

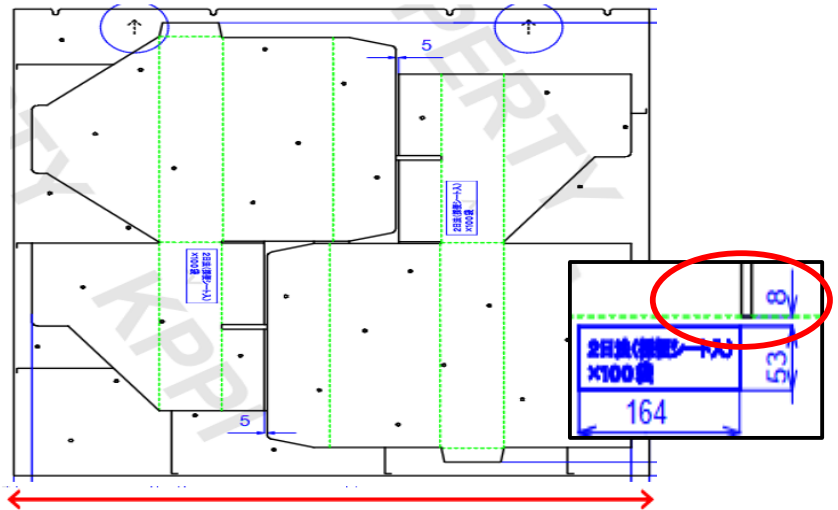
Investigation Report for Misalign Diecut of Arkray 84-05467A Inner Box F821629-1

CONTROL No:	IRF - 0009			REJECT PERCENTAGE:	1.32%
REJECT QTY:	27	LOT QTY:	2050		

DIRECT CAUSE	W1	We also consider misalign print in investigation but no factor found in Eqos since upon checking of CCTV Eqos operator follow on the Standard Height Limit Set in Eqos Feeder.
	W2	The factor that consider contributing random of misalign print is the abnormal lateral movement of Eterna die-chase of almost 7mm due to worn-out die-chase spring.
	W3	The die-chase movement corresponds on the misalignment based on the blade layout and print. Since only 8mm the gap of print to creasing line the movement of die-chase resulted to random misalign diecut.



Eqos operator follow on the Standard Height Limit Set in Eqos Feeder.



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

PRODUCTION ACTION PLAN

CORRECTIVE ACTION	Replacement of 6pcs worn-out die-chase spring.	PIC:	Engineering & Caledonian	TARGET DATE:	240731
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:	240731

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