KANEPACKAGE PHILIPPINE INC. No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna Telephone No. (049) 545-7166 to 69

INVESTIGATION REPORT

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

DATE:	OCTOBER 17, 2023

Fax No. (049) 545-6302

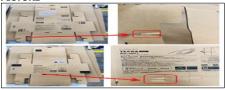
5M	REVIEW	DOCUMENT REVIEW				
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	No Changes	Procedure Manual		With Revision No Revision	K. DIAZ	N/A
MATERIAL	No Changes	Work Instruction	231025	With Revision No Revision	K. DIAZ	N/A
METHOD	NO STANDARD SHEET AND WAY TO DETACH THE ITEMS	Process Flow	231025	With Revision No Revision	K. DIAZ	N/A
ENVIRONMENT	No Changes	Forms		With Revision No Revision	K. DIAZ	N/A

I. PROBLEM DESCRIPTION

1.1. ISSUE: | TEAR OFF | | 1.2. ITEM DESCRIPTION: | PART CODE: | 516336400 / 516728200 | | PART NAME: | MUFFRIN / FRANZ |

1.3. BACKGROUND:

PICTURE



DETAILS:

>Inhouse Detection: TEAR OFF

>Lot size: 691pcs > Reject Qty: 70pcs >Rejection Rate: 10.13%

PROCESS FLOW OF THE ITEM







DIECUT PROCESS



DETACHING







RESULT TO TEAR-OFF

IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
RE-EDUCATE THE OPERATORS FOR PROPER WAY OF DETACHING ITEMS	231025	PIC: OPERATOR AND SUBLEADER

III. CAUSE ANALYSIS:

WHY TEAR-OFF OCCURRED ON THE ITEM?

WHY 1: TEAR-OFF OCCURRED AS A RESULT OF THE OPERATOR'S WAY TO DETACH THE ITEM DURING THE DETACHING PROCESS.



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WHY 2:	WHY THE OPERATOR FAILED TO DETACH THE ITEM? BECAUSE THERE IS NO SET STANDARD FOR ITEMS AND THE APPROPRIATE WAY TO BE DETACHED.	APPLICANE DOCUMENTO IN CONSTITUTO APPLICANE DOCUMENTO IN CONSTITUTO
WHY 3:	WHY THERE IS NO SET OF STANDARD ITEMS AND WAYS TO BE DETACH? BECAUSE THERE IS NO DETAILS IN THE WORK INSTRUCTIONS AS TO HOW MANY AND HOW TO DETACH THE ITEMS.	2.1 A disrupt of the investment of a discharge with discharged in the process of the contract
WHY 4:		

IV. ACTION PLAN: V. EVIDENCES:

