
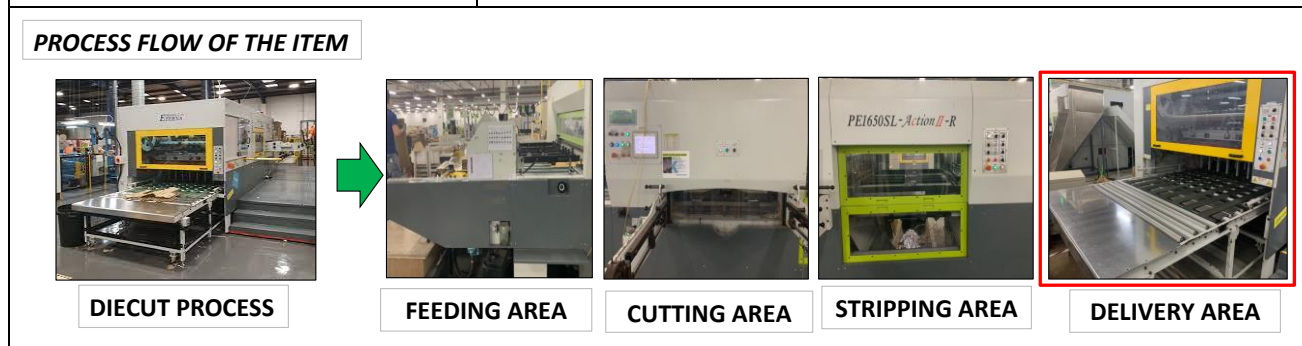
 KANEPACKAGE PHILIPPINE INC. No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna Telephone No. (049) 545-7166 to 69 Fax No. (049) 545-6302	<h1>INVESTIGATION REPORT</h1>		
	Prepared By:	Check By:	Approved By:
	K. DIAZ QA-IE/ Prodn IE	N. CEPEDA QA/ Prodn SV	R. MIRANDA KPLIMA Operations Gen. Mngr.
DATE:	NOVEMBER 14, 2023		

5M REVIEW		DOCUMENT REVIEW					
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:		PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	231114	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



1.1. ISSUE:	
	SCRATCHES
1.2. ITEM DESCRIPTION:	
PART CODE:	516378900
PART NAME:	LIME 2 MB
1.3. BACKGROUND:	
PICTURE 	DETAILS: >Inhouse Detection : SCRATCHES >Lot size: 585pcs > Reject Qty: 40pcs >Rejection Rate: 6.84%



IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
THE SUBLEADER OF SEMI AUTO INFORM THE DIECUT OPERATORS THAT THE ITEM HAVE SCRATCHES AND CONDUCT A MEETING		PIC: OPERATOR AND SUBLEADER

III. CAUSE ANALYSIS:

WHY 1:	WHY SCRATCHES OCCURRED ON THE ITEM? SCRATCHES OCCURRED DURING IN THE DELIVERY WHEN OPERATOR GETTING OF THE ITEM.	
WHY 2:	WHY THE OPERATOR ENCOUNTERED SCRATCH WHEN GETTING THE ITEM? BECAUSE THE DELIVERY STEEL TABLE HAVE SCRATCHES ON IT.	

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KPLIMA Operations Gen. Mngr.**DATE:**

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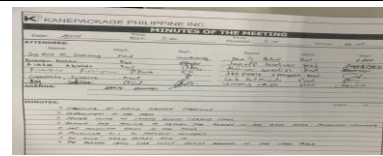
WHY 3:**WHY THE DELIVERY STEEL TABLE HAVE SCRATCHES?**

WHEN THEY ENCOUNTERED UNCUT ITEMS, THE OPERATOR REWORK THE ITEM IN THERE USING CUTTER AND THEY DIDN'T KNOW THAT THE TABLE WAS SHARPENED.

**WHY 4:****IV. ACTION PLAN:****V. EVIDENCES:**

1

CONDUCT A MEETING AND RE-EDUCATE THE OPERATORS ABOUT THE ISSUE AND FOR THE REWORK ITEMS THEY ARE NOT ALLOWED ON THE STEEL TABLE TO REWORK.



PIC: IE STAFF/LINELEADER/OPERATOR
TARGET DATE: NOV 14, 2023

2

THE OPERATOR SCRUB THE STEEL TABLE USING SANDPAPER (GWS 1500)



PIC: SUBLEADER/OPERATOR
TARGET DATE: NOV 14, 2023