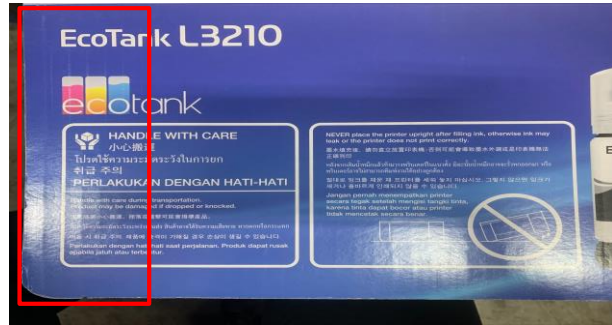


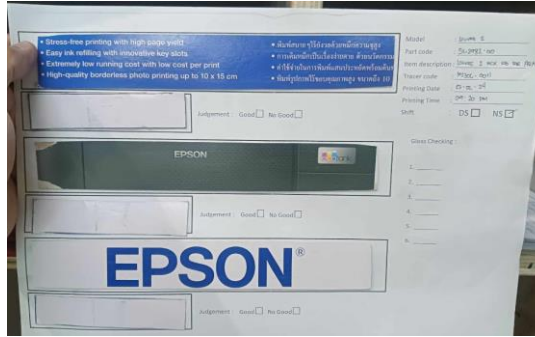
SLIGHT SCRATCHES FROM DIE CUT PROCESS



SCRATCHES ACCUMULATED IN SEMI AUTO GLUING MACHINE 4



ONE POINT LESSON



RUB TEST RESULT

STATUS OF GUIDE BAR OF DIE CUT

DIE CUT 3



NO PRESENCE OF TAPE ADHESIVE

BEFORE

AFTER

DIE CUT 2

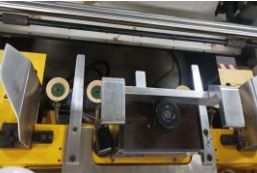


THE TAPE ADHESIVE HAD ALREADY BEEN REMOVED

BEFORE

AFTER


DIE CUT 1



NO PRESENCE OF TAPE ADHESIVE




NOTE: ETERNA DIECUT OPERATOR CLEANED THE GUIDE BAR OF EACH MACHINE

 KANEPACKAGE PHILIPPINE INC. No. 5 Ring Road LTSP 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.N.ACUIN	N. CEPEDA	R. MIRANDA
DATE:	230727	QA-IE/ Prodn IE	QA/ Prodn SV
		KPLIMA Operations Gen. Mngr.	

5M REVIEW		DOCUMENT REVIEW				
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:		PIC:
MACHINE	No Changes	Procedure Manual	230727	<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	K.N.ACUIN
MATERIAL	No Changes	Work Instruction		<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	K.N.ACUIN
METHOD	Due to tape adhesive of the diecut feeder guide bar	Process Flow		<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	K.N.ACUIN
ENVIRONMENT	No Changes	Forms		<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	K.N.ACUIN
						Target Date:

I. PROBLEM DESCRIPTION

1.1. ISSUE:	
	SCRATCHES
1.2. ITEM DESCRIPTION:	
PART CODE:	516298200
PART NAME:	LOUVRE 2 MCX ICB FOR ASIA
1.3. BACKGROUND:	
	DETAILS: > LOT QTY: 730EA > <i>REJECT QTY: 42EA (5.75%)</i> > JO#: 40527 > <i>MAJOR REJECT/DETECTED BY QA</i>

II. IMMEDIATE ACTION


ACTION ITEMS	Target Date:	Person In-charge
Upon encountering scratches, subleader in-charge tries to switch position of affected panel (PANEL B) to the position of the other panel (PANEL A) to verify if the occurrence of scratches was still on Panel B. Note: Scratches still encountered on Panel B.	230719	Operator
Sort of raw materials prior gluing process.	230719	Operator and QA

III. CAUSE ANALYSIS

WHY 1:	Scratches encountered on item 516298200 Louvre 2 MCX FOR ASIA during gluing process at machine 4.
WHY 2:	During gluing process, scratches been observed by the QA inspector and immediately stop the running to check occurrence of scratches. Note: Encountered 42 pcs/ 730 pcs but noticed on the last pallet running.
WHY 3:	Upon checking of panels prior gluing, subleader and QA observed that there was already scratches. Note: a. Scratches was getting worse when it was processed on gluing. (Please see attached picture.) b. Upon verification of the materials used, we seek help to ME and QA for the rub test. Rub Test Result: PASSED (Please see attached picture.)
WHY 4:	Upon checking on the diecut process (Diecut 2), scratches encountered due to scrapes of the panel on the guide bar of the diecut feeder.
WHY 5:	Scrapes of panels on the guide bar still have tape adhesive causing scratches on the item.


