


 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:
	K. DIAZ	N. CEPEDA	R. MIRANDA
DATE:	May 3, 2023	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		<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:	5165127
PART NAME:	LIGHT 2 FA AMERICA
1.3. BACKGROUND:	
PICTURE 	DETAILS: >Inhouse Detection :MISALIGN CUT >Lot size: 1248pcs > Reject Qty: 64pcs >Rejection Rate: 5.13% >JO#: 35396

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 11, 2023	Lamination subleader and Diecut subleader

III. CAUSE ANALYSIS:

WHY 1:	Mismatch of item Ps is bigger than Sf in lamination running, there will be too much gripper side in the item, resulting in a misaligned cut on the upper flap. Note: The extra gripper side was unnoticed by the Lamination catcher. Considering that they checked and believed the setup was proper
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 64 reject out of 1248 pcs.
WHY 3:	Wrong setup resulting in misalign cut while running
WHY 4:	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 misalign cut while running.

IV. ACTION PLAN:

1	Checking of Gripper side Remarks: Sorting the excess Ps item.	PIC: Operator Target Date: May 11, 2023
2	Checking of feeder set up	PIC: Sub-leader and operator Target: May 11, 2023
3	Orientation regarding the checkpoints of the lamination catcher operator.	PIC: Production IE Target Date: May 11, 2023