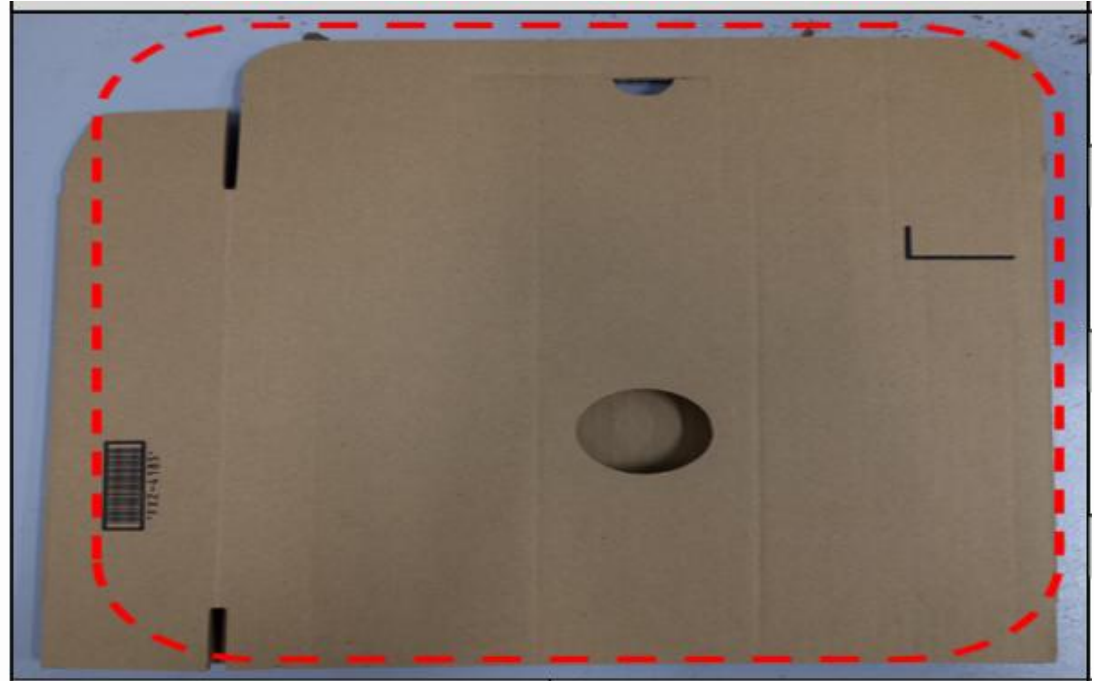


IRF 0053 FX2-4185-000 – SCORING

Customer	CANON
Item Description	FX2-4185-000-RMFG
Job Order Number	JO-F-25-72-1
Lot Quantity	1,996 pcs.
Rejected Quantity	56 pcs.
Rejection Rate / PPM	2.81 %
Detection date	250131
Occurrence No.	1 st
Detected by	QA SCREENING
Status	REJECT
Rejection Cost	-

NO GOOD



ACTUAL: Heavy scoring end to end.

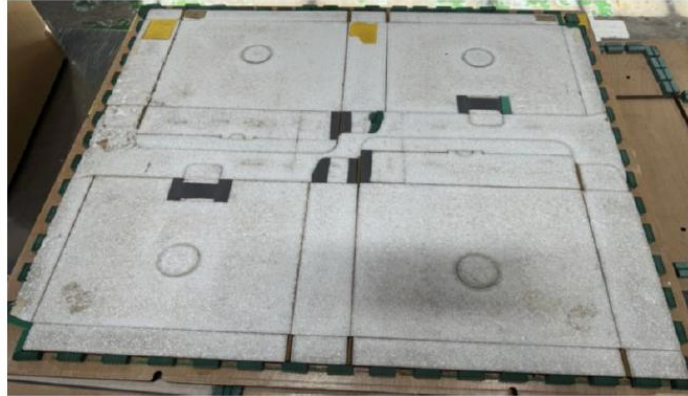
REQUIREMENT: Light scoring end to end is acceptable.

6M REVIEW

FACTORS	DETAILS
MAN	NO PROBLEM ENCOUNTERED
METHOD	NO PROBLEM ENCOUNTERED
MACHINE	EPERAN CUSHION WAS MOUNTED ALL OVER THE DIE-BLADE CREATING UNEVEN PRESSURE DISTRIBUTION
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 on the item surface resulted to Scoring.
	WHY 2	Due to mounting of Eperan cushion all over the die-blade.



IMMEDIATE / CORRECTIVE ACTION	PIC	TARGET DATE
Request for back to zero re-layout of die-blade.	Production Leaders	250319
Training on proper usage of ejector sponge (cito) for the standardization.	CITO	250319