
 <b>KANEPACKAGE PHILIPPINE INC.</b> No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna Telephone No. (049) 545-7166 to 69 Fax No. (049) 545-6302	<h1>INVESTIGATION REPORT</h1>		
	Prepared By:	Check By:	Approved By:
	K.DIAZ QA-IE/ Prodn IE	N. CEPEDA QA/ Prodn SV	R. MIRANDA KPLIMA Operations Gen. Mngr.
<b>DATE:</b>	OCTOBER 04, 2023		

5M REVIEW		DOCUMENT REVIEW					
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:		PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	231004	With Revision	No Revision	K. DIAZ	N/A
MATERIAL	No Changes	Work Instruction		With Revision	No Revision	K. DIAZ	N/A
METHOD	No Changes	Process Flow		With Revision	No Revision	K. DIAZ	N/A
ENVIRONMENT	No Changes	Forms		With Revision	No Revision	K. DIAZ	N/A

## I. PROBLEM DESCRIPTION

<b>1.1. ISSUE:</b>	
	PEEL OFF
<b>1.2. ITEM DESCRIPTION:</b>	
<b>PART CODE:</b>	515909100
<b>PART NAME:</b>	LOUVRE 2 MCX EPIL
<b>1.3. BACKGROUND:</b>	
<b>PICTURE</b> 	<b>DETAILS:</b> >Inhouse Detection : PEEL OFF >Lot size: 929pcs > Reject Qty: 75pcs >Rejection Rate: 8.07%

## IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
1. PUT BACKING TAPE ON THE UNCUT PORTION 2. THE SUBLEADER OF SEMI AUTO INFORMED THE SUBLEADER OF DIECUT THAT AN UNCUT WAS FOUND. THE SUBLEADER EDUCATES HIS OPERATOR ON MANUAL BROWSING AND INFORMS THE LEADER AND SENIOR OPERATOR ON ANY ABNORMALITIES ENCOUNTERED.	OCTOBER 04, 2023	PIC: OPERATOR AND SUBLEADER

## III. CAUSE ANALYSIS:

<b>WHY 1:</b>	<b>WHY PEEL OFF OCCURRED ON THE ITEM?</b> PEEL OFF OCCURRED BECAUSE THE ITEM WAS UNCUT.
<b>WHY 2:</b>	<b>WHY THE ITEM WAS UNCUT?</b> UNCUT OF AN ITEM ENCOUNTERED DUE TO THE UNBALANCED OF BLADE.
<b>WHY 3:</b>	<b>WHY IS THE UNBALANCED OF BLADE HAPPEN?</b> UNBALANCED BLADE OCCURS DUE TO THE WIDE CONDITION OF THE BACKING TAPE IN THE PATTERN SHEET.
<b>WHY 4:</b>	<b>WHY THE CONDITION OF BACKING TAPE WIDENS?</b> BECAUSE OF EXCESSIVE USE/PUNCH OVER TIME DUE TO PREVIOUS PROCESSES, THE BACKING TAPE WIDENS ON THE PATTERN SHEET.
<b>WHY 5:</b>	

## IV. ACTION PLAN:

## V. EVIDENCES:

1	RE-EDUCATE THE OPERATORS FOR TIGHTENING THE MANUAL BROWSING.	PIC: IE STAFF/LINELEADER TARGET DATE: SEPT. 29, 2023
2	INFORM THEIR SUBLEADER OR SENIOR OPERATOR FOR ANY ABNORMALITIES BEING ENCOUNTERED.	PIC: SUBLEADER/LINE LEADER/OPERATOR TARGET DATE: SEPT. 29, 2023
3	CHECKING AND INSPECT OF ITEMS BEFORE TRANSFERRING TO PALLET.	PIC: SUBLEADER/LINE LEADER/OPERATOR TARGET DATE: SEPT. 29, 2023

**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

N. CEPEDA

R. MIRANDA

QA-IE/ Prodn IE

QA/ Prodn SV

KPLIMA Operations Gen. Mngr.

**DATE:**

OCTOBER 04, 2023

4

APPLY BACKING TAPE TO THE UNCUT PORTION IN THE PATTERN SHEET.

PIC: SUBLEADER/LINE LEADER/OPERATOR  
TARGET DATE: SEPT. 29, 2023