

**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

DATE: SEPTEMBER 14, 2023

Prepared By:

Check By:

Approved By:

K.N ACUIN
 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		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	K.N ACUIN	N/A
MATERIAL	No Changes	Work Instruction		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	K.N ACUIN	N/A
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:	
	TEAR OFF
1.2. ITEM DESCRIPTION:	
PART CODE:	516587700
PART NAME:	LIONEL 2 MBL
1.3. BACKGROUND:	
PICTURE 	DETAILS: >Inhouse Detection :TEAR OFF >Lot size: 993pcs/ 1,689pcs > Reject Qty: 83pcs/ 191pcs >Rejection Rate: 8.36%/ 11.31%

II. IMMEDIATE ACTION

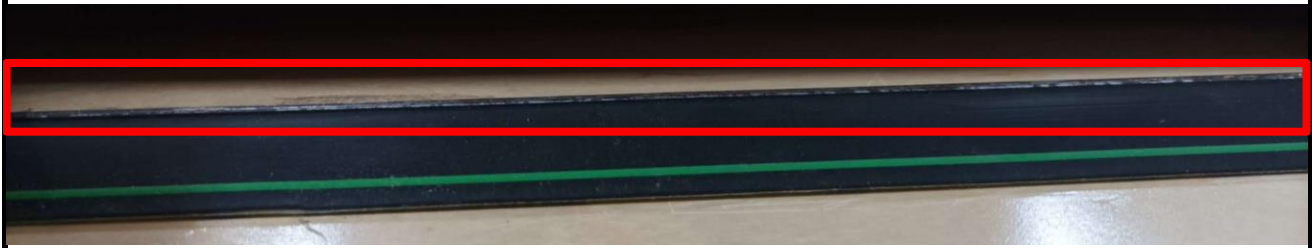
ACTION ITEMS	Target Date:	Person In-charge
OPERATOR INFORM THE IN LINE QA REGARDING THE TEAR OFF & SORT THE AFFECTED ITEMS	230826	OPERATOR

III. CAUSE ANALYSIS:

WHY 1:	TEAR OFF ENCOUNTERED ON ITEM 516587700 LIONEL 2 MBL AT SEMI AUTO GLUING PROCESS.
WHY 2:	TEAR OFF OCCURRED WHEN THE PANEL WAS BEING FOLDED BY THE OPERATOR NOTE: THE OPERATOR DIDN'T COMPRESS THE SIDES OF THE PANEL
WHY 3:	THE FOLDING LINE DOESN'T COMPRESS PROPERLY SO IT DEVELOPS A BUMP (BULDGE) ON THE SIDE OF THE FOLDING LINE
WHY 4:	THE CUSHION CREASE IS UNEVEN ON THE HEIGHT ON THE CREASING BLADE
WHY 5:	PROLONGED USE OF THE CUSHION CREASE HAS ALREADY COMPRESSED

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

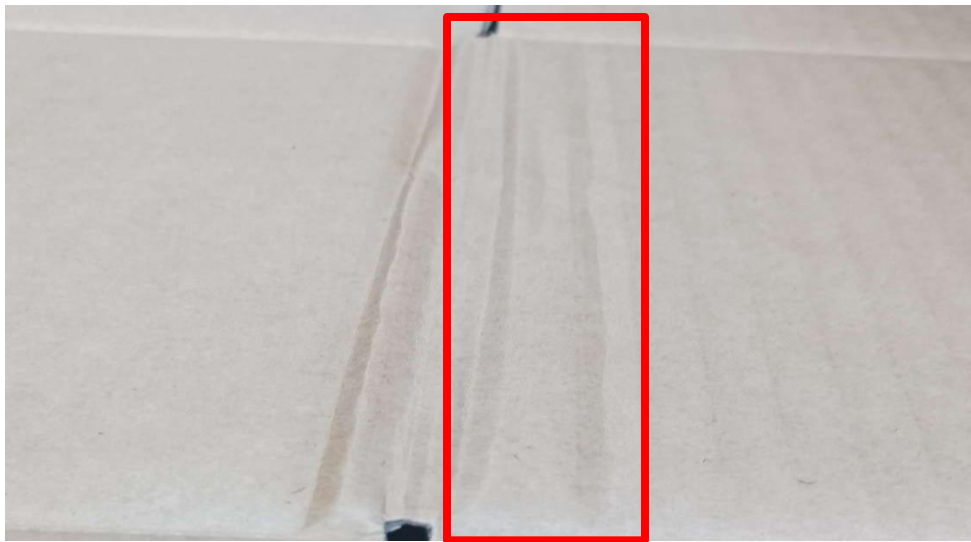
1	ORIENTATION FOR TOOLING CUSTODIAN AND DIECUT OPERATOR REGARDING FOR TEAR OFF ENCOUNTERED.	TARGET DATE :230914 PIC: IE STAFF
2	EDUCATE THE TOOLING CUSTODIAN AND OPERATOR REGARDING THE CHECKING OF CUSHION CREASE WHICH INCLUDE IN THE TOOLING CHECKSHEET	TARGET DATE :230914 PIC: IE STAFF
3	THE CUSHION CREASE INCREASED THE HEIGHT BY 1MM TO MAKE IT EVEN TO THE CREASING BLADE TO REMOVE THE BUMP ON THE SIDE OF THE FOLDING LINE (SUBJECT FOR TRIAL MONITORING)	TARGET DATE : NEXT RUNNING OF LIONEL ITEM PIC: IE STAFF



