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**TG MEDICAL(F3), TOP QUALITY, TOP EFFICIENCY,
GOOD HEALTH, SAFETY FIRST & BE HONEST**



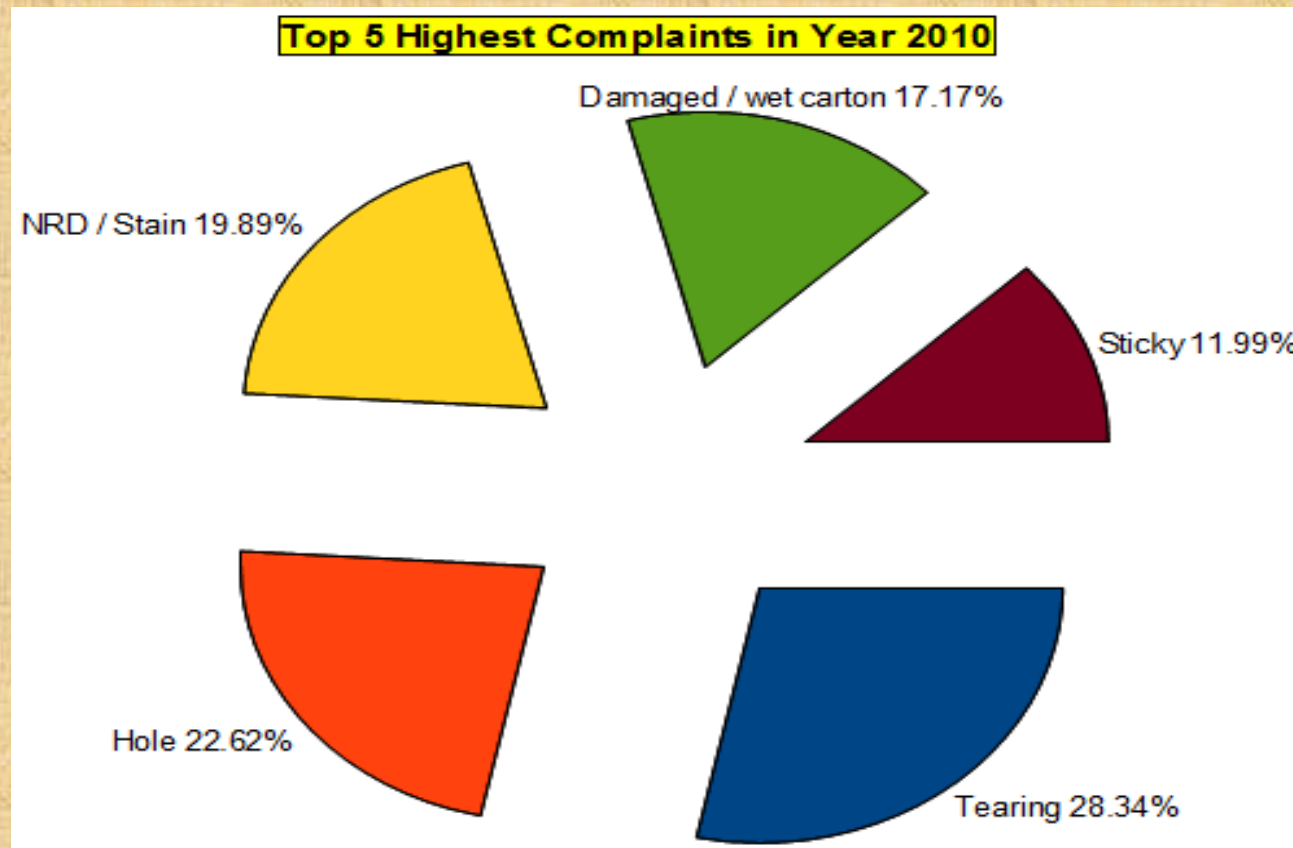
Non Removable Dirt

**Root Cause and
Corrective/Preventive Actions**

Presentation by Mr. Philip Thomas
Factory 3

Statistical Data on NRD Defect

20% customer complaints received in year 2010 for TG Group come from NRD/Stain defect



Root Cause

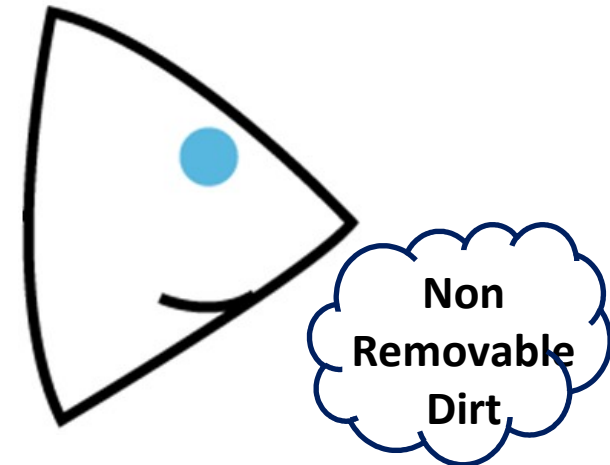
Machine

- Dirt from **Dipping Tank**
- Dirt from **Open Channel**
- GNO glove at **Autostripping Chain**
- Oil stain and dirt from **Compressed Air Line**

