

AUGUST 07, 2023

INVESTIGATION REPORT

Prepared By:	Check By:	Approved By:
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K.DIAZ	N. CEPEDA	R. MIRANDA
OΔ-IF/ Prodn IF	OΔ/ Prodn SV	KPI IMA Operations Gen. Mngr

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

I. PROBLEM DESCRIPTION

1.1. ISSUE:	
	BURSTING
1.2. ITEM DESCRIPTIO	N:
PART CODE:	516298200 / 516594700
PART NAME:	LOUVRE 2 MCXX / VINEGAR MDY
1.3. BACKGROUND:	

1.3. BACKGR

DATE:



DETAILS:

>Inhouse Detection :BURSTING

>Lot size: 1633pcs > Reject Qty: 75pcs >Rejection Rate: 4.59%

II. IMMEDIATE ACTION

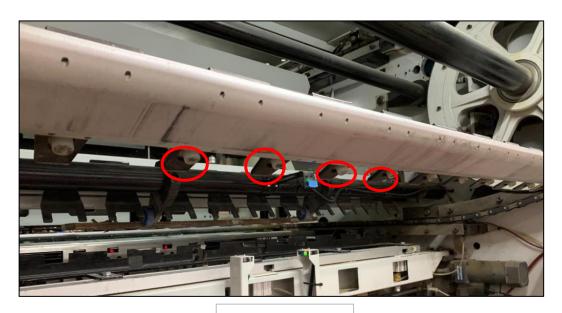
ACTION ITEMS	Target Date:	Person In-charge
REMOVING SCRAP ON THE GRIPPER BAR	03/08/2023	OPERATOR AND SUBLEADER

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.



GRIPPER BAR

	KANEPACKAGE PHILIPPINE INC.				
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