

Subject: Cleveland Process Audit

Date: September 25, 2015

Completed By: Steve Busicnki

On September 25, 2015, work order CLV 57488 was ran on the CPA Paxson for Arrow Tru-Line. Tag 67434 was verified prior to loading and use of the coil. The operator measured the overall width of the material with a tape measure and measured gauged at the both edges and the crown with a micrometer. The width of each cut was measured with calipers when the material was first fed through the arbors. The gauge was measured again at the end of the coil using a micrometer. All micrometer readings verified material to be within specification.

Part Spec/PO Audit Form

Cust #	9509	Customer	Arrow Tru-Line			Grp/Sz/Grd/Wdth	TGVC / 0.0800 / S33G40 / 2.2500		
Equip/Plant	Paxson	Work Order #	CLV 57488	Date	9/25/2015	Part No.	GY .0800 X 2.250 HDG		
Work Order Information		Material to be Used				Actual			
		Tag #1	67434	Tag #2		Gauge #1	.081 / .083	Gauge #2	
		PO#		PO#		% Gauge In Spec	100%	% Gauge In Spec	
Gauge Range	0.0800 - 0.0920	Gauge Min	.0800 Min	Gauge Min		Low/High Gauge	.081 / .083	Low/High Gauge	
Width Range	2.245 - 2.255	Width	48.0000"	Width		Average	0.082	Average	
Length Range	Coil					Width	2.2480	Width	
Rockwell		Rockwell		Rockwell		Length	Coil	Length	
Tensile						Rockwell		Rockwell	
Yield		Toll Processed							
% Elongation		GVC SS GR33							
Chem Rqmts		G40							
Other Rqmts		.0800 Min X							
		48.0000"				Other			
		1pcs 21,130lbs							
Summary									
Actions									
Final Status									

Slit Size Inspection

Date: 9-25-15

Work Order: CLV 57488

Size of Cuts	Beginning Width	Beginning Mics	(Paxson Only) Middle Mics	End Width	End Mics
8.375	8.374	.081	.081	8.374	.081
7.300	7.303			7.303	
"	7.302			7.302	
2.250	2.248	.083	.083	2.248	.083
7.375	7.377			7.377	
"	7.376			7.376	
7.625	7.625	.081	.081	7.625	.081

DO ANY CUTS HAVE:

Rust/Stain NO

Burrs OK

Knife Marks OK

Initials

RS

Slitting Order

Date:	Customer:
Work Order #:	Date Run:
CLV 57488	ARROW 9-25-15

Incoming Inspection Checklist

[illegible]

Cutting Instructions: 1cut 8.375 1cut 2.250
1cut 7.625
2cuts 7.375
2cuts 7.300

Slit Tolerance: $\pm .005$	Max O.D: STR THRU	Max Skid Wgt: 5000	I.D: 20
Gauge Range: 080-092		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

Name

Date