
 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	<h1>INVESTIGATION REPORT</h1>		
	Prepared By:	Check By:	Approved By:
	K. DIAZ	N. CEPEDA	R. MIRANDA
DATE:	230301	QA-IE/ Prodn IE	QA/ Prodn SV
		KPLIMA Operations Gen. Mngr.	

5M REVIEW		DOCUMENT REVIEW				
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	230228	<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	K. DIAZ	N/A
MATERIAL	No Changes	Work Instruction		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	K. DIAZ	N/A
METHOD	Used of Eperan instead of Cushion Crease	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 ENCOUNTERED ON THE FOLDING	
1.2. ITEM DESCRIPTION:	
PART CODE:	516297800
PART NAME:	LOUVRE 2 MDX ASIA
1.3. BACKGROUND:	
PICTURE 	DETAILS: > Inhouse Detection : Bursting > Lot size: 768pcs > Reject Qty: 96pcs > Rejection Rate: 12.50% > JO#: 31277

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
Gluing operator in-charge call the attention of his sub-leader and report occurrence of bursting found by Inline QA.	230220	Gluing Operator
N/A	N/A	N/A

III. CAUSE ANALYSIS:

WHY 1:	Bursting occurred on the folding side of the item upon gluing process.
WHY 2:	During folding process, folder operator chased the creasing line of the item in the 2nd gluing. Note: Folder in-charge encountered wide gap so they rubdown to met the standard gap of 8±2mm.
WHY 3:	While chasing and rubbing down the creasing line to met the standard gap, folder in-charge failed to observed occurrence of bursting defect which accumulates due to improper folding and creates tension during folding.
WHY 4:	Improper folding was due to bulging or bloated condition on the creasing area.
WHY 5:	Diecut process used eperan instead of cushion crease. Note: The benefit of using cushion crease was to improved productivity by reducing the difficulty of aligning the boards prior feeding to conveyor and to lessen encountered rejects such as bursting and tear off.

IV. ACTION PLAN:

V. EVIDENCES:

1	Conduct an orientation to operators regarding the bursting encountered on Louvre SF.	*Please see attached on next sheet*
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2	Return the standard usage of cushion crease for Louvre SF model.	Target Date: March 1 running of Louvre SF PIC: Tooling/ Diecut Sub-leader
3	Monitor 3 consecutive running using cushion crease for the possible recurrence of bursting.	Target Date: March 1 running of Louvre SF PIC: Production IE