

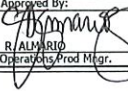
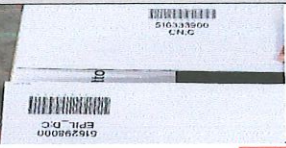




 <b>KANEPACKAGE PHILIPPINE INC.</b> No. 5 Pong Road USF II, Brgy. La Mesa, Calamba City, Laguna Telephone No. (045) 545-7168 to 69 Fax No. (045) 545-4392		<h2 style="text-align: center;">INVESTIGATION REPORT</h2>				
<b>DATE:</b> FEBRUARY 5, 2024		Prepared By:  KN. ACUIN QA-IE/ Prod'n IE	Check By:  J. CEPEDA QA/ Prod'n SV	Approved By:  R. ALVARADO KPLIMA Operations Prod Mgr.		
<b>SM REVIEW</b>		<b>DOCUMENT REVIEW</b>				
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	240201	<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	KN. ACUIN	N/A
MATERIAL	No Changes	Work Instruction		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	KN. ACUIN	N/A
METHOD	No Changes	Process Flow		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	KN. ACUIN	N/A
ENVIRONMENT	No Changes	Forms		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	KN. ACUIN	N/A

### I. PROBLEM DESCRIPTION

<b>1.1. ISSUE:</b> DOUBLE PANEL	
<b>1.2. ITEM DESCRIPTION:</b> PART CODE: 516054300 PART NAME: OUTER CARTON BOX	
<b>1.3. BACKGROUND:</b>	
	<b>DETAILS:</b> >Inhouse Detection : DOUBLE PANEL >Lot size: 194 pcs > Reject Qty: 1 pcs >Rejection Rate: 0.52% >JO#: 055541
<b>PROCESS FLOW OF THE ITEM</b>	
	
	
SEMI AUTO GLUING PROCESS	FEEDING AREA
FOLDING AREA	CATCHER AREA

### IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
MEETING REGARDING THE DOUBLE PANEL ENCOUNTERED	240201	SUBLEADER & IE STAFF

### III. CAUSE ANALYSIS:

WHY 1:	WHY DOUBLE PANEL OCCURRED? OPERATOR DID NOT NOTICE THAT THERE WAS MIXED PANEL ON THE FEEDER	
WHY 2:	WHY THE OPERATOR DIDN'T NOTICED THE MIXED PANEL AT FEEDER AREA? THE OPERATOR PLACED THE WRONG PANEL THAT CAME FROM THE SALVAGE ITEM (REWORKABLE) ON THE FEEDER AREA	
WHY 3:	WHY THE OPERATOR PLACE THE WRONG PANEL IN THE FEEDER AREA? NO PROPER CHECKING OF THE ITEM THAT CAME FROM THE SALVAGE AND SKIPPING THE CHECKING OF BARCODE	
WHY 4:	WHY THE OPERATOR NO PROPER CHECKING AND BYPASSED THE BARCODE? OPERATOR DID NOT FOLLOWING THE PROPER INSTRUCTION	

### IV. ACTION PLAN:

### V. EVIDENCES:

INCLUSION OF JOB ASSIGNMENT OF OPERATOR  INCLUSION OF THE FOLLOWING IN WI. MAIN OPERATOR WILL BROWSE THE SALVAGE ITEM BEFORE PUTTING IN THE FEEDER SUBLEADER WILL VERIFY THE SALVAGE ITEM  1 FEEDER OPERATOR - UNLOADING OF ALL PANELS AT THE FEEDING AREA TO CHECK THE POSSIBLE ERROR FOLDER OPERATOR - SLIGHT LIFTING THE GLUED PANELS TO CHECK THE BARCODE OF BOTH PANELS -RELEASE ALL THE ITEMS INSIDE THE CONVEYOR CATCHER OPERATOR - CHECKING/BROWISING ALL THE GLUED ITEMS	PIC: IE STAFF TARGET DATE: FEB. 2024
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