

**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:

K.DIAZ

QA-IE/ Prodn IE

Check By:

N. CEPEDA

QA/ Prodn SV

Approved By:

R. MIRANDA

KPLIMA Operations Gen. Mngr.

**DATE:**

April 4, 2023

**5M REVIEW****DOCUMENT REVIEW**

MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	No Changes	Procedure Manual		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	K. DIAZ	N/A
MATERIAL	<b>UNALIGNED CREASING BLADE</b>	Work Instruction		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	K. DIAZ	N/A
METHOD	No Changes	Process Flow		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	K. DIAZ	N/A
ENVIRONMENT	No Changes	Forms		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	K. DIAZ	N/A

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

BURSTING

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

51907900/515907800/515911400/515912200

**PART NAME:**

LOUVRE 2 (SF

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

> Inhouse Detection : BURSTING  
> Lot size: 3758pcs  
> Reject Qty: 397pcs  
> Rejection Rate: 10.56%  
> JO#: 33732/33748/33750/33751

**II. IMMEDIATE ACTION**

ACTION ITEMS	Target Date:	Person In-charge
The production gluing in-charge alerts the diecut subleader on the detected bursting at gluing process.	April 4, 2023	Gluing subleader and Diecut subleader

**III. CAUSE ANALYSIS:**

<b>WHY 1:</b>	Bursting occurred on the folding side and been detected during semi-auto gluing process. Note: Bursting was randomly encountered on the said affected part codes.
<b>WHY 2:</b>	Bursting occurred during diecut process since it was observed that the creasing blade is higher than the cutting blade. Note: Total of 397 bursting reject out of 3,758 pcs. input quantity.
<b>WHY 3:</b>	The creasing blade loose on the dieboard resulting from lifting of the creasing blade where bursting occurred. Note: During the machine set up, the tooling custodian did not notice that the creasing blade has sunk into the board which resulted to not being align due to the weakness of the board.

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

1	Checking and repair of the blade and Die blade Remarks: Sharpen the blade and trimming die plate if its needed. PIC: Tooling custodian Target Date: April 4, 2023	<b>*Still for monitoring*</b>
2	Checking of Creasing blade Note: New pattern sheet and cushion crease PIC: Sub-leader and operator Target: April 4, 2023	

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3

Orientation regarding the checkpoints of the diecut catcher operator.  
PIC: Production IE  
Target Date: April 4, 2023

**\*Please see attached on next sheet\***