

**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.N. ACUIN

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	230523	<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	KN ACUIN	N/A
MATERIAL	No Changes	Work Instruction		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	KN ACUIN	N/A
METHOD	no proper checking of sheets	Process Flow		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	KN ACUIN	N/A
ENVIRONMENT	No Changes	Forms		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	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:**

- > WORNOUT ON THE EDGE OF THE ITEM
- > REJECT QTY. 72 PCS
- > LOY QTY. 240 PCS
- > MAJOR REJECT /DETECTED BY QA

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
SORT THE ITEMS	230516	OPERATOR

III. CAUSE ANALYSIS:

WHY 1:	PRIOR GLUING PROCESS, ITEM CODE 515048700 CARTON BOX ENCOUNTERED WORN OUT DEFECT.
WHY 2:	WORN OUT WAS DUE TO ENCOUNTERED COLLAPSED OF ITEM DURING DIECUT-INLINE MANUAL DETACHING PROCESS.
WHY 3:	COLLAPSED OF ITEM WAS DUE TO IT'S IMPROPER ARRANGEMENT ON THE CASTER PALLET AND THE WEIGHTS WAS IMPROPERLY PUT. NOTE: THE ARRANGEMENT OF ITEM WAS DISORDERED AND THE WEIGHTS WAS IN MISALIGNED POSITION CAUSING THE ITEM TO COLLAPSED DURING MANUAL DETACHING.
WHY 4:	PROPER ALIGNMENT AND ARRANGEMENT OF THE ITEM AND PROPER PUTTING OF WEIGHTS WAS NOT COMPLIED APPROPRIATELY.

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

1	REORIENTATION OF OPERATORS TO PROPERLY USE THE PALLET SIDE GUIDE AND CORRECTLY PLACE THE WEIGHTS ALIGNED WITH THE ITEM.	PIC: PRODUCTION IE TARGET DATE: MAY 23, 2023
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