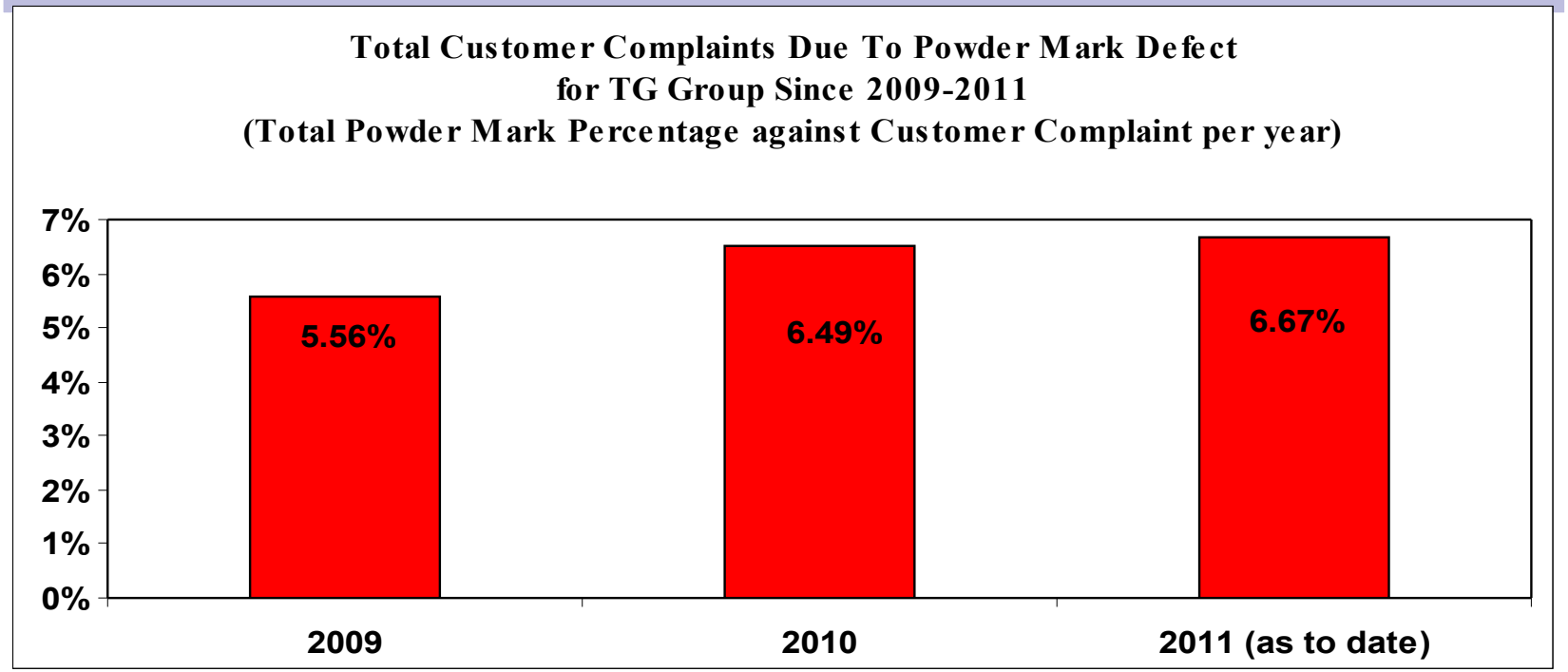
TOP GLOVE, TOP QUALITY, TOP EFFICIENCY,
GOOD HEALTH, SAFETY FIRST & BE HONEST
F2A & F9

POWDER MARK ON NITRILE

Presenter:
Mr. Wong Chong Ban
General Manager

1.0 Customer Complaints on Powder Mark



	2009	2010	2010 (as to date)
Total Total number of customer complaints (Nitrile)	18	77	15
Total complaints on nitrile powder mark	1	5	1
Percentage of complaint,%	5.56%	6.49%	6.67%

2.0 Types of Powder Mark Defects

a. BF area

Reason:- Poor former washing efficiency

b. U-Shape at BF area

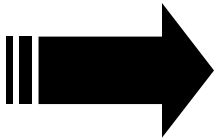
Reason:-Former not enough dry

2.0 Types of Powder Mark Defects

c. Critical Powder Mark

Reason:- Over topping up of

powderfree coagulant



2.0 Types of Powder Mark Defects

c. Critical Powder Mark

Reason:- Over topping up of

powderfree coagulant

3.0 ROOT CAUSES

3.0 Root Causes

i. MAN

- Excessive topping up of PF coagulant/ terric.
- Poor control of process parameters
  ie: Alkaline percentage, coagulant temperature, former temperature, main oven temperature.
- Machine operator that topping up once a while and not consistently topping up

Powder Mark

ii. MATERIAL

- Chemical properties of PF coagulant with high melting point cause difficult to dry/melt.
- Former:-Textured surface makes PF coagulant easily accumulated & difficult to wash.
  - Different heat absorption for different brand of formers.
- Alkaline chemical with poor cleaning effect/dirty.

