

INVESTIGATION REPORT

Prepared By:

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PROD. LL

Checked By:

N. CEPEDA
PROD. SV

Approved By:

R. ALVARADO
KPLIMA Operations Prod. Mngr.

DATE: June 13, 2024

5M REVIEW

MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	No Changes	Procedure Manual		<input type="checkbox"/> With Revision <input type="checkbox"/> No Revision	K.N.ACUIN	N/A
MATERIAL	No Changes	Work Instruction		<input type="checkbox"/> With Revision <input type="checkbox"/> No Revision	K.N.ACUIN	N/A
METHOD	No Changes	Process Flow	240510	<input type="checkbox"/> With Revision <input type="checkbox"/> No Revision	K.N.ACUIN	N/A
ENVIRONMENT	No Changes	Forms		<input type="checkbox"/> With Revision <input type="checkbox"/> No Revision	K.N.ACUIN	N/A

DOCUMENT REVIEW

I. PROBLEM DESCRIPTION

1.1. ISSUE:

PUNCTURED

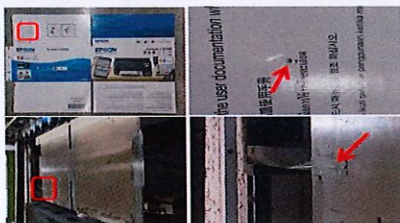
1.2. ITEM DESCRIPTION:

PART CODE: 516297700

PART NAME: LOUVRE 2 NDX ICB FOR ASIA

1.3. BACKGROUND:

PIC

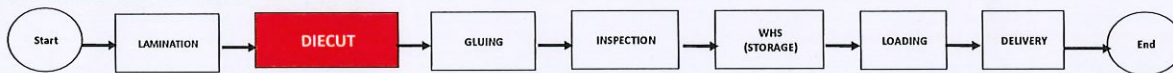


DETAILS:

> Inhouse Detection : PUNCTURED
> Lot size: 1597PCS
> Reject Qty: 134PCS
> Rejection Rate: 8.39%
> JO#: 35078

IMMEDIATE ACTION

PROCESS FLOW CHART



ACTION ITEMS

Target Date:

Person In-charge

MEETING WITH CONCERN OPERATOR

JUNE 13, 2024

PRODUCTION LEADER

III. CAUSE ANALYSIS:

WHY 1:	WHY PUNCTURED-OFF OCCURED? BECAUSE TRIMMING TRIPPER BLADE MISALIGN FROM ITS ORIGINAL LOCATION RESULTING TO BULGE THE OTHER SIDE OF BLADE FROM THE WOODEN BOARD.
WHY 2:	WHY TRIMMING TRIPPER BLADE MISALIGN FROM ITS ORIGINAL LOCATION RESULTING TO BULGE THE OTHER SIDE OF BLADE FROM THE WOODEN BOARD. BECAUSE DURING MASS PRODUCTION SCRAP HOOK ON THE STRIPPER BLADE THAT WHEN THE OPERATOR REMOVE THE TRIMMINGS FOR MANUAL CLEANING IT DISJOINT FROM THE DIECUT BOARD CAUSING BULGING OF THE OTHER SIDE. RESULTING TO PUNCTURED IN THE SURFACE OF ITEM.
WHY 3:	WHY DURING MASS PRODUCTION SCRAP HOOK ON THE STRIPPER BLADE THAT WHEN THE OPERATOR REMOVE THE TRIMMINGS FOR MANUAL CLEANING IT DISJOINT FROM THE DIECUT BOARD CAUSING BULGING ON THE OTHER SIDE OF BLADE RESULTING TO PUNCTURED IN THE SURFACE OF ITEM. BECAUSE DIECUT SCRAP CONVEYOR IS UNDER REPAIR THAT NEED TO CONDUCT MANUAL CLEANING UNDER DIECUT MACHINE, ALSO STRIPPER BLADE IS PRONE TO BULGING DUE TO LACK OF SUPPORT THAT CAUSE IT MOVING DURING MASS PRODUCTION.
WHY 4:	NOTE : TEMPORARILY TOOLING PROVIDED THE SUPPORT UNDER THE DIEBOARD & AT THE END OF THE STRIPPER BLADE BUT THIS WILL BE CONSIDER DURING THE NEXT PR OF BLADE.
WHY 5:	

IV. ACTION PLAN:

V. EVIDENCES:

1	CONDUCT MEETING REGARDING ON ENCOUNTERED PROBLEM	PIC: PRODUCTION LEADER June 13, 2024
2	REMINI OPERATOT TO BE CAREFUL IN REMOVING THE SCRAP/TRIMMING WHILE THE SCRAP CONVEYOR IS STILL UNDER REPAIR.	PIC: PRODUCTION LEADER MAY 24, 2024
3	ADDITIONAL APPLICATION OF STRIPPER BLADE SUPPORT & IMPROVE THE SPACE BETWEEN CUTTING & STRIPPER (MUST BE NO SPACE) WHICH BECOME NECKMARK THAT CAUSE ALSO THE DIFFICULTY TO DETACH THE TRIMMINGS.	PIC: FOR PR OF TOOLING (JULY 01, 2024)



