
 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 QA-IE/ Prodn IE	N. CEPEDA QA/ Prodn SV	R. MIRANDA KPLIMA Operations Gen. Mngr.
DATE:	MAY 18, 2023		

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	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:	
	Damage
1.2. ITEM DESCRIPTION:	
PART CODE:	516512700/51651300
PART NAME:	LIGHT 2 FA America/Light 2 MB America
1.3. BACKGROUND:	
PICTURE 	DETAILS: >Inhouse Detection :DAMAGE >Lot size: 2072 > Reject Qty: 48pcs >Rejection Rate: 2.32% >JO#: 36242/36243



IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
Line Leader immediately inform Diecut Sub-Leader and operator for the encountered damaged defect.	May 19, 2023	Sub-leader and Die cut operator

III. CAUSE ANALYSIS:

WHY 1:	Damaged encountered on the diecut- inline detaching process in which the edge part of board/panel was improperly teared.
WHY 2:	Improper teared causing damaged of the board/panel was due to encountered uncut.
WHY 3:	Uncut was due to encountered widen of the backing tape during running in mass production. Note: The pattern sheet was also observed to be almost worn out.
WHY 4:	Proper use of backing tape was not properly followed.

IV. ACTION PLAN:

V. EVIDENCES:

1	Replacement of pattern sheet for Light MA and FA.	PIC: Tooling Custodian and Subleader Target Date: May 19, 2023
2	Orientation to diecut operator regarding the encountered damaged due to uncut and proper use of backing tape and proper disposal of pattern sheet that was worn out.	PIC: Production IE Target Date: May 19, 2023
3	To have a monitoring to have a pattern sheet lifespan. Note: This is still under observation if needed and could be feasible.	PIC: Production IE Target Date: June, 2023
4	Generate an OPL (One Point Lesson) as an eyemark for the diecut operators regarding proper use of backing tape and pattern sheet as well.	PIC: Production IE Target Date: May 24, 2023