



THERMOFORMING JOB CARD NUMBER: TC00602

Document name: Form for production and quality on formers | Document reference : Vol 4D FO06
 Date: 03-06-2016 | Revision: 27

Final approval : Thermoforming

DATE: 12/10/18 MACHINE: C-F-SW1 TUB OR LID NUMBER: 113 PROD WGT g & BOX WGT: 17 Kg
 PRODUCT: CS 85-T113M TARGET BOXES/ HOUR: 22 UNITS PER BOX: 500 SPEC C/M
 OPERATOR: DELTON A B C D BOX REFERENCE: CS80 CAVITIES: 12

BRC sig	NIGHT SHIFT						ROLL LOT NO #	<u>221283</u>			REEL WEIGHT	<u>1804</u> Kg	Box Weight	
	1st ROLL						BOXES FROM#	TO#			REEL SPEC:	<u>860x375</u>	REJECTED REEL WEIGHT	Kg
	Time	Weight	Cutting	Form	Punch	Fit test	Label#	Qty	Cycle/Min	COMMENTS				
4:00	22	-	-	-	-	2200	157	15.50	Process within +/-25% tolerance			YES	NO	
4:30	22	-	-	-	-	2200	161	15.50	Cutting Prob MATERIAL					
5:00	22	-	-	-	-	2200	171	15.50	Run out OF GUIDE (x2)					
5:30	22	-	-	-	-	2200	184	15.50						
6:00	22	-	-	-	-	2200	196	15.50	62-60					
6:30									TOTAL REJECTED PRODUCTS				Kg	

BRC sig	2nd ROLL						ROLL LOT #	<u>221230</u>			REEL WEIGHT	<u>607</u> Kg	Box Weight
	BOXES FROM#						TO#	REEL SPEC:	<u>860x375</u>			REJECTED REEL WEIGHT	Kg
	Time	Weight	Cutting	Form	Punch	Fit test	Label#	Qty	Cycle/Min	COMMENTS			
3:30	22	-	-	-	-	2200	206	15.50	Process within +/-25% tolerance			YES	NO
4:00	22	-	-	-	-	2200	218	15.50	HYSTOR MARKS (cut off)				
4:30	22	-	-	-	-	2200	230	15.50					
5:00	22	-	-	-	-								
5:30									37-34				
									TOTAL REJECTED PRODUCTS				Kg

BRC sig	3rd ROLL						ROLL LOT #	<u>EC405432</u>			REEL WEIGHT	<u>742</u> Kg	Box Weight
	BOXES FROM#						TO#	REEL SPEC:	<u>860x375</u>			REJECTED REEL WEIGHT	Kg
	Time	Weight	Cutting	Form	Punch	Fit test	Label#	Qty	Cycle/Min	COMMENTS			
5:00	22	-	-	-	-	2200	230	15.50	Process within +/-25% tolerance			YES	NO
5:30	22	-	-	-	-	2200	235	15.50	MACHINE problem BECAUSE				
6:00	22	-	-	-	-	2200	240	15.50	product make curls + 100%				
6:30	22	-	-	-	-	2200	240	15.50	5:30 to 5:45				
7:00	22	-	-	-	-	2200	248	15.50	45-18				
									TOTAL REJECTED PRODUCTS				Kg

BRC sig	4th ROLL						ROLL LOT #				REEL WEIGHT		Box Weight
	BOXES FROM#						TO#	REEL SPEC:				REJECTED REEL WEIGHT	Kg
	Time	Weight	Cutting	Form	Punch	Fit test	Label#	Qty	Cycle/Min	COMMENTS			
									Process within +/-25% tolerance			YES	NO
									TOTAL REJECTED PRODUCTS				Kg

BRC sig	5th ROLL						ROLL LOT #				REEL WEIGHT		Box Weight
	BOXES FROM#						TO#	REEL SPEC:				REJECTED REEL WEIGHT	Kg
	Time	Weight	Cutting	Form	Punch	Fit test	Label#	Qty	Cycle/Min	COMMENTS			
									Process within +/-25% tolerance			YES	NO
									TOTAL REJECTED PRODUCTS				Kg

PRODUCTION SUMMARY

TOTAL KG REELS RECEIVED		Kg	TOTAL KG REEL USED		Kg	TOTAL BOXES	
TOTAL KG's REJECTED/ RETURN		Kg	TOTAL KG PRODUCTS REJECTED		Kg		

Process tolerances (3rd column) is defined as any perimeter setting outside 25% tolerance- such changes shall be recorded on rear side of this document under "PROCESS CHECKS"