

b		<div style="display: flex; align-items: center;"> <div> <b>KANEPACKAGE PHILIPPINE INC.</b>          Blk 6-B Lot 2 &amp; 3 P3,          Lima Technology Center, Malvar, Batangas          Telephone No.: (043) 236-6885       </div> </div>		INVESTIGATION REPORT	
Prepared By: MH VITO PROD'N IE				Check By: N. CEPEDA PROD'N SUPERVISOR	
Approved By: R. ALMARIO PRODUCTION MANAGER		DATE: 240208			

SM REVIEW		DOCUMENT REVIEW				
MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	240208	<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	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:	5167004-00
PART NAME:	STRATOS AMERICA
1.3. BACKGROUND:	
PICTURE 	DETAILS: > PLAN QTY: 293 EA > REJECT QTY: 70 EA > REJECT PERCENTAGE: 23.89% > JO ORDER: 055876 > 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	240208	PRODUCTION

**PROCESS FLOW CHART**

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graph LR
    Start([Start]) --> LAMINATION[LAMINATION]
    LAMINATION --> DIE CUT[DIE CUT]
    DIE CUT --> GLUING[GLUING]
    GLUING --> INSPECTION[INSPECTION]
    INSPECTION --> DELIVERY[DELIVERY]
    DELIVERY --> End([End])
          
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**III. CAUSE ANALYSIS:**

WHY 1:	Why Delamination occurred in Stratos America 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	
WHY 3:	Why glue applied on the SF does not penetrated nor adhere on the Printed sheets? The item run at Laminator machine 1 using dingshung glue and the roller of the machine is new replaced for monitoring.	
WHY 4:	Why they used to run at laminator machine 1 using dingshung glue since the roller are new and under monitoring? During trial of the item, the evaluation using dingshung glue are passed and no encounter delamination.	
WHY 5:	Why no encounter delamination on the item during trial using dingshung glue? The item run at Laminator machine 2 (note: both machine are same item run.)	

**IV. ACTION PLAN:**

1	CONDUCT MEETING/ ORIENTATION REGARDING DELAMINATION ISSUE IN STRATOS ITEM.		240208
2	CHANGE GLUE FROM DINGSHUNG GLUE TO WHITE GLUE (PREMIER GLUE) FOR BOTH MACHINE		240209
3	USED LAMINATOR MACHINE 2 FOR STRATOS ITEM		240210

**V. EVIDENCES:**