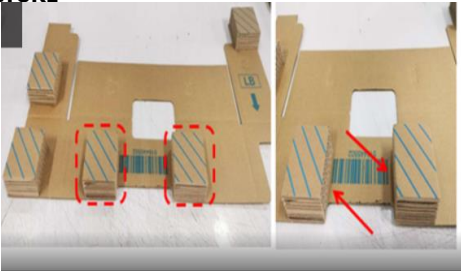


<div style="display: flex; align-items: center;"> <div> KANEPACKAGE PHILIPPINE INC. No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna Telephone No. (049) 545-7166 to 69 Fax No. (049) 545-6302 </div> </div>	INVESTIGATION REPORT		
	Prepared By:	Check By:	Approved By:
	MHVITO	N. CEPEDA	R. MIRANDA
DATE: 230713	QA-IE/ Prodn IE	QA/ Prodn SV	KPLIMA Operations Gen. Mngr.

5M REVIEW		DOCUMENT REVIEW				
MAN	new endorsed	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	230712	<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 checked="" type="checkbox"/> With Revision <input type="checkbox"/> No Revision	MH.VITO	230721

I. PROBLEM DESCRIPTION

1.1. ISSUE:	
	INVERTED PAD BLOCKS ATTACHMENT
1.2. ITEM DESCRIPTION:	
PART CODE:	516445502
PART NAME:	PAD ASSY,LB
1.3. BACKGROUND:	
PICTURE 	DETAILS: <i>LOT QTY: 962</i> <i>REJECT QTY: 2 EA</i> <i>REJECTION RATE: 0.21%</i> <i>JO#: 39907</i> <i>DETECTED BY PRODUCTION LUCIDA</i>

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
SORTING/HOLD THE RAW MATS FOR VERIFICATION	230712	OPERATOR/QA
REMIND THE OPERATOR FOR THE ISSUE OF INVERTED PAD BLOCKS ATTACHMENT	230712	OPERATOR

III. CAUSE ANALYSIS:

DIRECT CAUSE

WHY 1:	Encountered wrong assembly (wrong pad block attachment) on item 5164455-02 PAD ASSY, LB.
WHY 2:	Assigned operator was not skilled. Note: The operator was still under training assessment and qualification.
WHY 3:	Prior endorsement in the line assembly, no evaluation for qualification has been done.
WHY 4:	Implementation of standard training plan for newly endorsed manpower allocated for LUCIDA assembly line was not followed and monitored by the in-charge sub-leader.
WHY 4:	The sequence or flow of training plan was too general or not specific per day assessment. Note: Existing was on weekly assessment performance and evaluation.

**KANEPACKAGE PHILIPPINE INC.**

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INVESTIGATION REPORT

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QA-IE/ Prodn IE

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R. MIRANDA

KPLIMA Operations Gen. Mngr.

DATE:230713**INDIRECT CAUSE**

WHY 1:	Encountered flow out of wrong assy (wrong pad block attachment) on item 5164455-02 PAD ASSY, LB in the Lucida assembly line.
WHY 2:	Operator was confused on the poka yoke markings prior attachment of pad blocks.
WHY 3:	Lack of training assessment for newly endorsed manpower in Lucida Assembly line.
WHY 4:	Operator was immediately assigned to line (running mass production) without proper evaluation. Note: No verification of the actual output of new operator prior endorsement to QA inspector.
WHY 5:	Output of the newly operator was mixed with the output of the skilled operator. Note: There is no separate location for the output produced by new operator and skilled operator.

IV. ACTION PLAN:

1	Reorientation of Lucida operator regarding the encountered major defects. Agenda: OPL- Work guidance regarding the proper orientation and attachment of pad blocks to pad base.	PIC: Production IE/ Subleader Target Date: 230711
2	Revision of training plan for newly endorsed manpower in LUCIDA assembly line for more specific flow of training assessment.	PIC: Production IE/ Subleader Target Date: 230712
3	Inclusion of separate table of newly endorsed manpower in Lucida assembly line for tighten inspection by assigned sub-leader/line leader.	PIC: Production IE/ Subleader Target Date: 230713