

PACKAGES CONVERTORS LIMITED BU-FC	Document type WORK INSTRUCTION
	Title Monitoring, Measurement and Analysis Matrix

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BU-FC	Analysis tool = Histogram/pareto			
Process	Monitoring Parameter	Measurement Description	Data Reference	Recepients
Flat carton / glued carton / hinglid carton	Colour variation, print/text missing, varnish missing, smudging/filling in, lines/scratches/wrinkles, stains/spots, picking, hickies (skin), rubbing, offsetting, print to print registration, cut to print registration, embossing to print registration, emboss missing, un-cut flaps, crease cut ,dust/burr, through, board cracking on crease, glueability, grammage, cutting, carton damage & sticking, orientation, Quantity per bundle, Strips,Nicks, Stiffner, Seepage , Poly Packing,Tuck In,packing(NFL),Barcode readability ,seepage,read job card . Proof reading	SPQA/PROD/BU-FC/01	QRQA/BU-FC/04, 05, 05-A, 09	Internal Use
	Uncut Flaps	SPQA/PROD/BU-FC/01	QRQA/BU-FC/04, 05, 09	Internal Use
	Lamination (for e-flutes)	SPQA/PROD/BU-FC/01	QRQA/BU-FC/04, 05	Internal Use
	Curl (Bow), crease stiffness, varnish position	SPQA/PROD/BU-FC/01	QRQA/BU-FC/04, 09	Internal Use
	Solvent retention, moisture	SPQA/PROD/BU-FC/01	QRQA/BU-FC/09	Internal Use
	Window patching, perforation	SPQA/PROD/BU-FC/01	QRQA/BU-FC/05	Internal Use
	Folding	SPQA/PROD/BU-FC/01	QRQA/BU-FC/05, 05-A	Internal Use
Paper cups	Colour variation, print/text missing, varnish missing, smudging/filling in, lines/scratches/wrinkles, stains/spots, picking, hickies (skin), rubbing, print to print registration, offsetting, lip formation, sealability, cup formation, bottom folding, grease/burn marks on cup, grammage, Quantity per bundle, Poly Sealing	SPQA/PROD/BU-FC/01	QRQA/BU-FC/08	Internal Use

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BUSINESS UNIT FOLDING CARTON (BUFC)