

 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:	Wednesday, 29 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	230329	<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:	
	CRACKING
1.2. ITEM DESCRIPTION:	
PART CODE:	516513000
PART NAME:	LIGHT 2 MB AMERICA
1.3. BACKGROUND:	
PICTURE <div>   </div> <div> <div>GOOD</div> <div>REJECT</div> </div>	DETAILS: >Inhouse Detection : Cracking >Lot size: 898pcs > Reject Qty: 45pcs >Rejection Rate: 5.01% >JO#: 33380

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 retrial.	29-Mar-23	Diecut Operator and QA In-process
Inspection and sorting of the affected panels.	29-Mar-23	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 898 pcs. and it started to occurred and been detected in the middle of running.
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 ejector sponge.
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:

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Checking the raw material to be used.
Remarks: Tighten browsing inspection during feeding of the boards.
PIC: Diecut Feeder Operator
Target Date: March 29, 2023

Please see attached on next sheet

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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 29, 2023

Please see attached on next sheet