
 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:
		MHVITO	N. CEPEDA	R. MIRANDA
DATE:	230731	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	230731	With Revision	No Revision	MH.VITO	N/A
MATERIAL	ACCUMULATED SCRAP	Work Instruction		With Revision	No Revision	MH.VITO	N/A
METHOD	No Changes	Process Flow		With Revision	No Revision	MH.VITO	N/A
ENVIRONMENT	No Changes	Forms		With Revision	No Revision	MH.VITO	N/A

I. PROBLEM DESCRIPTION

1.1. ISSUE:	
	PEEL OFF
1.2. ITEM DESCRIPTION:	
PART CODE:	516074400
PART NAME:	LOUVRE 2 CHINA
1.3. BACKGROUND:	
PICTURE 	DETAILS: <ul style="list-style-type: none"> > LAMINATION MACHINE 1 > LOT QTY: 271 EA PANEL A > REJECT QTY: 130 EA > REJECT PERCENTAGE: 47.97%

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
SEGREGATION OF THE AFFECTED PANEL	230728	OPERATOR
CLEAN THE GLUE ROLLER AND GLUE PLATE	230728	OPERATOR

III. CAUSE ANALYSIS:

WHY 1:	PEEL OFF WAS DETECTED AT LAMINATION MACHINE 1 DUE TO GLUE STAIN.
WHY 2:	GLUE STAIN OCCUR FROM ACCUMULATED SCRAP AT SHIELD PLATE.
WHY 3:	SHIELD PLATE WAS NOT PROPERLY CLEANED. NOTE: SHIELD PLATE MUST BE CLEANED ONCE A WEEK.
WHY 4:	OPERATOR FAILED TO CLEANED THE SHIELD PLATE
WHY 5:	CLEANING OF SHIELD PLATE WAS NOT INCLUDED AT DMC NOTE: ALREADY INCLUDED AT WI OF LAMINATION MACHINE (WI-LPR-002-003)

IV. ACTION PLAN:

V. EVIDENCES:

1	ORIENT THE OPERATOR ON THE ENCOUNTERED ISSUE OF PEEL OFF DUE TO GLUE STAIN AND FREQUENCY FOR CLEANING OF SHIELD PLATE	PIC: PRODUCTION IE TARGET DATE: JULY 28, 2023
2	INCLUSION OF CLEANING SHIELD PLATE AT DMC FORM	PIC: PRODUCTION IE TARGET DATE: AUG 5, 2023

KANEPACKAGE PHILIPPINE, INC.
ATTENDANCE SHEET
 Date: _____
 Activity: _____
 Attendees:
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GLUE STAIN



ACCUMULATED
SCRAP AT SHIELD
PLATE

WI

PREPARED BY _____ CHECKED BY _____ APPROVED BY _____

10.3 Clean the roller to avoid the accumulation of glue in the shield plate once a week.
 In any roller sapang matman ang pagkikitid-did ng glue sa shield plate ang bawat sa bawat araw.

11. Process reject, reject from trial and destructive testing should be placed at the designated area using red pallet for easy disposal.

Any process ng pagretest mula sa trial at destructive testing ay dapat lagay sa designated area sa isang puting plastikang pah. Sa matay sa pagkikitid.

12. Cleaning of Roller
 Note: 2 persons must perform the clean up.
 Tandaan: Dugang ang ang kinakailangan para sa pagkikitid.

12.1. Turn off the machine, remove both the sheet guide and corrugated guide then clean the press roller.
 I-off ang machine pagkatapos ay tanggapin ang sheet guide at corrugated guide at kumita ang press roller.

12.2. For manual wiping of press roller (see illustrations below.)

REVISION OF DMC
 TARGET AUG 05,2023

KANEPACKAGE PHILIPPINE, INC.
HP LIMA DAILY MACHINE CHECKLIST (DMC)
 Machine Location: _____ Month & Year: _____

Parameter	Inspection	What to Check	How to Check	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30
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