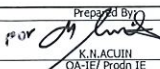
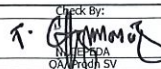
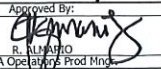


 KANEPACKAGE PHILIPPINE INC. No. 5 Ring Road USF II, Brgy. La Mesa, Calamba City, Laguna Telephone No. (049) 545-7156 to 59 Fax No. (049) 545-4392	INVESTIGATION REPORT		
	Prepared By:  K.N. ACUIN QA-IE/ Prodn IE	Check By:  R. ALVARO QA/Watch SV	Approved By:  R. ALVARO KPLINA Operations Prod Mngt.
DATE: FEBRUARY 17, 2024			

SM REVIEW		DOCUMENT REVIEW					
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:		PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	240318	<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	K.N.ACUIN	N/A
MATERIAL	No Changes	Work Instruction		<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	K.N.ACUIN	N/A
METHOD	No Changes	Process Flow		<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	K.N.ACUIN	N/A
ENVIRONMENT	No Changes	Forms		<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	K.N.ACUIN	N/A

I. PROBLEM DESCRIPTION

1.1. ISSUE:	
	SCRATCHES
1.2. ITEM DESCRIPTION:	
PART CODE:	516658600
PART NAME:	LIME FB JAPAN/B
1.3. BACKGROUND:	
 	DETAILS: >Inhouse Detection : SCRATCHES >Lot size: 106 pcs > Reject Qty: 62 pc >Rejection Rate: 58.49%

IMMEDIATE ACTION


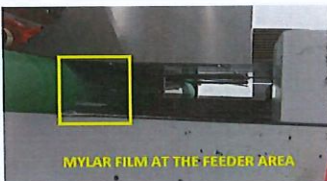
ACTION ITEMS	Target Date:	Person In-charge
CONDUCT MEETING REGARDING SCRATCHES	240306	IE STAFF

III. CAUSE ANALYSIS:

WHY 1:	WHY SCRATCHES OCCURRED AT LIME FB? UPON MASS PRODUCTION AT SEMI AUTO GLUING MACHINE 3 AND 4 THE PANEL GOT SCRATCHES DURING FEEDING	
WHY 2:	WHY THERE IS A SCRATCHES APPEAR DURING FEEDING? THE FEEDER ROLLER SCRATCHING THE PANEL AND THE FEEDER STOPPER GUIDE WAS ON THE OPPOSITE SIDE OF THE BLUE PORTION OF THE PANEL THAT HAS THE SCRATCHES	
WHY 3:	WHY THE FEEDER STOPPER GUIDE ON THE OPPOSITE SIDE OF THE BLUE PORTION OF THE PANEL GOT SCRATCHES? THE BLUE PORTION OF THE PANEL WAS FACING THE FEEDER ROLLER FIRST AND ONCE THE ROLLER ROLLS THE PANEL WITH BLUE PORTION GOT SCRATCHES	
WHY 4:	WHY THE BLUE PORTION OF THE PANEL WAS FACING THE FEEDER ROLLER IT IS THE STANDARD SET UP IN THE FEEDER AREA THAT GLUE TAB IS ALWAYS ON THE LEFT SIDE.	

IV. ACTION PLAN:

V. EVIDENCES:

1	RE- EDUCATE THE OPERATORS REGARDING THE TROUBLE SHOOTING OF THE SCRATCHES - PUTTING MYLAR FILM IN THE FEEDER ROLLER IF THE BLUE PORTION OF THE PANEL IF ENCOUNTERED SCRATCHES - KEEP A SAMPLE FOR RUB TEST	PIC: IE STAFF/LINELEADER TARGET DATE: MARCH, 2024
2		 
		MYLAR FILM AT THE FEEDER AREA