

5M + 1 REVIEW

FACTORS	DETAILS
MAN	NO CHANGES
MACHINE	Unbalanced blade
METHOD	NO CHANGES
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:				
	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: This is due to difficulty in detaching scrap due to uncut parts from die cut process.				Why 2:				
	Why 3: Uncut parts from die cut process was because of unbalanced blade.								
	Why 4:								
	Why 5:				Why 3:				
FINAL CONCLUSION									
OCCURRENCE ROOTCAUSE					OUTFLOW ROOTCAUSE				
Difficulty in detaching due to uncut parts because of unbalanced blade									
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	Put patching tape on parts with uncut in blade.			
Date	4/21/22	Time	9:00 am						
Title	Orientation of rootcause and counter measures								
Attendees	Concerned operators, Process, Prod IE								
C. Reworking					Process	>Manual Detaching operator must inform die cut regarding uncut parts. >Die cut operator must adjust setting. >In case item was run already must include to endorsement log book for check point on next process. (See attached orientation MOM)			Prod IE, process
Rework Quantity									
Total Good									
Rework Percentage (Good)									
					Date Conducted: _____ PIC: _____				

K KANEPACKAGE PHILIPPINE INC.			
MINUTES OF THE MEETING			
Date:	Time:	Start:	End:
4/11/22	9:40	am	
ATTENDEES:			
Name	Dept.	Signature	Sign
J. S. S. S.	Prod.		
R. R. R. R.	Prod.		
E. C. C. C.	Prod.		
AGENDA:			
REORGANIZATION OF CHINA'S RESOURCES; COUNTRY REPORT			
MINUTES:			
<p>DISCUSS: DEPT. OF ONE TO LOCATE</p> <p>REORGANIZATION: > difficulty in detecting etc. in west</p> <p>> west side has been of personnel block</p> <p>Immediate action: get riding tape</p> <p>minutes:</p> <p>General detaching operator must inform about operator upon</p> <p>detaching west in pack.</p> <p>> operator must immediately adjust setting.</p> <p>> in case of error affected west directly done in etc of pack.</p> <p>Still manual detaching must inform.</p> <p>> etc of operator must include to endowment by back to</p> <p>by 1st check point in next morning.</p>			
FOLLOW UP MEETING:			
(date & time)			
For KPMI fill up only			
Prepared by: _____			
Reviewed by: _____			

Minutes of meeting of orientation/ meeting



Actual orientation