

5M + 1 REVIEW

FACTORS	DETAILS
MAN	NO CHANGES
MACHINE	NO CHANGES
METHOD	NO CHANGES
MATERIAL	DUE TO SHORT AMOUNT OF VARNISH ON ITEM (LIONEL PG)
MEASUREMENT	NO CHANGES
ENVIRONMENT	NO CHANGES

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INVESTIGATION REPORT

Prepared By:

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KPLIMA Gen. Operation Mgr.

DATE:

19-Oct-22

I. PROBLEM DESCRIPTION**1.1. ISSUE:**

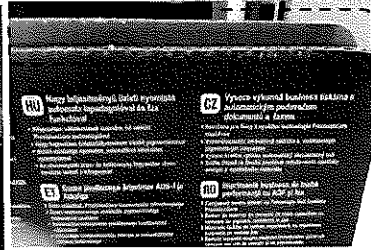
SCRATCHES

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

516428500

PART NAME:

LIONEL PG ICB FOR EAL

1.3. BACKGROUND:

> Inhouse Detection : Scratches

> Lot size: 290

> Reject Qty: 290

> Rejection Rate: 100%

> JO#: 023410

Remarks: Scratches occurred on the upper flap class B

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge

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

WHY 1: Scratches occurred on the upper flap class b at diecut process.

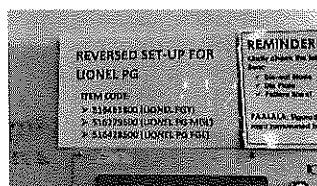
WHY 2: Due to short amount of varnish application of item that may caused scratches.

WHY 3: The operator didn't notice the item that it has a short varnish that may prone to scratches.

> The catcher operator skip the standard procedure to checking of item.

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

1. Orientation to the operator regarding the issue of scratches
2. Posting signage of item code that is prone to scratches
3. Reversing the set up of the dieblade, pattern sheet and dieplate of the item code that is prone to scratches.



Signage



Minutes of Meeting