



Prepared:

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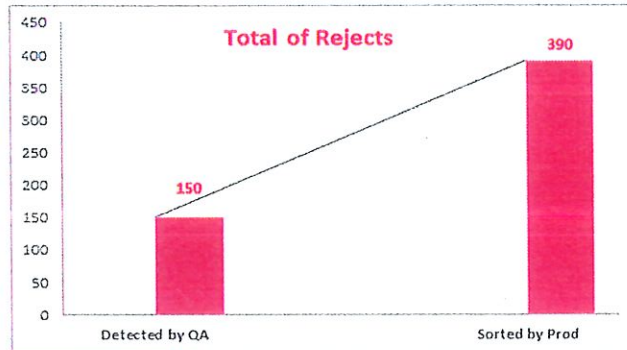
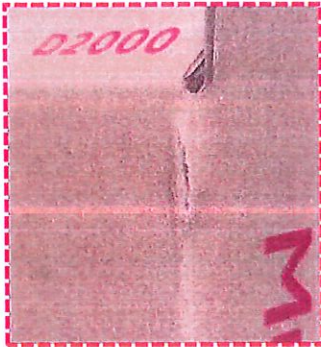
Approved:

Y. Sanhira
President**TECHNICAL REPORT****A. SUBJECT**

HP01D2000-3 Bursting Improvement

B. BACKGROUND

Last October 8, 2024 a total qty of 1,800 pcs, was run at eterna diecut machine upon mass production they encountered random occurrence of **bursting defect**, which led to accumulation of reject with a total of 540 pcs.

**C. OBJECTIVE**

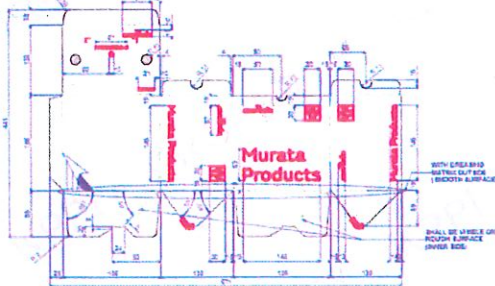
1. To eliminate the occurrence of bursting issues.
2. For productivity and quality improvement.

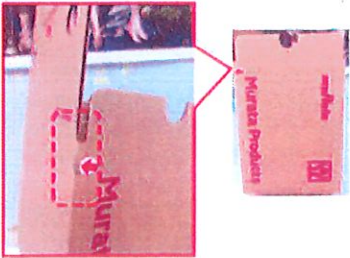
D. ITEM DETAILS

Customer: Kowa Emori

Item Code: HP01D200-3

Item Description: Carton Box

**E. PROBLEM DETAILS**

Customer	KOWA EMORI		<div>NO GOOD</div>  <p>ACTUAL: With bursting up to 10mm REQUIREMENT: Bursting not acceptable (Class A)</p>
Item Description	HP01D2000-3 CARTON BOX		
Job Order Number	J024-M-01612-15		
Lot Quantity	6,000 pcs.		
Rejected Quantity	150 pcs.	48 pcs	
Rejection Rate / PPM	2.2 % / 22,000 PPM		
Detection date	241008	241009	
Occurrence No.	1 st		
Detected by	QA SCREENING		
Status	REJECT (IRF ISSUANCE)		
Rejection Cost	Cost		



TECHNICAL REPORT

F. PROBLEM ANALYSIS

According to the implemented standard of creasing height per flute, the recommended creasing blade height is 22.8mm since the compress B Flute thickness is 0.85 mm, and the supplier does not have 23.3 mm available. Upon checking, the installed creasing blade is 23.20mm, which is only 0.6 mm different from the cutting blade height of 23.80mm as specified in the drawing.

ALL GREEN COLORS IS 3 PTS.

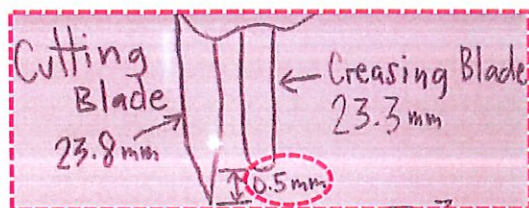
Blade Requirement

Type	Height	Thickness	Pitch
Creasing Line	23.3	3 Pts.	

Creasing height illustration - (Existing)



Actual height illustration - (Existing)



STANDARD DIECUT BLADE AND RULE

FOR CORRUGATED

STANDARD BLADE									
MATERIAL FLUTE	THICKNESS	COMPRESS MATERIAL THICKNESS	CUTTING HEIGHT	CREASING HEIGHT	CUTTING WITH CREA SE	CUTTING WITH CREA SE	STANDARD PERFORATION	STANDARD PERFORATION	STANDARD HALF CUT
AL/CB, EB	0.715	1.3 mm	23.8 mm	22.8 mm	23.8 mm	22.8 mm	23.8 mm	22.8 mm	23.3 mm
C	0.715	1 mm	23.8 mm	22.8 mm	23.8 mm	22.8 mm	23.8 mm	22.8 mm	23.3 mm
B	0.715	0.65 mm	23.8 mm	22.8 mm	23.8 mm	22.8 mm	23.8 mm	22.8 mm	23.3 mm
A	0.715	1.15 mm	23.8 mm	22.8 mm	23.8 mm	22.8 mm	23.8 mm	22.8 mm	23.3 mm
AL/CB, EB	0.715	1.3 mm	23.8 mm	22.8 mm	23.8 mm	22.8 mm	23.8 mm	22.8 mm	23.3 mm
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B	0.715	0.65 mm	23.8 mm	22.8 mm	23.8 mm	22.8 mm	23.8 mm	22.8 mm	23.3 mm
A	0.715	1.15 mm	23.8 mm	22.8 mm	23.8 mm	22.8 mm	23.8 mm	22.8 mm	23.3 mm

G. IMPROVEMENT DETAILS

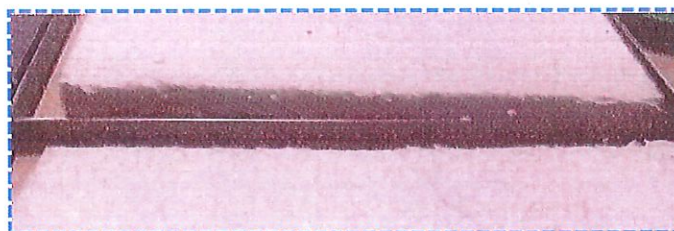
Change of all vertical creasing blade height from 23.20mm to 22.60mm



Work Request



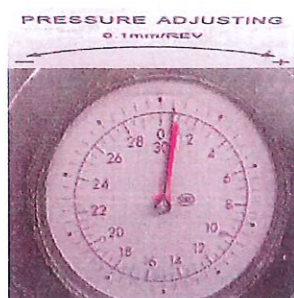
Repair the Creasing blade



Installed temporary creasing blade

Note: Coordinated to the prod leader & tooling custodian, the creasing installed is 22.60mm (3pts) due to the tooling custodian no available 22.80mm (3pts)

H. MACHINE SET UP



Machine Tons : 0.5



Machine Speed : 2390 S/H

I. Result

Using a temporary creasing blade height, the HP01D2000-3 carton box has been improved to produce a satisfactory diecut process with **no occurrence of bursting**, with a quantity of 7,200 pcs.

**J. RECOMMENDATION**

> Revision of drawing to use the standard the creasing blade height - (Ongoing on the side of design dept.)

RECEIVED BY (QA) : _____

REMARKS : _____

RECEIVED BY (PRODUCTION) : _____

REMARKS : _____