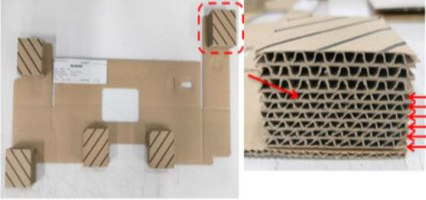
 KANEPACKAGE PHILIPPINE INC. No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna Telephone No. (049) 545-7166 to 69 Fax No. (049) 545-6302		INVESTIGATION REPORT		
		Prepared By:	Check By:	Approved By:
		MHVITO	N. CEPEDA	R. MIRANDA
DATE:	230509	QA-IE/ Prodn IE	QA/ Prodn SV	KPLIMA Operations Gen.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

5M REVIEW		DOCUMENT REVIEW					
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:		PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	230509	With Revision	No Revision	MH.VITO	N/A
MATERIAL	No Changes	Work Instruction		With Revision	No Revision	MH.VITO	N/A
METHOD	no proper checking of sheets	Process Flow		With Revision	No Revision	MH.VITO	N/A
ENVIRONMENT	No Changes	Forms		With Revision	No Revision	MH.VITO	N/A

I. PROBLEM DESCRIPTION

1.1. ISSUE:	
	EXCESS B FLUTE
1.2. ITEM DESCRIPTION:	
PART CODE:	516445401
PART NAME:	PAD ASSY
1.3. BACKGROUND:	
PICTURE 	DETAILS: > EXCESS B FLUTE DETECTED AT LUCIDA ASSEMBLY > LOT QTY 960EA > REJECT QTY: 1 EA MAJOR REJECT /DETECTED BY PACKING OPERATOR

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:	CESS FLUTE DETECTED AT LUCIDA ASSY DURING MASS PRODUCTION
WHY 2:	STANDARD FLUTE MUST BE 3 C-FLUTE AND 5 B-FLUTE, IN ACTUAL 3 C-FLUTE AND 6 B-FLUTE. SHEETS BEING USED WAS LAMINATED AT MANUAL LAMINATOR AND NO PROPER ORIENTAION REGARDING TO THE CHECKPOINTS OF THE OPERATOR.
WHY 3:	WORK INSTRUCTION WAS NOT CLEAR/NOT INDICATE THE CHECK POINTS TO THE PROCESS.
WHY 4:	NEW MACHINE BEING USED AND UNDER MONITORING FOR IMPROVEMENT

IV. ACTION PLAN:

V. EVIDENCES:

1	REMIND THE OPERATOR REGARDING TO THE ISSUE OF EXCESS B-FLUTE DETECTED AT LUCIDA ASSY.	230508
2	REVISION OF WI TO INCLUDE THE CHECKPOINTS/CHECKING OF ITEM PER PROCESS	230515