

Investigation Report for Ink Stain of EPPI IJP 5162342-00 Dice 2-5 LH Individual Box

CONTROL No:	IRF - 23-11-0104			REJECT PERCENTAGE:	10.00%
REJECT QTY:	80	LOT QTY:	800		

DIRECT CAUSE	W1	The edges of cyrel base for black print touch the anilox then touch the item that caused ink stain.
	W2	The edges of cyrel base lifted during mass production.
	W3	The tape adhesive got weak possible due to cyrel cleaning using water.



LIFTED PORTION OF CYREL BASE FOR BLACK PRINT

INDIRECT CAUSE (OUTFLOW)	W1	Operator didn't notice the ink stain since it is minimal and randomly occurrence.
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PRODUCTION CORRECTIVE ACTION

Orient the operator as awareness regarding this issue.	PIC:	Production Leader	TARGET DATE:	231117
Cleaning, re-adhesion and re-layout of cyrel.	PIC:	Tooling Custodian	TARGET DATE:	231116 (Done)
Ensure the print alignment next running, then after the process tooling custodian apply sealant to the cyrel base so the adhesive does not wet during cyrel cleaning.	PIC:	Tooling Custodian	TARGET DATE:	Next Running (No open schedule)

PREPARED BY:

GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

WEENA V. APALLA
ASST. MANAGER



CYREL ALREADY CLEAN, RE-ADHESION & RE-LAYOUT