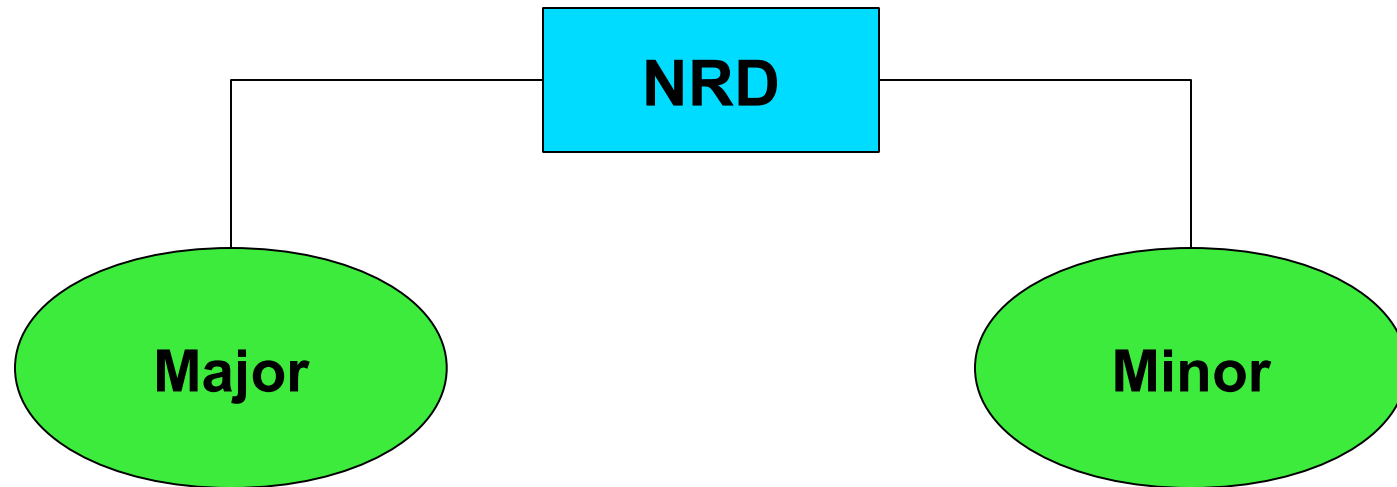


