

5M + 1 REVIEW

FACTORS	DETAILS
MAN	NO CHANGES
MACHINE	NO CHANGES
METHOD	No standard quantity for gripping
MATERIAL	NO CHANGES
MEASUREMENT	NO CHANGES
ENVIRONMENT	NO CHANGES

I. INVESTIGATION / ANALYSIS									
DIRECT CAUSE: (Analyze the reason of occurrence, why it happened?)					INDIRECT CAUSE: (Analyze the reason of occurrence, why it leaked?)				
System / Training	Why 1:				Why 1: New operator assigned in the position.				
	Why 2:				Why 2:				
	Why 3:				Why 3:				
	Why 4:				Why 4:				
	Why 5:				Why 5:				
Design / Toolings	Why 1:				Why 1:				
	Why 2:				Why 2:				
	Why 3:				Why 3:				
	Why 4:				Why 4:				
	Why 5:				Why 5:				
Process / Material	Why 1: Damaged occurred during manual detaching process, edge part of board/ panel was affected and included in detaching instead of scrap part.				Why 1:				
	Why 2: Edge part of panels were included because of multiple panels were grip and detach at the same time, alignment of panels made it also difficult >Panels were not aligned due to the palletizing process from Die cut, proper alignment can't be secured even with the help of palletizing guide.				Why 2:				
	Why 3: No standard gripping quantity in Detaching.				Why 3:				
	Why 4:								
	Why 5:								
FINAL CONCLUSION									
OCCURRENCE ROOTCAUSE					OUTFLOW ROOTCAUSE				
Affected by gripping/detaching multiple panels at once.					New operator assigned in the position.				
IMMEDIATE ACTION: (Action to be done to contain/ temporary correct the problem found)					CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)				
A. Sorting Result					Actions to be done to eliminate recurrence				Who / When
	Location	Total Stock	NG	Total Good	System				
RM									
WIP									
FG									
B. Orientation					Design / Tools				
Date	04/11/2022	Time	9:00 am						
Title	Orientation of detaching process (w/ regards to damage defect)								
Attendees	Concerned operators, Process, Prod IE								
C. Reworking					Process	Set standard grip quantity depending on the size of scrap of item to be detach. (see attached minutes) To established work instruction. (April 3rd week)			Prod IE, process
Rework Quantity									
Total Good									
Rework Percentage (Good)									
					Date Conducted: _____ PIC: _____				



KANEPACKAGE PHILIPPINE INC.

MINUTES OF THE MEETING

Date: 4/11/22 Time Start: 0:00 Time Finished: Venue:

ATTENDEES:

Name	Dept.	Sign	Name	Dept.	Sign
Jessie Rayson	prod		Mered Perez	Prod / Process	
Cherice Dequito	prod		Antonette Dequito	Prod IE	
Polly Ando	prod				

AGENDA: ORIENTATION OF DETACHING PROCESS
(w/ regards to damage defect)

MINUTES:

* Root cause of damage

- * panels are not align; difficult to detach
- * Die cut catcher although w/ palletizing guide alignment of panel can't be secured
- * there are items with wide scrap and with small scrap

* Counter measure

> FOR WIDE SCRAP ITEMS

- grip of quantity of detaching tools should be at least 1
maximum of 4 panels. (adjustment depends on alignment)

> FOR SMALL SCRAP ITEMS

- grip quantity of detaching tools should be 1
and maximum of 2 panels only. (adjustment depends on alignment)

* PALLETIZING FROM DIE CUT CATCHER

- remind to be cautious in aligning panels while palletizing even though there's palletizing guide.

FOLLOW UP MEETING:

(date & time)

for KPPI fill up only

Prepared by: A. Dequito

Reviewed by:

Noted by:

Minutes of meeting of orientation/ meeting