

INVESTIGATION REPORT FOR DELAMINATION OF 516398700, 516228900, 516228200, 515297600, 515821700 LIONEL

DIRECT CAUSE METHOD (MATERIALS)

W1: Delamination occurred on the lower flap.

W2: There was an application of glue on panels but it was weak.

- > Glue Viscosity was 2.5
- > Glue App was 4
- > Glue app and viscosity was in standard



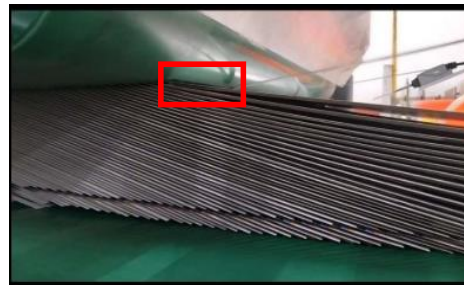
PRODUCTION ACTION PLAN

Immediate Action:

- > Slightly adjust the conveyor and reduce speed depends on items.
- > The affected items were under rework.



BEFORE



AFTER

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PRODUCTION IE

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