

<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	INVESTIGATION REPORT		
	Prepared By:	Check By:	Approved By:
	K. DIAZ QA-IE/ Prodn IE	N. CEPEDA QA/ Prodn SV	R. MIRANDA KPLIMA Operations Gen. Mngr.
DATE:	JUNE 16, 2023		

5M REVIEW		DOCUMENT REVIEW				
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	230616	With Revision <input checked="" type="checkbox"/> No Revision <input checked="" type="checkbox"/>	K. DIAZ	N/A
MATERIAL	OLD STEEL PLATE	Work Instruction		With Revision <input checked="" type="checkbox"/> No Revision <input checked="" type="checkbox"/>	K. DIAZ	N/A
METHOD	No Changes	Process Flow		With Revision <input checked="" type="checkbox"/> No Revision <input checked="" type="checkbox"/>	K. DIAZ	N/A
ENVIRONMENT	No Changes	Forms		With Revision <input checked="" type="checkbox"/> No Revision <input checked="" type="checkbox"/>	K. DIAZ	N/A

# I. PROBLEM DESCRIPTION

<b>1.1. ISSUE:</b>	
	CRACKING/BURSTING
<b>1.2. ITEM DESCRIPTION:</b>	
<b>PART CODE:</b>	515647400/516587200/516182300
<b>PART NAME:</b>	LINUS CHINA, LINUS FAL ETD, LINUS FAL ASIA
<b>1.3. BACKGROUND:</b>	
	<b>DETAILS:</b>  >Inhouse Detection : CRACKING/ BURSTING >Lot size: 717pcs > Reject Qty: 620pcs >Rejection Rate: 86.47%

# IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
TOOLING REPLACE A NEW PATTERN SHEET NAD STEEL PLATE FOR LINUS	230613	TOOLING

# III. CAUSE ANALYSIS:

WHY 1:	CRACKING OCCUR AT DIE-CUT MACHINE FOR THE ITEM 516181800 LINUS FAL AMERICA
WHY 2:	WHEN THE OPERATOR FOLDS THE ITEM, A CRACK IS FOUND IN THE SEMI AUTO GLUING PROCESS, AND THE ITEM HAS A CRACK ON THE FOLDING SIDE.
WHY 3:	CRACKING OCCURS DUE TO THE SET UP (PLATE AND PATTERN SHEET) THEY USED, THE OPERATOR DID NOT START FROM THE BEGINNING OF MACHINE SETTING (BACK TO ZERO) WHEN THEY PUT THE NEW STEEL PLATE IN THE DIE-CUT, AND STILL THEY USED AN OLD PATTERN SHEET.
WHY 4:	THE OPERATORS KNOW THAT WHEN THE BLADE IS NEW AND THE PATTERN SHEET IS ALSO NEW, THEY SHOULD ALSO GET A NEW PATTERN SHEET AND START FROM THE BEGINNING OF SET UP, BUT THEY ARE UNAWARE OF THE PROCEDURE FOR WHEN THE PLATE IS NEW, THEY SHOULD ALSO GET A NEW PATTERN SHEET AND START FROM THE BEGINNING OF SET UP (BACK TO ZERO).

# IV. ACTION PLAN:

# V. EVIDENCES:

1	RE- ORIENT THE DIE- CUT OPERATOR REGARDING THE CRACKING ENCOUNTERED AND THE PROPER PROCEDURE IN SETTING UP THE MACHINE.	
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2	WHETHER THE PLATE OR BLADE IS NEW AUTOMATICALLY THE PATTERN SHEET SHOULD ALSO NEW OR IF THEY USED A GOOD CONDITION PATTERN SHEET OPERATOR MUST REMOVE THE BACKING TAPE IN THE PATTERN SHEET AND REPLACE A NEW ONE. MOREOVER, OPERATOR MUST SET UP THE MACHINE FROM THE BEGINNING (BACK TO ZERO SET UP).	
3	POSTING A REMINDER IN THE DIE CUT AREA REGARDING USING NEW PLATE / NEW BLADE AND INCLUDING IT IN THE WORK INSTRUCTION.	