

☐ PR
☐ VP

Prepared	Checked	Approved
Signature over Printed Name	Signature over Printed Name	Signature over Printed Name
Date:	Date:	Date:

Note: Approval must be Manager level above

SUPPLIER'S ABNORMAL QUALITY ACTION REPORT

Issuing Section : UP PE

SUPPLIER NAME : KANEPACKAGE PHILS. INC.
 AQN Control No. : PRPE-AQN-22-12-0583
 AQN Received Date : 17-Dec-22
 SAQAR Reply Date : 19-Dec-22

Part Name : CARTON BOX,CD69500_W IN10;PH
 Part Code : 514218600
 Model : SOUFFLE
 Defect Name : OFFSET PRINT





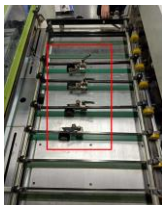


PREVIOUS LOTS CONFIRMATION (At least 3 lots):

IMMEDIATE ACTION (Include Lot Label Markings , Sorting and Rework Result)

LOT QUANTITY: 28
 NG QUANTITY: 0
 REJECTION RATE: 0%

CAUSES AND COUNTERMEASURES

WHY WHY ANALYSIS

SUBJECT (THEME)	WHY 1	WHY 2	WHY 3	WHY 4	WHY 5	JUDGMENT	CORRECTIVE ACTIONS (AVOIDANCE OF RECURRENCE)	PREVENTIVE ACTIONS (STANDARDIZATION)	To be filled up by EPPI: STATUS (During the time of verification)
 Root Cause: <i>(Direct Cause)</i> Offset print occurred on item 514218601 Souffle Carton Box. Attachment: Downtime encountered during diecut running. 	Leakage Cause: <i>(Indirect Cause)</i> QA inspector failed to detect all misaligned cut (offset print) that cause customer flow out. Total Lot Qty Process: 400 pcs. Misaligned cut detected by Inline QA: 7/400pcs. Misaligned cut detected by Inline QA: 9/400pcs. Misaligned cut that was not detected: 1 pc. **[SEE PROCESS MAP ON THE NEXT PAGE]**	Offset print was due to misalignment encountered on the diecut process. Good Condition: L-mark must be completely visible on the edge. (Up/Down and Left/Right)  NG Condition: L-mark was cut. (No visible appearance of L-mark print) 	Misalignment was due to encountered loose belt on the diecut feeder.  L-marking condition was not specified in work instruction as critical checkpoint. (Serve as basis for misaligned cut/print defect.) Note: Work Instruction is general for all model of ICB.	Loose belt encountered as part of machine capability. Work Instruction is not revised or updated upon implementation of L-marking guide. (L-marking is improvement for misaligned cut/print defect detection.)			Direct Cause(s) Call attention of the assigned sub-leaders regarding the issue and conduct orientation for awareness of the diecut operators regarding the issue of misaligned cut. Target Date: Dec. 19, 2022 PIC: Production-IE Status: DONE Request repair of loose feeder belt to Engineering. Target Date: Dec. 12, 2022 PIC: Engineering Status: DONE Assured Lot: Markings:  Indirect Cause(s) Conduct orientation on checking the L marking guide before bundling the item. Target Date: Dec. 19, 2022 PIC: QA-IE Status: DONE 	Direct Cause(s) Conduct preventive maintenance of machine every 6 months. Target Date: Dec. 12, 2022 PIC: Engineering Status: DONE Inclusion of checking the Brush and Rubber Roller/ Belt on the Line Leader Patrolling Checksheet. Frequency: Thrice a week every start of the shift. PIC: Production Line Leader Status: IMPLEMENTED Guaranteed Lot: Markings: Indirect Cause(s) Generate Work Instruction for Souffle Carton Box inspection including checking of L marking guide before bundling the items to eliminate flow out of misaligned cut. Target Date: Jan 7, 2023 PIC: QA-IE Status: Ongoing **Before Improvement and After Improvement: (See on next page)**	

**Note: If parts treatment is FOR DISPOSAL, Disposal records (photos or any proof of disposal) should be attached.

TO BE FILLED BY SUPPLIER:

