

**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:**

230405

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	230405	<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	MH.VITO	N/A
MATERIAL	No Changes	Work Instruction		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	MH.VITO	N/A
METHOD	WRONG SET-UP	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:**

516041100

**PART NAME:**

LIONEL F ASIA

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

Scratches

**DETAILS:**

> SCRATCHES AT GLUING MACHINE 4 LIONEL ASIA  
-SCRATCHES AT UPPER FLAP CLASS B  
-LOT QTY: 879 EA  
-REJECT QTY: 21 EA  
-REJECT PERCENTAGE: 2.39%

**II. IMMEDIATE ACTION**

ACTION ITEMS	Target Date:	Person In-charge
Re-setting of feeder roller AND TRIAL	230502	OPERATOR

**III. CAUSE ANALYSIS:**

<b>WHY 1:</b>	SCRATCHES OCCUR AT UPPER FLAP CLASS B OF LIONEL USING GLUING MACHINE 4
<b>WHY 2:</b>	UPON CHECKING OF THE SCRATCHES PROBLEM, FEEDER ROLLER IS NOT GOOD IN SET-UP (LOWER SET-UP FEEDER GUIDE)
<b>WHY 3:</b>	OPERATOR FAILED TO MEET THE REQUIRED HEIGHT OR ADJUSTMENT OF THE BOARD AT FEEDER AREA (ADJUSTMENT IS BASED ON THE THICKNESS OF THE BOARDS).

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

1	REMIND THE OPERATOR REGARDING SCRATCHES DUE TO WRONG SET-UP OR ADJUSTMENT OF STOPPER GUIDE (FEEDER GUIDE) AT FEEDER AREA.	230505
2	POST AN EYE MARK (OPL) AT FEEDER AREA	230507

**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

QA-IE/ Prodn IE

QA/ Prodn SV

KPLIMA Operations Gen. Mngr.

**DATE:**230405