MINUTES OF THE MEETING

Date: June 19 Time: 1: PM Finished: 1: 30 PM Venue: Diecut Area

ATTENDEES:

Name	Dept.	Sign	Name	Dept.	Sign
Ronilo Jr - TAEP	Prod				
Benjie Salazar	Prod				
JOHN Devese	Prod				
Mark Allen	Prod				
Law	Prod				
Reverend	Prod				
John Leilus	Prod				
Clariz Olave	Prod				
Mark Vincent	Prod				
Jesler Torres	Prod				

AGENDA:

Meeting is Diecut operator due to problem of
Punctured of wire 2NDX for Asia (51629770h)

MINUTES:

- remind operator to avoid pulling of scrap/trimming that
hook on the stripper blade.
- as discussed, to put support on the stripper blade to avoid
the misalignment during production.
- as part of improvement to align the space between cutting
blade & stripper blade for easy of detaching of scrap.

FOLLOW UP MEETING:

(date & time)

for KPPI fill up only

Prepared by:

Reviewed by:

Noted by:

**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

INVESTIGATION REPORT FORM (IRF)☒ Inhouse Detection☐ Customer Claim

Control No.: IRF-24-06-0030

Date Issued: 11-Jun-24

Customer	EPPI	Attention To	N. CEPEDA/ R. ALMARIO
Item Code	516297700	Department	KPLIMA- PRODUCTION
Item Description	LOUVRE 2 NDX ICB FOR ASIA	Date of Detection	10-Jun-24
Job Order Number	35078	Section Detected	INPROCESS DIE CUT 2/DS

ILLUSTRATION OF THE PROBLEM

<input type="checkbox"/> Major	<input checked="" type="checkbox"/> Minor	
Lot Quantity (pcs.)	Reject Quantity (pcs.)	Reject Percentage
1,597	134	8.39%

Nature of Defect:

PUNCTURED

ITEM SHOULD BE IN GOOD CONDITION; NO OCCURRENCE OF PUNCTURED

Actual:TEAR OFF WAS ENCOUNTERED ON THE ITEM
(PLEASE SEE ATTACHED PICTURE)

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN	CONTENT
<input checked="" type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Material
<input type="checkbox"/> Recurrence	<input type="checkbox"/> Special Acceptance	<input type="checkbox"/> EQOS	<input type="checkbox"/> Dimension
No.:	<input type="checkbox"/> For Rework	<input checked="" type="checkbox"/> Diecut	<input type="checkbox"/> Appearance
Date:	<input checked="" type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Detaching	<input checked="" type="checkbox"/> Process / Method

Issued by	Checked by	Approved by	Received by (Receiving Section)
M. Anduebo QA Staff	G. Magsino QA Supervisor	QA Asst. Manager	N. Cepeda/ R. Almario Head/ Supervisor/ Manager

I. INVESTIGATION / ANALYSIS

	DIRECT CAUSE: (Analyze the reason of occurrence, why it happened?)	INDIRECT CAUSE: (Analyze the reason of occurrence, why it leaked?)
System / Training	Why 1: Why 2: Why 3: Why 4: Why 5:	Why 1: Why 2: Why 3: Why 4: Why 5:
Design / Toolings	Why 1: Why 2: Why 3: Why 4: Why 5:	Why 1: Why 2: Why 3: Why 4: Why 5:
Process / Material	Why 1: Why 2: Why 3: Why 4: Why 5:	Why 1: Why 2: Why 3: Why 4: Why 5:

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INVESTIGATION REPORT FORM (IRF)**FINAL CONCLUSION****OCCURRENCE ROOTCAUSE****OUTFLOW ROOTCAUSE****IMMEDIATE ACTION:** (Action to be done to contain/ temporary correct the problem found)**CORRECTIVE ACTION:** (Actions to be done to ensure that the problem will not happen again)**A. Sorting Result**

	Location	Total Stock	NG	Total Good
RM				
WIP				
FG				

Actions to be done to eliminate recurrence**Who / When****B. Orientation**

Date		Time	
Title			
Attendees			

Design / Tools**C. Reworking**

Rework Quantity	
Total Good	
Rework Percentage (Good)	

Process**II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)**

Date Conducted: _____ PIC: _____

Identified Rootcause**Recommendation****III. CORRECTIVE ACTION VERIFICATION (To be filled out by QA In-charge)**

	Checked by	Date	Implemented?	Remarks
1st Verification of Action			[] Yes [] No	
2nd Verification of Action			[] Yes [] No	
3rd Verification of Action			[] Yes [] No	
Effectiveness of Action			[] Yes [] No	

