

Subject: Cleveland Process Audit

Date: July 31, 2015

Completed By: Steve Busicnki

On July 31, 2015, work order CLV 56832 was ran on the CPA Paxson for Arrow Tru-Line. Tag 66837 was verified prior to loading and use of the coil. The operator measured the overall width of the material and measured the gauge at both edges and the crown with a micrometer. The width of each cut was measured when fed through. The gauge of the material was measured again at the end of the coil along with the width of each cut.

Tag 66843 was then verified prior to loading and use of the coil. The operator measured the overall width of the material and measured the gauge at both edges and the crown with a micrometer. The width of each cut was measured when fed through. The operator stated that he measured the gauge at the end of the coil and measured the widths of each cut with calipers.

Part Spec/PO Audit Form

Cust #	9509	Customer	Arrow Tru-Line	Grp/Sz/Grd/Width	TGVC / 0.0800 / S33 G40 / 7.625
Equip/Plant	PWC CLO Paxson	Work Order #	CLV 56832	Part No.	62 .0800 X 7.625
		Date	7/31/2015		
Work Order Information		Material to be Used		Actual	
		Tag #1	66837	Gauge #1	Gauge #2
		PO#		% Gauge In Spec	% Gauge In Spec
Gauge Range	0.0800 - 0.0860	Gauge Min	0.0800	Low/High Gauge	Low/High Gauge
Width Range	7.6200 - 7.6300	Width	48.0000"	Average	Average
Length Range	Coil			Width	Width
Rockwell		Rockwell	Rockwell	Length	Length
Tensile				Rockwell	Rockwell
Yield		Toll Processed	Toll Processed		
% Elongation		GVC SS GR33	GVC SSGR33		
Chem Rqmts		G40	G40		
Other Rqmts		.0800 Min X	.0800 Min X		
		48.0000"	48.0000"	Other	
		1pcs 21,710lbs	1pcs 20,340lbs		
Summary					
Actions					
Final Status					

Slitting Order

Date: 07/31/15	Customer: ARROW
Work Order #: CLV56832	Date Run:

Incoming Inspection Checklist

Tag #	Gauge & Width	Type	Tag Wgt.	RB	Olsen	Actual Wgt.	Width	Mic
66837	080max 48" wide	SLC	21710	NA	NA		48 1/2	08/084
66843	1 / 1	1	20540	1	1		48 1/2	08/083

Cutting Instructions:

1 cut 9000
1 cut 8560
2 cuts 8135
1 cut 7625
1 cut 6250

Slit Tolerance: +/- .005	Max O.D: ST Thru	Max Skid Wgt: 5000 max	I.D: 20
Gauge Range: 080/086	Salesman: Maxwell S 3720		

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

_____ Name
 _____ Date

Slit Size Inspection

Date: 07/31/15 Work Order: 041156832

Size of Cuts	Beginning		(Paxson Only) Middle Mics	End	
	Width	Mics		Width	Mics
9.080	9.053	081	083	9.001	083
8.560	8.564			8.560	
8.125	8.125			8.125	
8.125	8.125			8.125	
7.625	7.625			7.625	
6.250	6.250	082	083	6.250	081
9.000	9.001	081	083	9.001	082
8.560	8.563			8.563	
8.125	8.125			8.125	
8.125	8.125			8.112	
7.625	7.625			7.626	
6.250	6.250	081	083	6.250	081

DO ANY CUTS HAVE:

Rust/Stain _____
 Burrs _____
 Knife Marks _____

Initials

EW