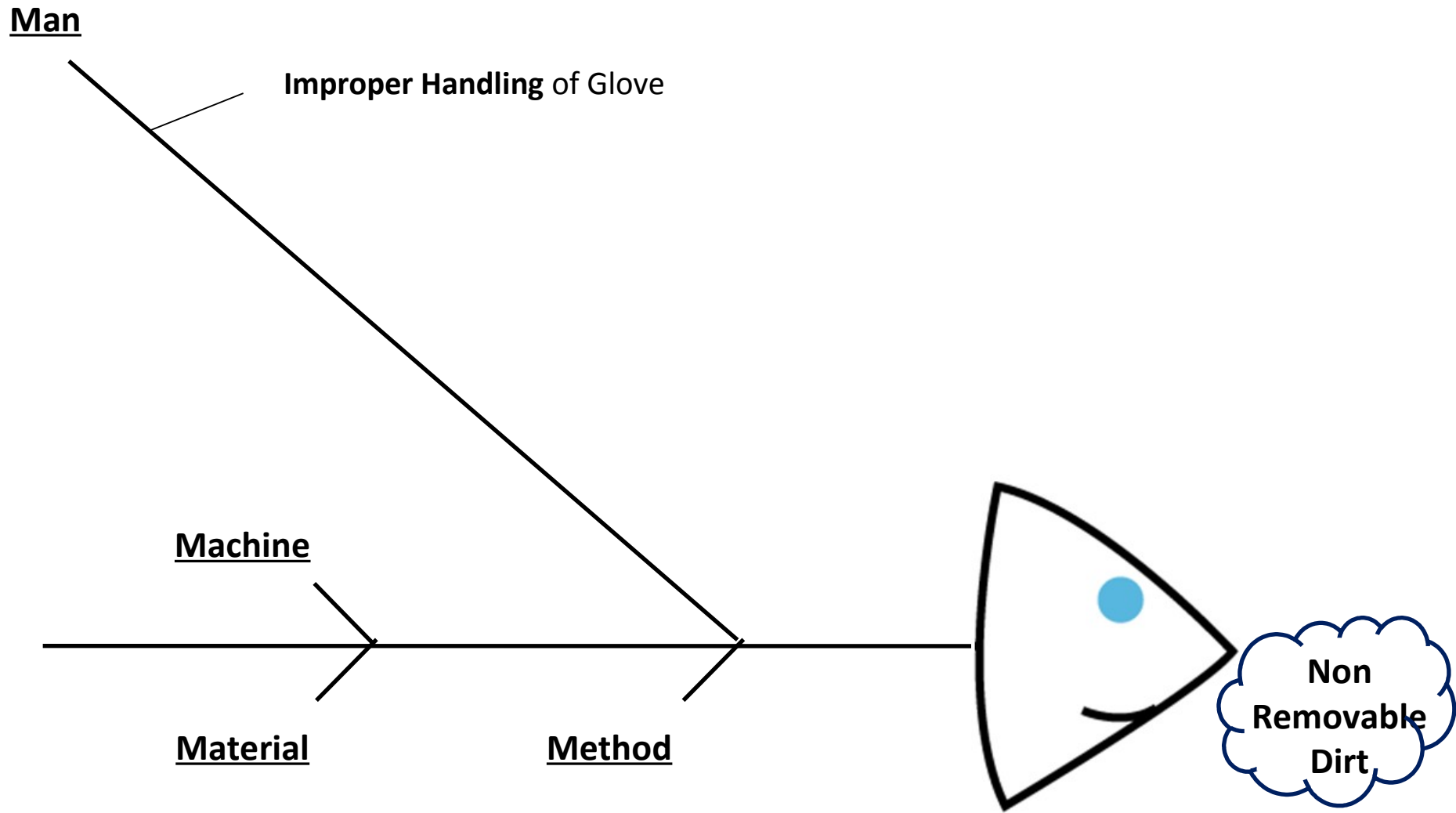
Man

Material

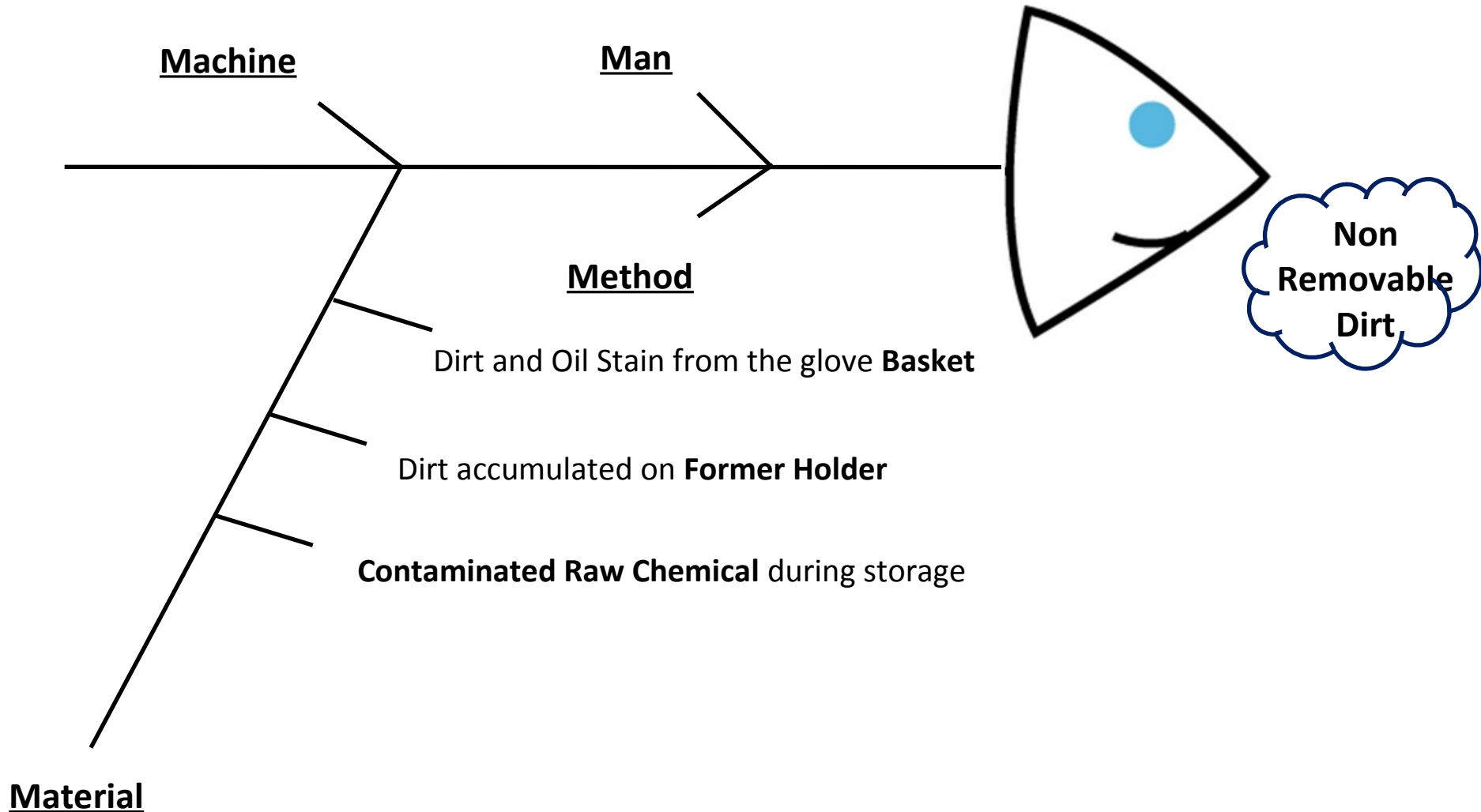
Method



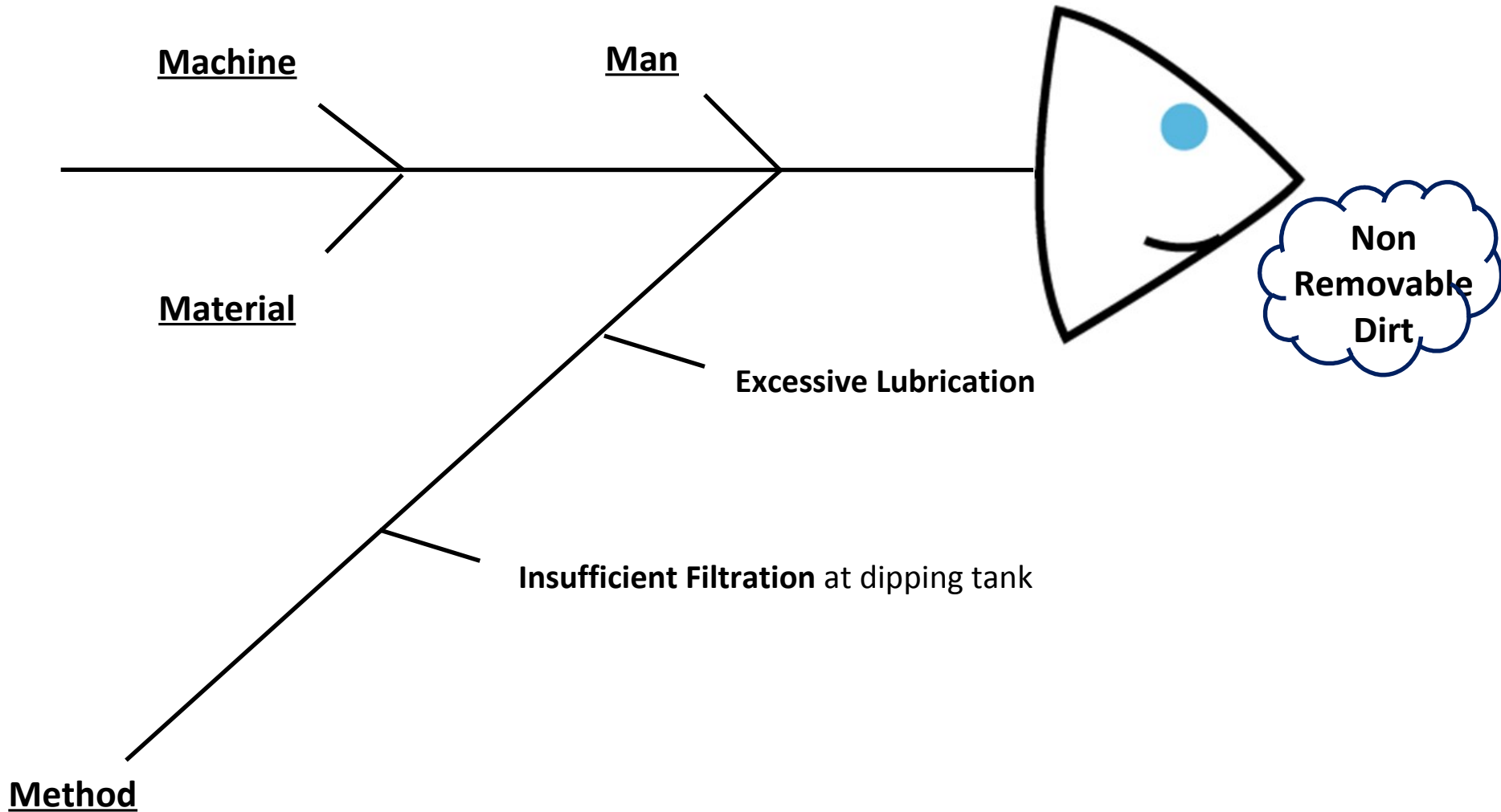
Root Cause



Root Cause



Root Cause



Corrective & Preventive Action

Check Dipping Tank

Dipping Tank including [Coagulant Tank](#), [Latex Tank](#), [Polymer Tank](#), [Cornstarch Tank](#)

1. **Ensure No Dirt Floating** on the surface of dipping tank.
2. Installation of **proper and sufficient filter**.
3. **Modification of dripping tray** to minimize dirt.
4. **Modification of former track** to avoid dirt fall.
5. **Usage of stainless steel rod** to guide former in all dipping tank.

Corrective & Preventive Action

