

**KANEPACKAGE PHILIPPINE INC.**

No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna  
Telephone No. (049) 545-7166 to 69  
Fax No. (049) 545-6302

**INVESTIGATION REPORT**

Prepared By:

Check By:

Approved By:

MHVITO

N. CEPEDA

R. MIRANDA

**DATE:**

230421

QA-IE/ Prodn IE

QA/ Prodn SV

KPLIMA Operations Gen. Mngr.

**5M REVIEW****DOCUMENT REVIEW**

MAN	No Changes	Affected Document:	Date Reviewed:	Disposition:	PIC:	Target Date:
MACHINE	No Changes	Procedure Manual	230420	<input type="checkbox"/> With Revision <input checked="" type="checkbox"/> No Revision	MH.VITO	N/A
MATERIAL	URGENT ITEM	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. ITEM DESCRIPTION:****PART CODE:**

516588100

**PART NAME:**

LIONEL 2 MBL

**1.3. BACKGROUND:****PICTURE****DETAILS:**

- > IN-HOUSE REJECT
- > DELAMINATION DETECT AT GLUING PROCESS
- > LOT QTY: 797 EA
- > REJECT QTY: 385 EA
- > REJECTION RATE: 48.3%

**II. IMMEDIATE ACTION**

ACTION ITEMS	Target Date:	Person In-charge
REWORK THE ITEM WITH DELAMINATION FOR RECOVERY	230420	OPERATOR
INFORM THE LAMINATION OPERATOR REGARDING THE ISSUE OF DELAMINATION	230420	IE STAFF

**III. CAUSE ANALYSIS:**

<b>WHY 1:</b>	DELAMINATION OCCUR AT THE LOWER AND UPPER FLAP OF THE ITEM WITH ITEM CODE OF 516588100-LIONEL 2 MBL AT LAMINATION MACHINE 2.
<b>WHY 2:</b>	THE VISCOSITY OF THE GLUE WAS 2.1 (standard 1.8 to 2.5) and the speed used was 60 pcs/min. (THE ITEM IS WAITING FOR THE ARRIVAL OF SF FOR LIONEL 2 MBL.)
<b>WHY 3:</b>	THE SF USED WAS DIRECTLY LAMINATED TO LAMINATION MACHINE AFTER UNLOADING AT TRUCK.
<b>WHY 4:</b>	IT IS POSSIBLE THAT THE MOISTURE/ TEMPERATURE OF THE SF AFFECT THE GLUE APPLICATION DURING RUN. (NO DELAMINATION AT FIRST AND SECOND ITEM RUN BOTH SF AND THE THIRD ITEM WITH DELAMINATION PROBLEM ALSO USED SF)

**IV. ACTION PLAN:****V. EVIDENCES:**

1	ORIENT THE OPERATOR REGARDING TO THE ISSUE OF DELAMINATION OF 51658100 LIONEL 2.	230419
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CHECKING OF THE NEXT RUN OF LIONEL SF FOR INVESTIGATION OF THE ISSUE OF  
DELAMINATION**NEXT PLAN**