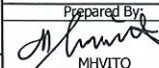

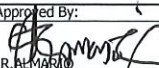

 KANEPACKAGE PHILIPPINE INC. Blk 6-B Lot 2 & 3 P3, Lima Technology Center, Malvar, Balangas Telephone No.: (043) 236-6885	INVESTIGATION REPORT		
	Prepared By:  MH VITO QA-IE/ Prodn IE	Check By:  N. CEPEDA QA/ Prodn EV/MANAGER	Approved By:  R. ALMARIO KPLIMA Prodn Manager
DATE: 240117			

5M REVIEW			DOCUMENT REVIEW			
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	240117	<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	WRONG ORIENTATION OF SHEET	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:	
	MISALIGNED PRINT
1.2 DETAIL	
PART CODE:	5164437-002
PART NAME:	PAD ASSY
1.3. BACKGROUND:	
PICTURE 	DETAILS: > PLAN QTY: 480 EA > REJECT QTY: 6 EA > REJECT PERCENTAGE: 15%

II. IMMEDIATE ACTION




ACTION ITEMS	Target Date:	Person In-charge
SORTING OF ITEM	240110	PRODUCTION

III. CAUSE ANALYSIS:

WHY	DETAIL	IMAGE
WHY 1:	Why Misaligned print occurred at Lucida Assy? Pad base used are in wrong position of barcode.	
WHY 2:	Why the position of barcode are in wrong position? Pad base are inverted during die cutting process	
WHY 3:	Why the Pad base are inverted at Die cut Process? The sheet/material used in die cut was wrong orientation during Eqos printing	
WHY 4:	Why wrong orientation of material at Eqos printing happened? During sampling test of sheet, operator place on the conveyor in wrong position.	
WHY 5:	Why operator place the sheet in wrong position? No standard for sampling item on how to place the material on caster or conveyor.	

IV. ACTION PLAN:

V. EVIDENCES:

1	ORIENT THE OPERATOR FOR THE CLAIM ISSUE OF MISALIGNED PRINT.		240111
2	REVISION OF WI FOR THE INCLUSION OF SAMPLING ITEM TO BE PLACE AFTER THE PROCESS TO AVOID WRONG ORIENTATION OF SHEETS ON THE PALLET		240122
3	PLACING OF ALL SAMPLING ITEM ON THE SAMPLING TABLE THEN TRANSFER IT ON THE CASTER/PALLET AFTER FINISHING THE JOB AND OPERATOR TO CHECK THE ITEM PRIOR MIXING IT TO ITEM COMING FROM MASS PRODUCTION OUTPUT		240111



KANEPACKAGE PHILIPPINE INC.

ATTENDANCE SHEET

Submitted by:

MHHTO

Date:

240111

ACTIVITY

Claim from EPPI regarding misaligned Print at 5164437-002 PAD assy

Attendees

	FIRST NAME	LAST NAME	DIV. / DEPT.	SIGNATURE
1	KIMBERLY	FADDA	PROD.	
2	Jy Mce	Dunauig	Prod	
3	JESSICA	BASAL	Prod.	
4	Mary Rose Alm	Caffio	Prod.	
5	Clair	Clare	Prod.	
6	DRLYN	MOLACAS	PROD	
7	Mariane	Junison	PROD	
8	MEY BELL	FERRAN	PROD	
9	Josephine	Jamito	Prod	
10	UAT	delma	PROD	
11	Jonna	Miranda	Prod	
12	Nina	paluyo	Prod	
13	Lester	Hernandez	Prod.	
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Note: This form is confidential. Do not use as scratch paper.

GA-001-F13-Rev. 01

Page 1 of 1