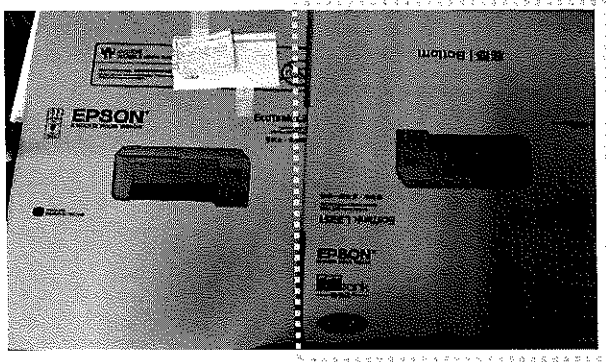


INVESTIGATION REPORT FOR INVERTED AND SAME PANEL AT 516387900 LOUVRE 2 MJX BROWN

DIRECT CAUSE METHOD (PROCESS)	W1: INVERTED AND SAME PANEL AT SEMI AUTO GLUING PROCESS. W2: DOUBLE PANEL DETECTED BY SCANNER AT PANEL B FEEDING AREA. IT IS POSSIBLE THAT THE REJECT ITEM PASSING THROUGH THE CONVEYOR W/O PRIOR CHECKING / PROPER SEGREGATION OF REJECT ITEM. W3: OPERATOR SKIPPING THEIR KEY POINTS /NOT FOLLOWING STANDARD.
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> INVERTED PANEL AND SAME PANEL A

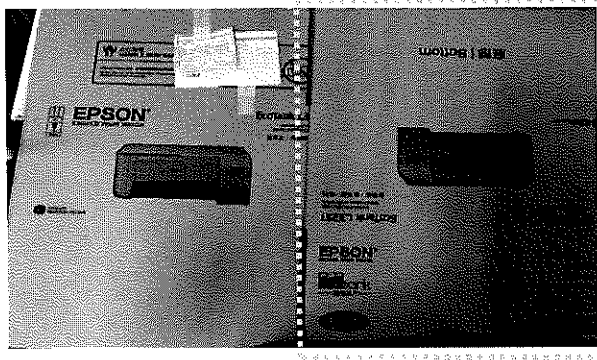
PRODUCTION ACTION PLAN

- > Re-orientation for QA& Production regarding to the issue of inverted and same panel issue
- > Re-orientation regarding segregation of panels for rework item and reject item for proper tag/label
- > Orientation regarding their key point.

INVESTIGATION REPORT FOR INVERTED AND SAME PANEL AT 516387900 LOUVRE 2 MJX BROWN

DIRECT CAUSE
METHOD (PROCESS)

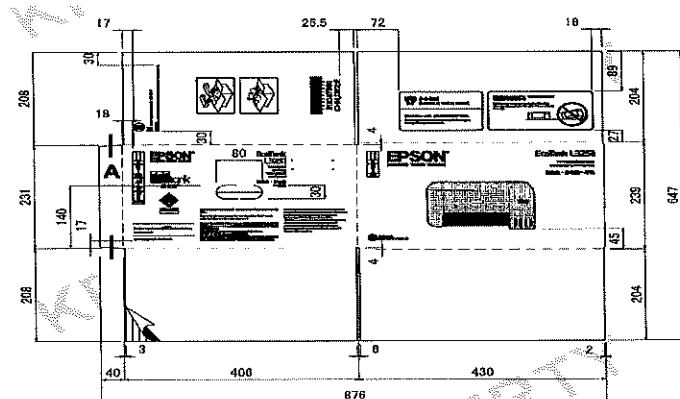
W1: INVERTED AND SAME PANEL AT SEMI AUTO GLUING PROCESS.
W2: DOUBLE PANEL DETECTED BY SCANNER AT PANEL B FEEDING AREA. IT IS POSSIBLE THAT THE DOUBLE PANEL A CAME FROM DIE CUTTED RAW MATS AND THEY CONTINUE ASSEMBLE THE SAME PANEL FOR NG BUSTER SAMPLE.
W3: KEEPING THE SAME PANEL FOR NG BUSTER TO BE SUBMITTED TO QA.
W4: UPON SEGREGATION OF PANEL THEY DID NOT ATTACHED NG BUSTER LABEL AT THE ITEM AND IT IS POSSIBLE THAT THEY PLACED IT ON THE FG ITEMS WITHOUT PRIOR CHECKING.



