KANEPACKAGE PHILIPPINE INC.

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INVESTIGATION REPORT

	Prepared By:	Check By:	Approved By:
DATE: 240111	MHVITO QA-IE/ Prodn IE	N. CEPEDA Production supervisor	R. ALMARIO Production Manager

5M REVIEW | DOCUMENT REVIEW

		Affected Document:	Date Reviewed:	Disposition:			PIC:	Target Date:
MAN	No Changes	Procedure Manual		☐ With Revision	☑ No Revision		MH VITO	N/A
MACHINE	No Changes	Work Instruction	240111	☑ With Revision	☐ No Revision		MH VITO	240229
MATERIAL	No Changes	Process Flow		☑ With Revision	☑ No Revision		MH VITO	N/A
METHOD	CYREL CANAL	Forms		☐ With Revision	☑ No Revision		MH VITO	N/A
ENVIRONMENT	No Changes							

I. PROBLEM DESCRIPTION

1.1. ISSUE:

FADED CHARACTER

1.2 DETAIL

PART CODE:	5167137-00
PART NAME:	INDIVIDUAL CARTON BOX

1.3. BACKGROUND:

PICTURE	DETAILS:
	> PLAN QTY: 587 PCS > REJECT QTY: 40 PCS > REJECT PERCENTAGE: 6.81% > JO #: 053454

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
ORIENTATION REGARDING INCOMPLTE PRINT ISSUE	240111	PRODUCTION

III. CAUSE ANALYSIS:

WHY'S	DETAIL	IMAGE
WHY 1:	**Why Faded character occur at item 5167137-00 Individual Carton Box?** The ink that was distributed was not able to penetrate in the cyrel	
WHY 2:	**Why the ink cannot penetrate in the cyrel?** Some parts of the cyrel particular on the affected image are not touch/ fit on the board	
WHY 3	**Why some parts of the cyrel are not touch/fit on the board?** Machine cylinder has canal which is aligned on the cyrel character that cause faded print	
WHY 4:	**Why the machine cylinder has canal?** Upon installation of the machine, It used to hang small cyrel and it has meter tape canal for measurement to aligned the cyrel on the cylinder.	
WHY 5:		

IV. ACTION PLAN: V. EVIDENCES:

1	PUTTING OF BACKING TAPE AT METER TAPE CANAL AND CYREL STICK ON PRINTING STRIP CANAL.		240111
2	INCLUSION IN WORK INSTRUCTION ON PUTTING OF BACKING TAPE AT METER TAPE CANAL AND CYREL STICK ON PRINTING STRIP CANAL.		240229