

DAILY IN-HOUSE REJECTION REPORT

COVERED DATE: JANUARY 15 & 16, 2025



TODAY'S AGENDA



01

IN-HOUSE REJECTION

DAILY IN-HOUSE REJECTION BREAKDOWN (JAN 15 & JAN 16)

02

PENDING ANSWER

OVER CUT & WORN OUT/DAMAGE

03

STATUS UPDATES

OPEN IRFs & CARs

04

OTHER CONCERNS



DAILY IN-HOUSE REJECTION BREAKDOWN

JANUARY 15

TOTAL OUTPUT QUANTITY

209,829 PCS.

TOTAL REJECT QUANTITY

123 PCS.

TARGET	ACTUAL
0.07%	0.06%
700 PPM	587 PPM
TARGET MET	

JANUARY 16

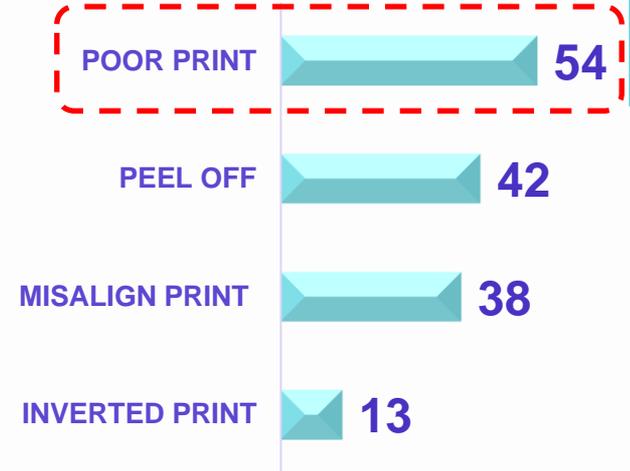
TOTAL OUTPUT QUANTITY

214,856 PCS.

TOTAL REJECT QUANTITY

46 PCS.

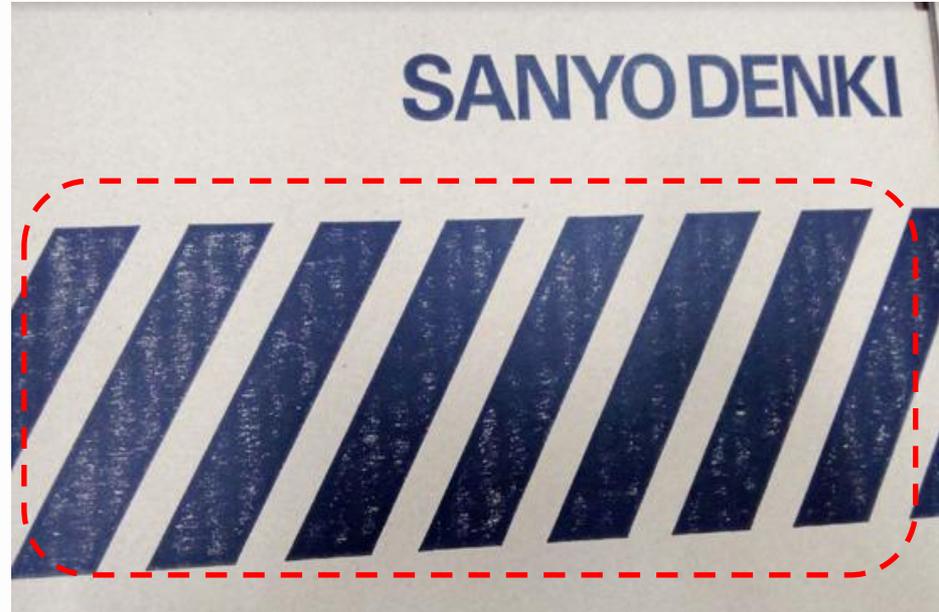
TARGET	ACTUAL
0.07%	0.02%
700 PPM	215 PPM
TARGET MET	



