AIAG CQI-29 Special Process: Brazing System Assessment

Company Name:	**Franklin Brazing and Metal Treating**			**Current Status**	**GREEN**	**Job Audit Summary**	
Street Address:	2025 McKinley Blvd					**CAB Furnace Overall**	**93%**
Country/City/State/ZIP Code:	United States / Lebanon/ Ohio / 45036			Brazing System % Compliance	**95.83%**	**CAB Furnace CTQ**	0 RED CTQ Items
Site Code:						**Vacuum Furnace Overall**	**Not Completed**
Parent Code:				Job Audit % Compliance	**92.86%**	**Vacuum Furnace CTQ**	0 RED CTQ Items
Current Quality Certification(s):	AS9100 and IATF 16949					**Flame Overall**	**Not Completed**
Date of This Assessment:	October 25, 2024			Overall Total of BSA and Job Audits	**95.06%**	**Flame CTQ**	0 RED CTQ Items
Date of Initial Assessment:	September 9, 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
Stacy Kreklau	Operations Manager	Stacy.kreklau@franklinbrazing.com	513.459.7782 ext. 122
Leydi Walle	Manufacturing Engineer	Leydi.Walle@franklinbrazing.com	513.459.7782 ext. 121
Chris Flowers	Maintenance and Heat Treat Spec.	Chris.Flowers@franklinbrazing.com	513.459.7782 ext. 103

Site Responsible Person	Title	Email Address	Phone
Chet Goodall	Manufacturing Engineer	chet.goodall@franklinbrazing.com	513.459.7782 ext. 121
Leydi Walle	Quality Engineer	Leydi.Walle@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**
Brazing Processes Used:	Continuous Furnace					
Brazing 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		94.44%	0	1	17	19
Section 4	Production Process Monitoring / Documentation		96.00%	0	1	24	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		100.00%	0	0	5	5
Section 9	Process Control		100.00%	0	0	30	33
% of Items Completed	**155.84%**	**Section 1-9 Total**	**95.83%**	0	5	115	

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
92.86%	2. CONTROL PLAN	92.86%	0	1	13	14
CAB Furnace Critical to Quality	3. BRAZE QUALITY INSPECTION & REPORTS	88.89%	0	1	8	9
0 RED CTQ Items	4. PARAMETER DOCUMENTATION	100.00%	0	0	3	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	**92.86%**	**0**	**3**	**39**	
	Overall Total	**95.06%**	0	8	154	