

**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:

DATE:

22-Nov-22

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QA-IE/ Prodn IE

QA/ Prodn SV

KPLIMA Operations Gen. Mngr.

5M REVIEW

MAN
MACHINE
MATERIAL
METHOD
ENVIRONMENT

Affected Document:
Procedure Manual
Work Instruction
Process Flow
Forms

Date Reviewed:

Disposition:

<input type="checkbox"/> With Revision	<input type="checkbox"/> No Revision
<input type="checkbox"/> With Revision	<input type="checkbox"/> No Revision
<input type="checkbox"/> With Revision	<input type="checkbox"/> No Revision
<input type="checkbox"/> With Revision	<input type="checkbox"/> No Revision

PIC:

Target Date:

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

DELAMINATION

1.2. ITEM DESCRIPTION:**PART CODE:**

515693001

PART NAME:

CARTON BOX

1.3. BACKGROUND:

INHOUSE DETECTION: DELAMINATION
LOT SIZE: 864
REJECT QUANTITY: 82
REJECTION RATE: 9.49%
REMARKS: DELAMINATION OCCURRED ON THE ITEM

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge

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

WHY 1: Delamination occurred on the item

- Glue Viscosity was 1.9 (Standard 1.8-2.5)
- Glue application was 3
- Impression was in standard which is 13
- Conveyor speed was 8 (Standard 8-9)

WHY 2: The operators failed to follow the standard procedure when it comes to staging on the WIP area.

INDIRECT CAUSE:

WHY 1: There's a possibility that during transportation there is a movement between the items while pushing through the WIP area.

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

- > Orient the operators regarding the issue for awareness
- > Orient the operators regarding the proper staging on the WIP area.