TOP CONTRIBUTOR DETAILS – POOR PRINT

Customer	SANYO DENKI
Item Description	00939007-01 CORRUGATED CARTON
Job Order Number	JO24-M-02368
Lot Quantity	1,700 pcs.
Rejected Quantity	30 pcs.
Rejection Rate / PPM	1.76 % / 17,647 PPM
Detection date	250115
Occurrence No.	1 st
Detected by	QA SCREENING
Status	REJECT (FOR IRF ISSUANCE)
Rejection Cost	PHP 423.30

NO GOOD



ACTUAL: With poor print
REQUIREMENT: No poor print

TOP CONTRIBUTOR DETAILS – POOR PRINT

Customer	SANYO DENKI
Item Description	00902009-01 PACKAGE
Job Order Number	JO24-M-02353-155
Lot Quantity	950 pcs.
Rejected Quantity	17 pcs.
Rejection Rate / PPM	2.95 % / 29,473 PPM
Detection date	250115
Occurrence No.	3 rd (250103, 250107)
Detected by	QA SCREENING
Status	REJECT (IRF #0044)
Rejection Cost	-

NO GOOD



ACTUAL: With poor print
REQUIREMENT: No poor print

TOP CONTRIBUTOR DETAILS – MISALIGN PRINT

Customer	SANYO DENKI
Item Description	00902010-01 PRINT SPECIFICATION
Job Order Number	JO24-M-02353-45
Lot Quantity	700 pcs.
Rejected Quantity	25 pcs.
Rejection Rate / PPM	3.57 % / 35,714 PPM
Detection date	250115
Occurrence No.	1 st
Detected by	QA SCREENING
Status	REJECT (FOR IRF ISSUANCE)
Rejection Cost	PHP 392.84 (6.72 USD)

NO GOOD



ACTUAL: With misalign print

REQUIREMENT: No misalign print



PENDING ANSWERS

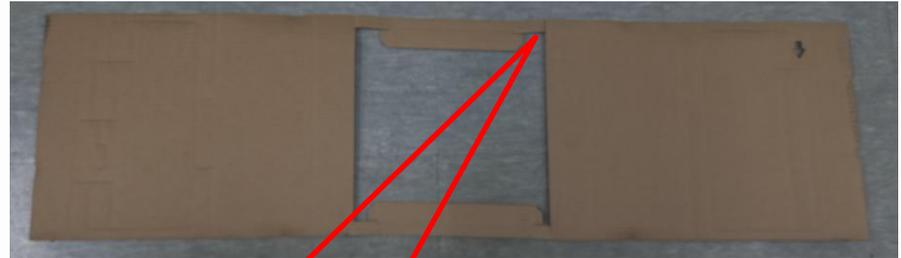
OVER CUT & WORN OUT/DAMAGE

OVERCUT

+

Customer	SUPERFLEX
Item Description	AZ409300 LOWER PAD
Job Order Number	JO-24-IPD-01038-2
Lot Quantity	100 pcs.
Rejected Quantity	65 pcs.
Rejection Rate / PPM	65% / 650,000 PM
Detection date	241107
Occurrence No.	1 st
Detected by	QA SCREENING
Status	REJECT
Rejection Cost	PHP 3,439.32 (59.04 USD)

NO GOOD



ACTUAL: With overcut
REQUIREMENT: No overcut

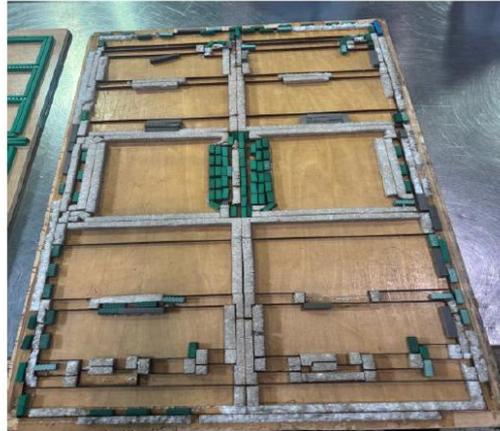


6M REVIEW

FACTORS	DETAILS
MAN	NO PROBLEM ENCOUNTERED
METHOD	NO PROBLEM ENCOUNTERED
MACHINE	EPERAN CUSHION WAS USED AS AN ALTERNATIVE EJECTOR
MATERIAL	NO PROBLEM ENCOUNTERED
MEASUREMENT	NO PROBLEM ENCOUNTERED
ENVIRONMENT	NO PROBLEM ENCOUNTERED

