

**KANEPACKAGE PHILIPPINE INC.**

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INVESTIGATION REPORT

Prepared By:

Check By:

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 KPLIMA Gen. Operation Mgr.

DATE:

20-Oct-22

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

SCRATCHES

1.2. ITEM DESCRIPTION:**PART CODE:** 515715400**PART NAME:** LIONEL FPY ICB FOR AMERICA**1.3. BACKGROUND:**

>Date Encountered: 221019

>Lot qty.: 180ea

>Reject qty.: 31ea

>Reject percentage: 17.22%

>Machine#: Gluing machine 4

Remarks:

Scratches occurred at upper flap class B (Blue Background) at panel B portion.

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge

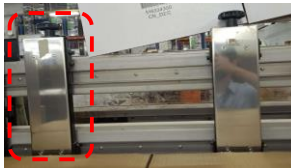
III. WHY WHY ANALYSIS DETAILS:**DIRECT CAUSE:**

WHY 1: Scratches at semi-auto gluing process.

WHY 2: During running, the item hang at the feeder area that can cause scratches on the upper flap.

WHY 3: Operator did not notice the loose guide at the feeder area.

WHY 4: The guide loose cause of the vibration of the machine and possible that the spacer is not in good condition and need to replace.

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

1. Orient the operator regarding to the issue of scratches for awareness.



2. Putting of Cable tie on the Guide for temporary usage.



3. Request for the replacement of spacer to Engineering.
Target date: 2nd week of November.