

INVESTIGATION REPORT

Prepared By: *[Signature]* K. DIAZ Prodn IE
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 Approved By: *[Signature]* R. ALMARIO KPLIM PROD Mnggr.

DATE: JANUARY 10, 2024

5M REVIEW			DOCUMENT REVIEW				
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:		PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	240110	<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	K. DIAZ	N/A
MATERIAL	PEEL-OFF DUE TO UNCUT	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: PEEL OFF

1.2. ITEM DESCRIPTION:
 PART CODE: 5151436-00
 PART NAME: CARTON BOX STD;B

1.3. BACKGROUND:

PICTURE



DETAILS:

- > Inhouse Detection : PEEL OFF
- > Lot size: 299pcs
- > Reject Qty: 15pcs
- > Rejection Rate: 5.01%



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.	JANUARY 10, 2024	PIC: OPERATOR AND SUBLEADER

III. CAUSE ANALYSIS:

WHY 1:	Why there are PEELED OFF defect in 5151436-00 ICB? There is an un-cut part on the box that causes the Top sheet un-detached	
WHY 2:	Why There is an un-cut part on the box that causes the Top sheet un-detached? There is un-balance pressure applied on the process resulting un balance cutting	
WHY 3:	Why there is un-balance pressure applied on the process resulting un balance cutting? Deteriorated Pattern Sheet with deteriorated and wron out backing Tape	
WHY 4:	Why there is a Deteriorated Pattern Sheet with deteriorated and wron out backing Tape? No Proper and Standard monitoring the life span of Pattern Sheet	

IV. ACTION PLAN:

V. EVIDENCES:

1	>RE-EDUCATE THE OPERATORS FOR TIGHTENING THE MANUAL BROWSING AND INFORM THEIR SUBLEADER OR SENIOR OPERATOR FOR ANY ABNORMALITIES BEING ENCOUNTERED. >MANUAL DETACHING OPERATOR MUST INFORM DIECUT REGARDING UNCUT PARTS.	 PIC: IE STAFF/LINELEADER/OPERATOR TARGET DATE: JANUARY 10, 2024
2	Study and Set Life Span monitoring of Pattern Sheet	PIC: IE STAFF/LINELEADER/OPERATOR TARGET DATE: JANUARY 12, 2024