

5M + 1 REVIEW

FACTORS	DETAILS
MAN	NO CHANGES
MACHINE	NO CHANGES
METHOD	NO CHANGES
MATERIAL	THERE WAS A SCRAP LEFT ON THE PLATE
MEASUREMENT	NO CHANGES
ENVIRONMENT	NO CHANGES

**KANEPACKAGE PHILIPPINE INC.**

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**INVESTIGATION REPORT**

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DATE:

21-Oct-22

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

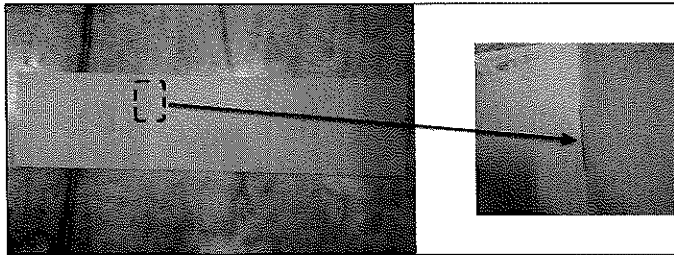
BURSTING

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

516224700

**PART NAME:**

LIONEL 2 MBL PAD SLEEVE

**1.3. BACKGROUND:**

> Inhouse Detection : Bursting  
> Lot size: 2480pcs  
> Reject Qty: 520pcs  
> Rejection Rate: 20.97%  
> JO#: 022792  
Remarks: Bursting occurred on the creasing

**II. IMMEDIATE ACTION**

ACTION ITEMS	Target Date:	Person In-charge

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

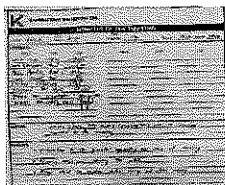
- WHY 1: Bursting occurred on the creasing of the item.  
WHY 2: Due to warp item, there is a possible to cause loose board.  
WHY 3: During running, the loose board of item had stuck on the machine.  
WHY 4: There is a possibility that the item had scrap left behind on the plate.  
WHY 5: The operator didn't notice that there was a scrap on the plate when running.

**INDIRECT CAUSE:**

- WHY 1 :  
WHY 2:  
WHY 3:

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

1. Orientation to the operator regarding the issue of bursting.
2. Removing scrap and cleaning the plate.
3. Always check the machine before, during and after running.

**Minutes of Meeting**