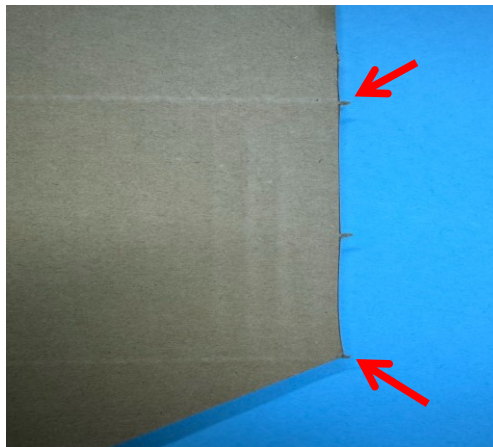


# Investigation Report for Misalign Glue of Arkray 8405467A Inner Box

CONTROL No:	IRF - 0008			REJECT PERCENTAGE:	1.95%
REJECT QTY:	40	LOT QTY:	2050		

DIRECT CAUSE	W1	Item already have existing improvement of putting nick mark in vertical and horizontal portion of glue tab as alignment reference during Gluing process.
	W2	The horizontal nick mark is effective since its visible, but the vertical nick mark is not so visible possible because its along grain direction.
	W3	Based on investigation and interview to manual gluing operator there is difficulty to align the vertical gluing alignment of this item since the design is off set lower flap and the applied vertical nick mark in the glue tab is not visible.



VISIBLE NICK MARK ON HORIZONTAL  
POSITION CROSS GRAIN DIRECTION



VISIBLE NICK MARK ON HORIZONTAL  
POSITION CROSS GRAIN DIRECTION

## PRODUCTION ACTION PLAN

CORRECTIVE ACTION	Since the diecut process of this item is in Eterna, the corrective action is the application of creasing matrix on the glue tab portion for more visible marking reference in gluing alignment.	PIC:	Production leader & Operator	TARGET DATE:	240809
IMMEDIATE ACTION	Attachment of note in the die-blade that inform the leader next running for the improvement of creasing matrix application on the glue tab.	PIC:	Gerald De Guzman	TARGET DATE:	240723

PREPARED BY:

GERALD DE GUZMAN  
PROD SUPERVISOR

APPROVED BY:

WEENA V. APALLA  
ASST. MANAGER

"ATTENTION"

CALL THE ATTENTION OF LEADER  
NEXT RUNNING FOR THE IMPROVEMENT  
OF CREASING MATRIX APPLICATION  
ON THE GLUE TAB DUE TO  
MISALIGN GLUE

GHE...

[illegible]