

 KANEPACKAGE PHILIPPINE INC. Blk 6-B Lot 2 & 3 P3, Lima Technology Center, Malvar, Batangas Telephone No.: (043) 236-6885	INVESTIGATION REPORT		
	Prepared By:	Check By:	Approved By:
DATE: 231107	MHVITO QA-IE/ Prodn IE	N. CEPEDA/R.ALMARIO QA/ Prodn SV/MANAGER	R. MIRANDA KPLIMA ASST.VICE PRESIDENT

5M REVIEW		DOCUMENT REVIEW					
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:		PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	231107	<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 type="checkbox"/> With Revision	<input checked="" type="checkbox"/> No Revision	MH VITO	N/A

I. PROBLEM DESCRIPTION

1.1. ISSUE:	
	DELAMINATION
1.2 DETAIL	
PART CODE:	5165009-00
PART NAME:	LUCIDA MDX ASIA
1.3. BACKGROUND:	
PICTURE <small>DEFECT DESCRIPTION: DELAMINATION</small> 	DETAILS: <ul style="list-style-type: none"> > PLAN QTY: 397 EA > REJECT QTY: 12 EA > REJECT PERCENTAGE: 3.02% > JO ORDER: 048181 > VISCOSITY: 2.2 > CONVEYOR SPEED: 9.5 > GLUE APP: 4 > IMPRESSION: 22

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
SORTING OF ITEM	231106	QA

PROCESS FLOW CHART



III. CAUSE ANALYSIS:

WHY 1:	Why Delamination occurred in Lucida item? The lower flap of panel B has a weak glue application.	
WHY 2:	Why it has Weak application of glue on the panel ? The single face and printed sheet does not adhere well even though it passes through the conveyor to flatten properly . The glue applied on the single Face does not penetrated to adhere on the printed sheets	

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DATE:	231107	
WHY 3	<p>Why glue applied on the SF does not penetrated nor adhere on the Printed sheets? The Single face used has a warpage issue and also the weights being used are lacking (actual used is 1 instead of 2 per caster)</p>	
WHY 4:	<p>Why Weights are lacking PRIOR USAGE? Other weights are used on raw material prior issuance to production.</p>	
WHY 5:	-	

IV. ACTION PLAN:

V. EVIDENCES:

1	CONDUCT MEETING/ ORIENTATION REGARDING DELAMINATION ISSUE IN ITEM 5165009-00 LUCIDA MDX ASIA		231107
2	ADDITIONAL WEIGHTS FOR WIP		231107
3	INCLUSION OF PUTTING OF WEIGHTS IN WORK INSTRUCTION		ON-GOING (231117)