> INVERTED PANEL AND SAME PANEL A

PRODUCTION ACTION PLAN

- > Re-orientation for QA& Production regarding to the issue of inverted and same panel issue
- >For improvement of eyemark for diecut for browsing process and serves as printing guide..
- > Re-orientation regarding segregation of panels for rework item and rejectr item for proper tag/label



PR
VP

Prepared	Checked	Approved
Signature over Printed Name	G. MAGSINO Signature over Printed Name	Y. MANDIRA Signature over Printed Name
Date: August 18, 2022	Date: August 19, 2022	Date: August 19, 2022

Note: Approval must be Manager level above

SUPPLIER'S ABNORMAL QUALITY ACTION REPORT

Issuing Section :

VPPE

SUPPLIER NAME : KANEPACKAGE
AQIN Control No. : VPPE-AQIN-22-08-0353
AQIN Received Date : AUGUST 18, 2022
SQA/R Reply Date : AUGUST 19, 2022

Part Name : H795 (CZECH) CARTON BOX (BAU)_PH

Part Code : 515048700

Model : CZECH

Defect Name : MIXED PANEL

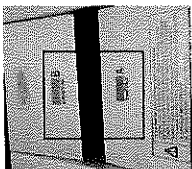
IMMEDIATE ACTION (Include Lot Label Markings , Sorting and Rework Result)

PREVIOUS LOTS CONFIRMATION (At least 3 lots):

Sorting quantity at Kplima : 134
Reject quantity : 0
Defect rate : 0%

CAUSES AND COUNTERMEASURES

WHY WHY ANALYSIS

SUBJECT (THEME)	WHY 1	WHY 2	WHY 3	WHY 4	WHY 5	JUDGMENT	CORRECTIVE ACTIONS (AVOIDANCE OF RECURRENCE)	PREVENTIVE ACTIONS (STANDARDIZATION)	To be filled up by EPPI: STATUS (During the time of verification)
	Root Cause: (Direct Cause) Mixed panel occurred due to mixed up of salvage item of 1st job 514471700 to the running of 3rd Job 515048700.	Item for salvage was not properly segregated. 	Operator-in-charge put the salvage item on the feeding without browsing just to catch on the machine running.				Direct Cause(s) Re-orientation of operator on proper line clearance and standard procedure. Prior set up of the next job and in order check the stocking section if they have remaining items. In-charge : KP/Lima Production Date : August 18, 2022	Direct Cause(s) •Separate trolley for the FG of rework items. •Senior operator/ sub leader do checking of panel from salvage location for the judgement of reject and for rework item. •Orientation of operator regarding their assigned position and their responsibilities.  In-charge : KP/Lima-Production Date: August 18, 2022	
STATUS	Leakage Cause: (Indirect Cause) Operator-in-charge proceed on placing the salvage item without checking if the barcode scanner was still on.	Standard procedure were not followed by operator- in- charge causing flow out of mixed panel.	QA Inspector only focused on checking the items which are not detectable by barcode scanner. (Manual/visual checking for items with no printed barcodes.)				514471700 Carton Box Assured Lot:KAN190800351 Markings: ALS S15048700 Carton Box Assured Lot:KAN15349D0351 Markings: ALS Indirect Cause(s) Re-orientation of production operator to strictly follow the standard process of checking the barcode scanner prior to running of the salvage item. Sort all affected stocks. Tighten inspection for item with or without barcode. Tighten inspection for items coming from salvage. In-charge : KP/Lima QA Date : August 18, 2022	Indirect Cause(s) Revised WI for Rework Process which specify standard procedure of production in processing and checking of items from rework. 100% inspection of QA inline during semi auto gluing machine. Provide inspection sequence for the VP model items for QA Inspector reference. Revised WI for ICB and Brown Box inspection standard to include inspection standard for items coming from salvage. In-charge : KP/Lima QA Date : August 18, 2022	
PRECONDITIONS	QA Inspector failed to detect mixed panel on Carton Box 515048700 that caused customer flow out.	QA Inspector did not followed the standard inspection process of VP ICB.							

Note: If there is no evidence for DISPOSAL, Disposal records (photos or any proof of disposal) should be attached.

TO BE FILLED BY SUPPLIER:		LEAKAGE CAUSE FACTOR (INDIRECT CAUSE)	
ROOT CAUSE FACTOR (DIRECT CAUSE)		LEAKAGE CAUSE FACTOR (INDIRECT CAUSE)	
☐ No Standard ☐ Incomplete Standard ☐ Design Problem	☐ Wrong Standard/Spec ☐ Did not follow Work Standard	☐ No Standard ☐ Incomplete Standard ☐ Design Problem	☐ Wrong Standard/Spec ☐ Did not follow Work Standard
P/s specify : _____		P/s specify : _____	

TO BE FILLED BY EPPI:

EFFECTIVENESS CHECK OF ACTIONS TAKEN

VERIFICATION RESULT		ASSESSMENT RESULT	
Guaranteed Lot	Delivery Date:	INPROCESS	
IOA	Result:	☐ SATISFACTORY ☐ UNSATISFACTORY	
Defect Rate:	Defect Rate:		
Judgment	Judgment		
☐ Passed ☐ Failed	☐ Passed ☐ Failed		

Notes:
(1) For Unsatisfactory result, Supplier must re-submit new action report until satisfactory result is attained.
(2) Provide additional attachments as supporting documents for this report.
(3) Verification result will depend on the corrective action taken by supplier (assured lot).

Prepared	Checked	Approved
STAFF	SV ABOVE	DEPT. HEAD
Date:	Date:	Date: