

**KANEPACKAGE PHILIPPINE INC.**

No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna  
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**INVESTIGATION REPORT**

Prepared By:

Check By:

Approved By:

K.DIAZ

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QA-IE/ Prodn IE

QA/ Prodn SV

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:**

MISALIGNED CUT

**1.2. ITEM DESCRIPTION:****PART CODE:** 516446102 / 516445502**PART NAME:** PAD BASE**1.3. BACKGROUND:****PICTURE****DETAILS:**

> Inhouse Detection : MISALIGNED CUT  
> Lot size: 6783pcs  
> Reject Qty: 1229pcs  
> Rejection Rate: 18.12%  
> JO#: 36209 / 36271 / 36362

**II. IMMEDIATE ACTION**

ACTION ITEMS	Target Date:	Person In-charge
Line Leader Immediately inform Diecut Sub-Leader and operator for Misalign cut.	May 15, 2023	Sub-leader and Die cut operator
Sorting affected Items	May 15, 2024	Sub-leader and Die cut operator

**III. CAUSE ANALYSIS:**

<b>WHY 1:</b>	Misalign cut occurred when the feeder side move during Mass production. Note: During set up and trial that released 1 pc for production sample and 10 pcs for QA sample that result good quality, while proceeding with mass production, the operator did not notice the feeder side moved which resulted in a misaligned cut.
<b>WHY 2:</b>	The operator is not aware that the feeder side has moved. Note: The operator base on the first set up is ok, and the operator is not expected that there will be an adjustment in the feeder side guide where the misalign cut appears
<b>WHY 3:</b>	Due to the feeder side mismatch, it resulted misalign cut while running. Note: In 3 J.O found 1229 rejects out of 6783 pcs of item

**IV. ACTION PLAN:****V. EVIDENCES:**

1	Follow the standard number of item in the feeder section (Only put 1pc) Remarks: During Set up and Trial	PIC: Operator Target Date: May 15, 2023
2	Reorient the operators regarding to the procedure manual of the machine operation process.	PIC: Production IE Target Date: May 15, 2023