

**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:

MHVITO

N. CEPEDA

R. MIRANDA

**DATE:**230502

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	230307	<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	MH.VITO	N/A
MATERIAL	SCRATCHES AT PANEL A	Work Instruction		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	MH.VITO	N/A
METHOD	No Changes	Process Flow		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	MH.VITO	N/A
ENVIRONMENT	No Changes	Forms		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	MH.VITO	N/A

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

SCRATCHES

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

516297700

**PART NAME:**

LOUVRE 2 MDX

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

- > SCRATCHES AT PANEL A LOUVRE 2MDX 516297700
- SCRATCHES AT UPPER FLAP CLASS B
- LOT QTY: 689 EA
- REJECT QTY: 69 EA
- REJECT PERCENTAGE: 10.01%

**II. IMMEDIATE ACTION**

ACTION ITEMS	Target Date:	Person In-charge
GLUING OPERATOR REPORT THE ABNORMALITY ENCOUNTER AT GLUING MACHINE 4 FOR THE ISSUE OF SCRATCHES AT PANEL A AND CONDUCT RETRIAL.	230325	Gluing Operator/QA
SEGREGATION OF REJECT ITEM(SCRATCHES) AND CHANGE PLAN	230325	Gluing Operator/QA

**III. CAUSE ANALYSIS:**

<b>WHY 1:</b>	SCRATCHES OCCURRED ON ITEM 516297700 LOUVRE 2 MDX PANEL (A) AT UPPER FLAP CLASS B.
<b>WHY 2:</b>	SCRATCHES WAS OBSERVED DURING MASS PRODUCTION AND THE OPERATOR IN-CHARGE IMMEDIATELY STOP RUNNING AND CONDUCT RETRIAL.  NOTE: TO CHECK IF THERE IS A PROBLEM WITH THE SET-UP, THEY CHANGE THE LOCATION OF PANEL A AND B, BUT STILL PANEL A HAS SCRATCHES.
<b>WHY 3:</b>	UPON SETTING OF THE ITEM AGAIN TO ITS STANDARD SET-UP, GOOD OUTPUT WAS ACHIEVED.

**IV. ACTION PLAN:**

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1	DO MANUAL GLUING TO THE ITEM FOR THE REAMAING PANELS	230325
2	REMIND THE OPERATOR TO THE ABNORMALITY ENCOUNTER TO THE PROCES REGARDING TO THE ISSUE OF SCRATCHES.	230325
3	HOLD THE ITEM AND CHANGE THE PLAN WHILE WAITING FOR APPROVAL	230325