
 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:
	K.N ACUIN	N. CEPEDA	R. MIRANDA
DATE:	OCTOBER 2, 2023	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:	
	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:	WHY DO SCRATCHES APPEAR ON THE CARTON BOX WHEN RUN ON THE SEMI AUTO GLUING MACHINE 4? THE PUSH ROLLER 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)

K KANEPACKAGE PHILIPPINE INC.

MINUTES OF THE MEETING

Date: 25/05/2020 Time: 1:00 PM Time Finished: 1:15 Version: 1/001 AUTO

ATTENDEES:

Name	Dept.	Sign	Name	Dept.	Sign
RODOLFO TORALANZA	PROD	[Signature]			
CHRISTIAN TORALANZA	PROD	[Signature]			
JEROME BORJA	PROD	[Signature]			
JENEL TORALANZA	PROD	[Signature]			
JOE REYES	PROD	[Signature]			
Jay-R R. Delgado	PROD	[Signature]			

AGENDA: TO DISCUSS THE ITEM CODE 510141900 (CARBON BOX) WITH JEROME

MINUTES: TO IMPLEMENT THAT ALL CARBON BOX THAT WILL RUN IN DIGITAL PRINTING WILL RUN ONLY ON MACHINE 1 & 3 IN JET-AND FINISH PROCESS

FOLLOW UP MEETING: (date & time)

For KPS fill up only

Prepared by: KYRAN NICOLE AGUIRRE

Reviewed by: _____

Noted by: _____

MINUTES OF MEETING REGARDING OF SCRATCHES

