

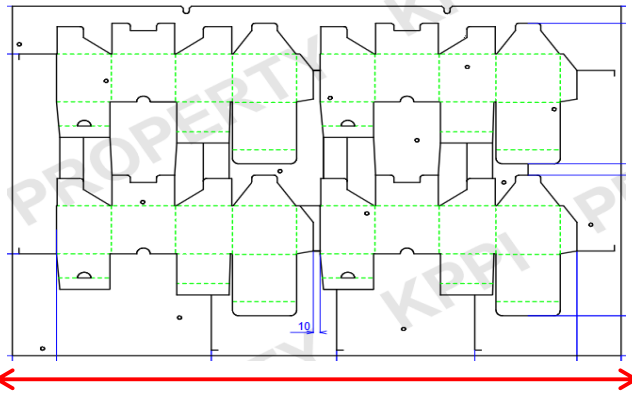
Investigation Report for Misalign Diecut of Superflex PKC404B-B Motor Inner Box

CONTROL No:	IRF - 0003			REJECT PERCENTAGE:	4.38%
REJECT QTY:	175	LOT QTY:	4000		

DIRECT CAUSE	W1	The factor we consider is misalign diecut due to abnormal lateral movement of Eterna die-chase.
	W2	The die-chase moved up to 7mm in the lateral direction (Left & Right) during mass production even though it was locked.
	W3	According to Caledonian the 6pcs die-chase springs on the cylinder are already worn-out that caused die-chase movement even if it is locked.



Evidence of diecut movement in steel plate



The movement of the die-chase corresponds to the reject items



The 5mm movement to left side is within the 7mm movement of the die-chase

PRODUCTION ACTION PLAN

IMMEDIATE ACTION	Temporarily transfer of process in Diecut S1700 while the Eterna die-chase spring didn't replace.	PIC:	Production Leaders & JC	TARGET DATE:	240614
CORRECTIVE ACTION	Replacement of 6pcs die-chase spring.	PIC:	Engineering & Caledonian	TARGET DATE:	240631
CORRECTIVE ACTION	Include the die-chase spring in Engineering Machine History Sheet of Eterna. This is the basis of Engineering for the monitoring of machine parts life span for those parts that only Caledonian can maintenance or check.	PIC:	Engineering	TARGET DATE:	240631

PREPARED BY:

GERALD DE GUZMAN
PROD SUPERVISOR

APPROVED BY:

WEENA V. APALLA
ASST. MANAGER