VKS TECH vkstech.com	INTEGRATED MANAGEMENT SYSTEM VKS TECH — Flexible Packaging Excellence	FORMAT NO: VKS/MET/INV/03 ISSUE NO: 01 REV: 00 EFFECTIVE: 20.04.2026

SUBJECT: Wrinkle & Crease Defect Investigation Record

▸ EVENT DETAILS

Date		**Shift**		**Machine**	
Jumbo / Roll No.		**Film Type / Micron**		**Operator**	
Batch No.		**Slit Width (mm)**		**Metres Run**	

▸ DEFECT TYPE IDENTIFICATION

Is it a wrinkle or crease? Do the shop-floor test:

Stretch the film flat by hand. Does the fold disappear or stay?

☐ **WRINKLE** (fold disappears when stretched — temporary, fixable) ☐ **CREASE** (fold stays visible — permanent, downgrade) ☐ **BOTH** (wrinkle in some areas, crease in others)

▸ WRINKLE PATTERN (tick one)

☐ **P1:** MD Symmetric (Tin-Canning) ☐ **P2:** MD Asymmetric (Broken MD) ☐ **P3:** CD (Cross-Direction) ☐ **P4:** Diagonal Symmetric (Bow) ☐ **P5:** Diagonal Asymmetric

▸ WALK THE LINE — ROLLER-BY-ROLLER INSPECTION

#	Roller / Station Name	Wrinkle Visible?	Shadow Visible?	Bearing Play (Y/N)	Alignment OK (Y/N)	Surface Clean (Y/N)	Observations / Notes
1							
2							
3							
4							
5							
6							
7							
8							

ROOT CAUSE CODES (tick applicable + write detail in "Root Cause" box below)

RA Roller Alignment RB Roller Bearing RD Roller Deflection RC Roller Contamination TN Tension Issue NP Nip Pressure TP Taper Tension TH Thermal (heater) GB Gauge Band HD Handling Damage SP Spreader Missing/Mis-set OT Other (specify)

▸ ROOT CAUSE CONFIRMED

Code(s):		**Component/Station:**	
Detailed description:			

▸ CORRECTIVE ACTION TAKEN

▸ PREVENTIVE ACTION (to stop recurrence)

▸ IMPACT SUMMARY

Rolls Affected		**Metres Downgraded**		**Grade Assigned**	
Downtime (min)		**Waste (kg)**		**Est. Cost (₹)**	

OPERATOR / INVESTIGATOR	SUPERVISOR / SHIFT INCHARGE	QUALITY / DEPT. HEAD
Name: _____ Sign: _____ Date: _____	Name: _____ Sign: _____ Date: _____	Name: _____ Sign: _____ Date: _____