

# Investigation Report for Bursting of SANYO DENKI PHILS INC. 00902009-01 PACKAGE

CONTROL No:	IRF- 44	REJECT PERCENTAGE:	7.69%
REJECT QTY:	40	LOT QTY:	520

DIRECT CAUSE	W1	Poor print occurred because the printing impression was set to 1.9 mm instead of the standard 1.4 mm ( $\pm 0.2$ mm), resulting in uneven ink transfer on the board. In addition, washboard materials were also encountered.
	W2	Operator was not fully aware of the correct EQOS Printing Standard setting, and there was no posted guideline on the machine indicating the required standard impression.

A. PEOL B. ACE C. EDWARD D. NIKE

KANE PACKAGE PHILIPPINE INC.		EQOS DEVELOPMENT MARKS SHEET																				
Customer	Item Code	Material / Sheet	Ink Color / Viscosity	Anilox Impression	Printing Impression	WS	Exh Flap	Exh Dept h	Ent Dept h	Pull Nip	Regi after	Lateral	Pull Nip	Regi after	Lateral	Pull Nip	Feeding Impression	1 Feed Pull Nip	2 Feed Pull Nip	Skip	Remarks	
SPP	0066365301	CF UPPC Black	9	6.2	1.8	134	5.8	244	5.7	0	0	16	33	0	16	01	01	17	23	<input checked="" type="checkbox"/> ON <input type="checkbox"/> OFF	Wash board	
SPP	0066365301	CF UPPC Black	9	6.2	1.8	134	5.8	244	5.7	0	0	16	33	0	16	01	01	17	23	<input checked="" type="checkbox"/> ON <input type="checkbox"/> OFF		
SPP	0090200901	Br UMC Black	9	6.2	1.9	10	6.7	305	6.8	07	130	1	16	35	1	15	01	01	12	16	<input checked="" type="checkbox"/> ON <input type="checkbox"/> OFF	
SPP	0090200901	Br UMC Black	9	6.2	1.9	10	6.7	305	6.8	07	130	1	16	35	1	15	01	01	12	16	<input checked="" type="checkbox"/> ON <input type="checkbox"/> OFF	
EQS	1000000000	1000000000	1000000000	1000000000	1000000000	1000000000	1000000000	1000000000	1000000000	1000000000	1000000000	1000000000	1000000000	1000000000	1000000000	1000000000	1000000000	1000000000	1000000000	<input checked="" type="checkbox"/> ON <input type="checkbox"/> OFF		

## PRODUCTION ACTION PLAN

ACTION PLAN	Increase the ink viscosity from 9 to 10 sec.	PIC:	EQOS Main Operator	TARGET DATE:	241228
ACTION PLAN	Discuss the encountered poor print problem with the EQOS operators.	PIC:	Production Leader	TARGET DATE:	250103
ACTION PLAN	Provide a posted reference for the EQOS Printing standard machine setting to ensure operators follow the correct impression parameter.	PIC:	Production	TARGET DATE:	250710
ACTION PLAN	Conduct re-orientation or refresher training for operators regarding EQOS Printing standard parameters.	PIC:	Production	TARGET DATE:	250710

PREPARED BY:

CHECKED BY:

APPROVED BY:

IRISH MAY ESTAREJA

GERALD DE GUZMAN

REXEL ALMARIO

PROD. LINE LEADER

PROD. SUPERVISOR

PROD. MANAGER