

**KANEPACKAGE PHILIPPINE INC.**

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INVESTIGATION REPORT

Prepared By:

Check By:

Approved By:

DATE:

13-Feb-23

K.DIAZ

QA-IE/ Prodn IE

QA/ Prodn SV

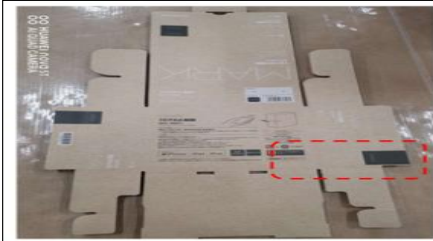
KPLIMA Operations Gen. Mngr.

5M REVIEW**DOCUMENT REVIEW**

MAN	NO CHANGES	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	NO CHANGES	Procedure Manual		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision		
MATERIAL	NO CHANGES	Work Instruction		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision		
METHOD	NO CHANGES	Process Flow		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision		
ENVIRONMENT	NO CHANGES	Forms		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision		

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

MISALIGNED CUT

1.2. ITEM DESCRIPTION:**PART CODE:** 515693100**PART NAME:** FRANZ CARTON BOX**1.3. BACKGROUND:****PICTURE****DETAILS:**

- > Inhouse Detection : Misaligned cut
- > Lot size: 870pcs
- > Reject Qty: 88pcs
- > Rejection Rate: 10.11%
- > JO#: 30257

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge

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

WHY 1: Misaligned cut encountered with actual measurement of 1mm; Requirement of 5mm.

WHY 2: On trial, there is no misaligned cut encounter but during mass production, the defect comes up.

WHY 3: In the middle of processing, the operator encountered excess single face and printed sheet on the item.

> Having the encountered issue, on the first process in the lamination, operator should check the set-up of items during running.

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

- > Orientation to the operators regarding to the problem being encountered.
- > Immediate Action: The operator sort the items having excess of sf and ps
 - > They adjust the side jucker on the diecut machine to get the exact set-up to prevent the defect.
- > In Lamination process, the catcher operator must inform the subleader/leader if there was an abnormality encountered.