
 <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	<h1>INVESTIGATION REPORT</h1>		
	Prepared By:	Check By:	Approved By:
	K.DIAZ QA-IE/ Prodn IE	N. CEPEDA QA/ Prodn SV	R. MIRANDA KPLIMA Operations Gen. Mngr.
<b>DATE:</b>	JUNE 27, 2023		

5M REVIEW		DOCUMENT REVIEW					
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:		PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	230627	With Revision	✓ No Revision	K. DIAZ	N/A
MATERIAL	No Changes	Work Instruction		With Revision	✓ No Revision	K. DIAZ	N/A
METHOD	No Changes	Process Flow		With Revision	✓ No Revision	K. DIAZ	N/A
ENVIRONMENT	No Changes	Forms		With Revision	✓ No Revision	K. DIAZ	N/A

## I. PROBLEM DESCRIPTION

<b>1.1. ISSUE:</b>	
	PEEL OFF
<b>1.2. ITEM DESCRIPTION:</b>	
<b>PART CODE:</b>	516512900
<b>PART NAME:</b>	LIGHT 2 MB AMERICA
<b>1.3. BACKGROUND:</b>	
<b>PICTURE</b> 	<b>DETAILS:</b> >Inhouse Detection : PEEL OFF >Lot size: 1168pcs > Reject Qty: 148pcs >Rejection Rate: 12.67%

## IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
1. PUT BACKING TAPE ON THE UNCUT PORTION 2. THE SUBLEADER OF SEMI AUTO INFORMED THE SUBLEADER OF DIECUT THAT AN UNCUT WAS FOUND. THE SUBLEADER EDUCATES HIS OPERATOR ON MANUAL BROWSING AND INFORMS THE LEADER AND SENIOR OPERATOR ON ANY ABNORMALITIES ENCOUNTERED.	JUNE 27, 2023	PIC: OPERATOR AND SUBLEADER

## III. CAUSE ANALYSIS:

<b>WHY 1:</b>	ITEM PEELED OFF ON THE UPPER FLAP CLASS B WHILE DETACHING IT AND THE MANUAL STRIP IT WAS USED ON.
<b>WHY 2:</b>	PEEL OFF OCCURED BECAUSE THE ITEM WAS UNCUT.
<b>WHY 3:</b>	UNCUT OF AN ITEM ENCOUNTERED DUE TO THE CONDITION OF THE BACKING TAPE (FLATTENED) ON THE PATTERN SHEET BECAUSE OF EXCESSIVE USE/PUNCH. REMARKS: WHEN ENCOUNTERED UNCUT, THE OPERATOR STOP THE PROCESS AND CHECK THE SETTINGS AND CHECK THE UNCUT PORTION AND IMMEDIATELY PUT A BACKING TAPE.
<b>WHY 4:</b>	DURING THE DIECUT PROCESS, THE CATCHER OPERATOR SKIPS THE MANUAL BROWSING OF AN ITEM, RESULTING IN A HIGH LOT OF REJECTION. NOTE: FOUND 148PCS REJECT OUT OF 1168PCS DURING SEMI AUTO PROCESS AND THEY REWORK FOR THE AFFECTED ITEMS.

## IV. ACTION PLAN:

1	RE-EDUCATE THE OPERATORS FOR TIGHTENING THE MANUAL BROWSING AND INFORM THEIR SUBLEADER OR SENIOR OPERATOR FOR ANY ABNORMALITIES BEING ENCOUNTERED.
2	THE TOOLING CUSTODIAN WILL TIGHTEN THE INSPECTION OF THE MATERIALS (BLADE, PLATE, PATTERN SHEET) PRIOR TO PRODUCTION.