VKS TECH
Industrial Knowledge for Packaging Pros

DEFECT INVESTIGATION FORMAT

# LOW OD DEFECT — INVESTIGATION & CORRECTIVE ACTION RECORD

Metallization Coating Thickness Recovery Format | Low OD जाँच एवं सुधारात्मक कार्यवाही प्रपत्र

| DOC NO. | DATE | SHIFT (A/B/C) | MACHINE | JUMBO / PO NO. | OPERATOR NAME |
|---|---|---|---|---|---|
| | | | | | |

## A DEFECT DETECTION DETAILS | डिफेक्ट का पता

| TIME DETECTED | OD READING | OD TARGET | DEVIATION % |
|---|---|---|---|
| | | | |

**Substrate / Film:** _____ **Line Speed (m/min):** _____ **Recipe ID:** _____

**Probe pattern:** ☐ All probes low (system) ☐ 1-2 probes low (local) ☐ Sudden drop / Slow drift

## B STEP 1 — CONFIRM | पुष्टि करें

⏱ 30 sec

- ☐ Sensor screen reading verified
- ☐ Trend checked — drift vs sudden
- ☐ Probe-wise pattern noted (L/C/R)
- ☐ Offline sample taken for cross-check

## C STEP 2 — WIRE FEED CHECK ⚡ (80% CASES) | वायर फीड जाँच

⏱ 1 min

| Check Point | Observation / Finding | OK | NOT OK |
|---|---|---|---|
| Wire spool level (sufficient?) | | ☐ | ☐ |
| Wire jam in spout / guide tube | | ☐ | ☐ |
| Drive wheel groove condition | | ☐ | ☐ |
| Spring tension & grip | | ☐ | ☐ |
| Spout alignment & condition | | ☐ | ☐ |

## D STEP 3 — BOATS CHECK | बोट जाँच

⏱ 1 min

| Check Point | Observation / Finding | OK | NOT OK |
|---|---|---|---|
| Boat glow uniformity (viewing window) | | ☐ | ☐ |
| Any dark / cold boat (crack?) | Boat position no.: _____ | ☐ | ☐ |
| Copper contact condition | | ☐ | ☐ |
| Thyristor controller current (>500A?) | Reading: _____ A | ☐ | ☐ |

## E STEP 4 — INLINE OD SENSOR CHECK | सेंसर जाँच

⏱ 1 min

| Check Point | Observation / Finding | OK | NOT OK |
|---|---|---|---|
| Sensor mode (AUTO / Manual / Standby) | Mode found: _____ | ☐ | ☐ |
| Wire feed rate (<100% headroom?) | Reading: _____ % | ☐ | ☐ |
| Sensor window clean | | ☐ | ☐ |
| Inline vs offline calibration match | Diff: _____ | ☐ | ☐ |

## F ROOT CAUSE IDENTIFICATION | मूल कारण

**Tick the SINGLE most likely cause based on findings above:**

- ☐ Worn drive wheel groove
- ☐ Boat crack / cold spot
- ☐ Wrong recipe loaded
- ☐ Blocked / damaged spout
- ☐ Wire spool ending
- ☐ Speed too high for capacity
- ☐ Sensor in Manual / Standby
- ☐ Copper contact oxidized
- ☐ Other: _____

## G CORRECTIVE ACTION TAKEN | की गई कार्यवाही

## H STEP 5 — VERIFICATION READINGS | सत्यापन रीडिंग

⏱ 2 min @ 200 m/min

| LEFT (L) | CENTRE (C) | RIGHT (R) | TARGET ±0.1? | Bare Waste (m) |
|---|---|---|---|---|
| | | | | |

**Final Status:** ☐ PASS ☐ FAIL **Production resumed time:** _____ **Total downtime (min):** _____

## I PREVENTIVE ACTION (if recurring) | रोकथाम कार्यवाही

| OPERATOR | SHIFT SUPERVISOR | QUALITY / ENGINEER |
|---|---|---|
| Name: Time: | Name: Time: | Name: Time: |