



Investigation Report on Misalign cut of Lionel MGY Asia 516555500

CONTROL No:	IRF - 0088			REJECT PERCENTAGE:	4.19%
REJECT QTY:	39	LOT QTY:	930		

DIRECT CAUSE	W1	Misalign cut was due to deformed PS of item.
	W2	Deformed PS was due to applied cover of stretch film Thin PS prone to deformed during stocking process in the loader area that hit the feeder sensor.
	W3	Thin printed sheets hit the cover of upper feeder sensor during mass production.
	W4	When printed sheet hit the feeder sensor it cause failed to detect the passing of printed sheet that cause misalign between printed and single face.
	W5	n/a

ILLUSTRATION:

GOOD :



REJECT :



PRODUCTION ACTION PLAN

IMMEDIATE ACTION	Notify the concern operator about the problem encountered.	PIC:	Prod Leader	TARGET DATE:	July 10, 2025
IMMEDIATE ACTION	Segregation of laminated boards with misalign single face and to have a different set-up in diecut to process the item with misalign problem.	PIC:	Operator	TARGET DATE:	July 10, 2025
CORRECTIVE ACTION	Operator to pressed the 4 corners of printed Sheet to avoid touching the feeder sensor cover.	PIC:	Operator	TARGET DATE:	July 28, 2025
CORRECTIVE ACTION	Operator to pressed the 4 corners of printed Sheet to avoid touching the feeder sensor cover.	PIC:	Operator	TARGET DATE:	July 28, 2025
CORRECTIVE ACTION	Provide reminders in Lamination area regarding the pressing processing process of 4 corners of PS applicable for Linus PS only	PIC:	Operator	TARGET DATE:	July 28, 2025
CORRECTIVE ACTION	Orientation to operator in conduction pressing in the 4 corners of printed sheet.	PIC:	Operator	TARGET DATE:	July 28, 2025

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