
 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:
	K. DIAZ	N. CEPEDA	R. MIRANDA
DATE:	11-May-23	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	230321	<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:	
	SCRATCHES
1.2. ITEM DESCRIPTION:	
PART CODE:	516297700
PART NAME:	LOUVRE 2 MDX ICB FOR ASIA
1.3. BACKGROUND:	
PICTURE 	DETAILS: >Inhouse Detection : SCRATCHES >Lot size: 1397pcs > Reject Qty: 189pcs >Rejection Rate: 13.53% >JO#: 35479

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
Die cut catcher inform diecut operator regarding the occurrence of scratches defect.	11-May-23	Die cut Sub-Leader and operator

III. CAUSE ANALYSIS:

WHY 1:	Due to putting tape on the feeder parts causing scratches on the item Note. Total quantity is 1397 pcs and reject is 189 pcs. The scratches item detected in catcher area while running
WHY 2:	Scratches occurred when putting a lot of tape on the feeder parts that have hardened that rub against the item. Note: the operator unnoticed the hardened tape while putting an item in the feeder during running.

IV. ACTION PLAN:

1	Checking of feeder section	PIC: Operator Target Date: May 11, 2023
	Request Buffing	PIC: Engineering Target Date: May 11, 2023
2	Orientation regarding the checkpoints of the diecut catcher operator. Remarks: Uncut must be rework immediately by in-charge once observed.	PIC: Production IE Target Date: May 11, 2023