

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

**KANEPACKAGE PHILIPPINE INC.**

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INVESTIGATION REPORT

Prepared By:

Check By:

Approved By:

DATE:

07-Oct-22

C. Arevalo/ K.Diaz
QA-IE/ Production IEG. Magsino
QA SupervisorR. Miranda
KPLIMA Gen. Operation Mgr.**I. PROBLEM DESCRIPTION****1.1. ISSUE:**

DAMAGED

1.2. ITEM DESCRIPTION:**PART CODE:**

515693100

PART NAME:

CARTON BOX

1.3. BACKGROUND:

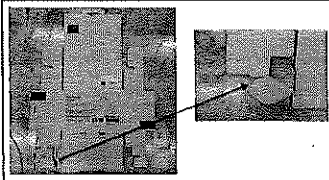
N/A

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge

III. WHY WHY ANALYSIS DETAILS:**DIRECT CAUSE:**

- WHY 1: Damaged occurred during manual detaching process, edge part of board/ panel was affected and included in detaching instead of scrap part.
WHY 2: Edge part of panels were included because of multiple quantity of panels were grip and detach at the same time.
WHY 3: No declared standard quantity for gripping in Detaching procedure.

**OCCURRENCE ROOTCAUSE:**

- > Affected by gripping/detaching multiple panels at once

IV. CORRECTIVE ACTION:

- > Set standard grip quantity on the size of scrap of item to be detach.
*Maximum : 4 panels
* Minimum : 2 panels