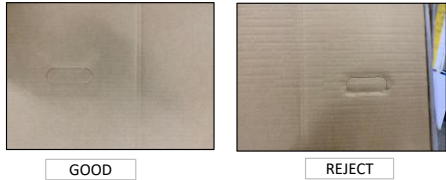
 KANEPACKAGE PHILIPPINE INC. No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna Telephone No. (049) 545-7166 to 69 Fax No. (049) 545-6302	<h1>INVESTIGATION REPORT</h1>		
	Prepared By:	Check By:	Approved By:
	K.DIAZ	N. CEPEDA	R. MIRANDA
DATE:	Thursday, 23 March 2023	QA-IE/ Prodn IE	QA/ Prodn 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

1.1. ISSUE:	
	CRACKING
1.2. ITEM DESCRIPTION:	
PART CODE:	516513000
PART NAME:	LIGHT MB ICB FOR AMERICA DE
1.3. BACKGROUND:	
PICTURE 	DETAILS: >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:

WHY 1:	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.
WHY 2:	Cracking was due to the placement of new stripping foam in the diecut plate in which caused an excessive pushing and squeezing during running.
WHY 3:	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.
WHY 4:	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	*Still for monitoring*
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