


<div style="display: flex; align-items: center;"> <div> 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 </div> </div>	INVESTIGATION REPORT		
	Prepared By:	Check By:	Approved By:
	K.N. ACUIN	N. CEPEDA	R. MIRANDA
DATE: 230522	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	<div><div></div>With Revision</div>	<div><div></div>No Revision</div>	KN ACUIN	N/A
MATERIAL	No Changes	Work Instruction		<div><div></div>With Revision</div>	<div><div></div>No Revision</div>	KN ACUIN	N/A
METHOD	no proper checking of sheets	Process Flow		<div><div></div>With Revision</div>	<div><div></div>No Revision</div>	KN ACUIN	N/A
ENVIRONMENT	No Changes	Forms		<div><div></div>With Revision</div>	<div><div></div>No Revision</div>	KN ACUIN	N/A

I. PROBLEM DESCRIPTION

1.1. ISSUE:	
	WORN-OUT
1.2. ITEM DESCRIPTION:	
PART CODE:	515048700
PART NAME:	CARTON BOX
1.3. BACKGROUND:	
	DETAILS: <div style="margin-left: 20px;"> > WORNOUT ON THE EDGE OF THE ITEM > REJECT QTY. 72 PCS >LOY QTY. 240 PCS > MAJOR REJECT /DETECTED BY QA </div>

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
SORT THE ITEMS	230516	OPERATOR
LESSEN THE NUMBER OF ITEM THET IS BEING DETACH	230516	OPERATOR

III. CAUSE ANALYSIS:

WHY 1:	THE ITEM CODE 515048700 SUDDENLY FALL DOWN DURING MANUAL DETACHING
WHY 2:	WHILE THE OPERATOR IS MANUALLY DETACHING THE ITEM, HE IS IN BENDING POSITION (NAKAYUKO) AND HE DETACH THE SCRAP SO FAST SO HE DIDN'T NOTICED THAT THE ITEMS ARE WIGGLING

IV. ACTION PLAN:

1	FROM 250 PCS OF ITEMS FOR EVERY CASTER PALLET DECREASE THE NUMBER OF ITEM DEPENDING ON THE HEIGHT OF THE OPERATOR (EXAMPLE IF THE OPERATOR HEIGHT IS 5'0 THE NUMBER OF ITEM SHOULD BE 200 PCS)	230515
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V. EVIDENCES: