
 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:	OCTOBER 17, 2023		

5M REVIEW		DOCUMENT REVIEW					
MAN	NEW OPERATOR	Affected Document:	Date Reviewed:	Disposition:		PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	231017	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:	
	INVERTED CUT
1.2. ITEM DESCRIPTION:	
PART CODE:	515143600
PART NAME:	CARTON BOX
1.3. BACKGROUND:	
PICTURE 	DETAILS: > Inhouse Detection : INVERTED CUT > Lot size: 189pcs > Reject Qty: 37pcs > Rejection Rate: 19.58%

IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
RE-EDUCATE AND GUIDE THE OPERATORS FOR TIGHTENING THE MANUAL BROWSING AND PROPER FEEDING OF ITEMS.	231017	PIC: OPERATOR AND SUBLEADER

III. CAUSE ANALYSIS:

WHY 1:	WHY INVERTED CUT OCCURRED ON THE ITEM? INVERTED CUT OCCURRED WHEN THE OPERATOR MISFEED THE ITEM IN THE FEEDING AREA.	
WHY 2:	WHY THE OPERATOR MISFEED THE ITEM? THE OPERATOR BYPASS THE MANUAL BROWSING OF THE ITEM.	PROPER OPERATION FOR FEEDER AND CATCHER OPERATOR AT DIECUT PROCESS FEEDER SECTION AREA 
WHY 3:	WHY THE OPERATOR BYPASS THE MANUAL BROWSING? THE OPERATOR FAIL TO DO THE GUIDELINES OF PROPER FEEDING AND CHECKPOINTS OF ITEMS.	FEEDER OPERATOR CHECKPOINT: -For every 20 pieces(start, middle,end) in the pallet, the feeder operator will inspect the items and also the last 20 panels (code /panel/paper shade)
WHY 4:	WHY THE OPERATOR FAIL TO DO THE GUIDELINES? BECAUSE THE NEW FEEDER OPERATOR IS IN TRAINING.	

IV. ACTION PLAN:

V. EVIDENCES:

1	RE-EDUCATE THE OPERATORS FOR TIGHTENING THE MANUAL BROWSING AND PROPER FEEDING OF ITEMS.	PIC: IE STAFF/LINELEADER TARGET DATE: SEPT. 29, 2023
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INFORM THEIR SUBLEADER OR SENIOR OPERATOR FOR ANY ABNORMALITIES BEING ENCOUNTERED.

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

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