

**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

INVESTIGATION REPORT

Prepared By:

K.DIAZ

QA-IE/ Prodn IE

Check By:

N. CEPEDA

QA/ Prodn SV

Approved By:

R. MIRANDA

KPLIMA Operations Gen. Mngr.

DATE:

March 28, 2023

5M REVIEW**DOCUMENT REVIEW**

MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	No Changes	Procedure Manual		<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:**

BURSTING

1.2. ITEM DESCRIPTION:**PART CODE:**

516298200/515913000

PART NAME:

LOUVRE 2MCX ASIA/LOUVRE 2MJX EAL (SF)

1.3. BACKGROUND:**PICTURE****DETAILS:**

> Inhouse Detection : BURSTING
> Lot size: 1077pcs
> Reject Qty: 67pcs
> Rejection Rate: 6.22%
> JO#: 33375/33383

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
A tear apart problem is reported to the diecut subleader by the production gluing in-charge.	March 28, 2023	Gluing subleader and Diecut subleader

III. CAUSE ANALYSIS:

WHY 1:	Bursting happens since the creasing blade is higher than the cutting blade while its running.
WHY 2:	Due to the cushion crease's weakening and decreased ability to adhere to the board, the sheet board fails to fold correctly, resulting in bursting while its running.
WHY 3:	Applying too much backing tape and not aligning with the standard adhesive backing tape line. Note: During mass production, the operator applies backing tape where the tape expands or bulges due to over-application that cause bursting
WHY 4:	The die plate had a slope shape that was not compatible in die chase where bursting occurred. Note: During the machine set up, the operator did not notice that the die plate was sloped and was no longer compatible with the die chase.

IV. ACTION PLAN:**V. EVIDENCES:**

1	Checking and repair of the blade and Die palte Remarks: Sharpen the blade and trimming die plate if its needed. PIC: Tooling custodian Target Date: March 28, 2023	*Still for monitoring*
---	---	-------------------------------

**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

INVESTIGATION REPORT

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.

2

Checking and repair of backing tape, creasing blade if align

Note: New pattern sheet and cushion crease

PIC: Sub-leader and operator

Target: March 28,2023

3

Orientation regarding the checkpoints of the diecut catcher operator.

PIC: Production IE

Target Date: March 28, 2023

Please see attached on next sheet