

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

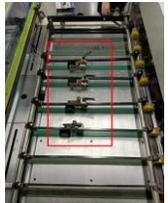
SUPPLIER NAME : KANEPACKAGE PHILS. INC.
 AQN Control No. : PRPE-AQN-22-12-0583
 AQN Received Date : 17-Dec-22
 SAQAR Reply Date : 19-Dec-22

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%
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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: (Direct Cause) Offset print occurred on item 514218601 Souffle Carton Box. Attachment: Downtime encountered during diecut running.  Leakage Cause: (Indirect Cause) 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)**	
STATUS									
PRECONDITIONS									
No changes on QA inspector. (All are qualified inspector)									

**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:

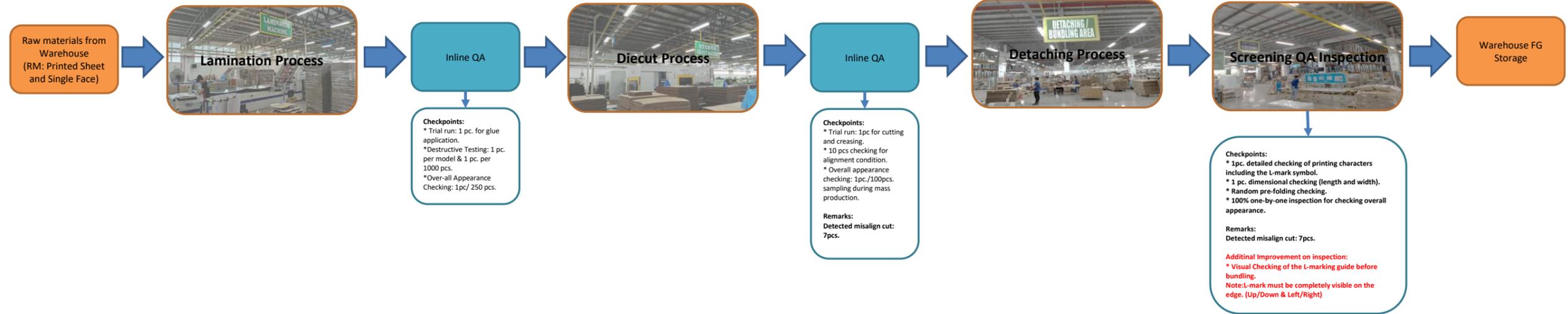
EFFECTIVENESS CHECK OF ACTIONS TAKEN		
VERIFICATION RESULT		
Guaranteed Lot:	Delivery Date:	
IQA	INPROCESS	ASSESSMENT RESULT
Result:	Result:	<input type="checkbox"/> SATISFACTORY <input type="checkbox"/> UNSATISFACTORY
Defect Rate:	Defect Rate:	
Judgment	Judgment	
<input type="checkbox"/> Passed <input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

Notes:

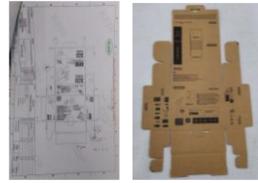
- (1) For Unsatisfactory result, Supplier must re-submit new action report until satisfactory result is attained.
- (2) Provide additional attachments as supporting documents for this report.
- (3) Verification result will depend on the corrective action taken by supplier (assured lot).

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

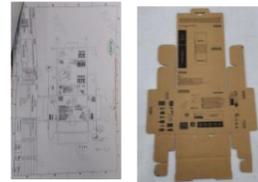


QA counting of 25 pcs per bundle.



QA bundle

After Improvement:



Checking of JO vs. Drawing vs. Actual

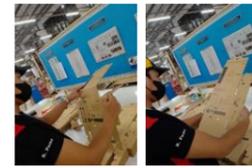


1 pc. detailed checking of the printing characters

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.