## **INVESTIGATION REPORT** KANEPACKAGE PHILIPPINE INC. No. 5 Ring Road LISP II, Brys. La Mesa, Calamba Chy, Laguna Telephone No. (049) 545-7166 to 69 / Fax No. (049) 545-6302 Prepared By: R. ALMARIO DATE: 240520 QA/ Prodn Head QA-IE/ Prodn IE KPLIMA Operations Prod Mngr. **5M REVIEW DOCUMENT REVIEW** IRF CONTROL NO .: IRF-24-05-0025 No Changes MAN Affected Document: PIC: Target Date: Date Reviewed: ( ) With Revision MACHINE No Changes Procedure Manual (X) No Revision N/A N/A MATERIAL N/A N/A No Changes Work Instruction ( ) With Revision (X) No Revision 240520 FAILED TO CONDUCT DETAILED INSPECTION PRIOR MASS PRO METHOD Process Flow N/A N/A ( ) With Revision (X) No Revisión ENVIRONMENT Forms No Changes ( ) With Revision N/A N/A (X) No Revision I. PROBLEM DESCRIPTION 1.1. ISSUE: WRONG GRAIN DIRECTION 1.2. ITEM DESCRIPTION PART CODE: PART NAME: 5138660-00 SPACER CB69010 1.3. BACKGROUND: PICTURE **DETAILS:** DATE DETECTIC 240424 DS SECTION DETEC SCREENING JO NO.: 20571 LOT QTY: 100 PCS NG QTY: 100 PCS NG RATE: 100% PROCESS FLOW CHART WHS Start DIECUT **GLUING** INSPECTION LOADING DELIVERY (STORAGE) IMMEDIATE ACTION

## III. CAUSE ANALYSIS:

AND PRESENT DURING MORNING MEETING.

**ACTION ITEMS** 

GENERATE PRESENTATION REGARDING ON HOW TO READ THE DRAWING PROPERLY

WHY 1:	WHY ENCOUNTERED WRONG GRAIN DIRECTION? OPERATOR FAILED TO IDENTIFY THE ITEM WITH GRAIN DIRECTION PRIOR MASS PRODUCTION.
WHY 2:	WHY OPERATOR FAILED TO IDENTIFY THE ITEM WITH GRAIN DIRECTION PRIOR MASS PRODUCTION? BECAUSE OPERATOR CONFUSED ABOUT THE ITEM SINCE THIS ITEM ONLY PLAN ONCE IN A WHILE & NOT FAMILIAR IN READING OF DRAWING, LIKEWISE PRODUCTION LEADER APPROVED THE TRIAL RUN AS ONE OF THE PROCEDURE PRIOR PROCEEDING TO MASS PRODUCTION.
WHY 3:	WHY PRODUCTION LEADER FAILED TO DETECT THE WRONG GRAIN DIRECTION? PRODUCTION LEADER FAILED TO CONDUCT DETAILED INSPECTION
WHY 4:	WHY PRODUCTION LEADER FAIL TO CONDUCT DETAILED INSPECTION? BECAUSE THIS IS A TRANSITION PERIOD OF TRIAL APPROVAL OF ITEM PRIOR MASS PRODUCTION AS ADDITIONAL TASK FOR PRODUCTION LEADER.
WHY 5:	WHY APPROVAL OF ITEM WAS TRANSFER TO PRODUCTION SUBLEADER? THIS IS A MGT. DIRECTIVES TO MAXIMIZE THE MANPOWER CAPABILITY AS PART OF COMPANY COST SAVING.

240430

Person In-charge

IE STAFF

## IV. ACTION PLAN:

1 CONDUCT RE-ORIENTATION REGARDING TO THE I	SSUE OF WRONG GRAIN DIRECTION.	PIC:PRODUCTION LEADER APRIL 30, 2024
TO ESTABLISH THE SECQUENCE OF INSPECTION FOR ITEM PRIOR MASS PRODUCTION.	OR SUBLEADER REFERENCES DURING THIER APPROVAL OF	PIC:PRODUCTION LEADER MAY 13, 2024
3 ORIENTATION OF NEWLY ESTABLISH SEQUENCE O	F APPROVAL FOR PRODUCTION LEADER.	PIC:PRODUCTION LEADER MAY 13, 2024

## SEQUENCE OF INSPECTION FOR DIECUT SUBLEADERS

