

Investigation Report for Misalign Glue of Kowa Emori HP01D2000-3 Carton Box

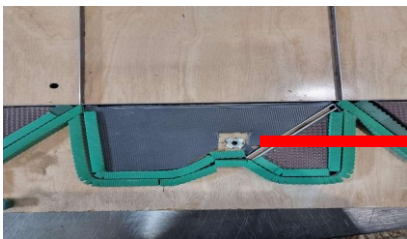
CONTROL No:	IRF - 724			REJECT PERCENTAGE:	3.00%
REJECT QTY:	270	LOT QTY:	9000		

DIRECT CAUSE	W1	No problem in 1st gluing process and during 2nd gluing process the lower flap alignment is uncontrolled upon feeding in Conveyor.
	W2	Upon checking of die-blade there's a portion on lower flap don't have brown sponge to pressed that portion during Eterna process.
	W3	Possible the operator removed the brown sponge because there is a screw nuts on that portion.
	W4	The un-pressed portion is the factor of misalign gluing or cannot fit lock since upon checking of affected only the cavity 1 is affected



PRODUCTION CORRECTIVE ACTION

<p>All the remaining wip for Gluing suggested the 2nd Gluing process on conveyor 1 because it will pressed the items more, compared to SD1800 where the affected run.</p> <p>Note: Before the suggestion we conduct trial in Conveyor 1 and no misalign glue or cannot fit lock occurs.</p>		PIC:	Gerald De Guzman	TARGET DATE:	240122
<p>Put Brown sponge in the affected portion and orient the operator regarding the technique if the screw nuts cover by sponge.</p>		PIC:	Gerald De Guzman	TARGET DATE:	240122



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