

**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 #	9509	Customer	Arrow Tru-Line	Grp/Sz/Grd/Width	TGVC / .0690 / S33G40 / 2.825
Equip/Plant	PWC CLO	Work Order #	CLV 56199	Part No.	H3 .0690 X 2.825 HDG
		Date	6/5/2015		
Work Order Information		Material to be Used		Actual	
		Tag #1	66126	Gauge #1	Gauge #2
		PO#	66127	% Gauge In Spec	% Gauge In Spec
Gauge Range	0.0690 - 0.0720	Gauge Min	.0690 Min	Low/High Gauge	Low/High Gauge
Width Range	2.820 - 2.830	Width	48.0000"	Average	Average
Length Range	0.0000 - 0.0000			Width	Width
Rockwell		Rockwell	Rockwell	Length	Length
Tensile				Rockwell	Rockwell
Yield		Toll Processed			
% Elongation		GVC SS GR33	Toll Processed	.072/.073/.072	.071/.074/.072
Chem Rqmts		G40	GVC SS GR33	2.827/2.826	2.827/2.826
Other Rqmts		.0690 Min	G40		
20.0" ID		X 48.0000"	.0690 Min	Other	
79.75" MaxOD		1pcs 20760lbs	X 48.0000"		
3750 MxWgt			1pcs 20780lbs		
Summary					
Actions					
Final Status					

2 of 2  
Slit Size Inspection

Date: 6-8-15

Work Order: CLV 56199

Size of Cuts	Beginning		(Paxson Only) Middle Mics	End	
	Width	Mics		Width	Mics
5.240	5.293 5.292	.071	.071	5.293 5.292	.071
	5.293			5.293	
	5.294			5.293	
	5.295	.073	.072	5.295	.071
2.825	2.827 2.826			2.827 2.826	
5.190	5.191			5.191	
✓	5.192 5.192	.072	.072	5.192 5.192	.072
5.240	5.293 5.292	.071	.070	5.293 5.292	.070
	5.293			5.293	
	5.293			5.293	
	5.295	.072	.071	5.295	.071
2.825	2.827 2.826			2.827 2.826	
5.190	5.191			5.191	
✓	5.192 5.192	.071	.071	5.192 5.192	.070

DO ANY CUTS HAVE:

Rust/Stain NO  
 Burrs OK  
 Knife Marks OK

Initials

RS

10F 2

## Slit Size Inspection

Date:

6-5-15

Work Order:

CLV 56194

Size of Cuts	Beginning Width	Beginning Mics	(Paxson Only) Middle Mics	End Width	End Mics
5.290	5.293	070	070	5.293	072
	5.292			5.292	
	5.293			5.293	
	5.293			5.293	
	5.295	071	072	5.295	073
2.825	2.827			2.827	
"	2.826			2.826	
5.190	5.191			5.191	
	5.192			5.192	
	5.192	071	071	5.192	072

DO ANY CUTS HAVE:

Rust/Stain

NO

Burrs

OK

Knife Marks

OK

Initials

RCS

