Investigation Report for Bursting of Kowa-Emori HP01D2000-3 Carton Box

CONTROL No:	IRF - 0015			REJECT PERCENTAGE:	1.67%
REJECT QTY:	150	LOT QTY:	9000		

DIRECT CAUSE	W1	Deep impression of creasing blade.
	W2	Discrepancy between ME recommended creasing blade height of 22.8 vs. actual creasing blade of 23.2.
	W3	The 23.2 actual creasing blade have only 0.6mm different from 23.8 cutting blade that resulted of bursting.

STANDARD DIECUT BLADE AND RULE

FOR CORRUGATED

STANDARD BLADE

MATERIAL FLUTE	THICKNESS	COMPRESS MATERIAL THICKNESS	CUTTING HEIGHT	CREASING HEIGHT	CUTTING WITH CREASING		STANDARD PERFORATION		STANDARD HALFCUT
					CUTTING (H)	CREASING	HEIGHT	PITCH (M)	HEIGHT
AB,CB, EB	3PTS.	1.3 mm	23.8 mm	22.6 mm	23.8 mm	22.6 mm	23.8 mm	5X10 mm	23.3 mm
C	3PTS.	1 mm	23.8 mm	22.8 mm	23.8 mm	22.8 mm	23.8 mm	5X5 mm	23.3 mm
B	2PTS.	0.85 mm	23.8 mm	22.8 mm	23.8 mm	22.8 mm	23.8 mm	3X3 mm	23.3 mm
A	3PTS.	1.15 mm	23.8 mm	22.8 mm	23.8 mm	22.8 mm	23.8 mm	5X5 mm	23.3 mm
E	2PTS.	0.7 mm	23.8 mm	22.8 mm	23.8 mm	22.8 mm	23.8 mm	3X3 mm	23.3 mm
CLAYCOAT	2PTS.	--	23.8 mm	23.3 mm	23.8 mm	22.6 mm	23.8 mm	5X10 mm	23.3 mm
KRAFT BOARD	2PTS.	--	23.8 mm	23.3 mm	23.8 mm	22.6 mm	23.8 mm	5X10 mm	23.3 mm

PRODUCTION ACTION PLAN

CORRECTIVE ACTION	Replacement of creasing blade from 23.2 to 22.6 since no available 22.8 creasing blade in tooling.	PIC:	Me & Tooling Custodian	TARGET DATE:	241007
CORRECTIVE ACTION	Effectivity of DT-005-F11 Standard Diecut Blade and Rule for new die-cutted items and existing items subject for die-blade replacement.	PIC:	ME, Design	TARGET DATE:	241104

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