Inco	ming Inspe	ection Ch	ecklist				
Tag #	Gauge & Width	Туре	Tag Wgt.	RB	Olsen	Actual Wgt.	Width	Mic	
66126	069 × 418"	GVC	20,760	NA	NA-	29,760	48k	.070	
66127	1		20,780	NA	NA	D, 780	48/2	നാ	
66154			23,600	NA	MA	83,600	48/2	977	
			į						
Cutting In		5,290 5,190 2,905	W						
Slit Tolerance:	- 006 -	Max O.D:	THEU	Max Skid \		5660	I.D:		
Gauge Range: ව(4-972			Salesman:		/			
Special Ir	structions:								
1 Cuts with some defect but okay to ship							_Cut Size		
					1:1	1	_Cut Weight		
					_///	A	Defect		
					7 0 7		_Approved E	Зу	
2	Cuts Rejected						Cut Size		
_					- / /	? _	- Cut Weight		
				,	AlV	1	Tag No. or I	No.'s	
					/3		Reason for		
				•	()	14	-		
3	Ok to move mater	ial for shipm	ent or to Stoc	k /	11	Ant,	Name		
				(6/8/15	Date		