
 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:	21-Mar-23	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	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:	
	PEEL-OFF
1.2. ITEM DESCRIPTION:	
PART CODE:	516513000
PART NAME:	LIGHT MB ICB FOR AMERICA DE
1.3. BACKGROUND:	
PICTURE 	DETAILS: > Inhouse Detection : PEEL OFF > Lot size: 1600pcs > Reject Qty: 47pcs > Rejection Rate: 2.94% > JO#: 33046

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
Production gluing in-charge inform the diecut subleader regarding the occurrence of peel off defect.	230320	Gluing subleader and Diecut subleader

III. CAUSE ANALYSIS:

WHY 1:	Peel off was due to manual stripping process in which the edge part of the board/ panel was been detached.
WHY 2:	Detached edge part was due to encountered uncut during running in the diecut process.
WHY 3:	Uncut was encountered randomly and alternating in which from every 20 pcs output, 5 pcs found out to have uncut issue. Note: During mass production, the catcher mislook the occurrence of uncut.
WHY 4:	Uncut was due to imbalance condition of the blade. Note: The item used new blade and new pattern sheet.

IV. ACTION PLAN:

V. EVIDENCES:

1	Checking and repair of the blade. PIC: Tooling custodian Target Date: Checking of the next running of the item	*Still for monitoring*
2	Orientation regarding the checkpoints of the diecut catcher operator. Remarks: Uncut must be rework immediately by in-charge once observed. PIC: Production IE Target Date: March 23, 2023	*Please see attached on next sheet*