
 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	<h1>INVESTIGATION REPORT</h1>		
	Prepared By:	Check By:	Approved By:
	K. DIAZ	N. CEPEDA	R. MIRANDA
DATE:	230314	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	K. DIAZ	N/A
MATERIAL	No Changes	Work Instruction		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	K. DIAZ	N/A
METHOD	No Changes	Process Flow		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	K. DIAZ	N/A
ENVIRONMENT	No Changes	Forms		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	K. DIAZ	N/A

I. PROBLEM DESCRIPTION

1.1. ISSUE:	
	DAMAGED DUE TO DIECUT STOPPER
1.2. ITEM DESCRIPTION:	
PART CODE:	514471900
PART NAME:	ICB
1.3. BACKGROUND:	
PICTURE  Damaged due to diecut stopper	DETAILS: > Inhouse Detection : Damage > Lot size: 393pcs > Reject Qty: 10pcs > Rejection Rate: 2.54% > JO#: 32240

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
N/A	N/A	N/A
N/A	N/A	N/A

III. CAUSE ANALYSIS:

WHY 1:	Damaged of item due to diecut stopper
WHY 2:	Improper arrangement of weights to the item and it result the warpage of the item which causes the problem when it place to the die cut because its not align to the feeder stopper. Sometime goes up and go down the item and it cause damage to the edges of item because hits the feeder stopper when running.
WHY 3	Improper set up in feeder stopper

IV. ACTION PLAN:

V. EVIDENCES:

1	Orient the operator on proper placement of weight to avoid warpage.	*Please see attached on next sheet*
2	Before and after work orient the operator about the level of feeder stopper depending to the Item size.	*Please see attached on next sheet*

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3	Conduct Monitoring every changes of the Items.	*Please see attached on next sheet*
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