Check Dipping Tank



Check Open Channel
And Former Track

1. Ensure **no excessive lubrication** of chain.
2. **Scheduled cleaning of open channel.**
3. **Sufficient Cotton Rag** at former track.

Corrective & Preventive Action

Check Dipping Tank



Check Open Channel



Check Stripping Area

1. **Frequent cleaning** at autostripping area
2. **Basket** was placed at autostripping area.
3. Installation of **moisture and oil separator** for compressed air line.

Corrective & Preventive Action

Check Dipping Tank



Check Open Channel



Check Stripping Area



Check Former

1. **Daily check of former cleanliness.**
2. Ensure **no oil stain** on former.

Corrective & Preventive Action

Check Dipping Tank



Check Open Channel



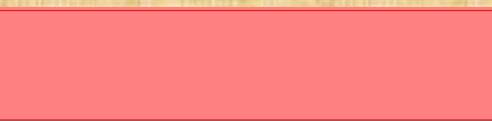
Check Stripping Area



Check Former



Check Tumbling Proc.



1. Ensure cleanliness of the **tumbler drum**.
2. Basket for glove storage must be **clean**.
3. **Practice GMP** while handling glove.

Corrective & Preventive Action

Check Dipping Tank



Check Open Channel



Check Stripping Area



Check Former



Check Tumbling Proc.



Check Packing

1. Ensure packing area **cleanliness**.

2. Packers strictly **follow GMP** when packing glove.

CONCLUSION

In order to prevent the customer's complaint on NRD, all departments had implemented the preventive actions.

THANK YOU