
 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 QA-IE/ Prodn IE	N. CEPEDA QA/ Prodn SV	R. MIRANDA KPLIMA Operations Gen. Mngr.
DATE:	AUGUST 07, 2023		

5M REVIEW		DOCUMENT REVIEW				
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	No Changes	Procedure Manual		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	K. DIAZ	N/A
MATERIAL	SCRAP LEFT ON THE PLATE	Work Instruction		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	K. DIAZ	N/A
METHOD	No Changes	Process Flow		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	K. DIAZ	N/A
ENVIRONMENT	No Changes	Forms		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	K. DIAZ	N/A

I. PROBLEM DESCRIPTION

1.1. ISSUE:	
	BURSTING
1.2. ITEM DESCRIPTION:	
PART CODE:	516298200 / 516594700
PART NAME:	LOUVRE 2 MCXX / VINEGAR MDY
1.3. BACKGROUND:	
PICTURE 	DETAILS: >Inhouse Detection :BURSTING >Lot size: 1633pcs > Reject Qty: 75pcs >Rejection Rate: 4.59%

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
REMOVING SCRAP ON THE GRIPPER BAR	03/08/2023	OPERATOR AND SUBLEADER

III. CAUSE ANALYSIS:

WHY 1:	BURSTING OCCURRED ON THE FLAP (FOLDING PORTION) OF THE ITEM 516298200 AND 516594700 LOUVRE 2 MCX/ VINEGAR MDY
WHY 2:	BURSTING WAS DUE TO ENCOUNTERED SCRAP LEFT ON THE DIECUT PLATE.
WHY 3	WHILE RUNNING, A PIECE OF SCRAP GOT STUCK ON THE GRIPPER AND DROPPED ON THE DIECUT PLATE.
WHY 4:	THE PANEL WENT TO THE DELIVERY AREA WHEN THE MACHINE MALFUNCTIONED. THE OPERATOR GRABBED THE PANEL, UNAWARE THAT THE PIECE OF SCRAP WAS LEFT ON THE GRIPPER.

IV. ACTION PLAN:

1	RE-EDUCATE THE OPERATOR WHEN THE MACHINE ENCOUNTERED MALFUNCTION AND CHECK THE SECTION AREA. (CUTTING AREA, STRIPPER AREA, DELIVERY AREA, GRIPPER). RUN THE MACHINE FOR AROUND 30 SECONDS AND INSPECT THE MACHINE IF THERE IS ANY REMAINED SCRAPS.
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