
 <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:
<b>DATE:</b>	MAY 25, 2023	K. DIAZ QA-IE/ Prodn IE	N. CEPEDA QA/ Prodn SV
		R. MIRANDA KPLIMA Operations Gen. Mngr.	

5M REVIEW		DOCUMENT REVIEW				
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	230616	<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

<b>1.1. ISSUE:</b>	
	NO CREASING MATRIX
<b>1.2. ITEM DESCRIPTION:</b>	
<b>PART CODE:</b>	513648400
<b>PART NAME:</b>	STRATOS WITH STICKER
<b>1.3. BACKGROUND:</b>	
<b>PICTURE</b> 	<b>DETAILS:</b> >Inhouse Detection : NO CREASING MATRIX >Lot size: 277pcs > Reject Qty: 277pcs >Rejection Rate: 100% >JO#: 36563

## IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
The catcher in die cut immediately inform the sub -leader and operator in No creasing matrix Item	230516	subleader & Line leader

## III. CAUSE ANALYSIS:

<b>WHY 1:</b>	No creasing matrix occur at Die-cut machine 3 for the item 513648400 -Stratos with Sticker
<b>WHY 2:</b>	No creasing matrix because the operator did not change the plate
<b>WHY 3:</b>	The operator is unsure whether the item needs a creasing matrix or not from the description. Note: the operator did not notice that the description need a creasing matrix. The operator procced tin mass production without changing plate where no creasing matrix occurred.

## 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 or next mass production