
 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			
	QA-IE/ Prodn IE	QA/ Prodn SV	KPLIMA Operations Gen. Mngr.			
DATE:	230313					
5M REVIEW		DOCUMENT REVIEW				
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	230313	<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	K. DIAZ	N/A
MATERIAL	<i>Worn out ejector sponge</i>	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:	
	BURSTING
1.2. ITEM DESCRIPTION:	
PART CODE:	516592900
PART NAME:	LOUVRE 2 MJX ICB FOR EUROPE
1.3. BACKGROUND:	
PICTURE 	DETAILS: > Inhouse Detection : Bursting > Lot size: 1900pcs (PANEL A) > Reject Qty: 60 pcs (PANEL A) > Rejection Rate: 3.16% > JO#: 32448

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
Operator in-charge call the attention of his sub-leader to inform encountered bursting.	230310	Diecut Operator
N/A	N/A	N/A

III. CAUSE ANALYSIS:

WHY 1:	Bursting occurred on the folding side of the bottom part Class A portion of the item.
WHY 2:	During mass production, catcher operator and in-process QA notice occurrence of bursting in the item that was caused by a left-over scrap on the creasing matrix.
WHY 3:	Scrap left on the plate was due to encountered worn out ejector sponge of the blade. Note: That the creasing matrix in the plate was in good condition.
WHY 4:	Worn out ejector sponge was not immediately check which caused to accumulate high rejection of bursting defect.
WHY 5:	

IV. ACTION PLAN:

V. EVIDENCES:

1	Conduct an orientation to operators regarding the bursting encountered on Louvre SB. PIC: Prod IE Target Date: 230313	*Please see attached on next sheet*
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2

Changing the ejector sponge from gray to green one since the green ejector sponge was harder than the gray ejector sponge.
PIC: Tooling Custodian
Target Date: 230310

Please see attached on next sheet

3

Checking the condition of creasing matrix before setting up of the machine.
PIC: Prod. In-charge
Target Date: 230313

N/A