

**KANEPACKAGE PHILIPPINE INC.**

No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna  
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**INVESTIGATION REPORT**

Prepared By:

K.N. ACUIN

Check By:

N. CEPEDA

Approved By:

R. MIRANDA

**DATE:**

230509

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	230509	<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	KN ACUIN	N/A
MATERIAL	No Changes	Work Instruction		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	KN ACUIN	N/A
METHOD	no proper checking of sheets	Process Flow		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	KN ACUIN	N/A
ENVIRONMENT	No Changes	Forms		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	KN ACUIN	N/A

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

PEEL OFF DUE TO EXCESS GLUE IN 1ST GLUING

**1.2. ITEM DESCRIPTION:****PART CODE:** 5159121-00**PART NAME:** LOUVRE 2 MJX ICB FOR AMERICA**1.3. BACKGROUND:****PICTURE****DETAILS:**

> EXCESS GLUE DETECTED IN 1ST GLUING  
 > AT MACHINE GLUING 4  
 > LOT QTY 598 EA  
 > REJECT QTY: 21 EA  
 MAJOR REJECT /DETECTED BY QA

**II. IMMEDIATE ACTION**

ACTION ITEMS	Target Date:	Person In-charge
ADJUST (THINNED) THE APPLICATION OF GLUE IN 1ST GLUING	230508	OPERATOR
SORT THE ITEMS	230508	OPERATOR AND QA

**III. CAUSE ANALYSIS:**

<b>WHY 1:</b>	EXCESS GLUE THAT RESULT TO PEEL OFF OF THE ITEM IN GLUING MACHINE 4
<b>WHY 2:</b>	THE OPERATOR (CATCHER ) PUT TOO MUCH APPLICATION OF WHITE GLUE IN THE 1ST GLUING DURING MASS PRODUCTION
<b>WHY 3:</b>	THE OPERATOR (CATCHER ) DIDN'T NOTICED THE EXCESS GLUE IN THE GLUE TAB
<b>WHY 4:</b>	THE OPERATOR INCHARGE WAS STILL UNDER TRAINING & NO PROPER ORIENTATION

**IV. ACTION PLAN:****V. EVIDENCES:**

1	RE EDUCATE THE OPERATOR ABOUT THE WORK I	230515
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