

Investigation Report for Bursting of Brother D02X6G001 PRN CARTON

CONTROL No:	IRF - 0010			REJECT PERCENTAGE:	4.92%
REJECT QTY:	64	LOT QTY:	1300		

DIRECT CAUSE	W1	Item from S1700 Diecut, then transfer to Eterna due to the improvement of creasing matrix application to avoid extra fold.
	W2	Eterna operator miss out to remove backing tape on the die-blade.
	W3	Based on the initial investigation conducted of QA & ME the caused of Bursting is the backing tape on the creasing blade portion since the item already have creasing matrix.

INDIRECT CAUSE (OUTFLOW)	W1	Eterna operator didn't notice the bursting since its occurs randomly and didn't expect since item already transfer in Eterna last June 21, 2024.
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CUSTOMER	ITEM CODE	ITEM DESCRIPTION	ORDER QTY	DELIVERY DATE	JO #	DATE-OUT ETERNA	ETERNA
BROTHER INDUSTRIES	D02X6G001	PRN CARTON (X3) E110 EU COC	1,750	June 10, 2024	JO24-M-00838-5		
BROTHER INDUSTRIES	D02X6G001	PRN CARTON (X3) E110 EU COC	231	June 19, 2024	JO24-M-00838-5.1		
BROTHER INDUSTRIES	D02X6G001	PRN CARTON (X3) E110 EU COC	500	June 22, 2024	JO24-M-00838-10	21-Jun	500
BROTHER INDUSTRIES	D02X6G001	PRN CARTON (X3) E110 EU COC	970	June 28, 2024	JO24-M-01054-4	01-Jul	384
BROTHER INDUSTRIES	D02X6G001	PRN CARTON (X3) E110 EU COC	522	July 01, 2024	JO-24-IPD-00618-1	01-Jul	530
BROTHER INDUSTRIES	D02X6G001	PRN CARTON (X3) E110 EU COC	240	July 01, 2024	JO24-M-01054-12	01-Jul	240
BROTHER INDUSTRIES	D02X6G001	PRN CARTON (X3) E110 EU COC	720	July 01, 2024	JO24-M-01054-13	01-Jul	737
BROTHER INDUSTRIES	D02X6G001	PRN CARTON (X3) E110 EU COC	1,300	July 10, 2024	JO-24-IPD-00637-2	10-Jul	565
BROTHER INDUSTRIES	D02X6G001	PRN CARTON (X3) E110 EU COC	100	July 11, 2024	JO24-M-01054-9	12-Jul	110
BROTHER INDUSTRIES	D02X6G001	PRN CARTON (X3) E110 EU COC	818	July 17, 2024	JO-24-IPD-00637-2.1		15-Jul

**START OF TRANSFER
IN ETERNA**

AFFECTED LOT

PRODUCTION ACTION PLAN

CORRECTIVE ACTION	Removal of backing tape on the affected die-blade.	PIC:	Tooling Custodian	TARGET DATE:	240713
CORRECTIVE ACTION	Discuss to all production Leaders and tooling custodian that die-blade from Diecut S1700 that subject for transfer to Eterna will apply Request for Tooling Re-layout form for the removal of backing tape before the process.	PIC:	Gerald De Guzman	TARGET DATE:	240719

PREPARED BY:

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APPROVED BY:

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ASST. MANAGER