

**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:

May 3, 2023

5M REVIEW

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	MISMATCH PS AND SF	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:**

MISALIGN CUT

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

516041100

PART NAME:

LIONEL F ASIA

1.3. BACKGROUND:**PICTURE**

Misaligned cut

DETAILS:

>Inhouse Detection :MISALIGN CUT
>Lot size: 879pcs
> Reject Qty: 19pcs
>Rejection Rate: 2.16%
>JO#: 35282

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
The production die cut in-charge alerts the lamination subleader to the misalign cut due to the gripper side.	May 3, 2023	Lamination subleader and Diecut subleader

III. CAUSE ANALYSIS:

WHY 1:	Misalign cut occurred on the upper flap due to the Mismatch of item Ps is bigger than Sf in lamination running, there will be too much gripper side in the item. Note: the catcher in Lamintaion dit not notice the excess gripper side.Because they thought the set up was correct and based on their checking
WHY 2:	Misalign cut happens in diecut process due to the extra gripper side, the gripper is folded due to the push of the side guide during running. Note: found 19 reject out of 879 pcs.
WHY 3	Due to pushing of side guide on the gripper side it folds while running where Misalign occurred. Note: During the feeder set up, the operator did not notice that the item has excess ps which resulted in misgalin cut while runing.

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

1	Checking of Gripper side Remarks: Sorting the excess Ps item.	PIC: Operator Target Date: May 3, 2023
2	Checking of feeder set up.	PIC: Sub-leader and operator Target: May 3, 2023

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Orientation regarding the checkpoints of the lamination catcher operator.

PIC: Production IE
Target Date: May 3, 2023