
 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>		
DATE: 230314		Prepared By: GIELEN SAYAS QA-IE/ Prodn IE	Check By: NOEMI CEPEDA QA/ Prodn SV	Approved By: RHODORA MIRANDA KPLIMA Operations Gen. Mngr.

5M REVIEW		DOCUMENT REVIEW				
MAN	NO CHANGES	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	Defective upper and lower wheel roller of the machine	Procedure Manual	230314	<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	N/A	N/A
MATERIAL	NO CHANGES	Work Instruction		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	N/A	N/A
METHOD	NO CHANGES	Process Flow		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	N/A	N/A
ENVIRONMENT	NO CHANGES	Forms		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	N/A	N/A

I. PROBLEM DESCRIPTION

1.1. ISSUE:	
	MISALIGN GLUING
1.2. ITEM DESCRIPTION:	
PART CODE:	516592900
PART NAME:	LOUVRE 2 MJX
1.3. BACKGROUND:	
PICTURE 	DETAILS: LOT QTY: 1900 REJECT QTY :97 REJECT PERCENTAGE: 5.11% MISALIGN GLUING MISALIGN GLUING ENCOUNTERED DUE TO MACHINE ERROR

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
Operator in-charge call the attention of his sub-leader to inform encountered misaligned gluing.	230311	LAMINATION OPERATOR
N/A	N/A	N/A

III. CAUSE ANALYSIS:

WHY 1:	Misaligned gluing encountered due to machine error at Lamination machine 2.
WHY 2:	Machine Error occurred at the start of mass production. Misalignment was detected by the Lamination Operator and In-process QA in which they automatically stop the machine to verify occurrence of error. Note: 97 pcs. were the affected quantity inside the conveyor that caused high incurred of rejection.
WHY 3	Upon verification, misaligned gluing was due improper movement of the upper and lower wheel roller. (Upper Wheel must be in clockwise rotation to catch the PS properly)
WHY 4:	Improper movement of the upper and lower wheel was due encountered defective upper and lower wheel roller of the machine. Note: Affected also due to it's long term use.

IV. ACTION PLAN:

V. EVIDENCES:

1	Conduct an orientation to operators regarding the misaligned gluing. PIC: Prod IE Target Date: 230313	*Please see attached on next sheet*
2	Submit work request for the total repair of the upper and lower wheel. PIC: Prod IE Target Date: 230313	*Please see attached on next sheet*

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3	Request of spare of upper and lower wheel. PIC: Engineering Target Date: Still Pending UPDATE: For the right lower and upper wheel. Lower wheel already replaced. Upper wheel for both right and left are already repair.		*Please see attached on next sheet*	