PRD – ROOT CAUSE ANALYSIS & CORRECTIVE ACTION

DIRECT CAUSE (PROCESS / MATERIAL)	WHY 1	Deep impression of Blade.
	WHY 2	Eperan cushion was used as an alternative ejector.
	WHY 3	Way back 2005, eperan cushion was a kaizen as substitute ejector from green sponge due to global crisis (dieblade was fabricated last 2005 but slow moving)



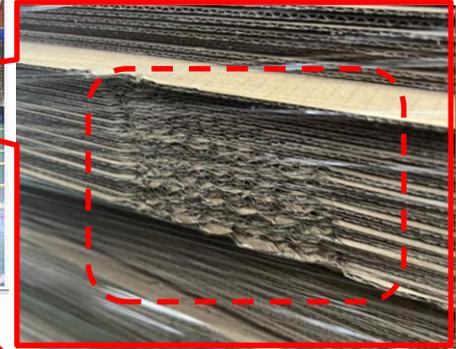
051208
DECEMBER 8, 2025

CORRECTIVE ACTION	PIC	TARGET DATE
Replacement of dieblade since it is already rusty.	Production	241120
Layout the new dieblade using green sponge as standard ejector.	Production Tooling	241122

WORN-OUT / DAMAGED

Customer	EPSON IJP
Item Description	5136687-00 STRATOS OUTER TRAY
Job Order Number	JO-TO-IPD-24-00372-7
Lot Quantity	927 pcs.
Rejected Quantity	287 pcs.
Rejection Rate / PPM	30.96 % / 309,600 PPM
Detection date	241211
Occurrence No.	1 st
Detected by	SCREENING SAMPLING
Status	REJECT
Rejection Cost	-

NO GOOD



WORN-OUT
(207 pcs.)

DAMAGED
(80 pcs.)

6M REVIEW

FACTORS	DETAILS
MAN	NO PROBLEM ENCOUNTERED
METHOD	INSUFFICIENT CHECKING OF SIZE AND CONDITION PALLET ON W.I.
MACHINE	PALLET THAT HAD BEEN USED WAS NOT APPLICABLE ON THE FG ITEM
MATERIAL	NO PROBLEM ENCOUNTERED
MEASUREMENT	NO PROBLEM ENCOUNTERED
ENVIRONMENT	NO PROBLEM ENCOUNTERED

ROOT CAUSE ANALYSIS & CORRECTIVE ACTION

DIRECT CAUSE (PROCESS / MATERIAL)	Root cause	During maneuvering item was accidentally bumped by forklift operator that causes the item hit the corner post that resulted to damage of the item.
	WHY 1	The pallet used is not standard (too small) to locate the item in a higher location. The size of the item was 1343mmX1350 and the pallet used was 900mmx100mm.
	WHY 2	No checking of delivery during unloading for palletized item. Delivery using palletize item shall be check by warehouse receiver if the pallet size is within the standard size.
	WHY 3	No reported incident upon damage of item (for pre alert.)

IMMEDIATE/CORRECTIVE ACTION	PIC	TARGET DATE
Conduct immediate sorting of the affected Lot.	Warehouse	241211
Issuance of NTE to involve Forklift operator to know the root cause and his corrective action.	R. Remoroza	241211
Conduct Re-orientation for safety forklift driving pre caution (refresher)	R. Remoroza	250113
Revise the Warehousing Process (PM-WH-001) additional note under Receiving of Material 5.1.8 Note no. 1: The warehouse receiver will check the size and condition of the pallet used during receiving. (all items with palletized delivery)	J. Chavez	250108
Orientation of the added note to all warehouse personnel.	R. Remoroza	250113



STATUS UPDATES

OPEN IRFs & CARs

STATUS UPDATES

(Pending IREs as of January 16, 2024)