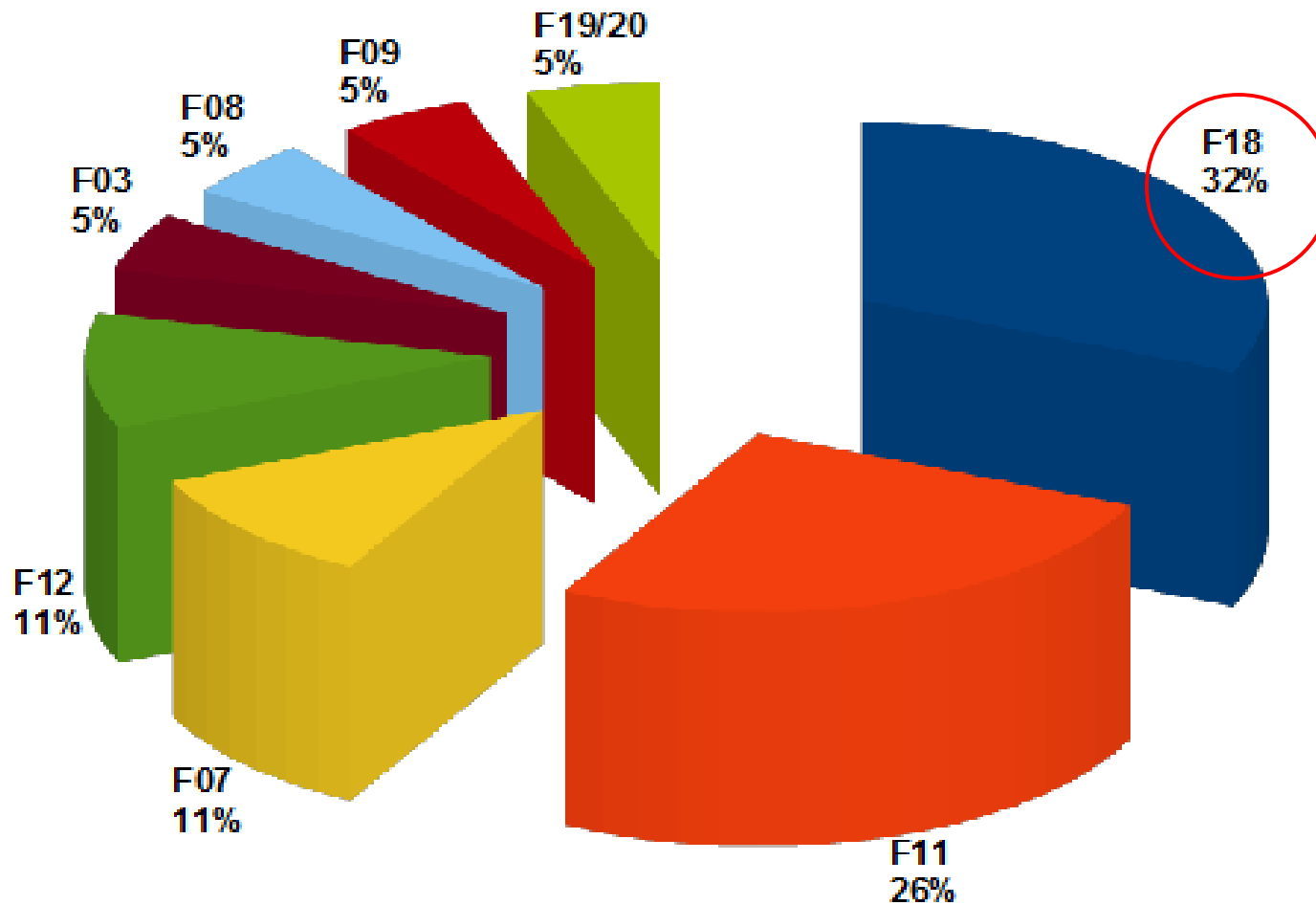
INTRODUCTION

NON REMOVABLE DIRT (NRD)

