

Subject: Cleveland Process Audit

Date: July 16, 2015

Completed By: Steve Busicnki

On July 16, 2015, work order SMT 57381 was ran on the CLO for Ohio Stamping. Tag NI47285 was verified prior to loading and use of the coil. The width of the material was measured with a measuring tape after it was fed through the arbors and trimmed. The operator stated that he measured the gauge of the material with a micrometer at the beginning of the coil. The operator measured the thickness of the material again at the end of the coil with a micrometer. Based on the gauge report, 99.7% of the material was within specification with an average thickness of 0.0303".

Part Spec/PO Audit Form

Cust #	2990	Customer	Ohio Stamping	Grp/Sz/Grd/Width	GVC / 0.0296 / DD30CD / 30.5000
Equip/Plant	PWC CLO	Work Order #	SMT 57381	Part No.	9000444177
		Date	7/16/2015		
Work Order Information		Material to be Used		Actual	
		Tag #1	NI47285	Gauge #1	Gauge #2
		PO#	17165-001	% Gauge In Spec	% Gauge In Spec
Gauge Range	0.0296 - 0.0336	Gauge Min	.0296 Min	Low/High Gauge	Low/High Gauge
Width Range	30.5000 - 30.5200	Width	31.0000"	Average	Average
Length Range	Coil			Width	Width
Rockwell		Rockwell	Rockwell	Length	Length
Tensile				Coil	Rockwell
Yield		A653 Galvanized			
% Elongation		Coil DDS-A30			
Chem Rqmts		CT Dry			
Other Rqmts					
24" ID		1pcs 22,250lbs		Other	
40" MnOD					
72" MxOD					
Summary	No Pads				
Actions					
Final Status					

Slitting Order

Date: 7/16/15	Customer: Ohio Shrapnel
Work Order #: 57381	Date Run: 7/16/2015

Incoming Inspection Checklist

Tag #	Gauge & Width	Type	Tag Wgt.	RB	Olsen	Actual Wgt.	Width	Mic
N147235	0.094 x 31.000	CWC	0.2, 250	—	—	0.2, 250	31 3/16	0.015
								0.030

Cutting Instructions: 1 cut 30.500

Slit Tolerance: 4.000-0	Max O.D: St. Thred	Max Skid Wgt:	I.D: 24"
Gauge Range: 0.094.6 / 0.033.40	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

(Y) _____ Name
 7/16/15 _____ Date

Slit Size Inspection

Date: _____

July 10, 2015

Work Order:

SMIT-5738

[illegible]

DO ANY CUTS HAVE:

Rust/Stain

Burrs

Knife Marks

Initials

59.

AGT400 Coil Summary Report

Jemison Metals -- 60 Inch Loopco Slitter

Work Order: SMT 57381 Coil Number: NI47285

Customer Name: OHIO STAMPING Heat Number: M R03946

Product: G30 Galvanized Jul-16-15 5:49 AM to 6:06 AM (clock 16.3 min/ run 13.5 min) Shift: 1

Average Thickness and Tolerance Data

Target 0.0310 in Average^ 0.0303 in Average - Target -0.0013 in (-4.24%)
Standard Deviation^ 0.0004 in (1.14%)

Length 6873 ft Above High Limit 0.0336 in 0 ft (0.0%)
Width 31.125 in In Tolerance 6850 ft (99.7%)
Weight 22061 lbs Below Low Limit 0.0296 in 23 ft (0.3%)

Max Thickness 0.0315 in at 1 ft Min Thickness 0.0295 in at 33 ft
Head Scrap 7 ft Tail Scrap 25 ft

Statistical Process Control Data

Upper Control Limit 0.0313 in Upper Tolerance Limit 0.0336 in
X Double Bar 0.0303 in R Bar 0.0011 in
Lower Control Limit 0.0292 in Lower Tolerance Limit 0.0296 in

CR 54.0% (Capability Ratio %, 100/CP)
CP 1.852 (Process Capability, HiLim-LoLim/6*Sigma)
CPK 0.611 (Capability vs Limits) TMW Ratio 0.978 (Low Limit/Avg)

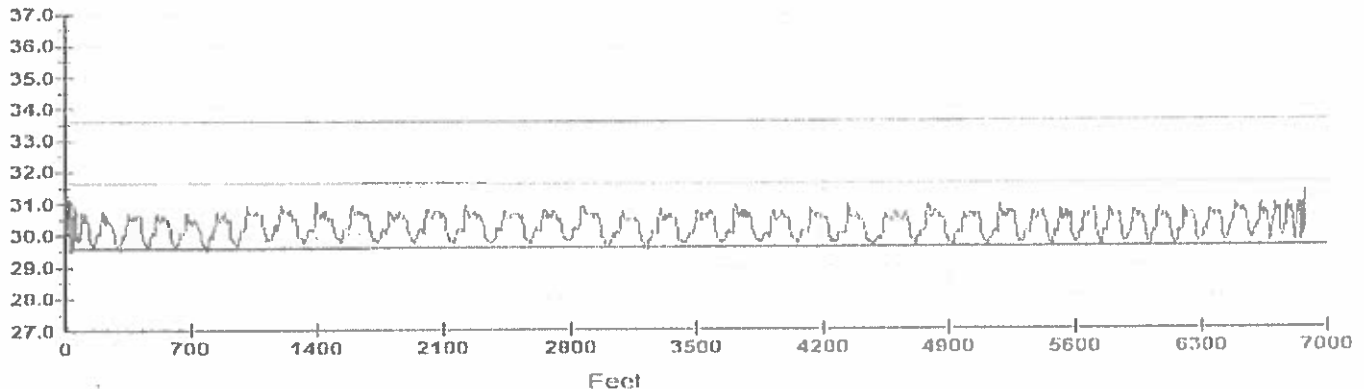
Thickness Distribution Relative to the Target

+++	0.0%
+0.0050	0.0%
+0.0045	0.0%
+0.0040	0.0%
+0.0035	0.0%
+0.0030	0.0%
+0.0025	0.0%
+0.0020	0.0%
+0.0015	0.0%
+0.0010	0.0%
+0.0005	0.0%
+0.0000	0.0%
-0.0005	0.1%
-0.0010	28.8%
-0.0015	34.7%
-0.0020	34.3%
-0.0025	0.3%
-0.0030	0.0%
-0.0035	0.0%
-0.0040	0.0%
-0.0045	0.0%
-0.0050	0.0%
---	0.0%

0 3 6 9 12 15 18 21 24 27 30 33 %

28.7% is within ± 0.0010 in of the target 100.0% is within ± 0.0025 in of the target
100.0% is within ± 0.0050 in of the target 100.0% is within ± 0.0100 in of the target

Thickness vs Length (Coil Number NI47285)



Gauge readings provided by Advanced Gauging Technologies, L.L.C. Plain City, OH 43064 USA Tel:(614) 873-6691