

AIAG CQI-29 Special Process: Brazing System Assessment						
Company Name: Franklin Brazing and Metal Treating			Current Status	YELLOW	Job Audit Summary	
Street Address: 2025 McKinley Blvd			Brazing System % Compliance	94.17%	CAB Furnace Overall	88%
Country/City/State/ZIP Code: United States / Lebanon/ Ohio / 45036					CAB Furnace CTQ	0 RED CTQ Items
Site Code:			Job Audit % Compliance	88.10%	Vacuum Furnace Overall	Not Completed
Parent Code:					Vacuum Furnace CTQ	0 RED CTQ Items
Current Quality Certification(s): AS9100 and IATF 16949			Overall Total of BSA and Job Audits	92.59%	Flame Overall	Not Completed
Date of This Assessment: December 16, 2021					Flame CTQ	0 RED CTQ Items
Date of Initial Assessment: December 16, 2021					Induction Overall	Not Completed
Date of Re-Assessment (if necessary):					Induction CTQ	0 RED CTQ Items
Number of Brazing Employees at this Facility: 32					CTQ= Critical to Quality	Higher is Better
Captive Brazing Organization (Y/N): No						
Review Members	Title	Email Address	Phone			
Madonna Kohnen	Vice President of Operations and Quality	Madonna.Kohnen@franklinbrazing.com	513.459.7782 ext. 122			
Leydi Walle	Manufacturing Engineer	Leydi.Walle@franklinbrazing.com	513.459.7782 ext. 121			
Chris Flowers	Maintenance and Safety Technician	Chris.Flowers@franklinbrazing.com	513.459.7782 ext. 103			
Chris Middleton	Quality Engineer and Heat Treat Spec.	Chris.Middleton@franklinbrazing.com	513.459.7782 ext. 107			
Site Responsible Person	Title	Email Address	Phone			
Leydi Walle	Manufacturing Engineer	Leydi.Walle@franklinbrazing.com	513.459.7782 ext. 121			
Chris Middleton	Quality Engineer	Chris.Middleton@franklinbrazing.com	513.459.7782 ext. 107			
Supplier Contacts	Title	Email Address	Phone			
Braze Classifications: Customer Specific		Ship To Locations	Tier Level	Contact Name	Contact eMail	
Braze Processes Used: Continuous Furnace						
Braze Specifications Used: AWS 3.6						
Commodity: Chassis						
Part Number(s) Assessed:	Vehicle / Program	Product Information	Overall Summary Comments:			
LEGEND						
Red	Any CTQ RED Element Any BSA RED Element ≥67% Yellow Items on BSA or Job Audit	Does NOT meet the requirements, needs immediate action. Process review indicates that there is a risk of non-conforming product.				
Yellow	<90% GREEN -0- RED	Does NOT meet the requirements, containment is in place. Process review indicates that there is sufficient containment of non-conforming product.				
Green	≥90% GREEN	Meets all requirements				

SUMMARY of RESPONSES						
Brazing System Assessment	Section	% Compliance of Rated Elements	RED	YELLOW	GREEN	Possible Elements
Section 1	Brazing System Process Assessment (SPS Assessment)	100.00%	0	0	7	7
Section 2	Documentation	95.24%	0	1	20	21
Section 3	Preplanning / Quality Documentation	100.00%	0	0	18	19
Section 4	Production Process Monitoring / Documentation	100.00%	0	0	25	26
Section 5	Fixture and Tooling	100.00%	0	0	4	4
Section 6	Rework or Scrap Procedures and Reports	80.00%	0	1	4	5
Section 7	Process and Test Equipment Requirements	80.00%	0	1	4	5
Section 8	Thermal Management	40.00%	0	3	2	5
Section 9	Process Control	96.67%	0	1	29	33
% of Items Completed	155.84%	Section 1-9 Total	94.17%	0	7	113
BRAZING JOB PROCESSES						
BRAZING JOB PROCESSES	Section	% Compliance of Rated Elements	RED	YELLOW	GREEN	Possible Elements
CAB Furnace Overall	1. PART PRINT	80.00%	0	1	4	5
88.10%	2. CONTROL PLAN	92.86%	0	1	13	14
CAB Furnace Critical to Quality	3. BRAZE QUALITY INSPECTION & REPORTS	77.78%	0	2	7	9
0 RED CTQ Items	4. PARAMETER DOCUMENTATION	66.67%	0	1	2	3
% of Items Completed	5. MAINTENANCE RECORDS	100.00%	0	0	5	5
100.00%	6. SUSTAINABILITY	100.00%	0	0	2	2
	7. PROCESS MONITORING	100.00%	0	0	1	1
	8. FIXTURING AND TOOLING	100.00%	0	0	3	3
Vacuum Furnace Overall	1. PART PRINT	Not Completed	0	0	0	5
Not Completed	2. CONTROL PLAN	Not Completed	0	0	0	14
Vacuum Furnace Critical to Quality	3. BRAZE QUALITY INSPECTION & REPORTS	Not Completed	0	0	0	9
0 RED CTQ Items	4. PARAMETER DOCUMENTATION	Not Completed	0	0	0	3
% of Items Completed	5. MAINTENANCE RECORDS	Not Completed	0	0	0	5
0.00%	6. SUSTAINABILITY	Not Completed	0	0	0	2
	7. PROCESS MONITORING	Not Completed	0	0	0	1
	8. FIXTURING AND TOOLING	Not Completed	0	0	0	3
Flame Overall	1. PART PRINT	Not Completed	0	0	0	5
Not Completed	2. CONTROL PLAN	Not Completed	0	0	0	14
Flame Critical to Quality	3. BRAZE QUALITY INSPECTION & REPORTS	Not Completed	0	0	0	9
0 RED CTQ Items	4. PARAMETER DOCUMENTATION	Not Completed	0	0	0	3
% of Items Completed	5. MAINTENANCE RECORDS	Not Completed	0	0	0	5
0.00%	6. SUSTAINABILITY	Not Completed	0	0	0	2
	7. PROCESS MONITORING	Not Completed	0	0	0	1
	8. FIXTURING AND TOOLING	Not Completed	0	0	0	3
Induction Overall	1. PART PRINT	Not Completed	0	0	0	5
Not Completed	2. CONTROL PLAN	Not Completed	0	0	0	14
Induction to Quality	3. BRAZE QUALITY INSPECTION & REPORTS	Not Completed	0	0	0	9
0 RED CTQ Items	4. PARAMETER DOCUMENTATION	Not Completed	0	0	0	3
% of Items Completed	5. MAINTENANCE RECORDS	Not Completed	0	0	0	5
0.00%	6. SUSTAINABILITY	Not Completed	0	0	0	2
	7. PROCESS MONITORING	Not Completed	0	0	0	1
	8. FIXTURING AND TOOLING	Not Completed	0	0	0	3
Job Audit Total		88.10%	0	5	37	
Overall Total		92.59%	0	12	150	