

KANEPACKAGE PHILIPPINE INC. No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna Telephone No. (049) 545-7155 to 59 Fax No. (049) 545-6302	INVESTIGATION REPORT		
	Prepared By: MH VITO QA-IE/ Prodn IE	Check By: R. MIRANDA QA/ Prodn SV/MANAGER	Approved By: R. MIRANDA KPLIMA ASST. VICE PRESIDENT
DATE: 231123			

5M REVIEW			DOCUMENT REVIEW			
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	231123	<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	MH VITO	N/A
MATERIAL	No Changes	Work Instruction		<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	MH VITO	N/A
METHOD	CLEANING OF CYREL	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:	
	INCOMPLETE PRINT
1.2. DETAIL	
PART CODE:	5167674-00
PART NAME:	INDIVIDUAL CARTON BOX FOR JAPAN
1.3. BACKGROUND:	
PICTURE <small>DEFECT DESCRIPTION: INCOMPLETE PRINT</small> 	DETAILS: > PLAN QTY: 110 PCS > REJECT QTY: 4 PCS > REJECT PERCENTAGE: 3.64% > JO #: 050023 > CUSTOMER CLAIM

II. IMMEDIATE ACTION

ACTION ITEMS	Target Date:	Person In-charge
ORIENTATION REGARDING INCOMPLTE PRINT ISSUE	231123	PRODUCTION

III. CAUSE ANALYSIS:

WHY'S	DETAIL	IMAGE
WHY 1:	Why incomplete print occur at item 5167674-00 Individual Carton Box for Japan? The ink that was distributed was not able to penetrate in the cyrel	
WHY 2:	Why the ink cannot penetrate in the cyrel? Some parts of the cyrel particular on the affected image is still wet	
WHY 3:	Why some parts of the cyrel is still wet? Liquid cleanser was directly spray in the cyrel and wipe it by rags after	
WHY 4:	Why Spraying directly in the cyrel causes incomplete print? Un control spraying of Liquid cleanser in the cyrel	
WHY 5:	Why spraying of Liquid Cleanser was uncontrol? No standard procedure on the proper cleaning of cyrel	

IV. ACTION PLAN:

V. EVIDENCES:

1	SPRAYING OF ANOFLEX CLAENER DIRECTLY ON THE RAG.		231123
2	INCLUSION IN WORK INSTRUCTION ON PROPER CLEANING OF CYREL USING ANOFLEX CLEANER		231210



KANEPACKAGE PHILIPPINE INC.

ATTENDANCE SHEET

Submitted by:

MHN/1123

Date:

23/11/23

ACTIVITY

Customer claim Regarding Poor Print / Incomplete print at 5167674-00 ~~Lowest cost~~
Individual Carton Box Per Japan ~~am/1123~~ 23/11/23

Attendees

	FIRST NAME	LAST NAME	DIV. / DEPT.	SIGNATURE
1	JOHN LOUIE	ABRENICA	PROD	
2	NORIN	ARCO/RET	PROD	
3	CLEMAZ	BELARDO	PROD	
4	Wilbert	Batallo	Prodn	
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