
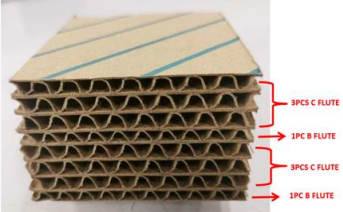


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|--|-------------------------------|------------------------------|--------------|
|  KANEPACKAGE PHILIPPINE INC. No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna Telephone No. (049) 545-7166 to 69 Fax No. (049) 545-6302 | <h1>INVESTIGATION REPORT</h1> | | |
| | Prepared By: | Check By: | Approved By: |
| | MHVITO | N. CEPEDA | R. MIRANDA |
| DATE: | 230524 | 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 | 230524 | <input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision | MH.VITO | N/A |
| MATERIAL | No Changes | Work Instruction | | <input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision | MH.VITO | N/A |
| METHOD | no proper checking or sheets | Process Flow | | <input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision | MH.VITO | N/A |
| ENVIRONMENT | No Changes | Forms | | <input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision | MH.VITO | N/A |

I. PROBLEM DESCRIPTION

| | |
|--|--|
| 1.1. ISSUE: | |
| | WRONG FLUTE COMBINATION |
| 1.2. ITEM DESCRIPTION: | |
| PART CODE: | 650X650 |
| PART NAME: | CF TX200/CM150 |
| 1.3. BACKGROUND: | |
| PICTURE  | DETAILS: > LOT QTY: 100EA > REJECT QTY: 100EA > JO#: 36960 -100 % REJECTION (1 SHEET LAMINATED AT MANUAL LAMINATOR) |

II. IMMEDIATE ACTION

| ACTION ITEMS | Target Date: | Person In-charge |
|------------------------------------|--------------|------------------|
| HOLD THE RAW MATS FOR VERIFICATION | 230524 | LEADER |
| SORTING OF AFFECTED BLOCKS | 230524 | OPERATOR |

III. CAUSE ANALYSIS:

| | |
|---------------|--|
| WHY 1: | WRONG FLUTE COMBINATION OF PAD BLOCKS WAS DETECTED DURING LUCIDA ASSEMBLY PROCESS. |
| WHY 2: | WRONG FLUTE COMBINATION OCCURRED AT MANUAL LAMINATION USING C-FLUTE (BLUE PRINT) AND C-FLUTE (BLACK PRINT). |
| WHY 3: | WRONG COMBINATION OF FLUTE WAS NOT NOTICE BY THE FEEDER OPERATOR(1) WHILE PICKING THE RAW MATS ON ITS LOCATION. <i>NOTE: THE ITEM WAS PREPARED BY FEEDER OPERATOR (2) BY COUNTING 3 C-FLUTE AND 4 B FLUTE .</i> |
| WHY 4: | WRONG PREPARATION OF SHEET AT FEEDER AREA. |

IV. ACTION PLAN:

V. EVIDENCES:

| | | |
|---|---|---|
| 1 | REMIND THE OPERATOR REGARDING TO THE ISSUE OF WRONG FLUTE COMBINATION | PIC: LINE LEADER TARGET DATE: 230524 |
| 2 | REVISION OF WI TO SEPARATE THE LOCATION OF C FLUTE AND B FLUTE | PIC: PRODUCTION IE TARGET DATE: 230525 |

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INVESTIGATION REPORT

| | | | | |
|----------------------------|--|-----------------|--------------|------------------------------|
| DATE: <u>230524</u> | | Prepared By: | Check By: | Approved By: |
| | | MHVITO | N. CEPEDA | R. MIRANDA |
| | | QA-IE/ Prodn IE | QA/ Prodn SV | KPLIMA Operations Gen. Mngr. |