

**KANEPACKAGE PHILIPPINE INC.**

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INVESTIGATION REPORT

Prepared By:

Check By:

Approved By:

K.DIAZ

QA-IE/ Prodn IE

QA/ Prodn SV

KPLIMA Operations Gen. Mngr.

DATE:

16-Jan-23

5M REVIEW

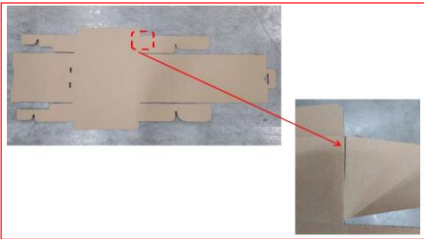
MAN	NO CHANGES
MACHINE	NO CHANGES
MATERIAL	NO CHANGES
METHOD	NO CHANGES
ENVIRONMENT	NO CHANGES

DOCUMENT REVIEW

Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
Procedure Manual		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision		
Work Instruction		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision		
Process Flow		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision		
Forms		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision		

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

BURSTING

1.2. ITEM DESCRIPTION:**PART CODE:** 516336400**PART NAME:** CARTON BOX**1.3. BACKGROUND:****PICTURE****DETAILS:**

- > Inhouse Detection : Bursting
- > Lot size: 700pcs
- > Reject Qty: 167pcs
- > Rejection Rate: 23.86%
- > JO#: 28742

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge

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

WHY 1: Bursting occurred on the side flap area.

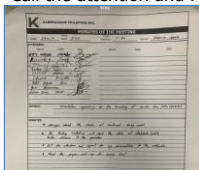
WHY 2: During running, the catcher operator did not notice that the item had bursting.

WHY 3: During setting up of the machine, the status of the die blade, creasing matrix, dieplate and pattern sheet were in good condition, but there was a movement occurred and it affects the item, therefore the defect turns out.

- > There is a possibility that the creasing blade was not aligned on the creasing matrix during mass production due to that movement. The dieplate might not balance because during set up, maybe the screw was not tight in the diechase.

IV. ACTION PLAN:**DIRECT CAUSE:**

- > Orientation to the operators regarding the problem being encountered.
- > Always check the status of materials being used or machine before, during or after running and set-up.
- > The tooling custodian will check the status of dieblade/plate before issuance to the operator.
- > Call the attention and report to the leader/subleader for any abnormalities.



Minutes of Meeting

