

**KANEPACKAGE PHILIPPINE INC.**

No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna  
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**INVESTIGATION REPORT**

**DATE:** SEPTEMBER 21, 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	230921	<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	Wrong Attachement of Backing Tape	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**

<b>1.1. ISSUE:</b>	
	TEAR OFF
<b>1.2. ITEM DESCRIPTION:</b>	
<b>PART CODE:</b>	5165877-00 / 5165878-00
<b>PART NAME:</b>	LIONEL 2 MBL
<b>1.3. BACKGROUND:</b>	
<b>PICTURE</b>	<b>DETAILS:</b>
	<p>In-house Detection : TEAR OFF            Lot size : 2983pcs            Reject Qty : 313pcs            Rejection Rate : 10.49%</p>

**II. IMMEDIATE ACTION**

ACTION ITEMS	Target Date:	Person In-charge
OPERATOR INFORM THE IN LINE QA REGARDING THE TEAR OFF & SORT THE AFFECTED ITEMS	230915	OPERATOR

**III. CAUSE ANALYSIS:**

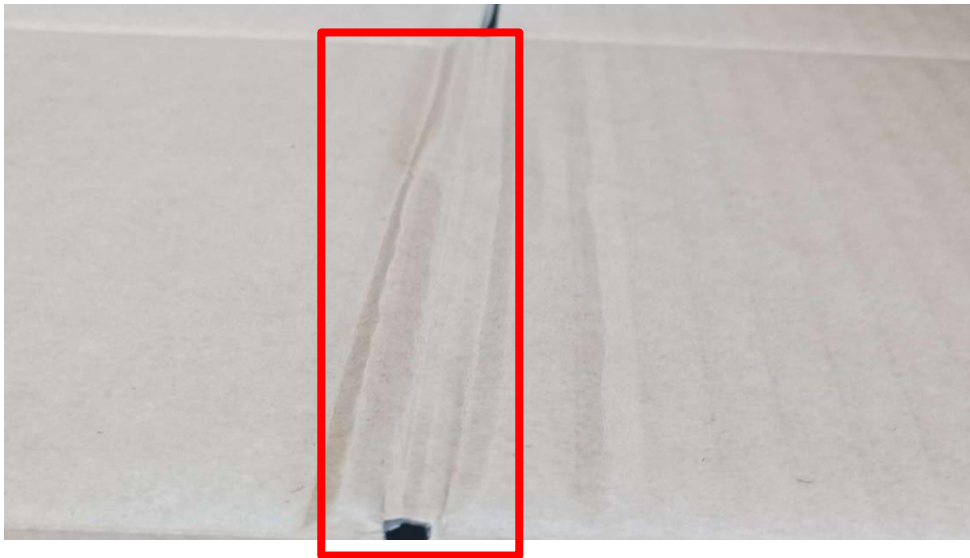
<b>WHY 1:</b>	Tear off occurred when the glued panels was being folded at semi auto gluing process
<b>WHY 2:</b>	The glued box was folded not in his original folding line
<b>WHY 3:</b>	There is bumped or bulging on the inner part of the box beside the Folding line resulting a strong tension on the horizontal Folding line
<b>WHY 4:</b>	Wrong and over backing of tape mounted on the creasing line
<b>WHY 5:</b>	Putting backing tape on the creasing line in the pattern sheet will cause additional pressure resulted to TEAR OFF

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

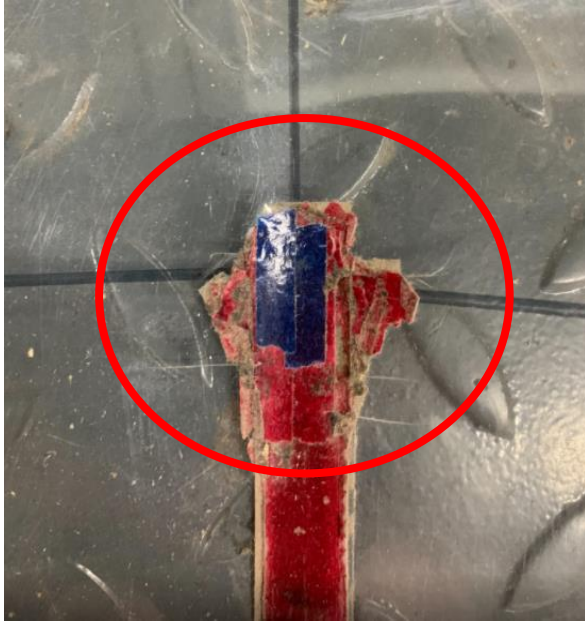
1	ORIENTATION FOR TOOLING CUSTODIAN AND DIECUT OPERATOR REGARDING TEAR OFF ENCOUNTERED.	TARGET DATE :230916 PIC: IE STAFF
2	TIGHTENING THE CHECKING OF THE PATTERN SHEET DURING SET UP.	TARGET DATE :230916 PIC: SUBLEADER
3	PROPER USE OF BACKING TAPE.	TARGET DATE : NEXT RUNNING OF LIONEL ITEM PIC: OPERATOR/SUBLEADER



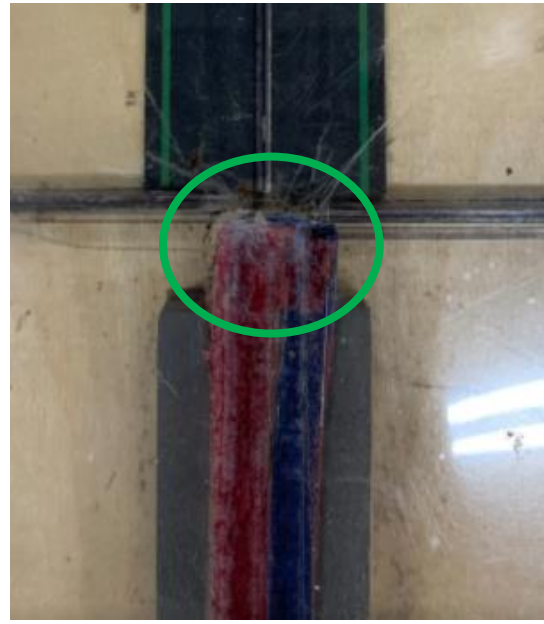
THE OUTSIDE APPEARANCE OF  
FOLDING SIDE IS THICK



THERE IS A BUMP (BULGED) BESIDE THE FOLDING LINE



NO GOOD



GOOD