

# Investigation Report for Misalign Print of Line Seiki RM-ZRY002C Standard Box

CONTROL No:	IRF - 0001			REJECT PERCENTAGE:	4.05%
REJECT QTY:	81	LOT QTY:	2000		

DIRECT CAUSE	W1	Materials to be used in Eqos has a paper attached, it indicates the different material sheet size because it has a discrepancy up to 5mm from the required dimension of 475x635 BF.
	W2	Operator set-up based on the required dimension of item, also adjustment was made to materials with discrepancy accordingly on what sheet sizes will be declared before printing.
	W3	The printed boards was piled up at the stacker area and didn't separated the materials with discrepancy according to its sheet sizes.
	W4	There is lack of communication, since the Eqos Operator B (Stacker) didn't inform regarding uneven board.
	W5	Since the uneven board didn't separated, the effect during diecut process was a random misalignment

INDIRECT CAUSE (OUTFLOW)	W1	Diecut operators didn't noticed the misalign print since the occurrence are randomly and the sampling required is one piece in every batch only.
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## PRODUCTION ACTION PLAN

CORRECTIVE ACTION	Inclusion in Eqos Job Assignment for Eqos Operator Feeder 1 ( <i>Base on 4-manpower activity</i> ), any important notes attached in the materials issued, he is the person in-charge to relay the information to his colleagues at Eqos.	PIC:	Production Leaders	TARGET DATE:	240628
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