



KPLIMA Operations Gen. Mnqr.

20-Dec-22

DOCUMENT REVIEW

MAN	Did not follow the standard	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE		Procedure Manual		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	Gielen Sayas	
MATERIAL		Work Instruction		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	Gielen Sayas	
METHOD		Process Flow		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	Gielen Sayas	
ENVIRONMENT		Forms		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	Gielen Sayas	

1.1. ISSUE:

DELAMINATION

1.2. ITEM DESCRIPTION:

ITEM DESCRIPTION:	
PART CODE:	516223000

PART CODE:	310225000
PART NAME:	LIONEL 2 MBL

1.3. BACKGROUND:

PICTURE



INHOUSE DETECTION: Delamination

LOT SIZE: 795

REJECT QUANTITY: 592

REJECTION RATE: 74.00%

REMARKS: Delamination occurred on the Lower flap class B

ACTION ITEMS

Target Date:

Person In-charge

DIRECT CAUSE:

WHY 1: Delamination occurred on the lower flap class b.

Why 2 : The speed of the machine was not in standard (Standard:60) (Speed used: 70)

Why 3: The operators failed to follow the standard procedure of the required speed set up.

INDIRECT CAUSE:

MODEL	SPEED
SOUFFLE	90
VINEGAR	-
LAM 1/8	90
LAM MID	90
LAM 1/2	60
LAM FULL	60
LAM F.P.	60
LAM F.S.	60
LAM F.L	90
GLASS WASH	90
GLASS HOLD	90
MIXER	LAM 1 = 60 LAM 2 = 70
VINEGAR	90

[illegible]

IV. ACTION PLAN:

DIRECT CAUSE:

- > Orient the operators regarding the issue of Delamination
- > Orient the operators regarding the proper set up before mass production. (New Operators)