Metal dust/grease on gloves

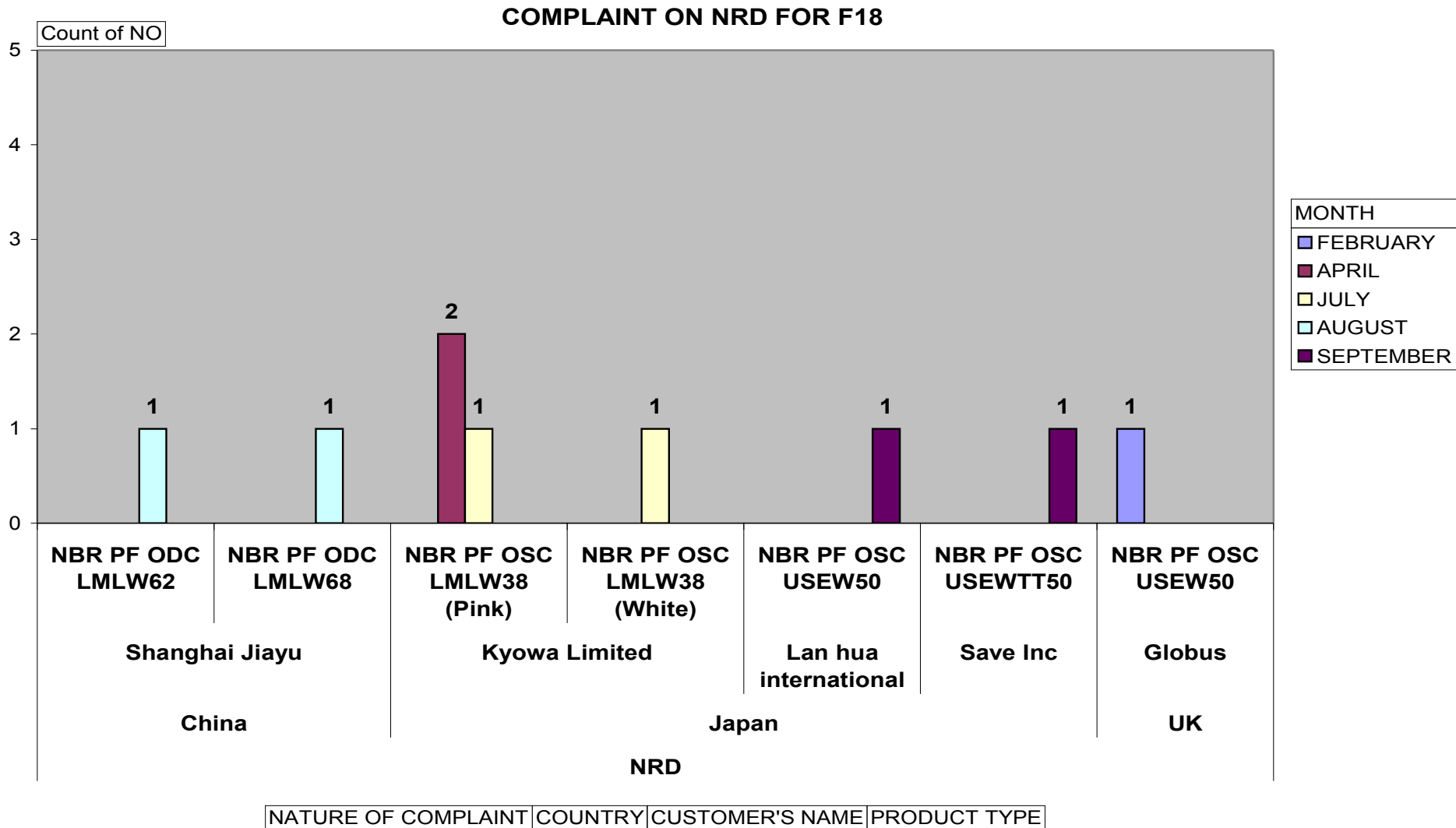


Compilation Of NRD / Stain Complaints for All TG Factories

