

Investigation Report for Poor Print of CBMP RX1-5781 Z10 Carton

CONTROL No:	IRF - 719			REJECT PERCENTAGE:	3.27%
REJECT QTY:	34	LOT QTY:	1040		

DIRECT CAUSE	W1	Laguna Eqos Operator transfer to KP Lima to process Laguna items due to down of Eqos machine.
	W2	Upon transfer, there was no orientation to Laguna operator regarding standard procedure/setup of Eqos Lima, they were immediately endorsed in machine process.
	W3	The two Lima Eqos operator support doing only feeding & materials preparation and Laguna operator stand as main operator.
	W4	Laguna operator setup the machine accordingly to the standard of Laguna Eqos but they incounter difficulty to get the good imprssion since they also encoutered blotted print.
	W5	The factor that caused poor print is the skip on and skip off setup that Laguna operator used since they are not familiar to the standard setup in Eqos Lima.

INDIRECT CAUSE (OUTFLOW)	W1	Operator did not expected the blotted defect since the time to time sampling conducted was approved by QA Patrol that time.
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PRODUCTION PROPOSAL CORRECTIVE ACTION

Request meeting with QA, ME, MPD and KP Lima Head to discuss this problem and set corrective action on this issue.	PIC:	Production	TARGET DATE:	240116 (Done)
<p>The following Corrective Action was approved by all attendees:</p> <p>1. In the event of Laguna Machine Breakdown & items of Laguna will be process in KPLima, KPLaguna and KPLima operators will combine during processes of item; applicable for Eterna & Eqos machine. However, the main operator for the said machines will be operator of KPLima while KPLaguna operators will assist in the process.</p> <p>2. There should be an In-line QA from KPLaguna during processing so as quality will be based on KPLaguna standard.</p> <p>3. Processing of item in KPLima is already combined items of KPLima & KPLaguna based on Planning and not per time allocation.</p>	PIC:	<p>KPLima & KP Laguna Prod Leaders</p> <p>QA Sir Dick</p> <p>KP-Lima & KP-Laguna Planning Staff</p>	TARGET DATE:	240117
Incorporate in Production Machine Operation Process Procedure (PM-PR-002) the generated corrective action	PIC:	Gerald De Guzman	TARGET DATE:	240126

PREPARED BY:

GERALD DE GUZMAN
PROD SUPERVISOR

APPROVED BY:

WEENA V. APALLA
ASST. MANAGER



