

Subject: Cleveland Process Audit

Date: September 4, 2015

Completed By: Steve Busicnki

On September 4, 2015, work order CLV 57287 was ran on the CLO for Arrow Tru-Line. Tag 67030 was verified prior to loading and use of the coil. The operator stated that he measured the gauge along with the width of each cut when the job began. The measurements were recorded on the Slit Size Inspection sheet. The coil was split at the customers requested point. The material thickness was measured with a micrometer at the beginning of the second set of coils. The material thickness was measured again at the end of the second set of coils. The width of each cut was also measured at the end of the second set. Based on the gauge report, 100.0% of the material was within specification for the customer.

Part Spec/PO Audit Form

Cust #	9509	Customer	Arrow Tru-Line	Grp/Sz/Grd/Width	TGVC / 0.0510 / 550G40 / 7.9690
Equip/Plant	PWC CLO	Work Order #	CLV 57287	Part No.	HM. 0510 X 7.969 WL
			Date	9/4/2015	
Work Order Information		Material to be Used		Actual	
		Tag #1	67030	Gauge #1	.0515,.052,.0525
		PO#		% Gauge In Spec	100.00%
Gauge Range	0.0510 - 0.0560	Gauge Min	0.0510	Low/High Gauge	0.0507/0.0546
Width Range	7.964 - 7.974	Width	48.1560"	Average	0.0526
Length Range	Coil			Width	7.971,7.972
Rockwell		Rockwell		Length	Length
Tensile				Rockwell	Rockwell
Yield		Toll Processed			
% Elongation		GVC SS			
Chem Rqmts		GR50 G40			
Other Rqmts		.0510 Min X			
		48.1560"		Other	
		1pcs 41,880lbs			
Summary					
Actions					
Final Status					

Slitting Order

Date: 9.4.2015	Customer: ARROW
Work Order #: 2LV 57287	Date Run: 9.4.2015

Incoming Inspection Checklist

Tag #	Gauge & Width	Type	Tag Wgt.	RB	Olsen	Actual Wgt.	Width	Mic
67030	.051 / 48.156	TGVC	41,880	—		41,880	48.3/8	.0515 / .052

Cutting Instructions:

60 CUTS 7.969

Slit Tolerance: + - .005	Max O.D: SPLIT IN HALF	Max Skid Wgt: 5000	I.D: 20
Gauge Range: .051 / .056	Salesman:		

Special Instructions:

1 Cuts with some defect but okay to ship

Cut Size
 Cut Weight
 Defect
 Approved By

N/A

2 Cuts Rejected

Cut Size
 Cut Weight
 Tag No. or No.'s
 Reason for Reject

N/A

3 Ok to move material for shipment or to Stock

Deming - Remag
 9-4-15
 Name
 Date

Slit Size Inspection

Date: 9.4.2015

Work Order: CLV 57287

Size of Cuts	Beginning Width	Mics	(Paxson Only) Middle Mics	End Width	Mics
7.969	7.971			7.971	
	7.971	.0515		7.971	.052
	7.971			7.971	
	7.972	.052		7.972	.0525
	7.971			7.971	
	7.972			7.972	

DO ANY CUTS HAVE:

Rust/Stain N/A
 Burrs N/A
 Knife Marks N/A

Initials

T. D.

AGT400 Coil Summary Report

Jemison Metals -- 60 Inch Loopco Slitter

Work Order: CLV 57287 Coil Number: 67030

Customer Name: ARROW Heat Number: METR04177

Product: G30 Galvanized Sep-4-15 12:42 PM to 1:09 PM (clock 26.9 min/ run 14.2 min) Shift: 1

Average Thickness and Tolerance Data

Target 0.0535 in Average 0.0526 in Average - Target -0.0009 in (-1.72%)
Standard Deviation 0.0006 in (1.14%)

Length 4877 ft Above High Limit 0.0560 in 0 ft (0.0%)
Width 48.156 in In Tolerance 48.16 ft (100.0%)
Weight 42086 lbs Below Low Limit 0.0510 in 2 ft (0.0%)

Max Thickness 0.0546 in at 26 ft Min Thickness 0.0507 in at 0 ft
Head Scrap 0 ft Tail Scrap 0 ft

Statistical Process Control Data

Upper Control Limit 0.0544 in Upper Tolerance Limit 0.0560 in
X Double Bar 0.0526 in R Bar 0.0018 in
Lower Control Limit 0.0508 in Lower Tolerance Limit 0.0510 in

CR 73.2% (Capability Ratio %, 100/CP)

CP 1.366 (Process Capability, HiLim-LoLim/6*Sigma)

CPK 0.863 (Capability vs Limits) TMW Ratio 0.970 (Low Limit/Avg)

Thickness Distribution Relative to the Target



99.5% is within ± 0.0020 in of the target 100.0% is within ± 0.0050 in of the target
100.0% is within ± 0.0100 in of the target 100.0% is within ± 0.0200 in of the target

Thickness vs Length (Coil Number 67030)

