

**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:

April 19, 2023

5M 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	THE DIEPLATE WAS DENTED	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

DOCUMENT REVIEW**I. PROBLEM DESCRIPTION****1.1. ISSUE:**

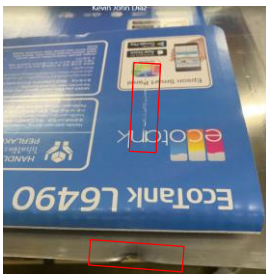
DAMAGED

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

516000200/516279400/516463600

PART NAME:

LIONEL PG

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

> Inhouse Detection : DAMAGED
> Lot size: 1194pcs
> Reject Qty: 196pcs
> Rejection Rate: 16.42%
> JO#: 34406/34405/34414

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
The production gluing in-charge alerts the diecut subleader to a tear apart issue and sorting of damaged panels.	April 19, 2023	Gluing subleader and Diecut subleader

III. CAUSE ANALYSIS:

WHY 1:	The machine is already set up before being used by the next assign in the machine die cut 3 and The damage occurs in the third JO of the diecut process because the edge of the plate is bent upwards while running. Note: The machine was set up at night, and the operator in the morning did not check the machine set up because they thought that the set up of the other shift was ok.
WHY 2:	Damage happens in diecut process since the edge of the plate is bent upwards while running Note: Found 196 pcs of reject out 1194 pcs
WHY 3:	The small part of the plate bent upwards where Damage occurred. Note: During the mass production, the catcher operator did not notice that the edge of the blade bent upwards during running where the damage occurred.
WHY 4:	

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

1	Checking and repair of Plate Remarks: PIC: Tooling custodian Target Date: April 19, 2023	*Still for monitoring*
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2

Checking of plate holder

Note: The operator will check the inside of the plate holder if needed

PIC: Sub-leader and operator and Operator

Target: April 19, 2023

3

Orientation regarding the checkpoints of the diecut catcher operator.

PIC: Production IE

Target Date: April 19, 2023

Please see attached on next sheet