
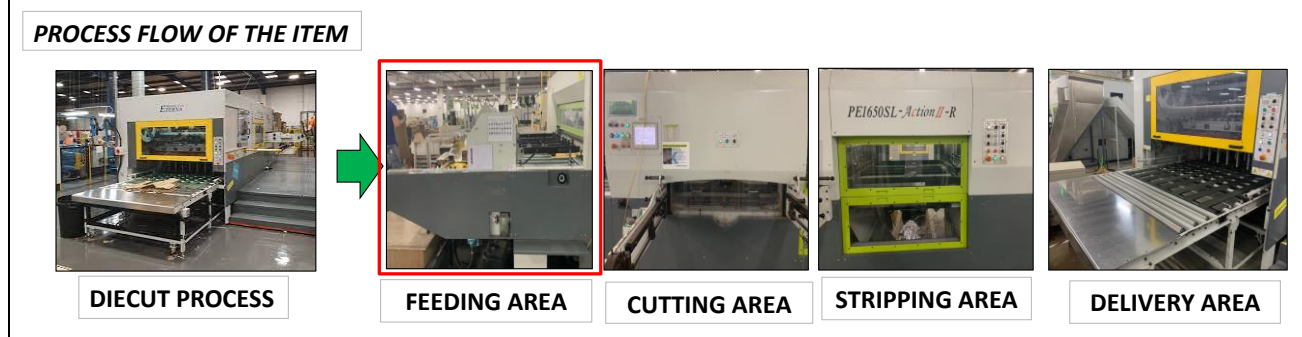
 KANEPACKAGE PHILIPPINE INC. No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna Telephone No. (049) 545-7166 to 69 Fax No. (049) 545-6302	<h1>INVESTIGATION REPORT</h1>		
	Prepared By:	Check By:	Approved By:
	K. DIAZ QA-IE/ Prodn IE	N. CEPEDA QA/ Prodn SV	R. MIRANDA KPLIMA Operations Gen. Mngr.
DATE:	NOVEMBER 20, 2023		

5M REVIEW		DOCUMENT REVIEW					
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:		PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	231120	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:	
	MISALIGN CUT
1.2. ITEM DESCRIPTION:	
PART CODE:	516212703
PART NAME:	CARTON BOX
1.3. BACKGROUND:	
PICTURE 	DETAILS: > Inhouse Detection : MISALIGN CUT > Lot size: 1721pcs > Reject Qty: 232pcs > Rejection Rate: 13.48%



IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
THE SUBLEADER OF DIECUT INFORM THE SUBLEADER OF LAMINATION THAT THE ITEM HAS EXCESS SF IN THE ITEM.		PIC: OPERATOR AND SUBLEADER

III. CAUSE ANALYSIS:

WHY 1:	WHY MISALIGN CUT OCCURRED ON THE ITEM? A MISALIGN CUT OCCURRED IN THE FEEDING SECTION DUE TO ITEM CONDITION (MISALIGN GLUING).	
WHY 2:	WHY THE CONDITION OF ITEM HAS MISALIGN GLUING? DURING PROCESSING THE OPERATOR ENCOUNTERED EXCESS SINGLE FACE IN THE ITEM.	

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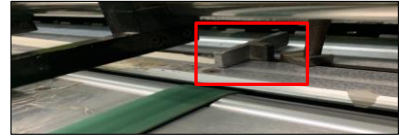
R. MIRANDA
KPLIMA Operations Gen. Mngr.

DATE:

NOVEMBER 20, 2023

WHY 3:**WHY EXCESS SINGLE FACE IN THE ITEM?**

DURING LAMINATION PROCESS, THEY ENCOUNTERED DELAY FEEDING OF SINGLE FACE AND INSTEAD OF PRINTED SHEETS, THE SIDE GUIDE PUSHES THE SINGLE FACE.

**WHY 4:****WHY ENCOUNTERED DELAY FEEDING OF SINGLE FACE IN THE ITEM?**

THE SENSOR HAD FIBER OF PAPER.

**IV. ACTION PLAN:****V. EVIDENCES:**

1	CONDUCT A MEETING AND RE-EDUCATE THE OPERATORS ABOUT THE ISSUE AND TIGHTENING OF MANUAL BROWSING OF AN ITEM.	PIC: IE STAFF/LINELEADER/OPERATOR TARGET DATE: NOV 20, 2023
2	IF ENCOUNTERED EXCESS SINGLE FACE, SORT AND REWORK THE ITEM.	PIC: SUBLEADER/OPERATOR TARGET DATE: NOV 20, 2023