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Tag Training	This Document expires one day after printing Last Printed: October 4, 2015	

Date	*Description Of Change*	*Signature*	*Rev. Level*
06/22/14	*Initial Release*	*Joseph Ravitsky*	*A*

Procedure Approval: **Company Title:** Quality Manager **Date:** 6/25/15

1. Scope

This details how to fill out to properly read and understand a tag and its uses.

2. Documents

2.1 Equipment Forms Model (excel)

2.2 MTR model (excel)

3. Tag Example

TAG #
3583

CHEMICAL COMPOSTION	
Heat Number	4215010904
Alloy	C71500
Arsenic	0
Nickel (+Cobalt)	29.826
Manganese	0.659
Copper (+Silver)	REM
Iron	0.633
Carbon	0
Lead	0
Sulphur	0
Zinc	0.012
Phosphurus	0
Copper + specified limits	not less than 99.5%

BUNDLE INFORMATION			
START OD	0.75	FINAL OD	0.625
START WALL	0.0530	FINAL WALL	0.049
START LENGTH	192	FINAL LENGTH	240
CUSTOMER	Thermofin		
PO#	44255		
SO#	5010		
Starting QTY	91	Final QTY	

Incoming Weight, Lbs.	653
Outgoing Weight, Lbs.	

Inventory Weight		NCMR Weight	
Yield			

4. Tag Elements

a. *Tag Number* – The tag number is the identifier of this group of tubing in the plant and out of the plant. This tag number is a unique number that is generated sequentially as the next lot number in the process.

b. *Heat Number* – the heat number is the melt provided by the supplier. This heat number is directly connected to the actual melt at the time of casting. This is the most important number and references an exact chemical composition. Ameritube does not permit mixing of material from different heats and uses this tag and tag# to control the heat throughout the process.

c. *Chemical Composition* – The chemical composition is listed below the alloy to ensure that anyone can check the tag and alloy and make sure the chemical composition of the alloy is correct and in line with the alloys specification. This tag is on the back of the traveler in the job packet at all times effectively identifying not just the material and heat number, but the actual chemical composition of the material connected to this group of material.

d. *Bundle Information* – The bundle information includes the starting and final sizes, the customer, purchase order number, and sales order number. This information serves to provide a start and end point for the bundle, effectively the beginning of process and its projected goal. This information is also used to calculate the expected return on material staged into the process.

e. *Incoming Weight, Outgoing Weight, Inventory, NCMR, Yield* - This information allows Ameritube to track the effectiveness of the process. By keeping track of how much material was put into the process and the subsequent compliant and non compliant material, Ameritube can analyze the process and make improvements. Since Ameritube has a stated goal of yield in its quality objectives, this serves to bring that quality objective into each and every bundle's processing.