



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

DATE:	16-Nov-22	Prepared By:	Check By:	Approved By:
		C. Arevalo/ M. Vito QA-IE/ Production IE	G. Magsino QA Supervisor	R. Miranda KPLIMA Gen. Operation Mgr.

I. PROBLEM DESCRIPTION

1.1. ISSUE:

SCRATCHES

1.2. ITEM DESCRIPTION:

PART CODE:

515821700

PART NAME:

LIONEL MGY

1.3. BACKGROUND:



>Date Encountered: 221116

>Lot qty.: 170ea

>Reject qty.: 106ea

>Reject percentage: 62.35%

>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: Feeder operator do set-up at the feeding area and the first run of the item are in good condition

WHY 3: During Running of item, they did not notify the panels are having scratches due to feeder guide not in good set-up.

WHY 4: The guide was too close to the item during running and it is possible that when the operator re-feed the feeder area the weight of the item affect while feeding



INDIRECT CAUSE:

WHY 1 :

WHY 2:

WHY 3:

IV. CORRECTIVE ACTION:

DIRECT CAUSE:

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

- follow the maximum qty of the item at feeder area

- re-setting of feeder guide

-checking of item at catcher/folder for the scratches issue

- Already given NTE to the operator

KANEPACKAGE PHILIPPINE, INC.

ATTENDANCE SHEET

Submitted by: Date: 13/11/22

ACTIVITY: Scratches due to wrong set-up at Feeder

Attendees			
SERIAL NO.	FIRST NAME	LAST NAME	SIGNATURE
1	JOHN CARLOS		
2	JOHN CARLOS		
3	JOHN CARLOS		
4	JOHN CARLOS		
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