

**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

INVESTIGATION REPORT

Prepared By:

Check By:

Approved By:

MHVITO

N. CEPEDA

R. MIRANDA

DATE:

230616

QA-IE/ Prodn IE

QA/ Prodn SV

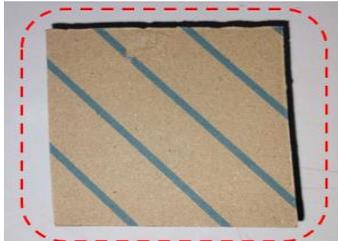
KPLIMA Operations Gen. Mngr.

5M REVIEW**DOCUMENT REVIEW**

MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	SHORT SIZE OF BLADE	Procedure Manual	230616	<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 Changes	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:**

SLANTED CUT

1.2. ITEM DESCRIPTION:**PART CODE:** 516444701**PART NAME:** PAD BLOCK 60 X60**1.3. BACKGROUND:****PICTURE****DETAILS:**

*LOT QTY: 2400
 REJECT QTY: 50 EA
 REJECTION RATE: 2.08%
 JO#: 038240
 DETECTED BY PRODUCTION LUCIDA*

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
SORTING/HOLD THE RAW MATS FOR VERIFICATION	230509	OPERRATOR
REMIND THE OPERATOR FOR THE ISSUE OF SLANTED CUT	230509	OPERRATOR

III. CAUSE ANALYSIS:

WHY 1:	SLANTED BLOCKS OCCUR AT VERTICAL MACHINE 3
WHY 2:	SLANTED CUT OCCUR WHEN THE BLADE ARE WAVING DUE TO SHORT SIZE OF THE BLADE. <i>NOTE: THE BLADE SIZE MUST NOT LESTHAN 21mm (REPLACE THE BLADE WHEN IT MEET 21mm SIZE)</i>
WHY 3:	MISALIGNED CUT AND SHORT BLADE DID NOT NOTICE BY THE OPERATOR WHILE RUNNING.
WHY 4:	SHORT BLADE OCCUR CAUSE BY MULTIPLE SHARPENING

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

1	REQUEST FOR THE REPLACEMENT OF THE NEW BLADE	230616
2	REMIND THE OPERATOR REGARDING TO THE ISSUE OF MISALIGNED CUT	230619

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