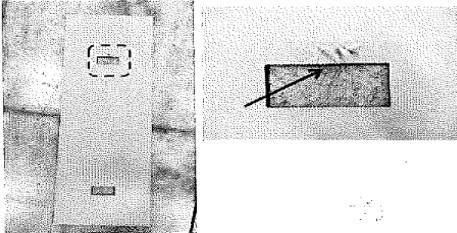
 <b>KANEPACKAGE PHILIPPINE INC.</b> No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna Telephone No. (049) 545-7166 to 69 Fax No. (049) 545-6302	<h1>INVESTIGATION REPORT</h1>		
	Prepared By:	Check By:	Approved By:
DATE: JULY 20, 2023	K. DIAZ QA-IE/ Prodn IE	N. CEPEDA QA/ Prodn SV	R. MIRANDA KPLIMA Operations Gen. Mngr.

5M REVIEW		DOCUMENT REVIEW					
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:		PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	230720	<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	K. DIAZ	N/A
MATERIAL	<b>WORN OUT PATTERN SHEET</b>	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

<b>1.1. ISSUE:</b>	
	PEEL OFF
<b>1.2. ITEM DESCRIPTION:</b>	
<b>PART CODE:</b>	516225000
<b>PART NAME:</b>	PAD SLEEVE
<b>1.3. BACKGROUND:</b>	
<b>PICTURE</b> 	<b>DETAILS:</b> >Inhouse Detection : PEEL OFF >Lot size: 3000pcs > Reject Qty: 206pcs >Rejection Rate: 6.87%

## IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
PUTTING OF BACKING TAPE ON THE UNCUT PORTION OF THE ITEM.	AUG 11, 2023	PIC: OPERATOR AND SUBLEADER

## III. CAUSE ANALYSIS:

<b>WHY 1:</b>	PEEL OFF WAS ENCOUNTERED DURING MANUAL DETACHING PROCESS OF THE ITEM.
<b>WHY 2:</b>	PEEL OFF WAS DUE TO ENCOUNTERED UNCUT DURING DIECUT PROCESS.
<b>WHY 3:</b>	BASED ON CHECKING THE DIECUT TOOLINGS FOR PROCESSING THE ITEM, PATTERN SHEET WAS NOT IN THE GOOD CONDITION.
<b>WHY 4:</b>	NOT GOOD CONDITION OF PATTERN SHEET WAS DUE TO VISIBLE APPEARANCE OF EXCESSIVE PATCHING TAPE AND WORN OUT CONDITION. <i>NOTE: THE OPERATOR AND TOOLING IN-CHARGE THOUGHT THAT THE PATTERN SHEET CAN BE USE AND STILL PRODUCED OUTPUT WITH LOW REJECTION.</i>

## IV. ACTION PLAN:

1	REQUEST OF NEW PATTERN SHEET. NOTE: MUST ABLE TO BACK TO ZERO SET UP TO ACHIEVED 50% CUTTING AND BACKING.	PIC: TOOLING AND OPERATOR IN-CHARGE TARGET DATE: JULY 21, 2023
2	ORIENTATION TOOLING AND DIECUT OPERATORS REGARDING THE STANDARD USE AND CONDITION OF TOOLINGS PRIOR USAGE.	PIC: PRODUCTION IE TARGET DATE: JULY 3, 2023
3	TIGHTEN CHECKING OF TOOLINGS (BLADE, PLATE & PATTERN SHEET) TO PREVENT UNUSUAL OCCURNECE OF REJECTS. FREQUENCY OF CHECKING: EVERY ISSUANCE	PIC: TOOLING AND OPERATOR IN-CHARGE TARGET DATE: JULY 4, 2023

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# INVESTIGATION REPORT

Prepared By:

Check By:

Approved By:

K.DIAZ

N. CEPEDA

R. MIRANDA

QA-IE/ Prodn IE

QA/ Prodn SV

KPLIMA Operations Gen. Mngr.

**DATE:**JULY 20, 2023

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TRACK DOWN OF OLD PATTERN SHEETS TO BE REPLACED.

PIC: PRODUCTION IE  
TARGET DATE: ONGOING