## 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

OCTOBER 2, 2023

### **INVESTIGATION REPORT**

Prepared By:	Check By:	Approved By:
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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	231002	☐ With Revision ☐ No Revision	K.N ACUIN	N/A
MATERIAL	FAILED ON RUB TEST	Work Instruction		☐ With Revision ☐ No Revision	K.N ACUIN	N/A
METHOD	No Changes	Process Flow		With Revision No Revision	K.N ACUIN	N/A
ENVIRONMENT	No Changes	Forms		With Revision No Revision	K.N ACUIN	N/A

#### I. PROBLEM DESCRIPTION

# 1.1. ISSUE: | SCRATCHES | 1.2. ITEM DESCRIPTION: | PART CODE: | 515141900 | | PART NAME: | CARTON BOX

#### 1.3. BACKGROUND:

DATE:



#### DETAILS:

>Inhouse Detection :SCRATCHES

>Lot size: 48pcs > Reject Qty: 25pcs >Rejection Rate: 52.08%

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

ACTION ITEMS	Target Date:	Person In-charge	
QA SORT THE AFFECTED ITEMS	230926	QA PERSONNEL	

#### III. CAUSE ANALYSIS:

WHY 1:	WHY THE SCRATCHES OCCURRED ON ITEM CODE 515141900 (CARTON BOX)? SCRATCHES ENCOUNTERED ON ITEM 515141900 CARTON BOX AT SEMI AUTO GLUING 4 PROCESS.		
WHY 2:	2: WHY DO SCRATCHES APPEAR ON THE CARTON BOX WHEN RUN ON THE SEMI AUTO GLUING MACHINE 4? THE PUSH ROLLLER SCRATCH THE CHARACTER PRINT OF THE ITEM WHILE RUNNING		
WHY 3	WHY DOES THE PUSH ROLLER SCRATCH THE CHARACTER PRINT OF THE ITEM? PRINT FROM DIGITAL PRINTING IS EASY TO ERASE OR SCRATCH		
WHY 4:	WHY IS CHARACTER PRINT EASY TO ERASE OR SCRATCH? THE CHARACTER PRINT FROM THE DIGITAL PRINTING DOES NOT PASSED THE RUB TEST		

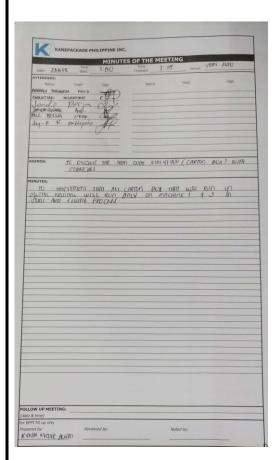
#### IV. ACTION PLAN: V. EVIDENCES:

1	EDUCATE THE OPERATOR NOT TO RUN THE ITEMS CAME FROM DIGITAL PRINTING TO THE SEMI AUTO GLUING MACHINE 4 (CARTON BOX WILL BE RUN IN SEMI AUTO GLUING MACHINE 1 & 3)	231002 PIC: IE STAFF
2	Suggestion: To used softer rubber roller in running this item.	





#### **DURING MANUAL RUB TEST (FAILED)**



MINUTES OF MEETING REGARDING OF SCRATCHES