4M FACTOR (DIRECT CAUSE)	4M FACTOR (INDIRECT CAUSE)
<input type="checkbox"/> Man <input type="checkbox"/> Machine <input type="checkbox"/> Material <input type="checkbox"/> Method	<input type="checkbox"/> Man <input type="checkbox"/> Machine <input type="checkbox"/> Material <input type="checkbox"/> Method
Pls specify :	Pls specify :

TO BE FILLED BY EPPI:

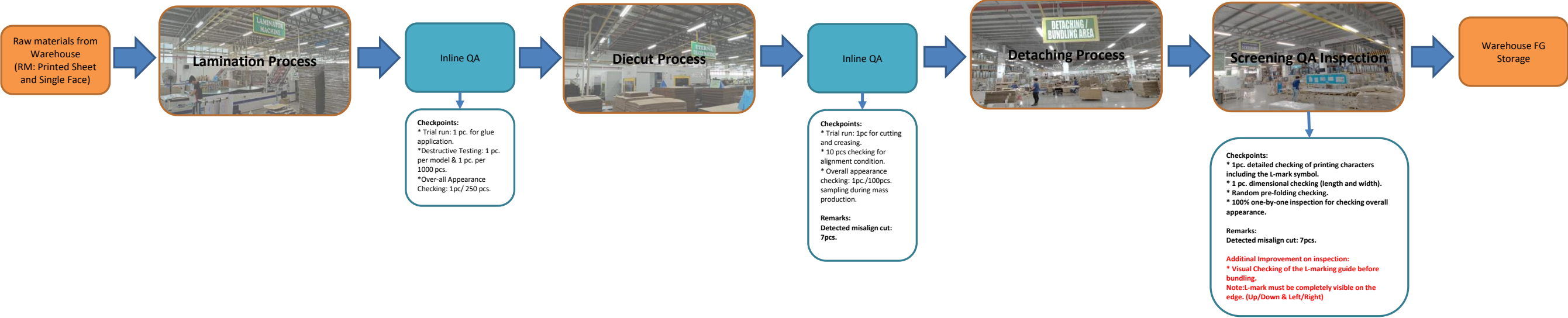
EFFECTIVENESS CHECK OF ACTIONS TAKEN		
VERIFICATION RESULT		
Guaranteed Lot:		Delivery Date:
IQA	INPROCESS	ASSESSMENT RESULT
Result:	Result:	<input type="checkbox"/> SATISFACTORY <input type="checkbox"/> UNSATISFACTORY
Defect Rate:	Defect Rate:	
Judgment	Judgment	
<input type="checkbox"/> Passed <input type="checkbox"/> Failed	<input type="checkbox"/> Passed <input type="checkbox"/> Failed	

Notes:

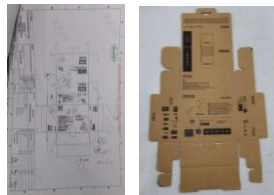
- (1) For Unsatisfactory result, Supplier must re-submit new action report until satisfactory result is attained.
 (2) Provide additional attachments as supporting documents for this report.
 (3) Verification result will depend on the corrective action taken by supplier (assured lot).

Prepared	Checked	Approved
STAFF	SV ABOVE	DEPT. HEAD
Date:	Date:	Date:

PROCESS MAPPING



Before Improvement:



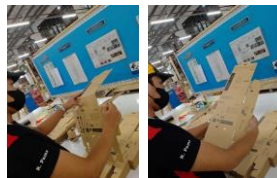
Checking of JO vs. Drawing vs. Actual



1 pc. detailed checking of the printing characters



1 pc. dimension checking (length & width)



Random pre-folding checking



100% one-by-one inspection for checking overall appearance

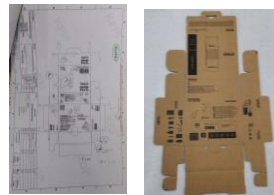


QA counting of 25 pcs per bundle.



QA bundle

After Improvement:



Checking of JO vs. Drawing vs. Actual



1 pc. detailed checking of the printing characters

Note: : L-mark symbol must be check thoroughly. This serve as critical point and guide to detect misaligned cut/ print.



1 pc. dimension checking (length & width)



Random pre-folding checking



100% one-by-one inspection for checking overall appearance



QA counting of 25 pcs per bundle.



Visual Checking of the L-marking guide before bundling. (Up/Down & Left/Right)

Note:L-mark must be completely visible on the edge.



QA bundle

Additional checkpoint during 100% inspection of Screening QA Inspector.

