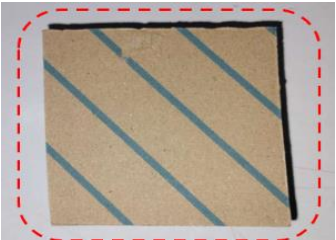
 <b>KANEPACKAGE PHILIPPINE INC.</b> No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna Telephone No. (049) 545-7166 to 69 Fax No. (049) 545-6302	<b>INVESTIGATION REPORT</b>		
	Prepared By:	Check By:	Approved By:
	MHVITO	N. CEPEDA	R. MIRANDA
<b>DATE:</b>	230509	QA-IE/ Prodn IE	QA/ Prodn SV
	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

5M REVIEW		DOCUMENT REVIEW					
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:		PIC:	Target Date:
MACHINE	MISALINGED BRASS BAR	Procedure Manual	230509	<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	MH.VITO	N/A
MATERIAL	No Changes	Work Instruction		<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	MH.VITO	N/A
METHOD	No Changes	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

<b>1.1. ISSUE:</b>	
	SLANTED CUT
<b>1.2. ITEM DESCRIPTION:</b>	
<b>PART CODE:</b>	516444701
<b>PART NAME:</b>	PAD BLOCK 60 X60
<b>1.3. BACKGROUND:</b>	
<b>PICTURE</b> 	<b>DETAILS:</b>  <i>LOT QTY: 10,000</i> <i>REJECT QTY: 180 EA</i> <i>REJECTION RATE: 1.80%</i> <i>JO#: 035881</i> <i>DETECTED BY PRODUCTION LUCIDA</i>

## II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
SORTING/HOLD THE RAW MATS FOR VERIFICATION	230509	OPERRATOR
REMINDE THE OPERATOR FOR THE ISSUE OF SLANTED CUT	230509	OPERRATOR

## III. CAUSE ANALYSIS:

<b>WHY 1:</b>	SLANTED BLOCKS OCCUR AT VERTICAL MACHINE 2
<b>WHY 2:</b>	SLANTED CUT OCCUR WHEN THE BLADE ARE WAVING AND IT IS POSSIBLE THAT THE BRASS BAR ARE DEFORMED. <i>NOTE: BRASS BAR MUCH BE RE-ALIGNED WHEN THE BLADE ARE WAVING.</i>
<b>WHY 3:</b>	OPERATOR DID NOT NOTICE THE MISALIGNED CUT DURING RUNNING DUE TO URGENCY OF THE ITEM

## IV. ACTION PLAN:

## V. EVIDENCES:

1	REALIGNED THE BRASS BAR TO AVOID WAVE BLADE	230509
2	REQUEST TO THE ENGINEERING FOR THE REPLACEMENT OF BRASS BAR	230516