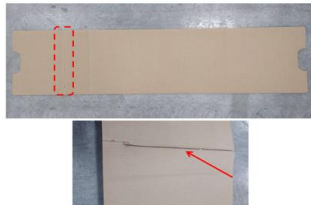
 <b>KANEPACKAGE PHILIPPINE INC.</b> No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna Telephone No. (049) 545-7166 to 69 Fax No. (049) 545-6302	<b>INVESTIGATION REPORT</b>		
	Prepared By:	Check By:	Approved By:
	K. DIAZ	N. CEPEDA	R. MIRANDA
<b>DATE:</b>	Thursday, 23 March 2023	QA-IE/ Prodn IE	QA/ Prodn SV
		KPLIMA Operations Gen. Mngr.	

5M REVIEW		DOCUMENT REVIEW				
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:		PIC:
MACHINE	No Changes	Procedure Manual	230321	<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	K. DIAZ
MATERIAL	Stiffness condition and Winkled Appearance	Work Instruction		<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	K. DIAZ
METHOD	No Changes	Process Flow		<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	K. DIAZ
ENVIRONMENT	No Changes	Forms		<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	K. DIAZ
						Target Date:

## I. PROBLEM DESCRIPTION

<b>1.1. ISSUE:</b>	
	CRACKING
<b>1.2. ITEM DESCRIPTION:</b>	
<b>PART CODE:</b>	51649900
<b>PART NAME:</b>	PAD SLEEVE
<b>1.3. BACKGROUND:</b>	
<b>PICTURE</b> 	<b>DETAILS:</b> >Inhouse Detection : Cracking >Lot size: 1800pcs > Reject Qty: 400pcs >Rejection Rate: 22.22% >JO#: 35568

## II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
Detatching operator call the attention of their leaders and immediately report In die-cut sub leader and operator	11-May-23	Diecut Operator and QA In-process
Sorting of the affected panels.	11-May-23	Production Diecut and QA Sub-leader

## III. CAUSE ANALYSIS:

<b>WHY 1:</b>	Due to the fragility of the material used. Note: Total quantity running was 1,800 pcs and reject is 400 detected in Detaching area
<b>WHY 2:</b>	Cracking was due to the placement of new stripping foam in the diecut plate in which caused an excessive pushing and squeezing during running.
<b>WHY 3:</b>	The cracking occurs as a result of the creasing blade getting hit incorrectly.

## IV. ACTION PLAN:

## V. EVIDENCES:

1	Checking the raw material to be used. Remarks: Tighten browsing inspection during feeding of the boards. PIC: Diecut Feeder Operator Target Date: May 11, 2023	
2	Orientation and reminder regarding the implementation and correct checking and/or browsing during feeding of the boards. PIC: Production IE and Sub-leader in-charge Target Date: May 11, 2023	