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|  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 | INVESTIGATION REPORT | | |
| | 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 29, 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 | THE DIEBLADE WAS DAMAGED | 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: | |
| | DAMAGED |
| 1.2. ITEM DESCRIPTION: | |
| PART CODE: | 516592600 |
| PART NAME: | LOUVRE 2 MJX |
| 1.3. BACKGROUND: | |
| PICTURE  | DETAILS: >Inhouse Detection :DAMAGED >Lot size: 1085pcs > Reject Qty: 260pcs >Rejection Rate: 23.96% >JO#: 43114 |

II. IMMEDIATE ACTION

| ACTION ITEMS | Target Date: | Person In-charge |
|--|-----------------|---------------------------------|
| USE A NEW BLADE AND APPLIED 4M APPLICATION FOR THE BLADE | AUGUST 25, 2023 | SUBLEADER AND TOOLING CUSTODIAN |

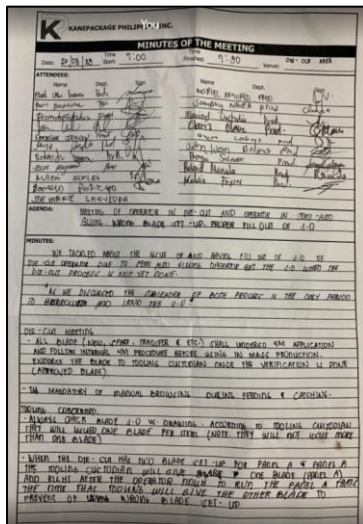
III. CAUSE ANALYSIS:

| | |
|---------------|--|
| WHY 1: | DAMAGED OCCURRED ON THE LOWER PART OF THE ITEM. |
| WHY 2: | THE CUTTING BLADE SNAP ON THE DIEBLADE DURING MASS PRODUCTION. |
| WHY 3 | UPON CHECKING THE BLADE,THE DIEBLADE SHOTS HAS 280K+ AND THE NICKMARK IS ON THE BLADE'S BRIDGE MIGHT CAUSE TO BROKEN BLADE. |
| WHY 4: | THE OPERATOR DID NOT NOTICE THAT THE DIEBLADE WAS BROKEN AND BYPASS THE MANUAL BROWSING/CHECKING OF AN ITEM CAUSING HIGH MASS REJECTION. |

IV. ACTION PLAN:

V. EVIDENCES:

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|---|---|
| 1 | ORIENTATION FOR TOOLING CUSTODIAN AND DIECUT OPERATOR REGARDING FOR DAMAGED ENCOUNTERED. |
| 2 | THEY WILL JUST PLACE A NICKMARK AWAY FROM THE BRIDGE IF THE BLADE IS NEW AND DOESN'T HAVE ONE AND ALSO IN THE EXISTING BLADE. |
| 3 | RESTRICT OF MANUAL BROWSING/CHECKING DURING FEEDING AND CATCHING OF THE ITEMS. |

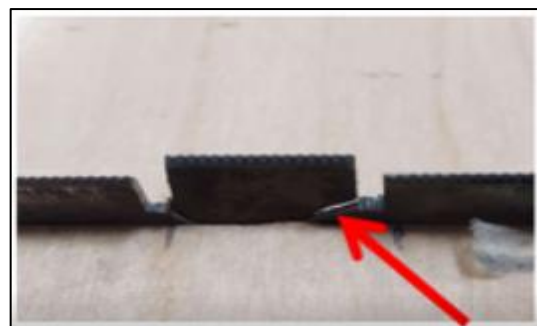


MINUTES OF MEETING



| | | |
|--------|---------|-----|
| 257-24 | 256 | 1.2 |
| 25727 | 259187 | 1.2 |
| 710798 | 219707 | 1.2 |
| 210771 | 2114987 | 1.2 |
| 258-1 | 248987 | 1.2 |
| 231802 | 252987 | 1.2 |
| 230803 | 255987 | 1.2 |
| 230804 | 258987 | 1.2 |
| 23207 | 262287 | 1.2 |
| 230809 | 265987 | 1.2 |
| 230805 | 278987 | 1.2 |
| 230812 | 2714509 | 1.2 |
| 230814 | 276487 | 1.2 |
| 270818 | 272755 | 1.2 |
| 257745 | 27155 | 1.2 |
| 257204 | 2790 | 1.2 |
| 258498 | 286650 | 1.2 |

**DIECUT STICKER
(280K+ SHOTS)**



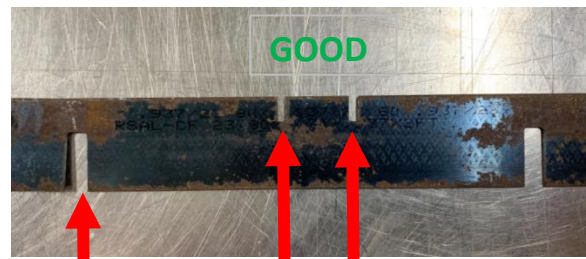
BROKEN BLADE



NICKMARK

BRIDGE

THE NICKMARK IS NEAR THE BRIDGE.



NICKMARK

BRIDGE

THE NICKMARK SHOULD BE AWAY