


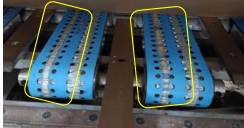
 <b>KANEPACKAGE PHILIPPINE INC.</b> No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna Telephone No. (049) 545-7166 to 69 Fax No. (049) 545-6302	<h1>INVESTIGATION REPORT</h1>		
	Prepared By:	Check By:	Approved By:
	MHVITO	N. CEPEDA/R.ALMARIO	R. MIRANDA
<b>DATE:</b>	231010	QA-IE/ Prodn IE	QA/ Prodn SV/MANAGER
		KPLIMA ASST.VICE PRESIDENT	

5M REVIEW		DOCUMENT REVIEW					
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:		PIC:	Target Date:
MACHINE	<b>NEW FEEDER BELT</b>	Procedure Manual	231010	With Revision	No Revision	MH VITO	N/A
MATERIAL	No Changes	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

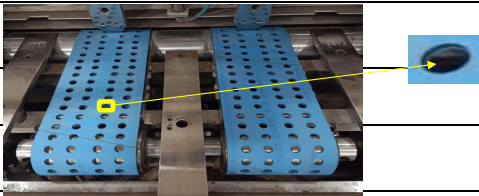
## I. PROBLEM DESCRIPTION

<b>1.1. ISSUE:</b>	
	PEEL OFF
<b>1.2 DETAIL</b>	
<b>PART CODE:</b>	516590200
<b>PART NAME:</b>	LOUVRE 2 MDX
<b>1.3. BACKGROUND:</b>	
<b>PICTURE</b> 	<b>DETAILS:</b>  > PLAN QTY: 895 EA > REJECT QTY: 66 EA > REJECT PERCENTAGE: 7.37%

## II. IMMEDIATE ACTION


ACTION ITEMS	Target Date:	Person In-charge
PUTTING PAPER TAPE AT FEEDER BELT 	10-Oct-23	PRODUCTION

## III. CAUSE ANALYSIS:

<b>WHY 1:</b>	<b>Why Peel Off occurred in Louvre item?</b> It was hardly scrubbed by the feeder belt during lamination process	
<b>WHY 2:</b>	<b>Why Scrubbing by the Feeder Belt causes Peel Off?</b> Feeder Belt has a sharp edges and rough surface particular on the hole area	
<b>WHY 3:</b>	<b>Why Feeder Belt has a sharp edges and rough texture?</b> Feeder belt installed in the feeding section is New	
<b>WHY 4:</b>	<b>Why New Feeder Belt with a Sharp edges and Rough Texture installed in the machine?</b> Current Feeder Belt installed was Old and Deteriorated already	
<b>WHY 5:</b>	-	

## IV. ACTION PLAN:

## V. EVIDENCES:

1	CONDUCT MEETING/ ORIENTATION REGARDING TO THE ISSUE OF PEEL OFF AT ITEM CODE 5167377-00 LOUVRE 2 MCX ETD		231010
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**DATE:**

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2

CHECKING FOR THE USE OF SAND PAPER TO REMOVE SHARP  
SURFACE (WHEN THE BELT ARE NEW REPLACE)



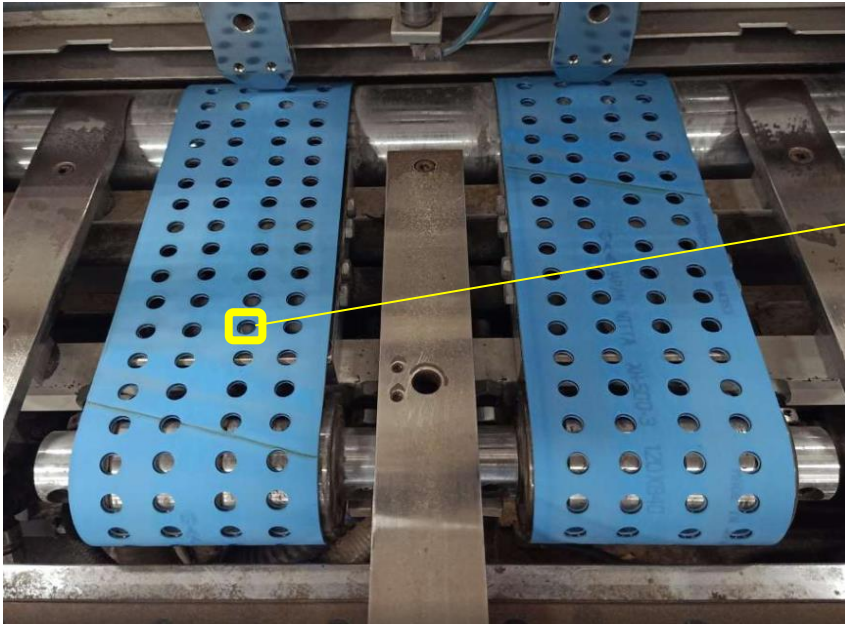
231009

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***Standardize and Inclusion of Putting Tape if Feeder Belt  
is New in Work Instruction***



231020



SHARP EDGE



USE SAND PAPER TO REMOVE SHARP OBJECT

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