# 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

230921

# **INVESTIGATION REPORT**

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OA-IE/ Produ IE	OA/ Prodn SV	KPI IMA Operations Con Moor

5M REVIEW			DOCUMENT REVIEW			
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	UNBALANCE RUBBER ROLLER	Procedure Manual		☐ With Revision ☐ No Revision	MH VITO	N/A
MATERIAL	No Changes	Work Instruction	230921	☑ With Revision ☐ No Revision	MH VITO	N/A
METHOD	No Changes	Process Flow	230921	☐ 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:		
	DELAMINATION	
1.2 DETAIL		
PART CODE:	5163364-00	
PART NAME:	SOUFFLE CARTON BOX	
1.3 PACKCROUND		

#### 1.3. BACKGROUI

DATE:



#### DETAILS:

> LOT QTY: 347EA > REJECT QTY: 272EA > VISCOSITY: 10.1

> GLUE TYPE: WHITE GLUE

> DETECTION: DIE CUT PROCESS

#### **II. IMMEDIATE ACTION**

ACTION ITEMS	Target Date:	Person In-charge
SORTING OF ITEM	230919	PRODUCTION/QA

#### **III. CAUSE ANALYSIS:**

WHY 1:	DELAMINATION ENCOUNTER ON TH E ITEM 5163364-00 SOUFFLE CARTON BOX DETECTED AT DIE CUT PROCESS.	
WHY 2:	SOME PART OF CURROGATED MEDIUM OF THE SINGLE FACE WAS FLATTEN WHILE RUNNING AT LAMINATION THAT RESULT AN INSUFFICIENT APPLICATION OF GLUE.	
WHY 3	THE LEFT PORTION OF RUBBER ROLLER CAME DOWN DURING FEEDING OF SINGLE FACE.	
WHY 4:	THE ADJUSTER SCREW OF THE RUBBER ROLLER ACCIDENTALLY LOOSE.	
WHY 5:	RUBBER ROLLER WAS NOT CHECK BY OPERATOR PRIOR MACHINE SET-UP. NOTE: CHECKING OF RUBBER ROLLER NOT INDICATE ON DMC.	

## **IV. ACTION PLAN:**

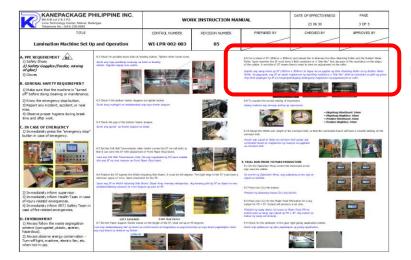
1 1	ORIENTATION TO LAMINATION OPERATOR REGARDING DELAMINATION ISSUE FOR THE ITEM 5163364-00 SOUFFLE CARTON BOX	230921
2	INCLUSION OF RUBBER ROLLER AT DMC AND WI FOR THEIR ADDITIONAL CHECKPOINT.	230929



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INCLUSION OF RUBBER ROLLER AT DMC



ATTENDANCE SHEET

SAME PACKAGE PHILIPPINE INC.

ATTENDANCE SHEET

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SAME PACKAGE PHILIPPINE INC.

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SAME PACKAGE

ACTIVITY

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INCLUSION OF RUBBER ROLLER AT WI

#### CLOSE MEETING UMETANI FOR EQOS MACHINE

SEPTEMBER 16-17 INSTALLING OF DIAGNOSTIC SYSTEM

**PRINTING UNIT** 

1 WEEK

TRAINING 18-22 MACHINE OPERATION TRAING

MORE ATTENTION SPECIALLY WHEN OPEARTING AUTO FEEDER IN LOADING

NO TROUBLE SHOOTING TRAINING BY ENGINEERING

DAMAGE MONITOR ALREADY ARRIVE FOR THE REPLACEMENT OF THE DAMAGE/BROKEN I

8G FLASHDRIVE FOR THE HISTORY COPY AT EQOS MACHINE

VISCOSITY

9 SEC

STIRRING SAME VISCOSITY USED ON SKIP ON/OFF

7-12 RANGE VISCOSITY USED

SPEACIAL REQUIREMENT SKIP ON AND ALSO WITH SOLID

REDUCE SKIP ON PROCESS

DAILY MAINTENANCE C/O BY OPERATOR
15 DAYS MAINTENANCE BY ENGINEERING
INK TANK MAINTEMNACE EVERY MONTH CLEANING

2 TYPE OF SETTING TOUCH GUIDE DEFENDS ON THE SIZE OF THE ITEM TO BE USE FOR THE DIFFICULTY

50MM INSIDE CYREL

9G LAGUNA INK 12G LIMA INK

OF LOADING

\_ ON THE ROLLER