WAITING FOR APPROVAL	0
WAITING FOR ANSWER	15
FOR ISSUANCE	1

Ctrl. #	Customer	Item Description	Defect	Status	Issue Date	Target Date	# of Days Delayed	Received Date
0025	CANON	3CB-0059-000 PARTITION	SCORING	WAITING FOR ANSWER	241030	241105	43	-
0028	KOWA EMORI	HP01D5601 CARTON BOX	MISALIGN SLOT	WAITING FOR ANSWER	241115	241121	31	-
0029	ARKRAY	01-11138 PACKAGING BOTTOM	BURSTING	WAITING FOR ANSWER	241115	241121	31	-
0034	NIDEC SUBIC	L0078652 VR-E CARTON / L00078650 VR-C CARTON	POOR PRINT	WAITING FOR ANSWER	241123	241126	28	-
0035	SANYO DENKI	00972065-01 TOP PAD	MISALIGN PRINT	WAITING FOR ANSWER	241128	241203	24	-
0037	SANYO DENKI	00918237-01	POOR PRINT	WAITING FOR ANSWER	241212	241216	15	-
0038	ARKRAY	63-29360 BOX	DENT	WAITING FOR ANSWER	241213	241220	11	-
0039	KOWA EMORI	HP01D2200C-1	OVERLAP	WAITING FOR ANSWER	241213	241220	11	-
0040	CANON	3CB-0007-000 / 3CB-0008-000	SCORING	WAITING FOR ANSWER	241227	250108	7	-
0041	EMD TECH	TR1236-008 RELAY BOX	MISALIGN GLUE	WAITING FOR ANSWER	241227	250108	7	-
0042	CANON	3CB-0003-000 / 3CB-0005-000	INVERTED DIECUT	WAITING FOR ANSWER	241227	250108	7	-
0043	SFLI KOYAMA	PKC505B-B INNER BOX	POOR PRINT	WAITING FOR ANSWER	250104	250109	4	-
0044	SANYO DENKI	00902009-01 PACKAGE	POOR PRINT	WAITING FOR ANSWER	250107	250117	-	-
0045	SANYO DENKI	00912906-01 PACKAGE	SMEARED PRINT	WAITING FOR ANSWER	250107	250117	-	-
0046	GOLD KOGYO	RRM12D-80 MASTER BOX	GLUE STAIN	WAITING FOR ANSWER	250111	250117	-	-
0047	SANYO DENKI	00897168-01 PACKAGE	POOR SLOT	FOR ISSUANCE	-	-	-	-

STATUS UPDATES

(IRF Closure Monitoring as of January 16, 2025)

+



IRF Contr ol No.	Part Name/ Part Code	Defect	Target Date	LOT 1	LOT 2	LOT 3	LOT 4	LOT 5	Status/ Remarks
0016	HP33D1057-1 CARTON BOX	BURSTING	241204	JO24-M-02017-28 3 NG/ 3000 PCS 241206	JO24-M-02017-29 20 NG/ 4000 PCS 241210	JO24-M-02017-55 0 NG/ 4000 PCS 241219	JO24-M-02017-56 0 NG/ 3500 PCS 241226	JO24-M-02413-31 0 NG/ 3000 PCS 250106	Closed
0018	HP33D1057-1 CARTON BOX	MISALIGN GLUE	241204	JO24-M-02017-28 0 NG/ 3000 PCS 241206	JO24-M-02017-29 0 NG/ 4000 PCS 241210	JO24-M-02017-55 0 NG/ 4000 PCS 241219	JO24-M-02017-56 15 NG/ 3500 PCS 241226	JO24-M-02413-31 5 NG/ 3000 PCS 250106	Closed
0021	6CB-0011-000 OUTERBOX	MISALIGN GLUE	241216	JO-F-24-1202-7 0 NG/ 600 PCS 241221	JO-F-24-1222-12 0 NG/ 600 PCS 250108				On-Going Monitoring
0022	PH989702- 0721 BOX	PEEL OFF	250110						On-Going Monitoring
0026	PKG-PRO-31- RMFG A585 BOX	OVERCUT	241220						On-Going Monitoring
0027	AZ409300 LOWER PAD	OVERCUT	241122						On-Going Monitoring

STATUS UPDATES

(IRF Closure Monitoring as of January 16, 2025)

