

**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
 QA-IE/ Prodn IE

N. CEPEDA
 QA/ Prodn SV

R. MURANDA
 KPLIMA Operations Genl. Mngr.

DATE:

NOVEMBER 13, 2023

5M REVIEW**DOCUMENT REVIEW**

MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	231113	<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	K. DIAZ	N/A
MATERIAL	No Changes	Work Instruction		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	K. DIAZ	N/A
METHOD	No Changes	Process Flow		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	K. DIAZ	N/A
ENVIRONMENT	No Changes	Forms		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	K. DIAZ	N/A

I. PROBLEM DESCRIPTION**1.1. ISSUE:**

BURSTING

1.2. ITEM DESCRIPTION:

PART CODE: 516106500

PART NAME: ROSA SAX

1.3. BACKGROUND:**PICTURE****DETAILS:**

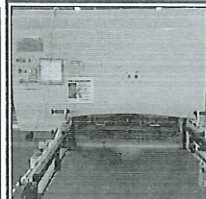
> Inhouse Detection : BURSTING
 > Lot size: 1284pcs
 > Reject Qty: 94pcs
 > Rejection Rate: 7.32%

PROCESS FLOW OF THE ITEM

DIECUT PROCESS



FEEDING AREA



CUTTING AREA



STRIPPING AREA



DELIVERY AREA

IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
INFORM THE DIECUT LEADER FROM SEMI AUTO GLUING THAT THE ITEM HAS BURSTING DURING FOLDING.		PIC: OPERATOR AND SUBLEADER

III. CAUSE ANALYSIS:

WHY 1:	WHY BURSTING OCCURRED ON THE ITEM? BURSTING OCCURRED DUE TO THE CONDITION OF TOOLS OF DIEPLATE (BULGE/WORNOUT)	
WHY 2:	WHY THE DIEPLATE BULGE? THE DIEPLATE (IMPORTED PLATE) FOR ROSA SAX BULGES DUE TO LONG-TERM USE.	
WHY 3:	WHY THE DIEPLATE (IMPORTED) HAS LONG TERM OF USE? BECAUSE OF NO MONITORING OF IMPORTED PLATE WHEN IT STARTED.	
WHY 4:		

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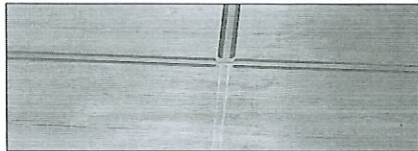
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QA-IE/ Prodn IEN. CEPEDA
QA/ Prodn SVR. MIRANDA
KPLIMA Operations Gen. Mngr.**IV. ACTION PLAN:****V. EVIDENCES:**

1	CONDUCT A MEETING AND RE-EDUCATE THE OPERATORS ABOUT THE ISSUE.	PIC: IE STAFF/LINELEADER/OPERATOR TARGET DATE: NOV 13, 2023
2	THE OPERATOR REVERSE THE PLATE AND PUT NEW CREASING MATRIX. <i>NOTE: THE LOCAL PLATE HAS DIESHOTS MONITORING</i>	 PIC: IE STAFF TARGET DATE: NOV 13, 2023