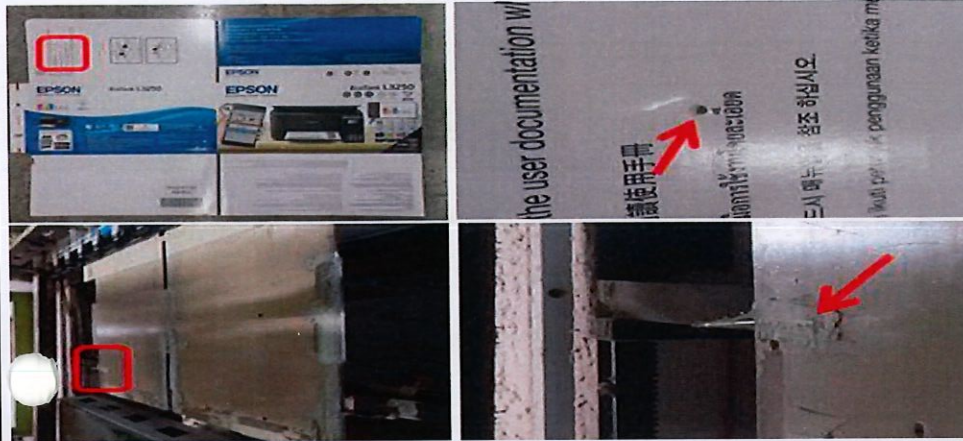
Note: If no same defects / problems occurs for 5 consecutive deliveries, corrective action is considered effective / closed. If the same problem occurs within 5 consecutive deliveries or 3rd verification of action still not yet implemented, Investigation Report shall be re-issued to the affected department to provide new improvement action.

IV. CLOSURE

Status:	Remarks:	Approved by:		Process Owner Acknowledgment: (Receiving Section)	
<input type="checkbox"/> Closed		QA Supervisor	QA Asst. Manager	Line Leader	Department Head
<input type="checkbox"/> Still Open		Date:	Date:	Date:	Date:
<input type="checkbox"/> Re-Issue IRF					

Item Code	5162977-00	Customer	EPPI
Item Description	LOUVRE 2 MDX ASIA;C	Delivery Date	N/A
Detection (Section / Area)	IN-PROCESS DIE CUT 2/DS	Job Order Number	JO-35078
Inspection Date	10/06/2024	External Provider	IN-HOUSE
Affected Quantity	134/1597 8.39%	Date Received	N/A
Problem Description	PUNCTURED	Delivery Receipt Number	1600

II. Visual Reference (Defect Illustration)



PUNCTURED OCCUR ON CLASS C UPPER FLAP PANEL A
DETECTED IN DIE CUT 2
PROCESS ON JUNE 10, 2024
DS DIE CUT 2
DUE TO UNEVEN SCRAP BLADE
WITH 134/1597

III. Documented Information Review (To be filled out by QA Line leader)

Related Doc. Info.	Control Number	Requirement:	ITEM SHOULD BE IN GOOD CONDITION; NO OCCURRENCE OF PUNCTURED
<input type="checkbox"/> Procedure Manual :		Actual:	PUNCTURED OCCUR ON UPPER CLASS C / PANEL A
<input type="checkbox"/> Technical Drawing :		Conclusion and Recommendation:	CHECKING OF STRIPPER BEFORE RUNNING CHECKING OF SAMPLING DURING RUNNING DUE TO UNEVEN SCRAP BLADE
<input type="checkbox"/> Work Instruction :			<input type="checkbox"/> Applicable <input type="checkbox"/> Not Applicable
<input type="checkbox"/> Job Order :			
<input type="checkbox"/> Reports :			
<input type="checkbox"/> Defect Limit :			

IV. Initial Disposition (To be filled out by ME Department If Needed)

V. Final Disposition

<input type="checkbox"/> Good	<input type="checkbox"/> Conditional (Please indicate details)	<input checked="" type="checkbox"/> Rejected	<input type="checkbox"/> Conditional (Please indicate details)
<input checked="" type="checkbox"/> Rejected		<input type="checkbox"/> Backload	
<input type="checkbox"/> Backload		<input type="checkbox"/> Good	
		<input type="checkbox"/> For Sorting	
		<input type="checkbox"/> For Rework	
		Person In Charge	Target Date
			Signature

Remarks:

AUTO STRIP

Detected by	Checked by	Initial Approved by (If Needed)	Noted by	Approved by
D.DIMASUPIL	R. MANALO			
QA Inspector	QA Line Leader	ME Supervisor	QA Supervisor	QA Head

Important: Backloading Policy (External Provider Rejects) Rejection rate that is more than 80% of the total quantity shall be approved by Top Management before backloading.	Evaluation	Approved by	Final Disposition
	<input type="checkbox"/> <80% No Need		<input type="checkbox"/> Backload
	<input type="checkbox"/> >80% Need	Top Management	<input type="checkbox"/> Accept
			<input type="checkbox"/> Other _____

Note: All details must be filled out completely.
Submit this form to Line Leader immediately after accomplishment.