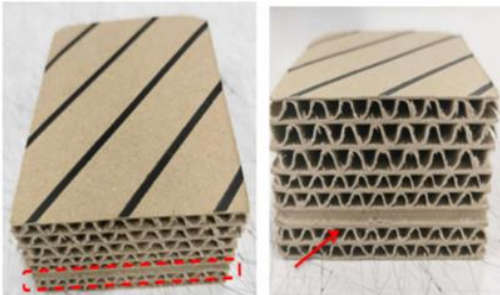
 KANEPACKAGE PHILIPPINE INC. No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna Telephone No. (049) 545-7166 to 69 Fax No. (049) 545-6302	<h1>INVESTIGATION REPORT</h1>		
	Prepared By:	Check By:	Approved By:
	MHVITO	N. CEPEDA	R. MIRANDA
DATE:	230509	QA-IE/ Prodn IE	QA/ Prodn SV
		KPLIMA Operations Gen. Mngr.	

5M REVIEW		DOCUMENT REVIEW					
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:		PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	230509	<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	MH.VITO	N/A
MATERIAL	No Changes	Work Instruction		<input checked="" type="checkbox"/> With Revision	<input type="checkbox"/> No Revision	MH.VITO	230514
METHOD	No proper checking of sheets	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:	
	INVERTED LAMINATED OF B FLUTE
1.2. ITEM DESCRIPTION:	
PART CODE:	516446201
PART NAME:	PAD ASSY
1.3. BACKGROUND:	
	DETAILS: > INVERTED LAMINATED B FLUTE DETECTED AT LUCIDA ASSY. > LOT QUANTITY: 100 EA > REJECT QTY: 100 EA <i>100 PERCENT REJECT</i>

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
SORTING OF AFFECTED BLOCKS	230505	OPERRATOR/ IE STAFF
HOLD THE RAW MATS FOR VERIFICATION	230505	LEADER/STAFF

III. CAUSE ANALYSIS:

WHY 1:	INVERTED LAMINATE OF B-FLUTE FOR 53X53 PAD BLOCKS OCCURED AT MANUAL LAMINATOR. NOTE: THIS WAS FOUND BY PRODUCTION ASSEMBLY.
WHY 2:	DURING LAMINATION PROCESS OF PAD BLOCKS, INVERTED B FLUTE OCCUR WHEN THE FEEDER OPERATOR FEED TWO FLUTE IN A SAME TIME. NOTE: ALL FLUTE MUST BE IN ONE OR IN THE SAME DIRECTION.
WHY 3	UPON PROCESSING OF PAD BLOCKS, CATCHER OPERATOR ALSO FAILED TO CHECK THE POSITION OF THE FLUTE.
WHY 4:	THERE IS NO STANDARD CHECKPOINTS FOR THE FEEDER AND CATCHER OPERATOR SPECIFIED ON THE WORK INSTRUCTION.

IV. ACTION PLAN:

V. TARGET DATE:

**KANEPACKAGE PHILIPPINE INC.**

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KPLIMA Operations Gen. Mngr.

1 REMIND THE OPERATOR REGARDING TO THE ISSUE OF INVERTED FLUTE.

230508

2 REVISION OF WI FOR THE CHECKPOINT OF THE OPERATOR.

230513