
 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	<h1>INVESTIGATION REPORT</h1>		
	Prepared By:	Check By:	Approved By:
	GIELEN SAYAS	NOEMI CEPEDA	RHODORA MIRANDA
DATE:	23-Mar-23	QA-IE/ Prodn IE	QA/ Prodn SV
		KPLIMA Operations Gen. Mngr.	

5M REVIEW		DOCUMENT REVIEW				
MAN	No changes	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	No changes	Procedure Manual	230321	<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	G. Sayas	N/A
MATERIAL	WARP AND FLATTED	Work Instruction		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	G. Sayas	N/A
METHOD	No changes	Process Flow		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	G. Sayas	N/A
ENVIRONMENT	No changes	Forms		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	G. Sayas	N/A

I. PROBLEM DESCRIPTION

1.1. ISSUE:	
	DELAMINATION
1.2. ITEM DESCRIPTION:	
PART CODE:	516106500/ 515912200
PART NAME:	ROSA SAX ASIA/ LOUVRE 2 MJX EAI
1.3. BACKGROUND:	
PICTURE 	DETAILS: ROSA SAX LOT QTY: 398 REJECT QTY :23 REJECT PERCENTAGE: 5.78% DETAILS: LOUVRE 2 MJX EAI LOT QTY: 794 REJECT QTY :100 REJECT PERCENTAGE: 12.59%

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
Gluing operator inform their subleader and lamination sub-leader in-charge regarding the flow out of delamination.	230318	Gluing Operator

III. CAUSE ANALYSIS:

WHY 1:	DELAMINATION OCCURRED ON THE UPPER AND BOTTOM FLAP
WHY 2:	GLUE VISCOSITY WAS 2 FOR ROSA SAX AND 2.1 FOR LOUVRE 2 (STANDARD 1.8-2.5) GLUE APPLICATION WAS 4 IMPRESSION 22mm (RUNNING WATER 5mm) CONVEYOR SPEED 8
WHY 3:	GLUE APPLICATION WAS 4 IMPRESSION 22mm (RUNNING WATER 5mm) CONVEYOR SPEED 8
WHY 4:	THERE ARE CERTAIN PARTS OF THE SINGLE FACE USED THAT ARE WARP AND SLIGHTLY PRESSED/ FLAT
WHY 5:	DURING MASS PRODUCTION, THE OPERATOR DID NOT NOTICE THAT THE QUALITY OF SOME SINGLE FACE ARE NOT GOOD OR DID NOT MET THE QUALITY STANDARD.

IV. ACTION PLAN:

V. EVIDENCES:

1	The process should be put on hold while the quality assurance team verifies the raw materials. If the QA team determines that the items met the requirements, they should make a note or sign for the approval of the items. This is especially important if the operators notice any single faces that are not good, did not meet the quality standard, or had any abnormalities encountered on the raw materials (including warpage and flattened or pressed single faces).	*Please see attached on next sheet*
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