3.0 Root Causes

Powder Mark

iii. METHOD

- Rely on manual topping up of PF coagulant/CMR by line boy.
- No standard testing method to determine accurately PF coagulant percentage in the coagulant tank. (supplier also unable to provide us the testing method)

iv. MACHINE

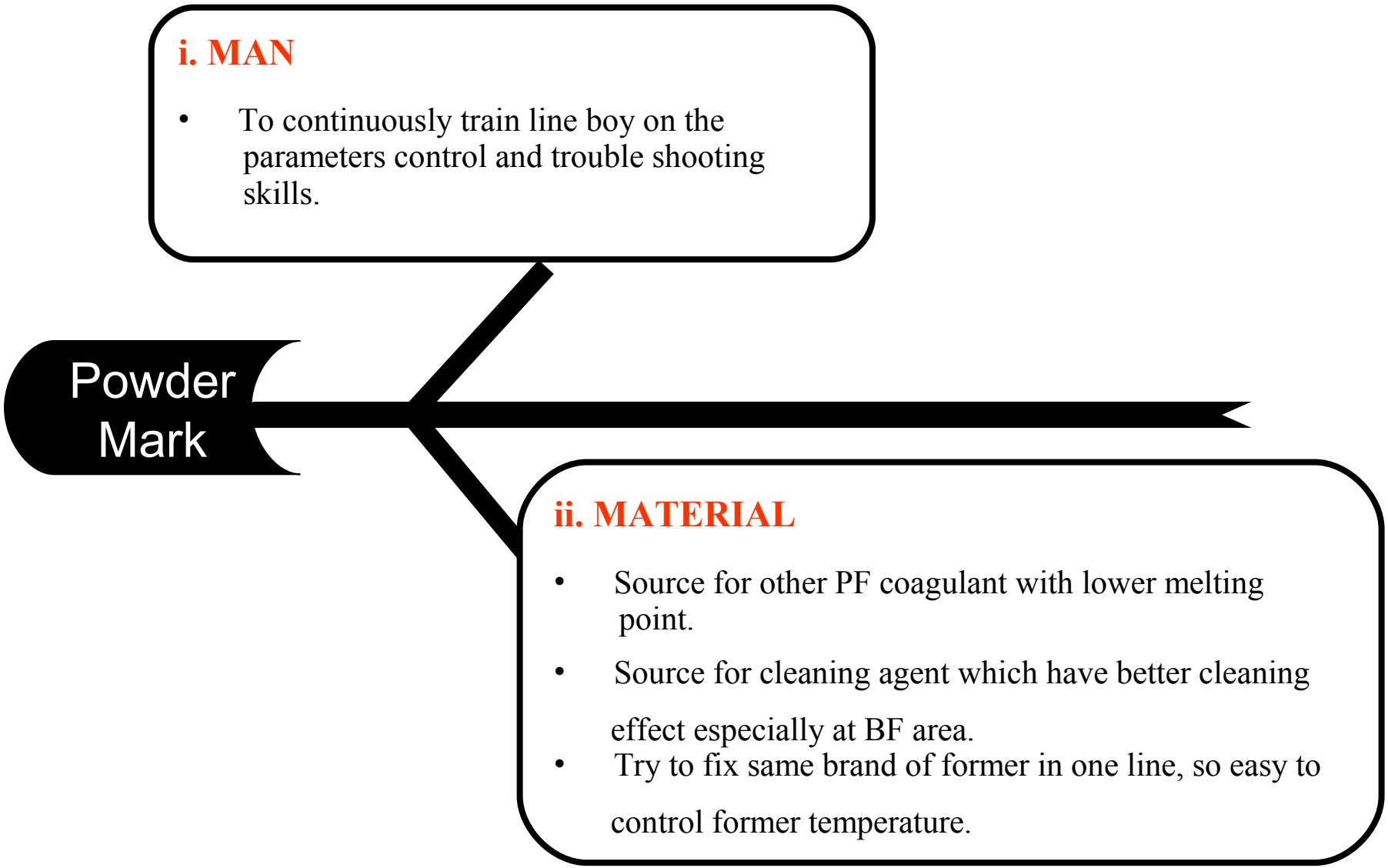
- Small washing brush worn out/trip.
- Inefficient of rinsing system (shower).
- Coagulant oven trip.
- Main oven trip.
- Poor circulation of chemicals in coagulant tank due to coagulant nozzle blocked/wrong orientation.

4.0 CORRECTIVE

&

PREVENTIVE ACTIONS

4.0 Corrective & Preventive Actions



4.0 Corrective & Preventive Actions

iii. METHOD

- In progress of established PF coagulant testing method using calcium carbonate(CaCO3) testing method.

Powder Mark

iv. MACHINE

- Maintenance and production to make sure:
  a. Small washing brush that worn out/trip being repaired immediately.
  b. Rinsing system (shower) in good working condition.
  c. Good circulation of chemicals in coagulant dip tank.
  d. Follow TPM (Total Preventive Maintenance) schedule.
  e. Coagulant / main oven that trip being repaired immediately.

TERIMA

KASIH…

THANK

YOU…