

KANEPACKAGE PHILIPPINE INC. No. 5 Ring Road (TSP II, Brgy. La Mesa, Calamba City, Laguna) Telephone No. (043) 545-7166 to 69 Fax No. (043) 545-8302	INVESTIGATION REPORT		
	Prepared By: <u>R. DIAZ</u>	Checked By: <u>Mark B. N. CEPEDA</u>	Approved By: <u>[Signature]</u>
DATE: <u>240304</u>	QA-IE/ Prodn IE	QA/ Prodn Head	KPLIMA Operations Prod Mngr.

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	240304		N/A	N/A
MATERIAL	No Changes	Work Instruction			N/A	N/A
METHOD	INCORRECT DRAWING ATTACHMENT	Process Flow			N/A	N/A
ENVIRONMENT	No Changes	Forms			N/A	N/A
				() With Revision <input checked="" type="checkbox"/> No Revision () With Revision <input checked="" type="checkbox"/> No Revision () With Revision <input checked="" type="checkbox"/> No Revision () With Revision <input checked="" type="checkbox"/> No Revision		

I. PROBLEM DESCRIPTION

1.1. ISSUE:

DOUBLE CREASING

1.2. ITEM DESCRIPTION:

PART CODE: 5167283-00

PART NAME: FRANZ CARTON BOX

1.3. BACKGROUND:

PICTURE

DETAILS:

DATE DETECTION: 240305 DS

SECTION DETECTED: SCREENING QA

JO NO.: 11893

LOT QTY: 36

NG QTY: 36

NG RATE: 100%

IMMEDIATE ACTION

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

III. CAUSE ANALYSIS:

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. <i>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)</i>
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. <i>NOTE: THE OPERATOR IN-CHARGE ALREADY PROCESS THE ITEM 516728300 WITHOUT CHECKING THE JO VS. THE ATTACHED DRAWING.</i>
WHY 3:	WHY DOES THE DRAWING BEING ATTACHED WAS INCORRECT? <ul style="list-style-type: none"> 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:

1	REEDUCATE JC (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												In-Put	Out-Put	Reject	
Item #	Customer	Job Order #	Item Code	Item Description	Qty. Plan	Machine Capacity / Hr	Running Time	Delivery Date	MatQty	Materials	Remarks				
1	PHILIPPINES TRC INC.	JO-11672	BACK SENSOR 3	PACKAGING	20	150	0.13	01-Apr-24	320	1475X1000 EF TX200		20	80	40	DONE

**KANEPACKAGE PHILIPPINE INC.**

No. 5 King Road 159 B, Brgy. La Mesa, Calabarzon City, Laguna
Telephone No. (049) 545-7186 to 89
Fax No. (049) 545-6302

INVESTIGATION REPORT

Prepared By:

K. DIAZ

Check By:

N. CEPEDA

Approved By:

R. ALMARIO

DATE:

240304

QA-IE/ Prodn IE

QA/ Prodn Head

KPLIMA Operations Prod Mngr.

2	CANON BUSINESS MACHINE PHILS	JO-11891	RJ1-9002-000 D	CST BOX	80	150	0.20	21-Mar-24	600	1475X2400 CBF TX200	U/L2 SAVED / EVAL BY PRE-APR, FOCUS CATEGORY # 2	15	30	-15	DONE
3	EPSON PRECISION (PHILIPPINES) INC. -JP	JO-11564	515956100	OUTER BOX PM1	200	150	1.33	03-Apr-24	200	698x1600 CBF TX200		200	200	0	DONE
4	EPSON PRECISION (PHILIPPINES) INC. -JP	JO-11893	516728300	OUTER CARTON BOX 2 CH900	45	180	0.30	03-Apr-24	15	1475X2400 CBF TX200		15	35	-21	DONE
5	EPSON PRECISION (PHILIPPINES) INC. -JP	JO-11925	30X330 BF TX17	PAD 530X330 BF TX175	30	150	0.20	23-Mar-24	30	580X580 BF TX175		30	30	0	DONE
Total					375		2.17		1,165			280	375	-95	
Remarks: WITH 15 MINS CLEANING TIME / PLS SUPPORT TO DETACHING UNTIL 3PM												Prod Performance		116.7%	27.1%