

**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

INVESTIGATION REPORT

Prepared By:

Check By:

Approved By:

K. DIAZ
QA-IE/ Prodn IE

M. CAPEDA
QA Prodn SV

R. MIRANDA
KPLIMA Operations/Gen. Mngr.

DATE:

NOVEMBER 25, 2023

5M REVIEW

MAN	No Changes
MACHINE	No Changes
MATERIAL	No Changes
METHOD	No Changes
ENVIRONMENT	No Changes

Affected Document:

Procedure Manual

Work Instruction

Process Flow

Forms

Date Reviewed:

231125

DOCUMENT REVIEW

Disposition:

☐ With Revision ☒ No Revision☐ With Revision ☒ No Revision☐ With Revision ☒ No Revision☐ With Revision ☒ No Revision

PIC:

K. DIAZ

K. DIAZ

K. DIAZ

K. DIAZ

Target Date:

N/A

N/A

N/A

N/A

I. PROBLEM DESCRIPTION**1.1. ISSUE:**

PEEL OFF

1.2. ITEM DESCRIPTION:**PART CODE:**

515297500

PART NAME:

LIONEL MGY EUR

1.3. BACKGROUND:**PICTURE****DETAILS:**

> Inhouse Detection : PEEL OFF

> Lot size: 298pcs

> Reject Qty: 19pcs

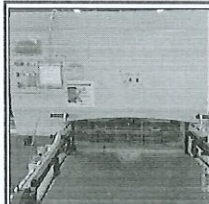
> Rejection Rate: 6.38%

PROCESS FLOW OF THE ITEM

DIECUT PROCESS



FEEDING AREA



CUTTING AREA



STRIPPING AREA



DELIVERY AREA

IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
1. PUT BACKING TAPE ON THE UNCUT PORTION 2. THE SUBLEADER OF SEMI AUTO INFORMED THE SUBLEADER OF DIECUT THAT AN UNCUT WAS FOUND. THE SUBLEADER EDUCATES HIS OPERATOR ON MANUAL BROWSING AND INFORMS THE LEADER AND SENIOR OPERATOR ON ANY ABNORMALITIES ENCOUNTERED.		PIC: OPERATOR AND SUBLEADER

III. CAUSE ANALYSIS:

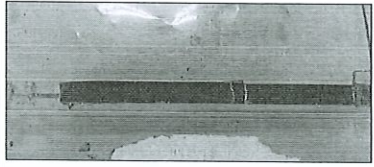
WHY 1:	ITEM PEELED OFF ON THE UPPER FLAP CLASS B FOR CODE 515297500 LIONEL	
WHY 2:	PEEL OFF OCCURED BECAUSE THE ITEM WAS UNCUT.	

**KANEPACKAGE PHILIPPINE INC.**

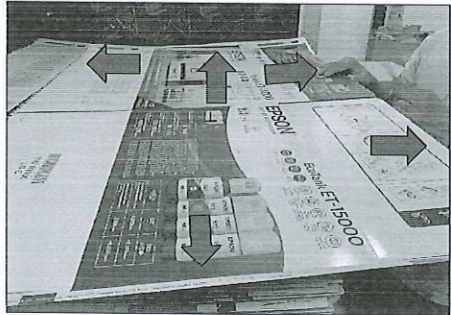
No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna
Telephone No. (049) 545-7166 to 69
Fax No. (049) 545-6302

INVESTIGATION REPORT

DATE:	NOVEMBER 25, 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 3:	UNCUT OF AN ITEM ENCOUNTERED DUE TO THE CONDITION OF THE BACKING TAPE ON THE PATTERN SHEET. REMARKS: WHEN ENCOUNTERED UNCUT, THE OPERATOR STOP THE PROCESS AND CHECK THE SETTINGS AND CHECK THE UNCUT PORTION AND IMMEDIATELY PUT A BACKING TAPE.	
WHY 4:	DURING THE DIECUT PROCESS, THE CATCHER OPERATOR SKIPS THE MANUAL BROWSING OF AN ITEM.	

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

1	RE-EDUCATE THE OPERATORS FOR TIGHTENING THE MANUAL BROWSING AND INFORM THEIR SUBLEADER OR SENIOR OPERATOR FOR ANY ABNORMALITIES BEING ENCOUNTERED.	PIC: IE STAFF/LINELEADER/OPERATOR TARGET DATE: NOV 25, 2023
2	CHECKING OF 1 SHEET FOR EVERY 20 OUTS IN THE DELIVERY	 PIC: SUBLEADER/OPERATOR TARGET DATE: NOV 20, 2023