

**KANEPACKAGE PHILIPPINE INC.**

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INVESTIGATION REPORT

Prepared By:

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Approved By:

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KPLIMA Operations Gen. Mngr.

DATE:

12-Dec-31

5M REVIEW**DOCUMENT REVIEW**

MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	230811	<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	K.N.ACUIN	N/A
MATERIAL	No Changes	Work Instruction		<input checked="" type="checkbox"/> With Revision <input type="checkbox"/> No Revision	K.N.ACUIN	230831
METHOD	No Changes	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:**

516378500

PART NAME:

LIME 2 FB ICB FOR AMERICA

1.3. BACKGROUND:

GOOD



NG

DETAILS:

- > LOT QTY: 226EA
- > REJECT QTY: 14EA (6.19%)
- > JO#: 041944
- > MINOR REJECT/ IN HOUSE DETECTION

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
RE-ORIENTATION THE INVOLVED OPERATORS REGARDING THE SCRATCHES ENCOUNTERED	230815	IE STAFF

III. CAUSE ANALYSIS:

WHY 1:	SCRATCHES ENCOUNTERED ON ITEM CODE 516378500 LIME 2 FB ICB FOR AMERICA DURING PROCESS AT SEMI AUTO GLUING MACHINE 4
WHY 2:	DURING RUNNING, THE UPPER BLUE FLAP OF THE PANEL SCRAPED AGAINST THE DELIVERY CONVEYOR THAT CAUSE SCRATCHES
WHY 3:	OPERATOR PULL THE ENTIRE SET OF CARTON BOXES, SCRATCHING THE BOTTOM ITEM AT SENDING CONVEYOR.
WHY 4:	OPERATOR FAILED TO WAIT THE ITEM TO PASS IN CLOSEST TO HIM. NOTE: THE OPERATOR IS UNDER TRAINING
WHY 5:	

IV. ACTION PLAN:**V. EVIDENCES:**

1	EDUCATE THE CATCHER OPERATOR THE PROPER HANDLING OF THE ITEMS WHEN GETTING THE ITEMS IN THE CONVEYOR	230829 PIC : IE STAFF
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