

# EVIDENCE

Blade already re-layout and removal of all eperan



Work Instruction regarding guidelines in using diecut blade ejector was already revised based on the acquired knowledge from CITO Training

KANEPACKAGE PHILIPPINE INC.		WORK INSTRUCTION MANUAL			DATE OF EFFECTIVENESS	PAGE
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TITLE	CONTROL NUMBER	REVISION NUMBER	PREPARED BY	CHECKED BY	APPROVED BY	
GUIDELINES IN USING DIECUT BLADE EJECTOR	WI-PR-003-004	02	Edgar C. Calabes	Edgar C. Calabes	Edgar C. Calabes	
<b>A. PPE REQUIREMENT</b> 1) Safety Shoes 2) Anti-Cut Gloves <b>B. GENERAL SAFETY REQUIREMENT</b> 1) Report any incident, accident, near miss or hazards. 2) Observe proper hygiene during break time and after work. <b>C. IN CASE OF EMERGENCY</b> 1) Immediately inform supervisor. 2) Immediately inform Safety and Health Team in case of injury-related emergencies. 3) Immediately inform ERT Safety Team in case of fire-related emergencies. <b>D. ENVIRONMENT</b> 1) Always follow the waste segregation scheme (composted, plastic, eperan, hazardous). 2) Always observe energy conservation - Turn-off light, machine, electric fan, etc. when not in use.						
Purpose: 1. To serve as reference or guidance in using EJECTOR as remedy for BURSTING, UNCUT, PEEL OFF, CLOGGED SLOT, and SCORING defects. 2. To recommend setups applicable to different diecut blade designs processed in diecut machines. (Gising magpapakita ng mga setup na nangangailangan sa iba't ibang disenyo ng diecut blade na pinapagaganap sa mga diecut machine.)						
Types of Ejector	Illustration	Origin	Thickness	Hardness	Characteristics	
Type 1: Japan Dark Green Ejector		Japan	12mm	32HA	1. Soft Malambot 2. Used for Cutting and Perforation Ginagamit sa Cutting at Perforation	
Type 2: Local Green Ejector		Local	12mm	42HA	1. Hard Matigas 2. Used for Cutting and Perforation, commonly for blade gap and slot Ginagamit sa Cutting at Perforation, kadalasan sa mga pagitan ng blade at slot	
Type 3: Daim Blue Ejector		Japan	10mm	20HA	1. Soft Malambot 2. Used for Cutting and Perforation Ginagamit sa Cutting at Perforation	
TYPE 4 : Cito and Dieboard Yellow Ejector		Germany / Local	10mm 11mm 12mm	25HA	1. Soft Malambot 2. Used for Slot only Ginagamit para sa Slot lamang	
Type 5: Cito Green Ejector		Germany / Local	10mm 11mm 12mm	35HA	1. Hard Matigas 2. Used for Slot only Ginagamit para sa Slot lamang	
Type 6: Rubber Slot Ejector		Japan	4mm 5mm	n/a	1. Hard Matigas 2. Used for Slot only Ginagamit para sa Slot lamang	