IV. ACTION PLAN:

1	Orientation for the diecut operators and subleader. Agenda: OPL for the standard of not using tape on the guide bar of the diecut feeder.	PIC: Production IE Target Date: July 31, 2023
2	Request buffing of all diecut machine. Status: (Please see attached picture)	PIC: Production IE Target Date: July 31, 2023

 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		<h1>INVESTIGATION REPORT</h1>		
		Prepared By:	Check By:	Approved By:
		K.N.ACUIN	N. CEPEDA	R. MIRANDA
DATE:	230727	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	No Changes	Procedure Manual	230719	<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	K.N.ACUIN	N/A
MATERIAL	No Changes	Work Instruction		<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	K.N.ACUIN	N/A
METHOD	no proper checking of sheets	Process Flow		<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	K.N.ACUIN	N/A
ENVIRONMENT	No Changes	Forms		<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	K.N.ACUIN	N/A

I. PROBLEM DESCRIPTION

1.1. ISSUE:	
	SCRATCHES
1.2. ITEM DESCRIPTION:	
PART CODE:	516298200
PART NAME:	LOUVRE 2 MCX ICB FOR ASIA
1.3. BACKGROUND:	
	DETAILS: > LOT QTY: 730EA > <i>REJECT QTY: 42EA (5.75%)</i> > JO#: 40527 > <i>MAJOR REJECT/DETECTED BY QA</i>

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
UPON ENCOUNTERING SCRATCHES, SUBLEADER INCHARGE TRIES TO SWITCH POSITION OF AFFECTED PANEL (PANEL B) TO THE POSITION OF OTHER PANEL (PANEL A) TO VERIFY IF THE OCCURRENCE OF SCRATCHES WAS STILL ON PANEL B. (SCRATCHES STILL ENCOUNTERED ON THE PANEL B)	230719	OPERATOR
SORT OF RAW MATERIALS BY SEMI AUTO GLUING OPERATOR WITH THE HELP OF QA	230719	OPERATOR & QA

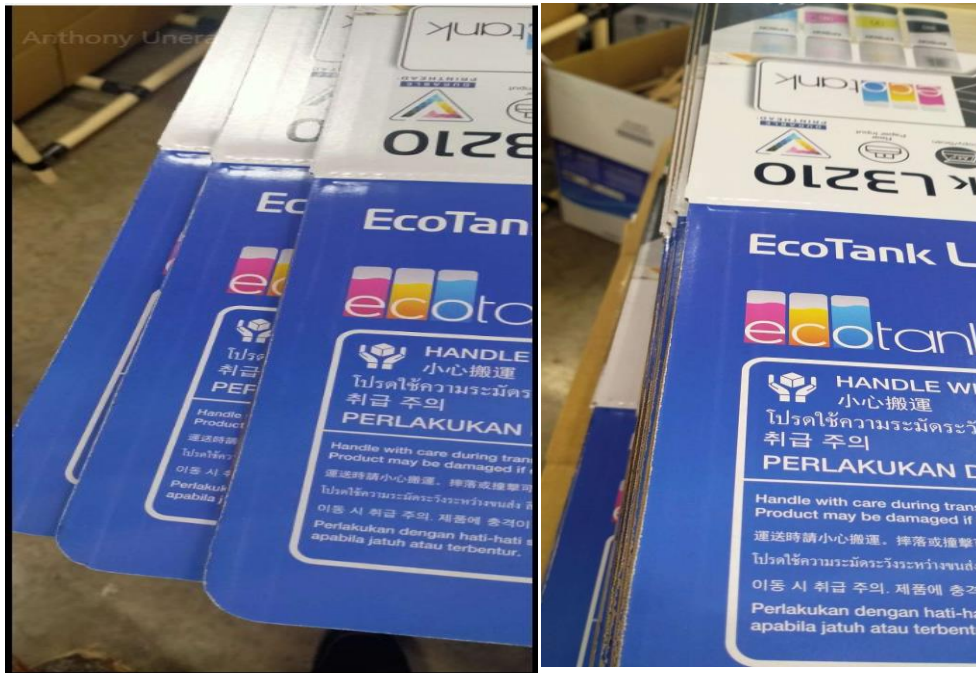
III. CAUSE ANALYSIS:

WHY 1:	SCRATCHES ENCOUNTERED IN ITEM CODE 516298200 LOUVRE 2 MCX FOR ASIA (AFFECTED PANEL B) DURING PROCESS AT GLUING MACHINE 4
WHY 2:	QA INSPECTOR OBSERVED SCRATCHES DURING THE GLUING PROCESS AND IMMEDIATELY HOLD THE RUNNING FOR THE OCCURRENCE OF SCRATCHES. NOTE: ENCOUNTERED 42 PCS OUT OF 732 PCS BUT BEEN NOTICED ON THE LAST PALLET RUNNING
WHY 3	UPON CHECKING OF RAW MATERIALS (PANELS FOR GLUING) SUBLEADER AND QA OBSERVED THAT THERE WAS ALREADY SCRATCHES ON THE ITEM NOTE: SCRATCHES WAS GETTING WORSE WHEN IT WAS PROCESS ON GLUING. NOTE: UPON VERIFICATION OF THE MATERIALS USED. WE SEEK HELP TO THE M.E AND QA FOR THE RUB TEST OF THE RAW MATERIALS (BASED ON THE RESULT THE PRINTED SHEET PASSED THE TEST)
WHY 4:	UPON CHECKING ON THE DIE CUT PROCESS (ETERNA DIE-CUT 2) SCRATCHES ENCOUNTERED DUE TO SCRAPES OF THE PANELS ON THE GUIDE BAR OF DIECUT FEEDER
WHY 5:	SCRAPES OF PANELS ON THE GUIDE BAR STILL HAVE TAPE ADHESIVE

IV. ACTION PLAN:

V. EVIDENCES:

1	ORIENTATION FOR THE DIE CUT OPERATOR OPERATORS/SUBLEADER AGENDA: STANDARD OF NOT USING TAPE ON THE GUIDE BAR OF DIE CUT FEEDER (OPL)	230731
2	REQUEST FOR BUFFING OF ALL DIE CUT MACHINE (STATUS)	230731



SLIGHT
SCRATCHES
FROM DIE CUT
PROCESS