# 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

**SEPTEMBER 14, 2023** 

# **INVESTIGATION REPORT**

Prepared By:	Check By:	Approved By:
K.N ACUIN	N. CEPEDA	R. MIRANDA
OA-IE/ Prodn IE	QA/ Prodn SV	KPLIMA Operations Gen. Mngr.

5M	REVIEW			OCUMENT REV	[EW	
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	No Changes	Procedure Manual		└ With Revision ☑ No Revision	on K.N ACUIN	N/A
MATERIAL	No Changes	Work Instruction		☐ With Revision ☐ No Revision	on K.N ACUIN	N/A
METHOD	No Changes	Process Flow		☐ With Revision ☐ No Revision	on K.N ACUIN	N/A
ENVIRONMENT	No Changes	Forms	1	└ With Revision ☑ No Revision	on 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
1.2 PACKCROLIND	

DATE:



#### 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:**

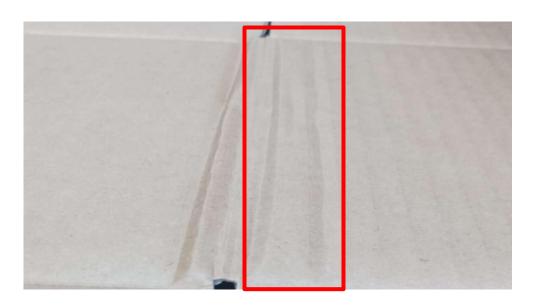
1	ORIENTATION FOR TOOLING CUSTODIAN AND DIECUT OPERATOR REGARDING FOR TEAR OFF ENCOUNTERED.	TARGET DATE :230914 PIC: IE STAFF
2	EDUCATE THE TOOLING CUSTODIAN AND OPERATOR REGARDING THE CHECKING OF CUSHION CREASE WHICH INCLUDE IN THE TOOLING CHECKSHEET	TARGET DATE :230914 PIC: IE STAFF
3	THE CUSHION CREASE 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



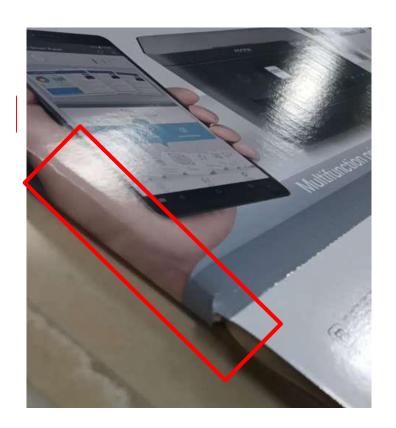
# CUSHION CREASE INCREASED BY 1MM TO MAKE IT EVEN TO THE CREASING BLADE



THERE IS A BUMP (BULGED) BESIDE THE FOLDING LINE

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	KAN	IEPACKA	GE PHILIP	PINE INC.	JIKIF	FING	STATUS			DIE CUT B	LADE			PATTERN	SHEET	DIE PL	ATE	VERIFIC	LATION
DATE yyyylmmi dd	SHIFT	MACHINE	ITEM CODE	DESCRIPTION	MANUAL	AUTO	(USAGE)	CUTTING BLADE (NICKMARK)	CREASING BLADE	PERFORATION BLADE	WAVED BLADE	CUSHION	WOOD	APPEARANCE	BACKING TAPE	APPEARANCE	CREASING MATRIX	RECEIVED BY	ISSUED AND INSPECT BY
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CRITERIA OF INSPECTION OF CUSHION CREASE (INCLUDED IN TOOLING CHECKSHEET)



THE OUTSIDE APPEARANCE OF FOLDING SIDE IS THICK

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REGARDING ON THE MINUTES:  PROBLEM:  ** TEAR OFF OCCURRED  DURING GLOING	TAR-OFF EXCOUNTY	ITERED	POR LIONE	2 2 MBL	
MINUTES:  PROBLEM:  ** TEAR OFF OCCURRED  DUENG GLEING  BOOT CAUSE:	THE OFF ENCOUNTY THE OFFER PRINCESS.	MOR PO	POR LIGHE	2 2 MBL	
MINUTES:  PROBLEM:  ** TENR OFF OCCURRED  DURING GLEINE  BOUT CAUSE:  ** THE COSION CRESSE	WARN THE SPER. PRINCESS.	MOR PO	POR LIONE	2 2 MBL	
MINUTES:  PROBLEM:  ** THE OFF ORURED  DUENG GLOWE  BOOT CAUSE:	WARN THE SPER. PRINCESS.	MOR PO	POR LIONE	2 2 MBL	
MINUTES:  PROBLEM:  ** TENR OFF OCCURRED  DURING GLOING  ROUT CAUSE:  ** THE CUSION CRESSE  CREMING BLADE.	wagsi 175 APER.  ON 176 BLADE	MOR PO	POR LIONE	2 2 MBL	
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MINUTES OF MEETING BY SIR KEVIN DIAZ