

**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	THE CRANK OF THE BACK G	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:**

DAMAGED

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

516041100

PART NAME:

LIONEL F ASIA

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

>Inhouse Detection : DAMAGED =
>Lot size: 879pcs
> Reject Qty: 22pcs
>Rejection Rate: 2.50%
>JO#: 35282

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
The production die cut in-charge alerts the subleader to a damage apart issue	May 3, 2023	Die cut subleader and Operator

III. CAUSE ANALYSIS:

WHY 1:	Damaged of item due to diecut stopper
WHY 2:	Damage happens in diecut process since the crank of die cut stopper is not lock that result loose of the crank during running. Note: found 22 reject out of 879 pcs.
WHY 3:	The crank of die cut stopper is loosen where Damage occurred. Note: During mass production, the operator did not notice that the crank of diecut stopper was loose.

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

1	Repair of Crank of Die cut stopper	PIC: Tooling custodian and Engineering Target Date: May 3, 2023
2	Checking of Die cut stopper	PIC: Sub-leader and operator Target: May 3, 2023

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Orientation regarding the checkpoints of the diecut catcher operator.

PIC: Production IE
Target Date: May 3, 2023