UNEVEN HEIGHT OF CUSHION CREASE AND CEASING BLADE
NOTE: THIS BLADE IS A COMMON BLADE



CUSHION CREASE INCREASED BY 1MM TO MAKE IT EVEN TO THE CREASING BLADE



THERE IS A BUMP (BULGED) BESIDE THE FOLDING LINE

KANEPACKAGE PHILIPPINE INC.					STRIPPING		STATUS (USAGE)	CRITERIA OF INSPECTION, APPEARANCE AND PERFORMANCE								VERIFICATION	
DATE yyyy/mm/dd	SHIFT	MACHINE	ITEM CODE	DESCRIPTION	MANUAL	AUTO		DIE CUT BLADE				PATTERN SHEET		DIE PLATE		RECEIVED BY	ISSUED AND INSPECT BY
								CUTTING BLADE (NICKMARK)	CREASING BLADE	PERFORATION BLADE	WAVED BLADE	CUSHION	WOOD	APPEARANCE	BACKING TAPE		
							BEFORE										
							AFTER										
							BEFORE										
							AFTER										
							BEFORE										
							AFTER										
							BEFORE										
							AFTER										

CRITERIA OF INSPECTION OF CUSHION CREASE (INCLUDED IN TOOLING CHECKSHEET)



THE OUTSIDE APPEARANCE OF FOLDING SIDE IS THICK

KANEPACKAGE PHILIPPINE INC.

MINUTES OF THE MEETING

Date: 230919 Time Start: 2:30 Time Finished: 2:45 Venue: DIECUT AREA

Name	Dept.	Sign	Name	Dept.	Sign
MODE: Olan (operator)	Prod	<i>[Signature]</i>			
REY WALTER WIGAN PROD		<i>[Signature]</i>			
Jerson Padecer	PROD	<i>[Signature]</i>			
Jenel Rosales	Prod	<i>[Signature]</i>			
Richard Sarmiento	Prod	<i>[Signature]</i>			
John P. P. P.		<i>[Signature]</i>			

AGENDA: ORIENTATION TO DIECUT OPERATOR AND TOOLING CUSTODIAN REGARDING ON TEAR-OFF ENCOUNTERED FOR LIGNE 2 MBL

MINUTES:

PROBLEM:
 ▼ TEAR OFF OCCURRED WHEN THE OPERATOR FOLDS THE PANELS DURING GLIDING PROCESS.

ROOT CAUSE:
 ▼ THE CUSHION CREASE ON THE BLADE WAS UNEVEN ON THE CREATING BLADE.

IMMEDIATE ACTION / MONITOR MEASURE:

- * RE-EDUCATE THE TOOLING CUSTODIAN AND OPERATOR REGARDING THE CHECKING OF CUSHION CREASE WHICH INCLUDE IN THE ROLLING CHARACTER.
- * THE TOOLING CUSTODIAN ADD 1MM ON THE CUSHION CREASE BESIDE THE CREATING BLADE SO THAT THE THICKNESS IS EQUAL.

MINUTES OF MEETING BY SIR KEVIN DIAZ