

**KANEPACKAGE PHILIPPINE INC.**

No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna  
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**INVESTIGATION REPORT**

Prepared By:

Check By:

Approved By:

K. DIAZ

QA-IE/ Prodn IE

QA/ Prodn SV

KPLIMA Operations Gen. Mngr.

DATE:

13-Jan-23

**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:

Disposition:

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

PIC:

Target Date:

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

MISALIGNED CUT

**1.2. ITEM DESCRIPTION:**

PART CODE:

516297700

PART NAME:

LOUVRE MINI MDX ASIA

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

&gt;Inhouse Detection : Misaligned cut

&gt;Lot size: 2100pcs

&gt; Reject Qty: 55pcs

&gt;Rejection Rate: 2.62%

&gt;JO#: 28669

**II. IMMEDIATE ACTION**

ACTION ITEMS	Target Date:	Person In-charge

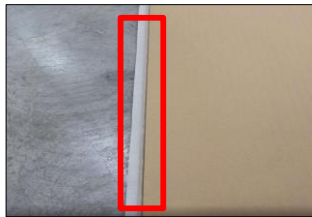
**III. WHY WHY ANALYSIS DETAILS:****DIRECT CAUSE:**

WHY 1: Misaligned cut occurred on the upper flap with excess with background on the blue background.

WHY 2: On trial, there is no misaligned cut encounter but during mass production, the defect comes up.

WHY 3: In the middle of processing, the operator encountered excess single face and printed sheet on the item.

&gt; Having the encountered issue, on the first process in the lamination, operator should check the set-up of items during running.

**IV. ACTION PLAN:****DIRECT CAUSE:**

&gt; Orientation to the operators regarding to the problem being encountered.

&gt; Immediate Action: The operator sort the items having excess of sf and ps

&gt; They adjust the side jugger on the diecut machine to get the exact set-up to prevent the defect

&gt; In Lamination process, the catcher operator must inform the subleader/leader if there was an abnormality encountered.



DIECUT PROCESS (FEEDER AREA)

DIECUT FEEDER AREA

