

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 (±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. PEDRO B. ACE C. EDWARD D. NIÑO

KANEPACKAGE PHILIPPINE INC.				EQOS DEVELOPMENT														MARKS SHEET							
Operator A: <u>PEP2</u>		Date: <u>12/28</u>		Shift: <input checked="" type="checkbox"/> Day Shift <input type="checkbox"/> Night Shift																					
Customer	Item Code	Material / Sheet	Ink Color / Viscosity	Anilox Impression	Printing Impression	WS				1ST UNIT				2ND UNIT				Creasing Impression		Feeding Impression		Skip	Remarks		
						Flap	Ext Dept h	Dept h	Ent Dept h	Pull Nip	Regi ster	Later al	Pull Nip	Regi ster	Later al	Pull Nip	1C	2C	1 Feed Pull Nip	2 Feed Pull Nip					
SDP	0060305301	CF HPPC	Black 9	4.2	1.8																		<input checked="" type="checkbox"/> ON <input type="checkbox"/> OFF	Wash board	
SDP				4.4	1.0	134	5.8	249	5.7	0.7	0.35	0	1.6	0.33	0	1.8	0.1	0.1	1.7	2.3		<input type="checkbox"/> ON <input type="checkbox"/> OFF			
SDP	0090200901	GR UMC	Black 9	6.2	1.9	10	6.7	503	6.8	0.7	0.37	0	1.6	0.35	0	1.8	0.1	0.1	1.2	1.8		<input type="checkbox"/> ON <input type="checkbox"/> OFF			
SDP				6.4	1.7																	<input type="checkbox"/> ON <input type="checkbox"/> OFF			
SDP				4.2	1.6	21	6.7	412	6.8	0.7	0.33	0	1.6	0.35	0	1.8	0.1	0.1	1.2	1.8		<input 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