
 <b>KANEPACKAGE PHILIPPINE INC.</b> No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna Telephone No. (049) 545-7166 to 69 Fax No. (049) 545-6302	<b>INVESTIGATION REPORT</b>		
	Prepared By:	Check By:	Approved By:
	MHVITO QA-IE/ Prodn IE	N. CEPEDA QA/ Prodn SV	R. MIRANDA KPLIMA Operations Gen. Mngr.
<b>DATE:</b>	230921		

5M REVIEW		DOCUMENT REVIEW					
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:		PIC:	Target Date:
MACHINE	UNBALANCE RUBBER ROLLER	Procedure Manual	230921	<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	MH VITO	N/A
MATERIAL	No Changes	Work Instruction		<input checked="" type="checkbox"/> With Revision	<input type="checkbox"/> No Revision	MH VITO	N/A
METHOD	No Changes	Process Flow		<input type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	MH VITO	N/A
ENVIRONMENT	No Changes	Forms		<input checked="" type="checkbox"/> With Revision	<input type="checkbox"/> No Revision	MH VITO	N/A

## I. PROBLEM DESCRIPTION

<b>1.1. ISSUE:</b>	
	DELAMINATION
<b>1.2 DETAIL</b>	
<b>PART CODE:</b>	5163364-00
<b>PART NAME:</b>	SOUFFLE CARTON BOX
<b>1.3. BACKGROUND:</b>	
<b>PICTURE</b> 	<b>DETAILS:</b> > 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:

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

## IV. ACTION PLAN:

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

## INCLUSION OF RUBBER ROLLER AT DMC

[illegible]

## INCLUSION OF RUBBER ROLLER AT WI

<b>K KANEPACKAGE PHILIPPINE INC.</b>				
<b>ATTENDANCE SHEET</b>				
Submitted by:	<u>MICHELLE</u>	Date:	<u>5/28/80</u>	
Description issued at item 5167554-00 Carter Dist., Clark City				
<b>Attendees</b>				
#	FIRST NAME	LAST NAME	DIV. / DEPT.	SIGNATURE
1	Talbot	Campbell	prod.	[Signature]
2	Gilbert	Pineda	prod.	[Signature]
3	Figueroa	Rosales	prod.	[Signature]
4	Diaz	Sims	prod.	[Signature]
5	Boby	Wickard	prod.	[Signature]
6	Michel	Webster	prod.	[Signature]
7	Nelson	McNair	prod.	[Signature]
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Note: This form is confidential. Do not use as scratch paper.

CLOSE MEETING UMETANI FOR EQOS MACHINE

SEPTEMBER 16-17      INSTALLING OF DIAGNOSTIC SYSTEM  
PRINTING UNIT

1 WEEK  
TRAINING    18-22      MACHINE OPERATION TRAINING

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 MAINTENANCE EVERY MONTH CLEANING

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

50MM INSIDE CYREL

9G LAGUNA INK  
12G LIMA INK

OF LOADING

. ON THE ROLLER