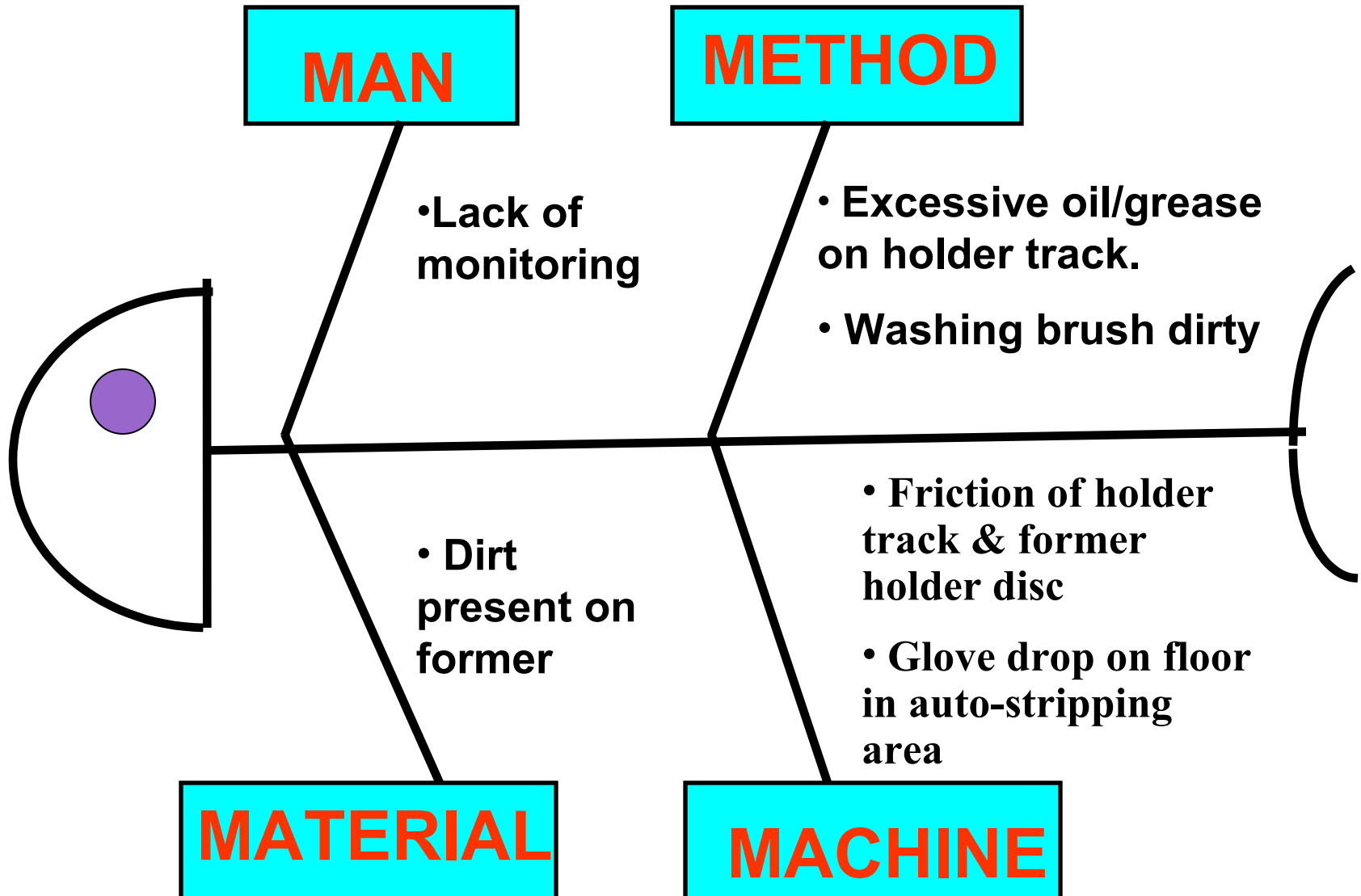


Factory	Total Complaints
F18	6
F11	5
F07	2
F12	2
F03	1
F08	1
F09	1
F19/20	1
F2A	0
F2B	0
F04	0
F05	0
F06	0
F10	0
F13	0
F14	0
F15	0

