


<div style="display: flex; align-items: center;"> <div> 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 </div> </div>	INVESTIGATION REPORT			
	Prepared By:	Check By:	Approved By:	
	MHVITO	N. CEPEDA	R. MIRANDA	
DATE:	230505	QA-IE/ Prodn IE	QA/ Prodn SV	KPLIMA Operations Gen. Mngr.

5M REVIEW		DOCUMENT REVIEW				
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:		PIC:
MACHINE	No Changes	Procedure Manual	230307	<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	MH.VITO
MATERIAL	No Changes	Work Instruction		<input checked="" type="checkbox"/> With Revision	<input type="checkbox"/> No Revision	MH.VITO
METHOD	Failed to Check both Panel A and Panel B	Process Flow		<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	MH.VITO
ENVIRONMENT	No Changes	Forms		<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	MH.VITO
						Target Date:
						N/A
						230512
						N/A
						N/A

I. PROBLEM DESCRIPTION

1.1. ISSUE:	
	Double Pannel
1.2. ITEM DESCRIPTION:	
PART CODE:	515998000
PART NAME:	LIONEL PG MGL ICB FOR AMERICA
1.3. BACKGROUND:	
PICTURE 	DETAILS: > DOUBLE PANEL -DOUBLE PANEL OCCURED ON THE ITEM (SAME PANEL B) -LOT QTY: 99 -REJECT QTY: 1 -REJECT PERCENTAGE:1.01%

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
A double panel is discovered and immediately informed the sub leader.	230504	Gluing Operator

III. CAUSE ANALYSIS:

WHY 1:	DOUBLE PANEL OCCURRED ON THE ITEM (SAME PANEL B) DURING MANUAL GLUING PROCESS
WHY 2:	WHILE EXECUTING A MANUAL GLUING, OPERATORS CHECK BOTH PANELS AND THEY DID NOT ENCOUNTER SAME PANEL DURING THE PROCESS. NOTE: IT'S POSSIBLE THAT WHILE DOING THE MANUAL GLUING, SOME OTHER PANEL WAS MIXED UP UPON THE PROCESS.
WHY 3	CHECKING THE QUANTITY OF BOTH PANELS IF THEY WERE EVEN (PANEL A AND PANEL B) BEFORE FOLDING IT WAS MISSED BY THE OPERATOR IN-CHARGE.
WHY 4:	OPERATOR FAILED TO DO MANUAL BROWSING BEFORE START RUNNING.
WHY 5:	THERE IS NO STANDARD WORK INSTRUCTION FOR MANUAL GLUING. NOTE: ONLY SEMI-AUTO GLUING AND MANUAL GLUING FOR EMORI ITEMS WAS USED AS TEMPORARY WI.

IV. ACTION PLAN:

**KANEPACKAGE PHILIPPINE INC.**

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ORIENT THE OPERATOR REGARDING TO THE ISSUE OF DOUBLE PANEL AND REMIND THE OPERATORS TO ALWAYS CONFIRM THAT BOTH PANELS ARE ACCURATE BEFORE BEGINNING THE FOLDING PROCESS.

Target Date: 230506

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REVISION OF WI TO INCLUDE MANUAL GLUING

Target Date: 230512