

**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:

K. DIAZ
QA-IE/ Prodn IEN. CEPEDA
QA/ Prodn SVR. MIRANDA
KPLIMA Operations Gen. Mngr.**DATE:**

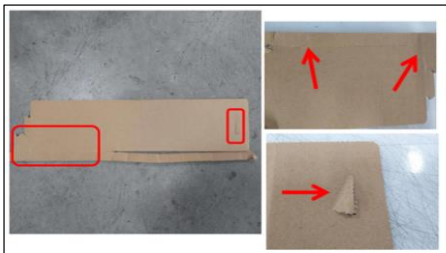
JULY 20, 2023

5M REVIEW**DOCUMENT REVIEW**

MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	230720	With Revision <input checked="" type="checkbox"/> No Revision <input checked="" type="checkbox"/>	K. DIAZ	N/A
MATERIAL	WORN OUT PATTERN SHEET	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**1.1. ISSUE:**

PEEL OFF

1.2. ITEM DESCRIPTION:**PART CODE:** 514784500**PART NAME:** PAD SLEEVE**1.3. BACKGROUND:****PICTURE****DETAILS:**

- > Inhouse Detection : PEEL OFF
- > Lot size: 3000pcs
- > Reject Qty: 375pcs
- > Rejection Rate: 12.50%

IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
PUTTING OF BACKING TAPE ON THE UNCUT PORTION OF THE ITEM.	JULY 3, 2023	PIC: OPERATOR AND SUBLEADER

III. CAUSE ANALYSIS:

WHY 1:	PEEL OFF WAS ENCOUNTERED DURING MANUAL DETACHING PROCESS OF THE ITEM.
WHY 2:	PEEL OFF WAS DUE TO ENCOUNTERED UNCUT DURING DIECUT PROCESS.
WHY 3:	BASED ON CHECKING THE DIECUT TOOLINGS FOR PROCESSING THE ITEM, PATTERN SHEET WAS NOT IN THE GOOD CONDITION.
WHY 4:	NOT GOOD CONDITION OF PATTERN SHEET WAS DUE TO VISIBLE APPEARANCE OF EXCESSIVE PATCHING TAPE AND WORN OUT CONDITION. <i>NOTE: THE OPERATOR AND TOOLING IN-CHARGE THOUGHT THAT THE PATTERN SHEET CAN BE USE AND STILL PRODUCED OUTPUT WITH LOW REJECTION.</i>

IV. ACTION PLAN:

1	REQUEST OF NEW PATTERN SHEET. NOTE: MUST ABLE TO BACK TO ZERO SET UP TO ACHIEVED 50% CUTTING AND BACKING.	PIC: TOOLING AND OPERATOR IN-CHARGE TARGET DATE: JULY 21, 2023
2	ORIENTATION TOOLING AND DIECUT OPERATORS REGARDING THE STANDARD USE AND CONDITION OF TOOLINGS PRIOR USAGE.	PIC: PRODUCTION IE TARGET DATE: JULY 3, 2023
3	TIGHTEN CHECKING OF TOOLINGS (BLADE, PLATE & PATTERN SHEET) TO PREVENT UNUSUAL OCCURRNCE OF REJECTS. FREQUENCY OF CHECKING: EVERY ISSUANCE	PIC: TOOLING AND OPERATOR IN-CHARGE TARGET DATE: JULY 4, 2023

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DATE:JULY 20, 2023

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TRACK DOWN OF OLD PATTERN SHEETS TO BE REPLACED.

PIC: PRODUCTION IE
TARGET DATE: ONGOING

