

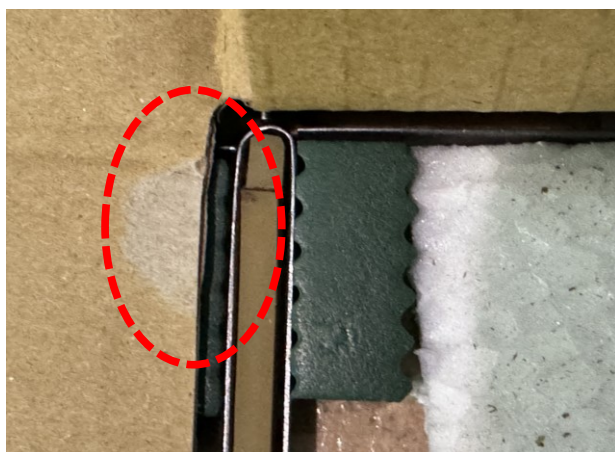
Investigation Report for Peel Off of Kowa Emori HP01D2200C-1 Carton Box

CONTROL No:	IRF - 0011			REJECT PERCENTAGE:	1.69%
REJECT QTY:	76	LOT QTY:	4500		

DIRECT CAUSE	W1	Based on investigation and interview to Eterna operator they notice the peel off in the middle of mass production upon sampling, they conducted sorting and they found out that its occurs randomly.
	W2	Eterna operator inform the leader in-charge and leader in-charge alert the next process SD-1800 to the possible random occurrence of peel off.
	W3	Peel off occurs due to the repeated shot of die-blade that result to compression or breakage of backing tape attached in Eterna pattern .
	W4	The affected portion got uncut kraft liner that resulted to peel off since item underwent auto stripping process.

PRODUCTION ACTION PLAN

IMMEDIATE ACTION	Eterna operator put additional backing tape in the Eterna pattern on the portion of feel off.	PIC:	Eterna Operator	TARGET DATE:	240709
CORRECTIVE ACTION	Since this scenario is uncontrollable our corrective action is to check the die-blade condition	PIC:	Production Leaders & Tooling Custodian	TARGET DATE:	240723



**BASED ON DIE-BLADE
CHECKING THE PORTION OF
FEEL OFF AND DIE-BLADE
AS A WHOLE ARE STILL IN A
GOOD CONDITION**

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