

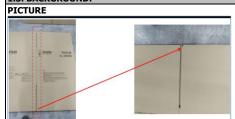
INVESTIGATION REPORT

Fax No. (049) 545-6302		Prepared By:	Check By:	Approved By:	
DATE:	26-Jan-23	K.DIAZ			
DAIL.	<u>20-Jan-25</u>	QA-IE/ Prodn IE	QA/ Prodn SV	KPLIMA Operations Gen. Mngr.	

5M REVIEW		DOCUMENT REVIEW					
MAN	NO CHANGES	Affected Document:	Date Reviewed:	Disposition:		PIC:	Target Date:
MACHINE	NO CHANGES	Procedure Manual		With Revision No R	evision		
MATERIAL	NO CHANGES	Work Instruction		□ With Revision □ No R	evision		
METHOD	NO CHANGES	Process Flow		With Revision ✓ No R	evision		
ENVIRONMENT	NO CHANGES	Forms			evision		

I. PROBLEM DESCRIPTION

1.1. ISSUE:						
	MISALIGNED CUT					
1.2. ITEM DESCRIPTION:	1.2. ITEM DESCRIPTION:					
PART CODE:	516172102					
PART NAME:	SMART CLIPPER					
1.3. BACKGROUND:						



DETAILS:

>Inhouse Detection : Misaligned cut

>Lot size: 170pcs > Reject Qty: 125pcs >Rejection Rate: 73.53%

>JO#: 29487

II. IMMEDIATE ACTION

	ACTION ITEMS	Target Date:	Person In-charge
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III. WHY WHY ANLYSIS DETAILS:

WHY 1: Misaligned cut occurred on the item 516172102 (SMART CLIPPER) on diecut machine 1.

WHY 2: The operator do the manual feeding during mass production to support the item in the delivery. WHY 3: The issued item was warp. (urgent item)

INDIRECT CAUSE:
WHY 1: The item being issued was warp and no weights on top of the items.
WHY 2: There is a possibility that no available weights to be used.

IV. ACTION PLAN:

DIRECT CAUSE:

- Orientation to the opearators regarding to the problem being encountered.
 Request the item to run in diecut 3 since diecut 1 gripper was not in good condition.
 Report and inform for any abnormalities to leader.

INDIRECT CAUSE:

> Inform the qa to have weights in every item before issuance.