

5M + 1 REVIEW

FACTORS	DETAILS
MAN	NO CHANGES
MACHINE	NO CHANGES
METHOD	NO CHANGES
MATERIAL	DEFORMED BLADE OF 516485000
MEASUREMENT	NO CHANGES
ENVIRONMENT	NO CHANGES

**KANEPACKAGE PHILIPPINE INC.**

No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

INVESTIGATION REPORT

Prepared By:

Check By:

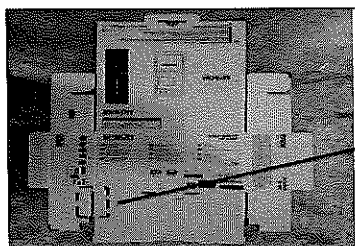
Approved By:

DATE:

20-Oct-22

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

WAVE CUT

1.2. ITEM DESCRIPTION:**PART CODE:** 51648500**PART NAME:** CARTON BOX**1.3. BACKGROUND:**

> Inhouse Detection : Wave cut
> Lot size: 452pcs
> Reject Qty: 48pcs
> Rejection Rate: 10.6%
> JO#: 022909
Remarks: Due to deform blade

II. IMMEDIATE ACTION

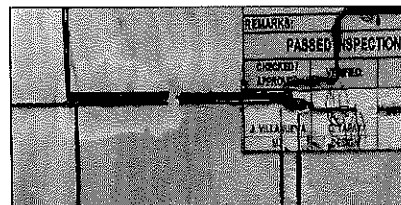
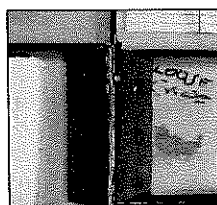
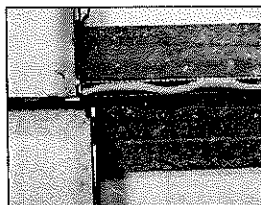
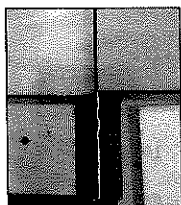
ACTION ITEMS	Target Date:	Person In-charge

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

WHY 1: Wave cut occurred on the item during running at die cut on the flap

WHY 2: There is a scrap stuck between the blade that lead to deforming the blade.

WHY 3: When the scrap stacking on the blade during running, it creates to widening the blade.



Actual Blade

IV. CORRECTIVE ACTION:**DIRECT CAUSE:**

1. The tooling custodian repaired the blade.
2. The tooling custodian already PR the blade.

