
 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. DIAZ	N. CEPEDA	R. MIRANDA
DATE:	August 3, 2023	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	230803	<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	K. DIAZ	N/A
MATERIAL	No Changes	Work Instruction		<input checked="" type="checkbox"/> With Revision <input type="checkbox"/> No Revision	K. DIAZ	230805
METHOD	No nickmark on the Scrap Blade	Process Flow		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	K. DIAZ	N/A
ENVIRONMENT	No Changes	Forms		<input checked="" type="checkbox"/> With Revision <input type="checkbox"/> No Revision	K. DIAZ	230805

I. PROBLEM DESCRIPTION

1.1. ISSUE:	
	BURSTING
1.2. ITEM DESCRIPTION:	
PART CODE:	515913300
PART NAME:	LOUVRE MJX CHINA
1.3. BACKGROUND:	
PICTURE 	DETAILS: >Inhouse Detection :BURSTING >Lot size: 694pcs > Reject Qty: 80pcs >Rejection Rate: 11.52%

II. IMMEDIATE ACTION

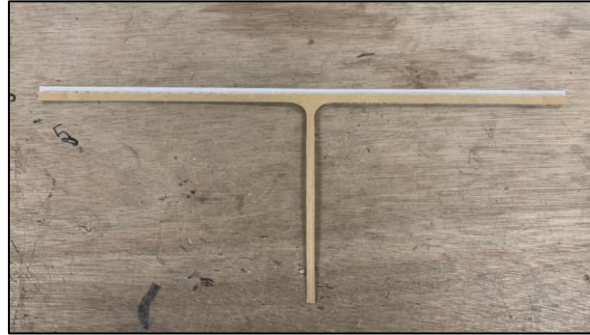
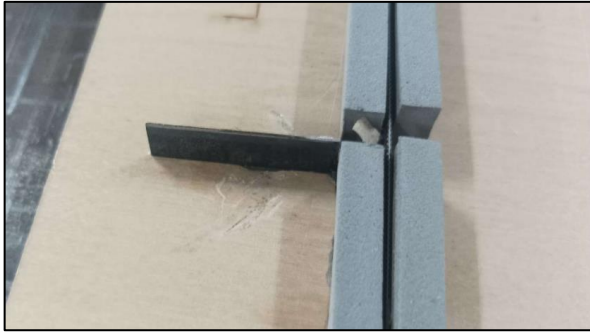
ACTION ITEMS	Target Date:	Person In-charge
THE OPERATOR CHECK THE DIEPLATE AND REMOVE THE SCRAP ON IT.	28-Jul-23	OPERATOR AND SUBLEADER

III. CAUSE ANALYSIS:

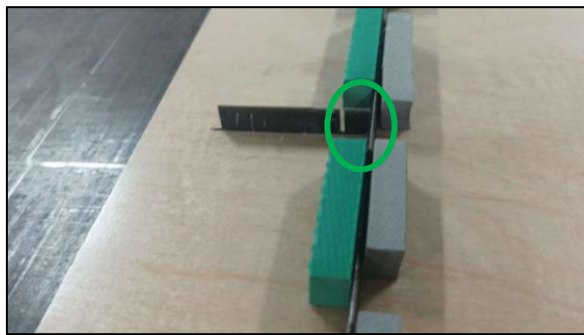
WHY 1:	Bursting occurred on the flap (folding portion) of the item 515913300 Louvre 2 MJX China.
WHY 2:	Bursting was due to encountered scrap left on the diecut plate.
WHY 3:	Scrap left on the diecut plate was due to having no nickmark on the scrap blade.
WHY 4:	No nickmark on the scrap blade was unnoticed by both tooling and operator prior usage.
WHY 5:	There is no standard work instruction and checking form for putting of nickmark for the scrap blade.

IV. ACTION PLAN:

1	The tooling custodian put nickmark on the scrap blade.	PIC: Tooling Custodian Target Date: July 31, 2023
2	Revision of work instruction for blade checking. Note: Add standard for putting of nickmark on scrap blade. ~Blade for manual strip: No nickmark ~Blade for auto strip: With nickmark	PIC: Production IE Target Date: August 5, 2023
3	Revision of tooling custodian checksheet for production tooling daily issuance. Note: Additional checkpoints of nickmark on scrap blade prior issuance to Production.	PIC: Production IE Target Date: August 5, 2023



ACTUAL SCRAP ON THE PLATE (T) AND NO NICKMARKS ON SCRAP BLADE PORTION RESULTING



ADDED NICKMARK ON THE SCRAP BLADE PORTION BY TOOLING CUSTODIAN

