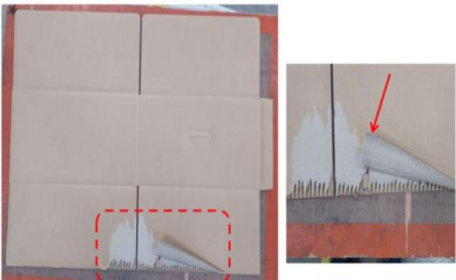
 KANEPACKAGE PHILIPPINE INC. No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna Telephone No. (049) 545-7166 to 69 Fax No. (049) 545-6302	<h1>INVESTIGATION REPORT</h1>		
	Prepared By:	Check By:	Approved By:
	K.DIAZ	N. CEPEDA	R. MIRANDA
DATE:	March 28-2023	QA-IE/ Prodn IE	QA/ Prodn SV
		KPLIMA Operations Gen. Mngr.	

5M REVIEW		DOCUMENT REVIEW					
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:		PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	230328	<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:	
	Damage
1.2. ITEM DESCRIPTION:	
PART CODE:	516297800
PART NAME:	LOUVRE 2MDX, ASIA W;C
1.3. BACKGROUND:	
PICTURE 	DETAILS: >Inhouse Detection : Damage >Lot size: 798pcs > Reject Qty: 15pcs >Rejection Rate: 1.88% >JO#: 33373

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
The process is immediately stopped for a re-trial once the catcher operator and the QA in-process inform their leaders	March 28-2023	Diecut Operator and QA In-process
Inspection of the affected panels.	March 28-2023	Production Diecut and QA Sub-leader

III. CAUSE ANALYSIS:

WHY 1:	During mass production, hand rod was not tight which caused damaged in the bottom flap of ICB. Note: Total quantity running was 798 pcs. and been detected in the middle of running wherein adjustments in the front guide hook was done.
WHY 2:	Loose hand rod was mislook by the operator in-charge and while placing the panel on the feeder section, the panel hits on the bottom feeder while running.
WHY 3	The placement of panel in the bottom feeder was improperly done. Note: The placement of panel in the bottom feeder not match the angle of the feeder section causing damaged.
WHY 4:	Operator in-charge was not following the standard machine start-up and set-up prior mass production.

IV. ACTION PLAN:

V. EVIDENCES:

**KANEPACKAGE PHILIPPINE INC.**

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Prepared By:

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QA-IE/ Prodn IE

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DATE:March 28-2023

1

Orientation and reminder regarding the implementation and correct and proper machine set-up.
PIC: Production IE and Sub-leader in-charge
Target Date: March 28, 2023

Please see attached on next sheet

2

Generate OPL as eyemark for the implementation of monitoring and checking every run the hand rod and front guide hook.
PIC: Die Cut Feeder Operator
Target Date: April 3, 2023

Please see attached on next sheet