

			OOD /28/2024	SAFETY/		RIS SEVERITY 1 = No potential harm or significant effects 3 = Negative effect/ Potential customer complaint 5 = End user getting sick	K RATING SCALE LIKELIHOOD 1 = Very unlikely 3 = Quite possible 5 = Very likely	ACTIONS REQUIRED IF: Severity = 5 Likelihood = 5 RPN> 8			
	PROCESS	ACTIVITY			LIKELIHOOD RPN	LAST VERIFICATOIN: 03/13/2025 GMP (Good Manufacturing Practices)	CP/CCP	РРЕ	MATERIALS	SDS	SUPPLIER
STATE Teceving Process NO NO NO NO NO NO NO NO NO NO	RECEIVING	- Receive raw material - Inspect Trailer - Stage material in warehouse	<mark>Biological</mark> Personal hygiene A cut (blood exposure) Sick employee	1 5 5	3 3 1 5 1 5	- Use a sanitiser to clean hands - Use colored band aid/ Clean contact area - Use face mask/ send home	СР СР		- Board, Pallets, Inks, Film, Plates, Corrugated - Coating, lubricants, cleaning solutions		
			Chemical Contaminated Trailer Contaminated (oil/dirt) Material Physical	5	1 5 1 3	- Reject load	СР	- Steel toe shoes - Latex/ plastic glooves	- Board, Pallets, Inks, Film, Plates, Corrugated - Coating, lubricants, cleaning solutions		Various
			Damaged material Wrong material	1 1	3 3 3 3	- Reject partial or total load	СР	- Steel toe shoes	 Board, Pallets, Inks, Film, Plates, Corrugated Coating, lubricants, cleaning solutions 		Various
START Pletes Procesor NO Plates Clean & VS Stage at printing Clates Procesor	PRE PRESS	- Plate processing - Preventive Maintenance - Fountain cleaning - Machine exterior cleanup	Biological Personal hygiene A cut (blood exposure) Sick employee Chemical	1 3 1	3 3 1 3 1 1	- Use a sanitiser to clean hands/ Staff Training - Use colored band aid/ Clean contact area - Use face mask/ send home	СР СР				
			Chemical solutions for plates	1	1 1	- Keep Chemical solutions closed and properly identified	СР		- Plate processing solutions - Cleaning solutions	Yes	ECO3 (AGFA)
			Physical Contaminated plates	1	1 1	- Identify, segregate and scrap material	СР	- Steel toe shoes	Aluminim Plates		ECO3 (AGFA)
START Printing Process	DN	- Feed board - Print - Remove printed load - Preventive Maintenance - Rollers cleaning - Fountain cleaning - Machine exterior cleanup	Biological Personal hygiene A cut (blood exposure) Sick employee Chemical	1 3 1	3 3 1 3 1 1	- Use a sanitiser to clean hands - Use colored band aid/ Clean contact area - Use face mask/ send home	СР СР				
Sheets Clean &	PRINTING		Chemical Solutions Oil or grease Physical	3 3	1 3 1 3	- Keep Chemical solutions closed and properly identified - Spray red and scrap material	СР СР	- Plastic Gloves - Saftey glasses	- Oils & grease - Coatings & Inks - Cleaning solutions	Yes	Sun Chemical
Stage printed sheets Printing Process	-							- Steel toe shoes	- Chipboard - Plastic and wood pallets		Mills
De Proces	DIE SHOP	 Wood dies manufacturing by CNC Wood dies knifing Preventive Maintenance Machine exterior cleanup 	Biological Personal hygiene A cut (blood exposure) Sick employee Chemical	1 1 1	3 3 3 3 1 1	- Use a sanitiser to clean hands - Use colored band aid/ Clean contact area - Use face mask/ send home	СР СР				
Die Set Clean & VES Stage Die Set END Die Process			Physical Contaminated/ rusted blades Contaminated/ wood sheets	1	1 1 1 1	- Identify, segregate and scrap material - Identify, segregate and scrap material	СР СР	- Steel toe shoes - Saftey glasses	- Metal blades - Wood Dies		Carton Craft Supply / BOBST Freeman Supply / CCM Die Supply
START Cuting Proces Make Resdy + Cut	UZ	Feed board Cut/ shape board Preventive Maintenance Machine exterior cleanup Feed cut pieces	Biological Personal hygiene A cut (blood exposure) Sick employee Chemical	1 1 1	3 3 3 3 1 1	- Use a sanitiser to clean hands - Use colored band aid/ Clean contact area - Use face mask/ send home	СР СР				
Arts of starts add a sperced	CUTTING		Oil or grease	3	1 3	- Identify, segregate and scrap material	СР				
Stage cut sheets Cutting Process			Physical Mixed material (Allergen risk) Biological					- Steel toe shoes	- Chipboard - Plastic and wood pallets - Wood Dies		
Finishing Process Make Ready + glue	FINISHING	- Fold andf glue - Weight and flat pack - Preventive Maintenance - Machine exterior cleanup	Personal hygiene A cut (blood exposure) Sick employee Chemical	1 1 1	3 3 3 3 3 3	- Use a sanitiser to clean hands - Use colored band aid/ Clean contact area - Use face mask/ send home	СР СР				
NO Glued prount clean & opproved			Glue Oil or grease	3 3	1 3 1 3	- Identify, segregate and scrap material - Identify, segregate and scrap material	СР СР		- Glue	Yes	Specialty Adhesives / Diamondback
FG warehouse Finishing Process			Physical					- Steel toe shoes	- Chipboard - Window film - Plastic and wood pallets - Corrugated & labels		
START Shopping Process No	DNIAAIHS	- Wrap Finished Goods skids - Damage boxes - Truck	Biological Personal hygiene A cut (blood exposure) Sick employee Chemical	1 1 1	3 3 1 1 3 3	- Use a sanitiser to clean hands - Use colored band aid/ Clean contact area - Use face mask/ send home	СР СР				
NO Trailer clean &											
END Die Process			Physical					- Steel toe shoes	- Wood pallets - Shrink wrap		