
 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:	Thursday, 23 March 2023					
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	Not following standard procedure	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:	
	DAMAGED
1.2. ITEM DESCRIPTION:	
PART CODE:	516513000
PART NAME:	LIGHT MB ICB FOR AMERICA DE
1.3. BACKGROUND:	
PICTURE 	DETAILS: >Inhouse Detection : Damage >Lot size: 1600psc > Reject Qty: 29pcs >Rejection Rate: 1.81% >JO#: 33046

II. IMMEDIATE ACTION

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

III. CAUSE ANALYSIS:

WHY 1:	Damaged was encountered randomly during running of mass production. Note: Found 29 pcs. out of 1,600 pcs.
WHY 2:	Damaged was due to encountered warp condition of the boards. Note: Proper placement of weights was not followed which contributes to warpage of the boards.
WHY 3	During feeding of the warp boards on the diecut feeder section, it hits and hang on the feeder stopper that causes damaged.
WHY 4:	Damaged was due to improper set up of the feeder section and improper filling of panels during feeding.
WHY 4:	Standard set-up for feeder section and proper filling of panels was not followed.

IV. ACTION PLAN:

V. EVIDENCES:

1	Orientation to lamination operator in-charge on proper placement of weight to avoid warpage. PIC: Production IE and Subleader in-charge Target Date: March 23, 2023	*Please see attached on next sheet*
2	Orientation regarding the proper set-up of the feeder when encountered warp condition of the boards and proper filling during feeding which needs to put enough panels/boards in the feeder section to flatten the bottom part while running and prevent the item from hitting on the diecut stopper. PIC: Production IE and Subleader in-charge Target Date: March 23, 2023	*Please see attached on next sheet*

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3	Monitor next running of this item to check if there will be recurrence. PIC: Production IE in-charge Target Date: March 23, 2023	*Still for monitoring*
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