IRF Contr ol No.	Part Name/ Part Code	Defect	Target Date	LOT 1	LOT 2	LOT 3	LOT 4	LOT 5	Status/ Remarks
0030	6CB-0005-000	BURSTING	241205	JO-TO-IPD-24-00392-2 0 NG / 1200 PCS 250104	JO-F-24-1256-2 0 NG / 600 PCS 250111	JO-F-24-1256-3 0 NG / 500 PCS 250112	JO-F-24-1256-4 0 NG / 300 PCS 250113	JO-F-24-1280-2 0 NG / 300 PCS 250113	Closed
0031	AZ812400 CARTON	EXTRA FOLD	241202	JO-24-IPD-01275-2 0 NG / 300 PCS 250110					On-Going Monitoring
0033	L00086480 FLEXWAVE BOX D	CANNOT FIT LOCK	241220	JO25-M-00069-4 0 NG / 1500 PCS 250118					On-Going Monitoring
0036	321-60182 OUTER BOX, BW	DENT	241207						On-Going Monitoring

STATUS UPDATES

(Pending CARs as of January 16, 2025)

FOR ISSUANCE		0
WAITING FOR APPROVAL		2
> 2425-PR-158 HP33D1057-1 CARTON BOX – MISALIGN DIECUT > 2425-PR-157 HP01D2000-3 CARTON BOX – BURSTING		
WAITING FOR ANSWER		1
>2425-PR-131 RM-ZRY002C STANDARD BOX – POOR PRINT	DATE APPROVED 01/11/2025	TARGET DATE 01/21/2025
FOR DISCUSSION		

STATUS UPDATES

(CAR Closure Monitoring as of January 16, 2025)

CAR Control No.	Part Name/ Part Code	Defect	Monitoring Date	LOT 1	LOT 2	LOT 3	LOT 4	LOT 5	Status/ Remarks
2425-PR-002	01-11137 PACKING	GLUE STAIN	241011	JO-24-IPD-00944-1 0 NG/ 50 PCS 241018	JO24-M-01832-2 0 NG/ 55 PCS 241112				On-Going Monitoring
2425-SA-MP-003	D02WH4001 CARTON B1	WRONG MATERIAL	241121	JO24-M-02339-113 0 NG/ 190 PCS 250107					On-Going Monitoring
2425-PR-023	D02349001 CARTON BIZSTEP	POOR PRINT	241017	JO24-M-01808-43 0 NG/ 200 PCS 241112	JO24-M-02073-5 29 NG/ 600 PCS 241205	JO24-M-02073-30 0 NG/ 350 PCS 250110	JO24-M-02339-88 0 NG/ 300 PCS 250110		On-Going Monitoring
2425-PR-ME-QA-032	LAH113000 PAD UPPER D210 AD	BURSTING	241207	JO-24-IPD-01141-1 12 NG/ 4700 PCS 241211					On-Going Monitoring
2425-PR-QA-107	MDAA00-183B000 PARTITION ASSY	WRONG ASSY	250109						On-Going Monitoring

STATUS UPDATES

(CAR Closure Monitoring as of January 16, 2025)

CAR Control No.	Part Name/ Part Code	Defect	Monitoring Date	LOT 1	LOT 2	LOT 3	LOT 4	LOT 5	Status/ Remarks
2425-QA-004	D02WH4001 CARTON B1 STDBK/D02W H5001 CARTON B1 STDCL	FAILED BARCODE RANKING (Rank F)	240923	JO24-M-02339- 113 0 NG / 190 PCS 250108					On-Going Monitoring
2425-PR-QA-025	01136580-01 SPACER	NO ADHESION	241016						On-Going Monitoring
2425-PR-QA-069	RX1-5735-000 Z10 BOTTOM SHEET	WRONG GRAIN DIRECTION	241210	JO-F-24-1265-1 0 NG / 543 PCS 250110					On-Going Monitoring
2425-PR-QA-072	L00078650 VR- C CARTON	OFF COLOR	241227						On-Going Monitoring
2425-PR-ME-QA-077	01032192-01 REAR TOP PAD	BURSTING	250111						On-Going Monitoring



OTHER CONCERNS/ UPDATES



END OF REPORT

THANK YOU!

