


 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:
	MHVITO QA-IE/ Prodn IE	N. CEPEDA/R.ALMARIO QA/ Prodn SV/MANAGER	R. MIRANDA KPLIMA ASST.VICE PRESIDENT
DATE:	231107		

5M REVIEW		DOCUMENT REVIEW				
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:		PIC:
MACHINE	No Changes	Procedure Manual	231107	With Revision	No Revision	MH VITO
MATERIAL	No Changes	Work Instruction		With Revision	No Revision	MH VITO
METHOD	No Changes	Process Flow		With Revision	No Revision	MH VITO
ENVIRONMENT	No Changes	Forms		With Revision	No Revision	MH VITO

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: > 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		Prepared By:	Check By:	Approved By:
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WHY 3	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)			
WHY 4:	Why Weights are lacking PRIOR USAGE? Other weights are used on raw material prior issuance to production.			
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)