Investigation Report for Misalign print of Sanyo Denki 00949344-01 Print Specification

CONTROL No:	IRF - 721			REJECT PERCENTAGE:	3.38%
REJECT QTY:	93	LOT QTY:	2750		

DIRECT CAUSE	W1	There's a factor that the caused of misalign print is the blunt rubber roller since according to sir Suzuki there's a factor that the B-flute is the next affected of misalignment since the difference in thickness to E-flute is only 1mm.
	W2	The blunt rubber roller has a significant effect on feeding timing of materials.
	W3	The delay feeding of materials due to blunt rubber roller may caused misalign print.

INDIRECT CAUSE (OUTFLOW)	W1	According to Eqos operator during sampling they encountered random of print movement but within the tolerance of ±3mm and consider as good.
	W2	Eterna operator encounter twice adjustment of sheets due to print movement.

PRODUCTION CORRECTIVE ACTION

As request of sir Suzuki gather Eqos data regarding feeder impression on the affected lot of misalign print, then set temporary standard for B-flute feeder impression by reducing feeder impression accordingly to the gathered data. **Gathered Data:** **Feeder 1 impression: 1.0mm to 0.8mm** **Feeder 2 impression: 1.7mm to 1.6mm** **Temporary Standard:** **Feeder 1 impression: 0.7mm to 0.6mm** **Feeder 2 impression: 1.5mm to 0.8mm** **Note: this counter measure is for monitoring of effectiveness after the implementation.**	**PIC:**	**Production Leader & IE**	**TARGET DATE:**	**240122**
Posting & orientation to operator regarding Eqos Temporary Standard Feeder Impression for B-flute materials specially die-cutted items.	**PIC:**	**Production Leader & IE**	**TARGET DATE:**	**240123**
Replacement of blunt rubber roller of Eqos	**PIC:**	**Top management**	**TARGET DATE:**	**240831**

PREPARED BY:

GERALD DE GUZMAN
PROD SUPERVISOR

APPROVED BY:

WEENA V. APALLA
ASST. MANAGER

REMINDER

FEEDING IMPRESSION FOR BF MATERIAL
ESPECIALLY FOR
DIECUTTED ITEMS SHALL BE :

FEEDER 1 IMPRESSION: 0.7mm to 0.6mm
FEEDER 2 IMPRESSION: 1.5mm to 0.8mm

NOTE: IMMEDIATELY INFORM THE LEADER ONCE ENCOUNTERED PROBLEM IN THE NEWLY IMPLEMENT FEEDER IMPRESSION

240122 — JUDYANN SARMIENTO — PREPARED BY:
GERALD DE GUZMAN — NOTED BY:
240122 — WEENA APALLA — APPROVED BY:

KANEPACKAGE PHILIPPINE, INC.

ATTENDANCE SHEET

Submitted by: G. DE GUZMAN Date: 240122-23

ACTIVITY: ORIENTATION TO EQOS OPERATORS REGARDING TEMPORARY STANDARD FEEDER IMPRESSION FOR BF MATERIAL ESPECIALLY DIECUTTED ITEMS
1ST FEEDER IMPRESSION: 0.7mm to 0.6mm
2ND FEEDER IMPRESSION: 1.5mm to 0.8mm

Attendees

	FIRST NAME	LAST NAME	DIV. / DEPT.	SIGNATURE
1.	Andre Alexis	Otto	EQOS / Prod'n	
2.	MICHAEL	[illegible]	"	
3.	PEDRO	CHAVEZ	"	
4.	Marvin	[illegible]	"	
5.	[illegible]	[illegible]	"	
6.	Elenar	Belardo	"	
7.	David	Banayan	"	
8.	Jessie James	Calva	"	
9.	CARLO	CALVARIO	"	
10.	Rolando	Lorenzo	"	
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Note: This form is confidential. Do not use as scratch paper.

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