
 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	N. CEPEDA QA/ Prodn SV	R. MIRANDA KPLIMA Operations Gen. Mngr.
DATE:	JUNE16, 2023		

5M REVIEW		DOCUMENT REVIEW					
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:		PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	230616	¹ With Revision	^{1,2} No Revision	K. DIAZ	N/A
MATERIAL	NO CREASING MATRIX	Work Instruction		¹ With Revision	^{1,2} No Revision	K. DIAZ	N/A
METHOD	No Changes	Process Flow		¹ With Revision	^{1,2} No Revision	K. DIAZ	N/A
ENVIRONMENT	No Changes	Forms		¹ With Revision	^{1,2} No Revision	K. DIAZ	N/A

I. PROBLEM DESCRIPTION

1.1. ISSUE:	
	NO CREASING MATRIX
1.2. ITEM DESCRIPTION:	
PART CODE:	516378900
PART NAME:	LIME 2 MB AMERICA
1.3. BACKGROUND:	
	DETAILS: >Inhouse Detection : NO CREASING MATRIX >Lot size: 348pcs > Reject Qty: 348pcs >Rejection Rate: 100% >JO#: 37836

IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
AFTER THE RUNNING THEY PLACED THE CREASING MATRIX ON THE PLATE	230607	TOOLING

III. CAUSE ANALYSIS:

WHY 1:	NO CREASING MATRIX OCCUR AT DIE-CUT MACHINE FOR THE ITEM 516378900 LIME 2 MB AMERICA WITH 100% REJECTION RATE
WHY 2:	WHILE RUNNING, PARTS OF THE PLATE DO NOT HAVE A CREASING MATRIX. NOTE:THE QA PERSONNEL ALSO FAILED TO NOTICE THAT THE LIME ITEM'S HAS NO CREASING MATRIX, SO ORDERED TO DO MASS PRODUCTION.
WHY 3:	THE OPERATOR DID NOT NOTICE THAT THE SOME PART CREASING MATRIX LOSS OF ADHESION TO THE PLATE
WHY 4:	THE PLATE ON THE RACK WAS LAYING ON TOP OF ANOTHER, CAUSING THE ADHESION OF THE CREASING MATRIX TO BE REMOVED WHEN THE OPERATOR GET AND RETURN ON THE RACK.

IV. ACTION PLAN:

V. EVIDENCES:

1	REPLACEMENT OF CREASING MATRIX	PIC: OPERATOR Target Date: JUNE 7, 2023
2	ORIENTATION TO DIECUT OPERATOR REGARDING THE ENCOUNTERED 100% REJECTION RATE IN LIME DUE TO NO CREASING MATRIX	PIC: Production IE Target Date: JUNE 16, 2023
3	REMIND OPERATOR ABOUT THE IMPORTANCE OF ALWAYS CHECKING THE CONDITION OF EQUIPMENT AND ITS CHECK POINTS (BLADES, CREASING MATRIX, PLATES ETC.) THAT IS BEING USED DURING MASS PRODUCTION	PIC: Production IE Target Date: June, 2023
4	IMPROVE THE PLATE RACK IN THE AREA	PIC: Production IE Target Date: -