VKS TECH
Industrial Knowledge for Packaging Pros

DEFECT INVESTIGATION FORMAT

HIGH OD DEFECT — INVESTIGATION & CORRECTIVE ACTION RECORD

Metallization Over-Coating Recovery Format | High 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: _____ **Actual Speed (m/min):** _____ **Recipe Speed:** _____

Trend type: ☐ Gradual rise (drift) ☐ Sudden jump ☐ All probes / 1-2 probes only

B STEP 1 — CONFIRM | पुष्टि करें

⏱ 30 sec

- ☐ Magnitude checked (0.1 / 0.3 / >0.3)
- ☐ Gradual vs sudden — noted
- ☐ New recipe loaded recently?
- ☐ Operator mode change recently?

C STEP 2 — WIRE FEED CHECK | वायर फीड जाँच

⏱ 1 min

Check Point	Observation / Finding	OK	NOT OK
Wire feed rate (vs recipe baseline)	Reading: _____ %	☐	☐
Sensor mode (AUTO/Manual/Standby)	Mode found: _____	☐	☐
Target OD in recipe matches PO	Recipe target: _____	☐	☐
Recipe ID matches job card	Loaded ID: _____	☐	☐

D STEP 3 — SPEED CHECK ⚡ (40% CASES) | स्पीड जाँच

⏱ 30 sec

Check Point	Observation / Finding	OK	NOT OK
Actual line speed vs recipe	Gap: _____ m/min (_____%)	☐	☐
Cause of speed drop (if any)	Tension / unwind / operator / other: _____	☐	☐
Can speed be restored immediately?	Yes / No + reason: _____	☐	☐

E STEP 4 — SENSOR CALIBRATION CHECK | सेंसर कैलिब्रेशन

⏱ 2 min

Check Point	Observation / Finding	OK	NOT OK
Offline sample OD	L: ____ C: ____ R: ____	☐	☐
Inline vs offline deviation	Diff: _____	☐	☐
Sensor window cleanliness		☐	☐
Last calibration date	Date: _____	☐	☐

F ROOT CAUSE IDENTIFICATION | मूल कारण

Tick the SINGLE most likely cause based on findings above:

- ☐ Line speed below recipe
- ☐ Wrong recipe loaded
- ☐ Sensor in Manual mode
- ☐ Sensor calibration drift
- ☐ Target OD wrongly entered
- ☐ Wire feed rate runaway
- ☐ Tension / unwind issue
- ☐ Shift handover miss
- ☐ Other: _____

G CORRECTIVE ACTION TAKEN | की गई कार्यवाही

H STEP 5 — VERIFICATION READINGS | सत्यापन रीडिंग

⏱ 2 min after 50 m

LEFT (L)	CENTRE (C)	RIGHT (R)	TARGET ±0.1?	Over-Run (m)

Final Status: ☐ PASS ☐ FAIL **Recovery time:** _____ **Extra wire used (kg):** _____

💰 **Cost Impact of This Event:** Over-run metres × (Deviation % × Wire rate) = ₹ _____ (record in monthly report)

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