

PRODUCTION PROGRESS /PLAN FOR ETERNA DIE CUT 2 6/15/22

PRODUCTION PROGRESS										UPPLINK PRODUCTION as of June 15,2022 - Day4/6/8	
Machine	#	Job Order #	Item Code	Item Description	Plan	Panel A	Panel B	Out-Part	Reject	Status	Remarks
DIE CUT #1											
	1	45-057361	516228800	LOUVRE 2 MIX KCB FOR ETTO CC350 (80)	3000	950	950	950	0	NO DONE	FOR CONTINUATION IN FOLLOWING
	2	45-057362	516228800	LOUVRE 2 MIX KCB FOR ETTO CC350 (80)	3000	950	950	950	0	NO DONE	FOR CONTINUATION IN FOLLOWING
	3	45-057378	516228800	LOUVRE 2 MIX KCB FOR ETTO CC350 (80)	3000	950	950	950	0	NO DONE	FOR CONTINUATION IN FOLLOWING
	4	45-057379	516228800	LOUVRE 2 MIX KCB FOR ETTO CC350 (80)	3000	950	950	950	0	NO DONE	FOR CONTINUATION IN FOLLOWING
	5	45-057380	516228800	LOUVRE 2 MIX KCB FOR ETTO CC350 (80)	3000	950	950	950	0	NO DONE	FOR CONTINUATION IN FOLLOWING
	6	45-057381	516228800	LOUVRE 2 MIX KCB FOR ETTO CC350 (80)	3000	950	950	950	0	NO DONE	FOR CONTINUATION IN FOLLOWING
	7	45-057382	516228800	LOUVRE 2 MIX KCB FOR ETTO CC350 (80)	3000	950	950	950	0	NO DONE	FOR CONTINUATION IN FOLLOWING
	8	45-057383	516228800	LOUVRE 2 MIX KCB FOR ETTO CC350 (80)	3000	950	950	950	0	NO DONE	FOR CONTINUATION IN FOLLOWING
	9	45-057384	516228800	LOUVRE 2 MIX KCB FOR ETTO CC350 (80)	3000	950	950	950	0	NO DONE	FOR CONTINUATION IN FOLLOWING

INITIAL INVESTIGATION /BACKGROUND

MATERIALS

- > Materials used was sheetboard, with history of susceptibility to bursting
- > Condition of boards is not consistent every running

MACHINE SET UP

- > Normal set up/ adjusted set up was not suitable for the actual condition of the boards
- > Panels were good during die cut process; bursting occurred during folding process in Semi-Auto gluing
- > Adjustment in set up for one running might be with good result but not be effective next running due to the inconsistent condition of boards

JO NO.	ITEM CODE	ITEM DESCRIPTION	PRESSURE USED
17175	516228800	LOUVRE 2 MIX KCB FOR ETTO CC350	1.4
17180	516399000	LOUVRE 2 MIX KCB FOR ETTO CC350	1.4
17217	516399100	LOUVRE 2 MIX KCB FOR ETTO CC350	1.2
17254	516399100	LOUVRE 2 MIX KCB FOR ETTO CC350	1.2
17218	516229900	LOUVRE 2 MIX KCB FOR EUROPE, C	1.2
17220	516230200	LOUVRE 2 MIX KCB FOR EUROPE, WH, C	1.2
17228	516228800	LOUVRE 2 MIX KCB FOR ETTO CC350	1.2

CORRECTIVE ACTION



MACHINE/ TOOLS ADJUSTMENT:

- *Used eperan as an alternative to cushion crease (see picture for reference) to enforce more pressure on the affected part of the panels during die cut process.
- *Used 1.3 pressure (1.4 normal set up).
- *Used new creasing matrix (last adjustment plastic of creasing matrix was removed on the affected part).

RESULTS/ STATUS: as of June 14, 2022

Still with occurrence in Die cut process

#	JO-057291	516399000	LOUVRE 2 MIX KCB	2000	2000	FOR CONTINUATION	500 PCS PANEL B (RECON, DUE TO BURSTING)
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Still with occurrence in Semi Auto gluing process

1 JO 12 pcs out of 700 qty

ACTION PLAN:

To trial sheetboard using Linus PS

Target date: Next week

PIC: Prod, QA and ME team

To propose changing of material used to Single Face .

PRODUCTION PROGRESS										UPPLINK PRODUCTION as of June 15,2022 - Night4/6/8	
Machine	#	Job Order #	Item Code	Item Description	Plan	Panel A	Panel B	Out-Part	Reject	Status	Remarks
DIE CUT #1											
	1	45-057371	516228800	LOUVRE 2 MIX KCB FOR ETTO CC350	3000	950	950	950	0	NO DONE	FOR CONTINUATION IN FOLLOWING
	2	45-057372	516228800	LOUVRE 2 MIX KCB FOR ETTO CC350	3000	950	950	950	0	NO DONE	FOR CONTINUATION IN FOLLOWING
	3	45-057373	516228800	LOUVRE 2 MIX KCB FOR ETTO CC350	3000	950	950	950	0	NO DONE	FOR CONTINUATION IN FOLLOWING
	4	45-057374	516228800	LOUVRE 2 MIX KCB FOR ETTO CC350	3000	950	950	950	0	NO DONE	FOR CONTINUATION IN FOLLOWING
	5	45-057375	516228800	LOUVRE 2 MIX KCB FOR ETTO CC350	3000	950	950	950	0	NO DONE	FOR CONTINUATION IN FOLLOWING
	6	45-057376	516228800	LOUVRE 2 MIX KCB FOR ETTO CC350	3000	950	950	950	0	NO DONE	FOR CONTINUATION IN FOLLOWING
	7	45-057377	516228800	LOUVRE 2 MIX KCB FOR ETTO CC350	3000	950	950	950	0	NO DONE	FOR CONTINUATION IN FOLLOWING