

Investigation Report for Extra Fold of Ina Micro AZ812400 Carton

CONTROL No:	IRF - 0031			REJECT PERCENTAGE:	33.33%
REJECT QTY:	50	LOT QTY:	150		

DIRECT CAUSE	W1	Operator conduct pre-folding (hilot).
	W2	Operator is having difficulty folding along the creasing line.
	W3	Misalignment of creasing line happened that caused close and wide gap.
	W4	EQOS creasing roller hit the grain direction line of the board which is the hardest part.

Customer	Item Code	Material / Sheet	Ink Color / Viscosity	Anilox Impression	Printing Impression	WS					1ST UNIT			2ND UNIT			Creasing Impression		Feeding	
						Flap	Exi Depth	Depth	Ent Depth	Pull Nip	Register	Lateral	Pull Nip	Register	Lateral	Pull Nip	1 Feed Pull Nip			
																	1C	2C	1st Adjust	2nd Adjust
Arkway	AK10250A	CAF	7.0/uc	6.3	4.4	0	6.5	0	6.5	3.3	-2	-2	3.5	0	0	3.4	1.0	1.0	3.4	
Arkway	AK10250B	CAF	7.0/uc	6.3	4.4	0	6.5	0	6.5	3.3	-2	-2	3.5	0	0	3.4	1.0	1.0	3.4	
Spilay	IM000001AB	CP	7.0/uc	6.3	1.4	6	5.5	5	5.5	1.1	-2	-2	1.4	0	0	1.4	0.1	0.1	1.3	
EPSON	S115F3500	CP	7.0/uc	6.3	1.4	4	5.5	5	5.5	1.0	-2	2	1.4	0	0	1.4	0.1	0.1	1.3	

CREASING IMPRESSION
REACHED THE MAXIMUM
OF 0.1MM

PRODUCTION ACTION PLAN

IMMEDIATE ACTION	Generate investigation report regarding this issue	PIC:	Production, QA & ME	TARGET DATE:	241127
CORRECTIVE ACTION	Proposal of die-blade for this item for the improvement of creasing since no improvement can apply in Eqos because the creasing impression already reached the maximum impression of 0.1mm. (to be discuss in sales development meeting)	PIC:	Production Leaders	TARGET DATE:	241202

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