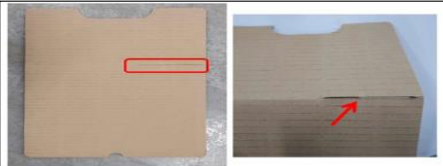





 KANEPACKAGE PHILIPPINE INC. No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna Telephone No. (049) 545-7166 to 69 Fax No. (049) 545-6302	<h1>INVESTIGATION REPORT</h1>		
	Prepared By:	Check By:	Approved By:
	K.DIAZ QA-IE/ Prodn IE	N. CEPEDA QA/ Prodn SV	R. MIRANDA KPLIMA Operations Gen. Mngr.
DATE:	NOVEMBER 09, 2023		

5M REVIEW		DOCUMENT REVIEW					
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:		PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	231109	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

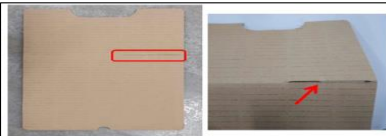
1.1. ISSUE:	
	BURSTING
1.2. ITEM DESCRIPTION:	
PART CODE:	516146300
PART NAME:	PAD SLEEVE
1.3. BACKGROUND:	
PICTURE 	DETAILS: >Inhouse Detection : BURSTING >Lot size: 4596pcs > Reject Qty: 371pcs >Rejection Rate: 8.07%


PROCESS FLOW OF THE ITEM				
				
DIECUT PROCESS	FEEDING AREA	CUTTING AREA	STRIPPING AREA	DELIVERY AREA

IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
RE-EDUCATE THE OPERATORS TO TIGHTENING THE MANUAL BROWSING OF AN ITEM		PIC: OPERATOR AND SUBLEADER

III. CAUSE ANALYSIS:

WHY 1:	WHY BURSTING OCCURRED ON THE ITEM? BURSTING OCCURRED WHEN A SCRAP LEFT IN THE CUTTING SECTION OF THE MACHINE.	
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DATE: NOVEMBER 09, 2023		Prepared By:	Check By:	Approved By:
		K. DIAZ QA-IE/ Prodn IE	N. CEPEDA QA/ Prodn SV	R. MIRANDA KPLIMA Operations Gen. Mngr.
WHY 2:	WHY THERE IS A SCRAP LEFT ON THE MACHINE? BECAUSE DURING RUNNING THE OPERATOR ENCOUNTERED LOOSEBOARD IN THE MACHINE.			
WHY 3:	WHY LOOSEBOARD ENCOUNTERED? BECAUSE WHEN PROCESSING THE ITEM, THE ITEM ITSELF DETACH IN THE CUTTING AREA AND SCRAP WAS LEFT ON THE DIECUT PLATE.			
WHY 4:	WHY THE ITEM DETACH IN THE CUTTING AREA? BECAUSE NOT ENOUGH NICKMARK ON THE BLADE.			

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 09, 2023
2	CHECK THE ACTUAL SCRAP AND PUT A NICKMARK ON THE PART OF THE BLADE WHERE THE SCRAP WAS CUT	PIC: IE STAFF TARGET DATE: NOV 09, 2023