

 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/ Prod'n IE	QA/ Prod'n SV
		KPLIMA Operations Gen. Mngr.	

5M REVIEW		DOCUMENT REVIEW				
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:		PIC:
MACHINE	No Changes	Procedure Manual	230731	With Revision	No Revision	K.N.ACUIN
MATERIAL	No Changes	Work Instruction		With Revision	No Revision	K.N.ACUIN
METHOD	No Changes	Process Flow		With Revision	No Revision	K.N.ACUIN
ENVIRONMENT	No Changes	Forms		With Revision	No Revision	K.N.ACUIN
						Target Date:
						N/A
						230731
						N/A
						N/A

I. PROBLEM DESCRIPTION

1.1. ISSUE:	
	DAMAGED
1.2. ITEM DESCRIPTION:	
PART CODE:	515907800
PART NAME:	LOUVRE 2 MAX
1.3. BACKGROUND:	
 GOOD	 NG
DETAILS: > LOT QTY: 1187EA > <i>REJECT QTY: 26EA (2.19%)</i> > <i>JO#: 04712</i> > <i>MINOR REJECT/ CUSTOMER CLAIM</i>	

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge

III. CAUSE ANALYSIS:

WHY 1:	DAMAGED ENCOUNTERED ON ITEM CODE 515907800 LOUVRE 2 MAX (AFFECTED: PANEL A) DURING PROCESS AT SEMI AUTO GLUING MACHINE 4
WHY 2:	DURING RUNNING, THE ITEM SCRAPES ON THE FEEDER STOPPER OF THE MACHINE
WHY 3	FEEDER STOPPER WAS OBSERVED TO ENCOUNTERED IMPROPER MOVEMENT DURING RUNNING NOTE: FOLDER IN-CHARGE FAILED TO DETECT DAMAGED PANEL DURING FOLDING PROCESS.
WHY 4:	IMPROPER MOVEMENT OF THE FEEDER STOPPER WAS DUE TO ENCOUNTERED LOOSEN LOCK SCREW NOTE: CHECKPOINTS OF THE FOLDER IN-CHARGE WAS NOT SPECIFICALLY STATED ON THE WORK INSTRUCTION.
WHY 5:	LOOSENING OF THE LOCK SCREW WAS DUE TO IMPROPER TIGHTEN SET UP OF THE LOCK

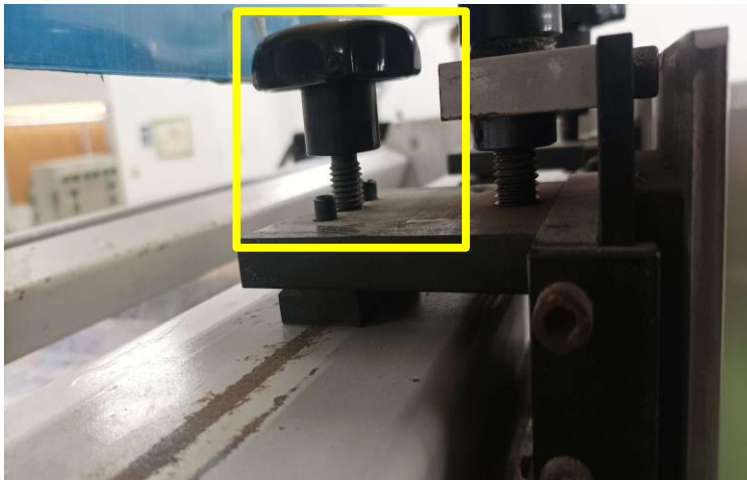
IV. ACTION PLAN:

V. EVIDENCES:

1	ORIENTATION OF PROPER SET UP OF LOCK SCREW FOR FEEDER STOPPER	230731
2	ORIENTATION FOR THE CHECK POINTS OF GLUING OPERATOR IN-CHARGE. FEEDER CHECK POINTS,FOLDER CHECKPOINTS, and CATCHER CHECKPOINTS	
3	GENERATE OF OPL (ONE POINT LESSON) FOR THE PROPER SET UP OF LOCK SCREW FOR FEEDER STOPPER.	
4	REVISION OF WI-LPR-002-01(GUIDELINES OF SEMI AUTO GLUING MACHINE) TO INCLUDE DETECTION OF DAMAGE INSIDE THE BOX AS ONE THE CRITICAL CHECKPOINT OF THE FOLDER OPERATOR	



**DEMONSTRATION
PICTURE OF STOPPER
SCRAPED THE PANEL A**



**LOOSE LOCK SCREW OF
FEEDER STOPPER**

4.5 Adjust the sheet stopper based on the thickness of the boards. *Unang set-up, the feeder operator must check the lock screw and star knob to see if the thread of the screw is in good condition.*

In Charge Person: Feeder

Ayusin ang sheet stopper batay sa kapal ng mga board. In first set up, dapat suriin ang lock screw at star knob para makita kung nasa maayos ang kondisyon ang thread ng screw.

In Charge Person: Feeder

Note: Hotmelt application is present in panel B only.

Tandaan: Ang Hotmelt application ay nasa panel B lamang.

02

5.2 In case of delayed feeding, immediately remove the first panel fed to avoid glue stain. *Before folding the panel, the inner panel appearance must be check while it is on the belt roller and coming towards the operator.*

In Charge Person: Folder

Note: check if there are defects in the inner panel such as damages, scratches and others.


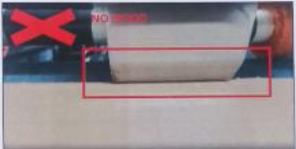

Kung sakaling maantala ang feeding, tanggalin kaagad ang unang panel na na-feed upang maiwasan ang mantsa ng pandikit. Bago tiklupin ang panel, dapat macheck ang hitsura ng pangloob ng panel habang ito ay nasa belt roller at papunta sa operator.

In Charge Person: Folder

Tandaan: Tignan kung may defects ang pangloob na panel tulad ng damages, scratches at iba pa.

02

**TO BE INCLUDED IN
THE WI OF SEMI
AUTO GLUING,
ADDITIONAL
CHECKPOINT OF
OPERATOR AND
AVOID DEFECTS
ENCOUNTERED**

 KANEPACKAGE PHILIPPINE INC. Implementation Date: 230721 <input checked="" type="checkbox"/> Permanent <input type="checkbox"/> Temporary		ONE POINT LESSON
OBJECTIVE:	GOOD & NO GOOD SET UP OF LOCK SCREW FOR FEEDER STOPPER.	
Purpose: To prevent damage of inner side of panels and other defects on the item. To aware the operator if the loose lock screw is cause by them, not/damage threat of screw or wrong set-up of lock screw.		
	The effect of loose lock screw is that the feeder stopper get harsh touch with the panel, resulting in panel scraping and damage.	
		
Prepared by: KANEPACK PHILIPPINE KANEPACK PHILIPPINE (Name & Sign)		
CHECKED BY: KANEPACK PHILIPPINE (Name & Sign)		
APPROVED BY: KANEPACK PHILIPPINE (Name & Sign)		
Note: The appearance of the thread on the lock screw must be checked during the first set-up of the machine.		

ONE POINT LESSON