
 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:
	K.N.ACUIN	N. CEPEDA	R. MIRANDA
	QA-IE/ Prodn IE	QA/ Prodn SV	KPLIMA Operations Gen. Mngr.
DATE:	230524		
5M REVIEW		DOCUMENT REVIEW	
MAN	No Changes	Affected Document:	Date Reviewed:
MACHINE	No Changes	Procedure Manual	230614
MATERIAL	No Changes	Work Instruction	
METHOD	no proper checking of sheets	Process Flow	
ENVIRONMENT	No Changes	Forms	
		Disposition:	PIC:
		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	MH.VITO
		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	MH.VITO
		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	MH.VITO
		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	MH.VITO
			Target Date:
			N/A

I. PROBLEM DESCRIPTION

1.1. ISSUE:	
	SCRATCHES
1.2. ITEM DESCRIPTION:	
PART CODE:	516001400
PART NAME:	LIONEL PG FGL
1.3. BACKGROUND:	
PICTURE	DETAILS:
	> LOT QTY: 904EA > <i>REJECT QTY: 112EA</i> > JO#: 37792 > <i>MINOR REJECT/DETECTED BY QA</i>

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
SORTING OF AFFECTED ITEMS	230607	OPERATOR
THE STOPPER WAS ADJUSTED UPWARD IN THE SAME AREA OF THE ITEMS WHERE THE VISIBLE SCRATCHES WERE	230607	OPERATOR

III. CAUSE ANALYSIS:

WHY 1:	SCRATCHES ENCOUNTERED ON THE UPPER FLAP B (BLUE PORTION) DURING SEMI AUTO GLUING PROCESS
WHY 2:	THE UPPER FLAP BLUE PORTION OF THE ITEM ALWAYS GETS SCRATCHES WHEN IT IS FACING THE ROLLER.
WHY 3:	WHEN THE BLUE PART OF THE ITEM WAS INSERTED FIRST, IT WAS SCRAPED (RUBBED) ON THE ROLLER
WHY 4:	THE ROLLER LEAVE A (MARK) SCRATCHES IN THE UPPER FLAP B PORTION WITH BLUE COLOR

IV. ACTION PLAN:

V. EVIDENCES:

1	REMINDE THE OPERATOR REGARDING TO THE ISSUE OF SCRATCHES	230614
2	REVISION OF DRAWING (THAT THE BLUE PART OF THE ITEM SHOULD NOT BE INSERTED FIRST INTO THE ROLLER)	230614

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