

**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

**INVESTIGATION REPORT**

Prepared By:

Check By:

Approved By:

K.DIAZ

N. CEPEDA

R. MIRANDA

**DATE:**

Thursday, 23 March 2023

QA-IE/ Prodn IE

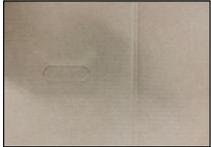
QA/ Prodn SV

KPLIMA Operations Gen. Mngr.

**5M REVIEW****DOCUMENT REVIEW**

MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	230321	<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	K. DIAZ	N/A
MATERIAL	Stiffness condition and Wrinkled Appearance	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**

<b>1.1. ISSUE:</b>	
	CRACKING
<b>1.2. ITEM DESCRIPTION:</b>	
<b>PART CODE:</b>	516513000
<b>PART NAME:</b>	LIGHT MB ICB FOR AMERICA DE
<b>1.3. BACKGROUND:</b>	
<b>PICTURE</b>	<b>DETAILS:</b>
 GOOD	 REJECT
	>Inhouse Detection : Cracking >Lot size: 1600pcs > Reject Qty: 269pcs >Rejection Rate: 16.81% >JO#: 33046

**II. IMMEDIATE ACTION**

ACTION ITEMS	Target Date:	Person In-charge
Catcher operator and QA in-process call the attention of their leaders and immediately stop the process for retrieval.	230320	Diecut Operator and QA In-process
Sorting of the affected panels.	230320	Production Diecut and QA Sub-leader

**III. CAUSE ANALYSIS:**

<b>WHY 1:</b>	During mass production, cracking in the materials was observed. Note: Total quantity running was 1,600 pcs. and it started to occurred and been detected from 1,000 pcs. onwards.
<b>WHY 2:</b>	Cracking was due to the placement of new stripping foam in the diecut plate in which caused an excessive pushing and squeezing during running.
<b>WHY 3:</b>	Excessive pushing and squeezing during running was due to encountered not good condition of the boards. Note:There seems to have a stiffness condition and a visible wrinkled appearance.
<b>WHY 4:</b>	Not good condition of the material use contributes to cracking and creased on item which randomly occurred during running.

**IV. ACTION PLAN:****V. EVIDENCES:**

1	Checking the raw material to be used. Remarks: Tighten browsing inspection during feeding of the boards. PIC: Diecut Feeder Operator Target Date: March 23, 2023	*Please see attached on next sheet*
2	Orientation and reminder regarding the implementation and correct checking and/or browsing during feeding of the boards. PIC: Production IE and Sub-leader in-charge Target Date: March 23, 2023	*Please see attached on next sheet*

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3	Monitor 3 consecutive running of this same item or model if there will be recurrence. PIC: Production IE Target Date: March 23, 2023	<b>*Still for monitoring*</b>
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