


 KANEPACKAGE PHILIPPINE INC. Blk 6-B Lot 2 & 3 P3, Lima Technology Center, Malvar, Batangas Telephone No.: (043) 236-6885	INVESTIGATION REPORT		
	Prepared By:	Check By:	Approved By:
	MHVITO QA-IE/ Prodn IE	N. CEPEDA/R.ALMARIO QA/ Prodn SV/MANAGER	R. MIRANDA KPLIMA ASST.VICE PRESIDENT
DATE:	231020		

5M REVIEW		DOCUMENT REVIEW					
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:		PIC:	Target Date:
MACHINE	NEW MACHINE	Procedure Manual	231020	<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	MH VITO	N/A
MATERIAL	No Changes	Work Instruction		<input checked="" type="checkbox"/> With Revision	<input type="checkbox"/> No Revision	MH VITO	N/A
METHOD	No Changes	Process Flow		<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	MH VITO	N/A
ENVIRONMENT	No Changes	Forms		<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	MH VITO	N/A

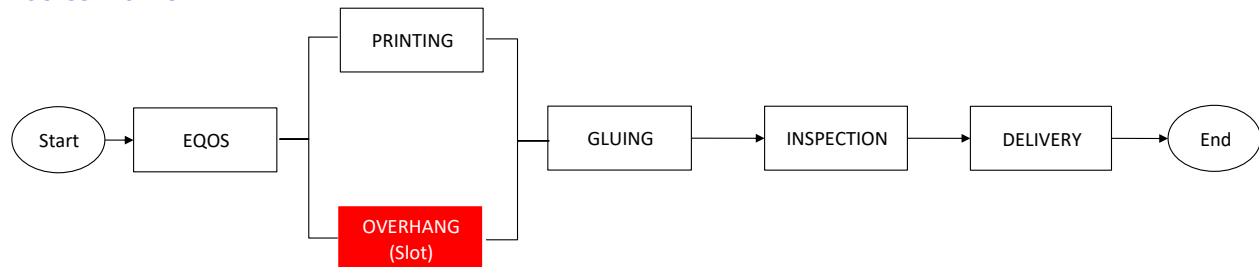
I. PROBLEM DESCRIPTION

1.1. ISSUE:	
	WRONG SLOT
1.2 DETAIL	
PART CODE:	5150863-01
PART NAME:	OUTER CARTON BOX
1.3. BACKGROUND:	
PICTURE 	DETAILS: <ul style="list-style-type: none"> > PLAN QTY:1240 EA > REJECT QTY: 400 EA > REJECT PERCENTAGE: 32.26%

II. IMMEDIATE ACTION


ACTION ITEMS	Target Date:	Person In-charge
SORTING OF ITEM	231016	PRODUCTION

PROCESS FLOW CHART





III. CAUSE ANALYSIS:

WHY 1:	Why Wrong Slot occurred in Outer Carton Box item? Overhang cutting Slot of EQOS mis-slot the lower part of the box
WHY 2:	Why the lower part of the box mis slotted? Corrugated Board moved when it was passed on the Feed Gripper Roller
WHY 3:	Why corrugated board moved when passed in the feed Gripper roller? The Feed Gripper roller was holding the sheets by 10mm only instead of 20mm
WHY 4:	Why the Feed Gripper Roller Holding the sheets too small? (10m)? To avoid the print images hit by the roller

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WHY 5:	-				

IV. ACTION PLAN:
V. EVIDENCES:

1	CONDUCT MEETING/ ORIENTATION REGARDING TO THE ISSUE OF WRONG SLOT ON THE ITEM 5150863-01 OUTER CARTON BOX		231016
2	ADJUSTMENT ON FEED ROLLER GRIPPER FROM 897mm TO 887mm GUIDED BY THE UMETANI JAPANESE TECHNICIAN		231016
3	FOLDING OF ITEM INTO BOX FORM FOR ADDITIONAL CHECK POINT ON THE CUTTING SLOT DURING SAMPLING		231020