VKS TECH
Industrial Knowledge for Packaging Pros

DEFECT INVESTIGATION FORMAT

PINHOLES DEFECT — INVESTIGATION & CORRECTIVE ACTION RECORD

Barrier-Failure Prevention Format | Pinholes 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	PINHOLES/M²	CUSTOMER SPEC	OVER SPEC BY

Substrate / Film: _____ **OD Target:** _____ **Boat Life %:** _____

Pattern: ☐ Random ☐ Clustered ☐ MD streaks ☐ Edge only ☐ Splatter

B STEP 2 — CONTAMINATION CHECK ⚡ (80% CASES) | कंटैमिनेशन जाँच

⏱ 3 min

Roller Inspection Map — Tick each roller as CLEAN (✓) or DIRTY (✗):

1	2	3	4	5	6
Unwind Layon	Spreader (Kickert)	Guide Pre-coat	Guide Pre-coat	Guide Pre-coat	Post-coat Guide
☐ ✓/✗	☐ ✓/✗	☐ ✓/✗	☐ ✓/✗	☐ ✓/✗	☐ ✓/✗

Check Point	Observation / Finding	OK	NOT OK
Last roller cleaning date	Date: _____ Hours since: _____	☐	☐
Coating shields — deposit flaking?	Shield #: _____	☐	☐
Unwind roll edge — dust visible?		☐	☐
Anti-static bar working?	Meter reading: _____ kV	☐	☐
Chamber walls — loose particles?		☐	☐

C STEP 3 — BOAT SPLASH CHECK | बोट स्प्लैश जाँच

⏱ 2 min

Check Point	Observation / Finding	OK	NOT OK
Boat usage — over 70% life?	Current life: _____ %	☐	☐
Wire feed rate — within normal?	Reading: _____ %	☐	☐
Wire spool — fresh & sealed?	Opened date: _____	☐	☐
Boat glow uniformity (viewing window)	Flickers / flashes / droplets seen?	☐	☐

D ROOT CAUSE IDENTIFICATION | मूल कारण

Tick the SINGLE most likely cause based on findings above:

- ☐ Dirty guide rollers 3-5
- ☐ Wire feed too high
- ☐ Static pickup (anti-static dead)
- ☐ Shield deposit flaking
- ☐ Oxidized / old wire spool
- ☐ Chamber loose particles
- ☐ Boat spitting (age)
- ☐ Unwind roll contaminated
- ☐ Other: _____

E CORRECTIVE ACTION TAKEN | की गई कार्यवाही

F STEP 4 — VERIFICATION READINGS | सत्यापन रीडिंग

⏱ After 100 m

Pinholes/m² (before)	Pinholes/m² (after)	Customer Spec	Within Spec?	Sample Position

Final Status: ☐ PASS ☐ FAIL **Recovery time:** _____ **Affected metres:** _____

💰 **Impact:** If rejected by customer: Affected metres × Film rate = ₹ _____ | B-Grade recovery: _____ metres

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