

Investigation Report for Overcut of Superflex PKG-PRO-31-RMFG A585 BOX

CONTROL No:	IRF - 0026			REJECT PERCENTAGE:	25.00%
REJECT QTY:	25	LOT QTY:	100		

DIRECT CAUSE	W1	THE CREASING BLADE PENETRATES THE CORRUGATED BOARDS/LINER
	W2	CREASING BLADE HEIGHT OF 23.3mm VS. CUTTING BLADE 23.8mm (ACTUAL BLADE INSTALLED) IS PRONE TO OVERCUT ISSUES SINCE THE DIFFERENCE IS ONLY 0.5mm.
	W3	BASED ON THE NEWLY SET STANDARD, CUTTING BLADE HEIGHT(23.8mm) MINUS COMPRESS THICKNESS OF CORR. BOARD(1mm) , CREASING BLADE SHOULD BE 22.8mm

NEW 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)	
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

BLADE REQUIREMENTS	
WOOD	1170 X 94
Type	Height
Cutting Blade	23.8
Waved Blade	
Perforation	
Half-Cut	
Creasing Line	23.3

EXISTING/ACTUAL BLADE
INSTALLED

PRODUCTION ACTION PLAN

CORRECTIVE ACTION	CHANGED CREASING BLADE HEIGHT FROM 23.3MM TO 22.8MM.	PIC:	Production Tooling	TARGET DATE:	241220
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