

Investigation Report for Misalign print of Kowa Emori HP33D1057-1 Carton Box

CONTROL No:	IRF - 720			REJECT PERCENTAGE:	1.03%
REJECT QTY:	31	LOT QTY:	3000		

DIRECT CAUSE	W1	There's a factor that the caused of misalign print is the blunt rubber roller of Eqos since the board of this item is B-flute with 679x797mm dimension.
	W2	The blunt rubber roller has a significant effect on feeding timing of materials specially if warp.
	W3	The delay feeding of materials may caused of misalign print.

PRODUCTION CORRECTIVE ACTION

Gather Eqos data regarding the usage of vacuum for the different material and warp condition then set standard vacuum power for different materials good or warp condition, because it will help in timing of materials feeding even if the rubber roller is blunt.	PIC:	Production IE	TARGET DATE:	240119
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INITIAL GATHERED DATA

SHIFT	MATERIAL SIZE	FLUTE	VACUUM AREA	VACUUM PERCENTAGE	MATERIAL CONDITION
PEDS	596X1398	CB	1,2	60%	GOOD
PEDS	507X1318	C	1,2	60%	GOOD
PEDS	1022X1132	CB	1,2	70%	GOOD
PEDS	420X1347	CB	1,2	65%	GOOD
PEDS	619X1932	CB	1,2	60%	GOOD
PEDS	688X1398	CB	1,2	60%	GOOD
DOMENG	612X1598	C	1,2,3	60%	GOOD
DOMENG	635X2000	C	1,2,3	60%	GOOD
DOMENG	703X2038	C	1,2,3	60%	GOOD
DOMENG	795X2192	CB	1,2,3	65%	GOOD
DOMENG	458X1852	CB	1,2,3	60%	GOOD
DOMENG	515X1645	C	1,2,3	65%	WARP
DOMENG	500X1512	CB	1,2,3	65%	GOOD
DOMENG	765X1494	EB	1,2	75%	GOOD
DOMENG	588X1622	CB	1,2,3	66%	GOOD
DOMENG	621X787	CB	1	60%	GOOD
DOMENG	399X1150	C	1,2	60%	GOOD
DOMENG	814X2164	C	1,2	60%	GOOD
DOMENG	495X1794	C	1,2,3	60%	GOOD
DOMENG	1160X1100	B	1,2	68%	WARP
DOMENG	740X800	B	1	68%	WARP
DOMENG	521X1806	C	1,2,3	65%	GOOD
DOMENG	679X797	B	1	59%	GOOD
DOMENG	990X2142	CB	1,2,3,4	70%	GOOD
DOMENG	939X2512	C	1,2,3,4	75%	WARP
DOMENG	366X1128	CB	1,2	80%	GOOD

PREPARED BY:

GERALD DE GUZMAN
PROD SUPERVISOR

APPROVED BY:

WEENA V. APALLA
ASST. MANAGER