# KANEPACKAGE PHILIPPINE INC. No. 5 Ping Read ITSP II, Engs. In Hota, Colombo City, Laguna Tolophore No. (1989) 145-7166 to 69 Fee No. (1985) 545-5202

**INVESTIGATION REPORT** 

Approved By:

KPLIMA Operations Prod Mingr. K. DIAZ QA-IE/ Prodn IE QA/ Prodn Head

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	5M REVIEW	·	DOCUMENT	REVIEW			IRF CONTROL NO.: IRF	-24-03-0020
MAN	No Changes	Affected Document:	Date Reviewed:				PIC:	Target Date:
MACHINE	No Changes	Procedure Manual		( ) With Revision	<b>V</b>	No Revision	N/A	N/A
MATERIAL	No Changes	Work Instruction	240304	( ) With Revision	<b>V</b>	No Revision	N/A	N/A
METHOD	INCORRECT DRAWING ATTACHMENT	Process Flow	240304	( ) With Revision	4	No Revision	N/A	N/A
ENVIRONMENT	No Changes	Forms		( ) With Revision	4	No Revision	N/A	N/A

#### I. PROBLEM DESCRIPTION

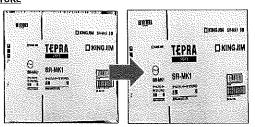
1.1. ISSUE: DOUBLE CREASING

1.2. ITEM DESCRIPTION:
PART COSS PART CODE: PART NAME: 1.3. BACKGROUND:

5167283-00 FRANZ CARTON BOX

### PICTURE

DATE:



240304

#### DETAILS:

DATE DETECTION: SECTION DETECTED:

JO NO.: LOT QTY: NG QTY:

NG RATE:

240305 DS **SCREENING QA** 

#### IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
CONDUCT MEETING REGARDING THE ENCOUNTERED DOUBLE CREASING	240306	IE STAFF

# III. CAUSE ANALYSIS:

III. CAUSE AWAL	1010;
WHY 1;	WHY DOUBLE CREASING OCCURRED IN THE ITEM? A SLITTER PROCESS IN WHICH THE ITEM BEING PROCESSED WAS NOT IN THE ITEM PLANNED CAUSED DOUBLE CREASING. NOTE: DOUBLE CREASING WAS VISIBLE ESPECIALLY WHEN THE ITEM WAS RUN IN SLITTER PROCESS. (CREASING WAS MALE-TO-FEMALE UNLIKE OTHER SUPPLIER WITH MALE-TO-MALE)
WHY 2:	WHY DOES THE ITEM WAS PROCESS EVEN IF NOT YET THE ITEM LINED UP? THE ATTACHED DRAWING ON THE LINED UP JOB ORDER WAS ITEM RJ1-3002 CST BOX WAS INCORRECT WHEREIN THE DRAWING OF 516728300 FRANZ WAS ATTACHED ON IT. NOTE: THE OPERATOR IN-CHARGE ALREADY PROCESS THE ITEM 516728300 WITHOUT CHECKING THE JO VS. THE ATTACHED DRAWING.
WHY 3:	WHY DOES THE DRAWING BEING ATTACHED WAS INCORRECT?  ● THE PLANNING IN-CHARGE AND JC (JOB CONTROLLER) DOES NOT NOTICE THE WRONG ATTACHMENT OF DRAWING CAUSING THE OPERATOR TO ACCIDENTALLY PROCESS THE LINED UP ITEM USING THE WRONG DRAWING.  ■ AND BECAUSE THE ITEM WAS BEING PROCESS, PLANNING AND JC CONTINUED TO PROCESS THE ITEM WITHOUT NOTIFYING AND APPROVAL OF CONCERNED DEPARTMENT AND NOT KNOWING THAT THEIR PRODUCED ITEM WAS ALREADY REJECT BASED ON EPPI STANDARDS.

## IV. ACTION PLAN:

REEDUCATE 3C (JOB CONTROLLER) REGARDING CHECKING OF JO VS. THE ATTACHED DRAWING PRIOR ISSUANCE.	PIC: IE STAFF TARGET DATE: 230304
2 REEDUCATE OPERATOR IN-CHARGE REGARDING THE STANDARD CHECKING OF JO VS, THE ATTACHED DRAWING PRIOR PROCESSING OF THE ITEM.	PIC: IE STAFF TARGET DATE: 230304

Machine: AUTOMATIC SLITTER MACHINE															
item #	Customer	Job Order#	Item Code	Hem Description	Cily, Pian		Aunning Time	Delivery Date	Mat 1 Oty.	Materials	Remarks	In-Put	O∪l-Put	Reject	
1	PHILIPPINES TRC INC.	JO-11672	BACK SENSOR S	PACKAGING	20	150	0.13	01-Apr-24	320	1475X2000 EF TX200		20	ВО	-€0	DONE

KANEPACKAGE PHILIPPINE INC.  Inc. 5 Step 2 Load 1159 E. E. Bry. Li Mana, Calarba Cry, Laguri						INVESTIGATION REPORT											
Telephone No. (041) 545-7166 to 69				Pr	epared	By:		Check B	у:	Approved By:							
Fan No. (N4) 545 6307						K. DIA	Z		N. CEPEDA		R. ALMARIO						
DATE:	<u>240304</u>					QA-	IE/ Pro	dn IE		QA/ Prodn	Head KP	KPLIMA Operations Prod Mngr.					
2	CANON BUSINESS MACHINE PHILS.	JO-11891	R/1-3002-000 D	CST BOX	30	150	0.20	21-Mar-24	660	1475X2400 CBF TX200	CATEGORY # 1	15	30	-15	DONE		
3	EPSON PRECISION (PHILIPPINES) INC., -IP	IO-11564	515956400	OUTER BOX, PM1	200	150	3.93	03-Apr-24	260	698x1600 CBF TX200		200	200	o	DONE		
4	EPSON PRECISION (PHILIPPINES) INCUP	Eest t-Ot	516728300	OUTER CARTON BOX 2 C18905	45	150	0.30	03-Apr-24	15	1475X2400 CBFTX200		35	36	-21	DONE		
5	EPSON PRECISION [PHILIPPINES] INCUP	10-11925	30X330 BF TXL	PAD 530/G30 BF TX175	30	150	0.20	23-Mar-24	30	580X580 BF TX1.75		30	30	0	DONE		
		Total			325		2.17		1,165			260	375	4	5		
1	rks : WITH 15 MINS CLEANING T												боглансе	i	M Milesol		