ANALYSIS OF NRD COMPLAINTS



FISH BONE CHART: ROOT CAUSE



MACHINE

Allocate magnet disc to
clean holder track

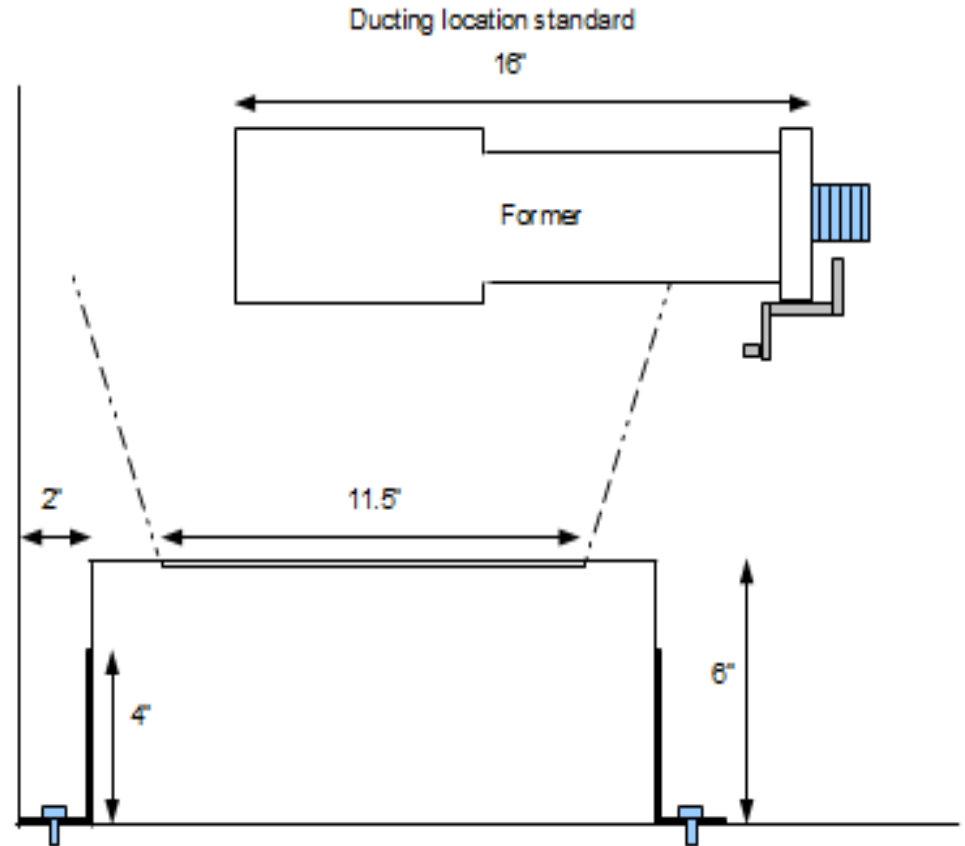
Allocated cotton rags (with
lubricant oil) before latex
and coagulant tank

Add another layer of nylon
plate onto existing S-plate



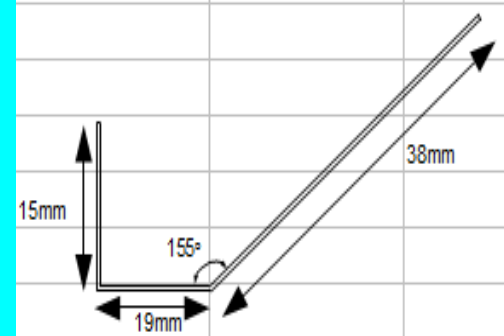
MACHINE

Rearranged position
of blower ducting to
prevent blowing on
holder track



METHOD: PRODUCTION

Install V-channel at holder track to collect dust



Cover the turning point with fiber tray to avoid dropping of NRD



Line boy to clean main oven and oven ducting



METHOD: PRODUCTION

Cleaning blower fan



Do house-keeping



METHOD-PRODUCTION

Stripper to segregate gloves with NRD using light table

Online QC to tighten control on NRD monitoring for Japan orders.



METHOD: QA

To standardize QA and QC checking of NRD

Major NRD	Quantity
1) NRD length $\geq 1\text{mm}$	1/more dot
2) NRD $< 1\text{mm}$, combine length $> 1\text{mm}$	2-3 dots
3)	> 4 dots
Minor NRD	Quantity
1) NRD $< 1\text{mm}$, combine length $< 1\text{mm}$	2-3 dots
Acceptable NRD	Quantity
1) NRD $< 1\text{mm}$	1-2 dot hardly seen (very very minor)

MAN

Give training to online QC and QA to identify and sort out NRD defect gloves

To train workers to have better quality mindset regarding NRD

CONCLUSION

- 1) NRD is still a major quality issue in F18.
- 2) Many preventive actions have been done to minimize the occurrence of NRD.
- 3) F18 will continue to study more on the preventive actions to solve NRD issue more effectively.